SETTING THE CRIMPING DIAMETER IS/AS

From the crimping diameter chart on the door of the die set storage locker you can see the die set numbers and the corresponding crimping ranges.

The upper section of the chart shows the corresponding dial position for each crimping diameter in the columns. The upper dial positions are for AS and lower for IS-models.

Crimping diameters in the grey zone of the chart are not recommended.

The crimping diameter dial has been calibrated at the factory so that when the dial is set at 0.0, the resulting diameter will be the minimum diameter of the die set installed, i.e. with die set No 32-16 the crimping diameter will be 16 mm, No 32-19 gives a diameter of 19 mm etc.

The crimping diameter increases when the dial is turned clockwise. In IS-models one turn is equivalent to a 1 mm change in the crimping diameter. In AS-models the diameter change is 1 mm between two digits. The measuring scale of the dial is divided into divisions of either 0.01 mm in IS-models or 0.1 mm in AS-models.

EXAMPLE: The crimping diameter of the fitting should be 20.6 mm. Select die set No 32-19 (min crimping diameter 19 mm) according to the die chart. Turn the IS-dial to position 1.60 (upper scale 1, lower 60). The AS-dial is turned to position 1.6. This setting will give the crimping diameter 20.6 mm (19 + 1.6 mm).

The machine has been calibrated at the factory with 40 bar pressure. This means that when you are crimping a fitting requiring 40 bar pressure, the measuring scale of the crimping diameter dial provides an accuracy of +/- 0.1 mm (possible elastic recovery of the fitting not regarded).

When fittings requiring higher pressure are crimped, the crimping diameter may become larger than the value on the scale due to machine deflections. Then the crimping diameter has to be corrected by changing the scale value.

SETTING THE CRIMPING DIAMETER VS

- While the crimping diameter display is surrounded by the cursor, activate it by pressing E.
- Select the desired crimping diameter by turning the selector and press E.
- Check the die set used and change it if need be.
- When required, set the retraction diameter in the same way.

The machine has been calibrated at the factory with 40 bar pressure. This means that when you are crimping a fitting requiring 40 bar pressure, the measuring scale of the crimping diameter dial provides an accuracy of +/- 0.1 mm (possible elastic recovery of the fitting not regarded).

When fittings requiring higher pressure are crimped, the crimping diameter may become larger than the value on the scale due to machine deflections. Then the crimping diameter has to be corrected using the correction function.
WHEN CRIMPING A FITTING, HOLD THE HOSE FAR ENOUGH TO AVOID CRIMPING YOUR HAND!

MANUAL MODE

Manual mode is used during die set change, set-up and test run.

1. Select MANUAL MODE.
2. Press the start button.
3. Adjust the recommended crimping diameter.
4. Press the crimping button until the dies hold the fitting lightly.
5. Adjust the retraction diameter when required.
6. Press the crimping button until the dies stop.
7. Open the dies and remove the fitting.
8. Check the crimping diameter.
9. If necessary, perform fine adjustment with the crimping diameter dial (IS/AS model) / using the correction function (VS model).

SEMI-AUTOMATIC MODE

Semi-automatic mode is used when performing small quantities of crimps.

1. Adjust the crimping and retraction diameters.
2. Select SEMI-AUTOMATIC MODE.
3. Insert the hose assembly between the dies.
4. Press the semi-automatic crimping button, and dies perform a crimping-retraction cycle. The cycle can be interrupted by releasing the button. If need be, dies can be opened by using the retraction button.

AUTOMATIC MODE

Automatic mode is best suited for serial production. Pressing the fitting against the stop device starts the crimping movement.

1. Select MANUAL MODE.
2. Set the required crimping diameter.
3. Insert the fitting (2) between the dies (1) to the correct position as shown in the figure.
4. Crimp the dies lightly until they hold the fitting properly.
5. Loosen the locking lever (3) and push the stop device (4) against the fitting so that the spring-loaded stop device is compressed, making the limit switch inside it actuate. Tighten the locking lever.
6. Open the dies until the fitting loosens.
7. Select AUTOMATIC MODE.
8. When the stop device is pressed, the machine performs a crimp and returns to the set retraction.
9. The movement stops if the fitting is not adequately pressed against the stop device. If need be, dies can then be opened by using the retraction button.
10. After dies have gripped the fitting, the crimping movement can be stopped only by the emergency stop push-button.
11. Make sure that there are no foreign objects between the dies.
12. Make a test crimp by pressing the fitting against the stop device.
13. Check the crimping diameter and correct the position of the stop device if necessary.