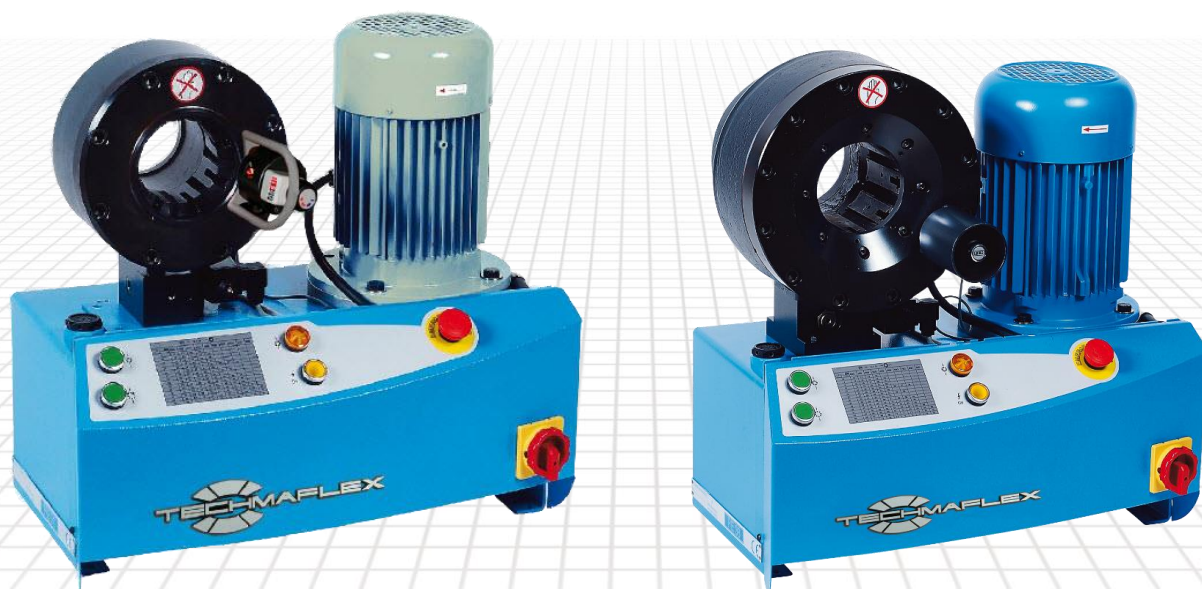


## PE28 – PE38

SWAGING / CRIMPING MACHINES



## ***MAINTENANCE & INSTRUCTIONS MANUAL***



## A. WARRANTY AND RESPONSIBILITY

**Warranty:** It's the supplier's responsibility to guarantee the conformity of the product, assuring that it's manufactured without fault and that it meets the agreement settlements between both parts.

The warranty is valid for one year, beginning at the date of the sale document. In this warranty are included all the pieces or parts of the components that may come to need replacement. Within the warranty period the supplier is responsible for any lack of conformity found on the equipment, as long as they are reported by written, within a maximum of 8 days from the delivery of the equipment. Where it concerns to lack of conformity duly verified, the manufacturer undertakes the responsibility to, within a reasonable period of time, to repair or replace the components, or parts of these, that are proven to not be within normal standards.

The return of defective goods, must always be authorized in written by the supplier. Furthermore the goods need to be returned in it's original packaging.

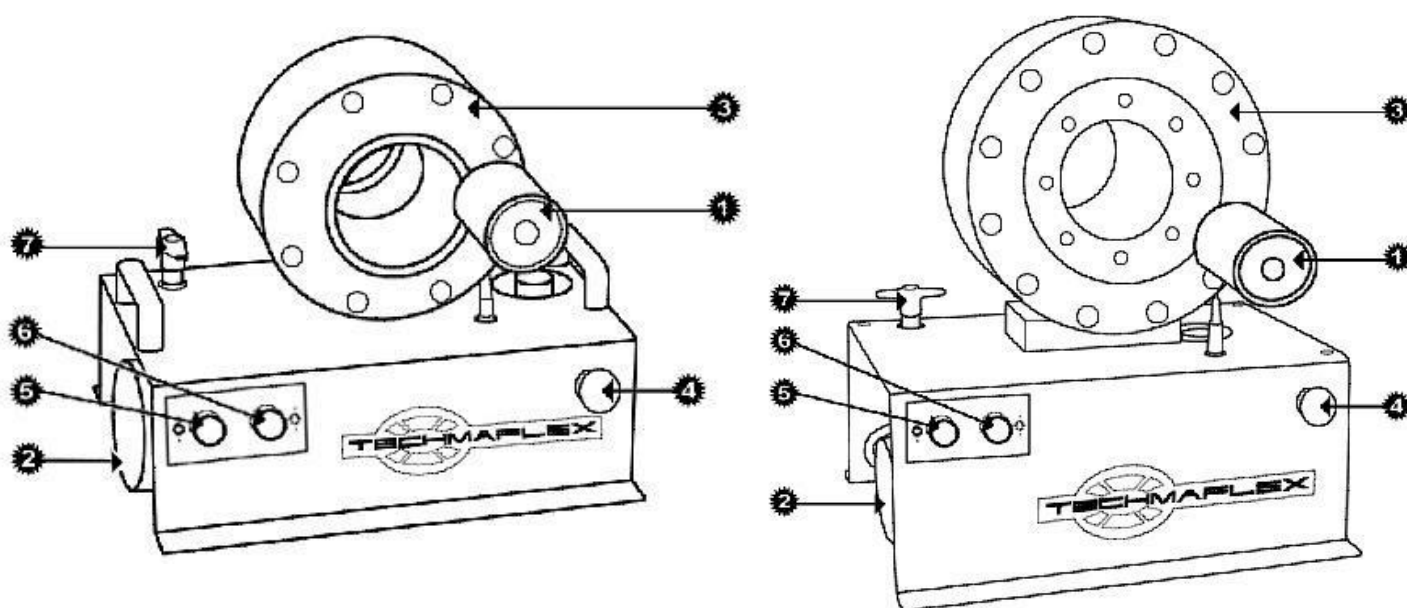
During the term of this warranty, Allswage UK will proceed to the replacement or repair of equipment - according to it's option - assuming the costs that come from it. To this end, it must be informed by the customer, within the 3 days after the malfunction started. All replaced parts are property of Allswage UK.

