

## SUPER RING CLOSING TOOL 55 (1030-55)

### Manual for Rutgerson Closing Tool 55

This is a manual for pressing a Rutgerson Super Ring 55 into the sail.  
Please read the manual carefully and follow the instructions step by step.

1. Use the Hole punch 1060-60 to make a hole in the sailcloth where the ring is to be pressed into the sail.
2. Place the centre piece of the Super Ring onto the lower die of the Closing tool. Then place the plastic washer on top with the uneven surface facing downwards and thereafter the sailcloth. Lastly, place the toothed washer of the Super Ring with the teeth pointing downwards and then the upper die 1030-55-02.
3. First tempo/pressing is with the lower die 1030-55-01 and 1030-55-02 as upper die and with the guide pin 1030-003 in the centre, at 25 tons pressure. Press all the way until the teeth have sunk through the sail cloth and the plastic washer.
4. Switch to the upper die 1030-55-03 part for the second pressing and press until the centre piece has curved neatly over the tooth washer, at a maximum pressure of 30 tons. Do not over-press the ring, it will damage the sailcloth and possibly the closing tool.

