Processing

Instructions, tips and best practices for the reliable setting of snap fasteners and eyelets.

01	Basics & best practices	Page 2
02	Ring-spring Super snap fastener	Page 3
03	S-spring Star snap fastener	Page 4
04	Prong-ring Elegant snap fastener	Page 5
05	Eyelets: placing the ring correctly	Page 6
06	Identifying and fixing errors	Page 7
07	Shank length and material thickness	Page 8



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Basics and best practices

Follow these six rules for a perfect result every time – from the first sample to series production.

1

Correct die set

Each product and size has its own dies. Screw dies in firmly and centre them.

2

Test piece first

Always test new fabric/product combinations on a scrap piece first.

3

Mark the position

Place upper and lower parts exactly opposite – so the fastener closes cleanly.

4

Reinforce the fabric

For thin or stretchy fabrics, use an interlining or double layer so nothing tears out.

5

Dose the pressure

Too little pressure: parts don't hold. Too much: parts deform and the snap jams.

6

Check the function

After setting, open and close several times and check the fit.

CHECKLIST

- [ ] Dies match product and size
- [ ] Position marked on both layers
- [ ] Dies firm and centred
- [ ] Eyelet washer: fabric side noted
- [ ] Test piece checked
- [ ] Function checked

Setting the Super ring-spring snap

Two operations with the matching die set in the toggle press.

1 Cap Ø 12,5 mm with socket





PART 1

Cap Ø 12,5 mm

Super 2/3 · Cap die

`510000012500W`





PART 2

Socket

Super 2/a · Socket die

`ZKB32000100`

2 Stud with post





PART 1

Stud

Super 2/b · Stud die

`ZKC32000100`





PART 2

Post

Super 2/c · Post die

`ZKD32000100`

Tip: Place upper and lower parts exactly opposite – mark the position on both fabric layers first.

Setting the Star S-spring snap

Two operations: which part goes on which die and how the die set sits in the press.

1 Socket with cap





TOP · 1×

Socket

Star M 4/a · Socket die





BOTTOM · 1×

Cap

Star M 4/2 or 4/3 · Cap die



How the die set sits in the press

2 Stud with post





TOP · 1×

Stud

Star M 4/b · Stud die





BOTTOM · 1×

Post

Star M 4/c · Post die



How the die set sits in the press

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Setting the Elegant prong-ring snap

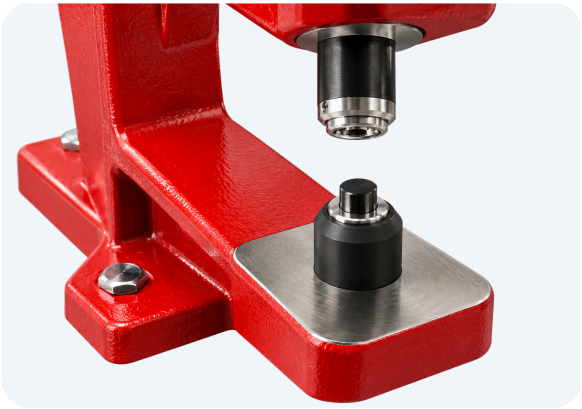
The prong ring grips through the fabric – ideal for thin and stretchy fabrics.

1 Prong ring





BOTTOM · 2×
Prong ring
Elegant M 3/1 · Prong-ring die



How the die set sits in the press

2 Socket





TOP · 1×
Socket
Elegant M 3/a · Socket die



How the die set sits in the press

3 Stud





TOP · 1×
Stud
Elegant M 3/b · Stud die



How the die set sits in the press

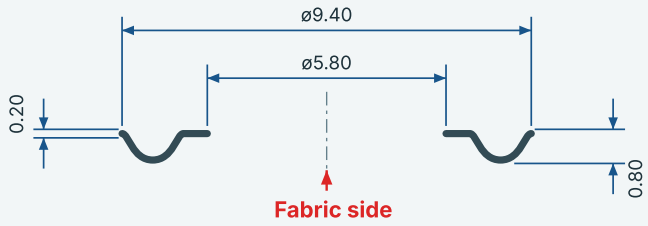
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Tip: fit the washer correctly

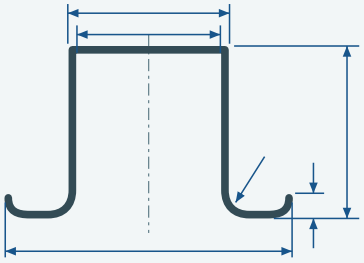
Example eyelet 5 mm: the washer is placed on the upper die. Note which side faces the fabric.



WASHER IN SECTION



EYELET IN SECTION



Identifying and fixing errors

The most common setting problems – and how to fix them.

Problem	Possible cause	Solution
Snap fastener is stiff or jams	Too much pressure, socket deformed	Reduce pressure, set a new part, check dies
Snap fastener doesn't hold or turns	Too little pressure, or fabric too thick or thin for the part	Increase pressure; choose a product suited to the fabric thickness
Part tears out of the fabric	Thin or stretchy fabric without reinforcement	Use interlining or a double layer; prong-ring Elegant snap for thin fabrics
Upper and lower parts don't match	Position not exactly opposite	Mark the position on both layers beforehand
Eyelet crooked or washer not cleanly flanged	Washer fitted the wrong way round or die not centred	Fit the washer with the correct side to the fabric; align the die
Scratches or pressure marks on the cap	Dirty or wrong die	Clean the die; use the die that belongs to the product

Questions about processing?

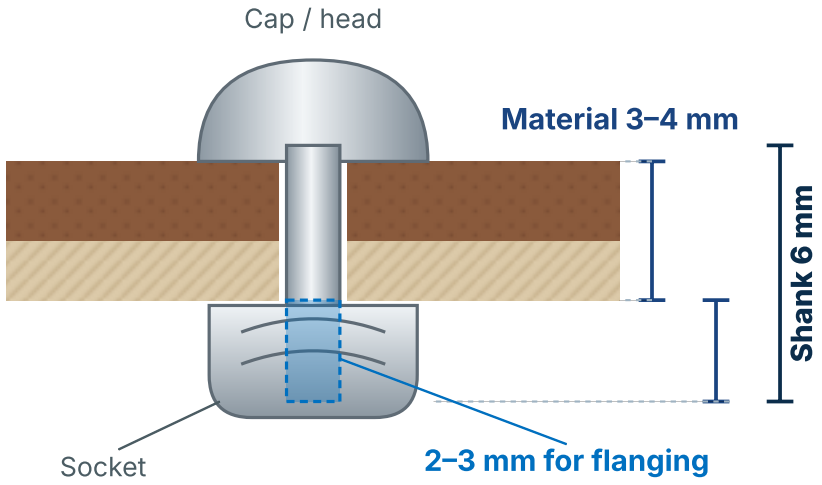
We are happy to advise you – on die sets, machines and the right settings.

+41 41 375 03 03
info@brero.ch

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Shank length and material thickness

For a secure connection, the shank length must match the thickness of the material.



Material thickness = shank length minus 2–3 mm

Shank length	Material up to	For flanging
6 mm	**3–4 mm**	**2–3 mm**

Why?

When setting, at least 2–3 mm of the shank is needed for flanging – the part that rolls over in the counterpart during pressing and holds the connection. If the material is too thick, too little shank remains for flanging and the connection will not hold.

Leather and fabric

They compress slightly during pressing – if in doubt, always test on a sample first.

Different shank lengths

Eyelets, rivets and snap fasteners are available with different shank lengths. You will find the height (H) for every item on brero.ch – we are happy to advise you.