The warranty is void when: The products have not be correctly assembled, or used for different purposes that the intended; Have not received proper maintenance, or have been modified or repaired without the authorization of the supplier. The manufacturer is not responsible for the natural consumption of the components.

**Supplier's Responsibility:** the supplier shall be the solely responsible for the proper functioning of the product and, for its characteristics and performances specifically stated by them. However, the manufacturer takes no responsibility as long as it's identified third party interference.

## B. PRESENTATION

Thank-you for choosing one of our Techmaflex swaging machines. This press is easy to use and robust and is specially designed for the swaging of hydraulic hose assemblies on site. Please read this user guide carefully to ensure you use the machine in a safely manner.



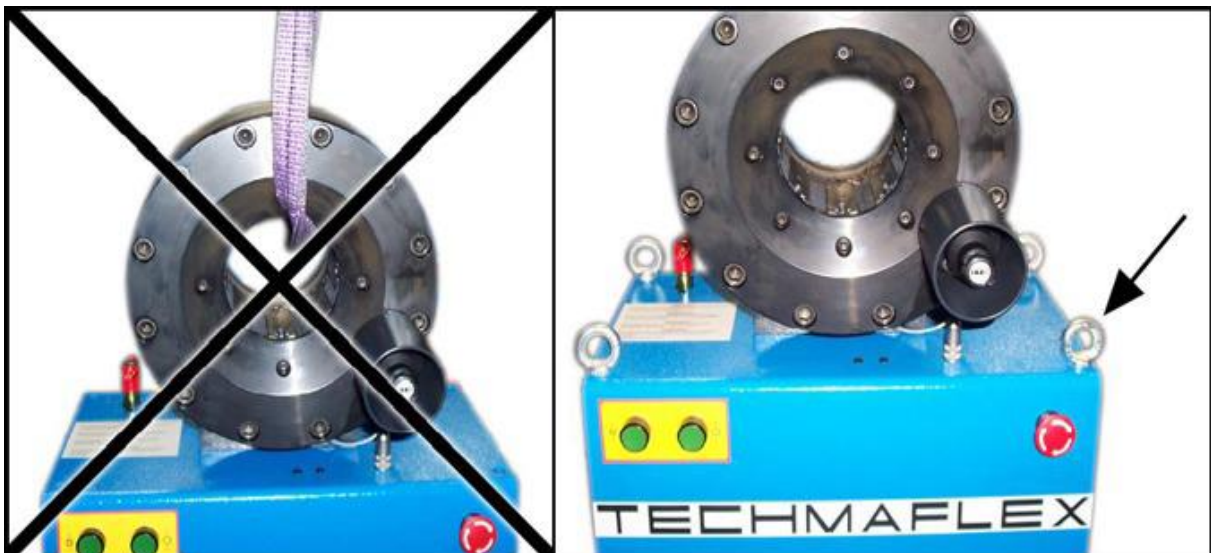
- 1 - Set Stop
- 2 - Power Pack
- 3 - Crimping Head
- 4 - Emergency stop push button
- 5 - Closing Push Button
- 6 - Opening Push Button
- 7 - Battery Disconnect

## C. INSTALLATION AND SET-UP

### C1. SECURITY

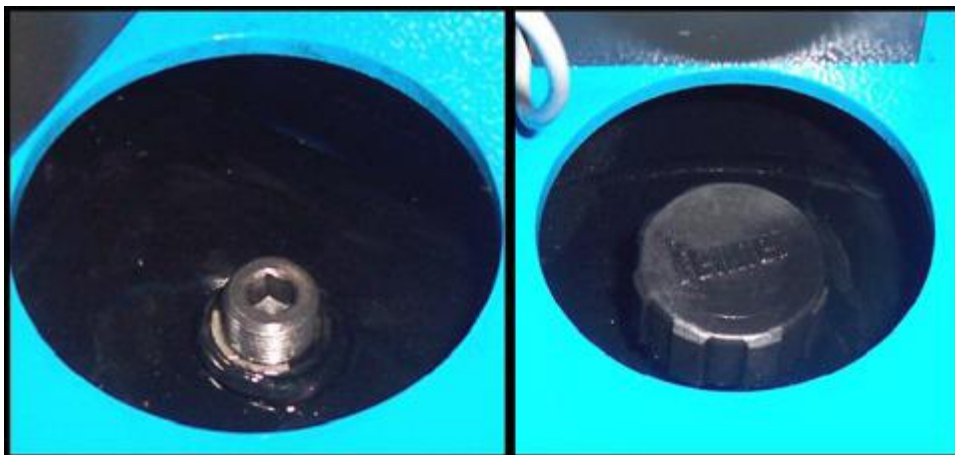


- ✓ The machine must be fixed on a flat and stable work surface.
- ✓ Keep hands and fingers away from pinch points.
- ✓ Do not modify the technical specifications of the machine.
- ✓ The machine must be switched off for any electrical intervention. Electrical intervention must be made by a qualified electrician.
- ✓ Handling: Do not lift the machine by the crimping head.



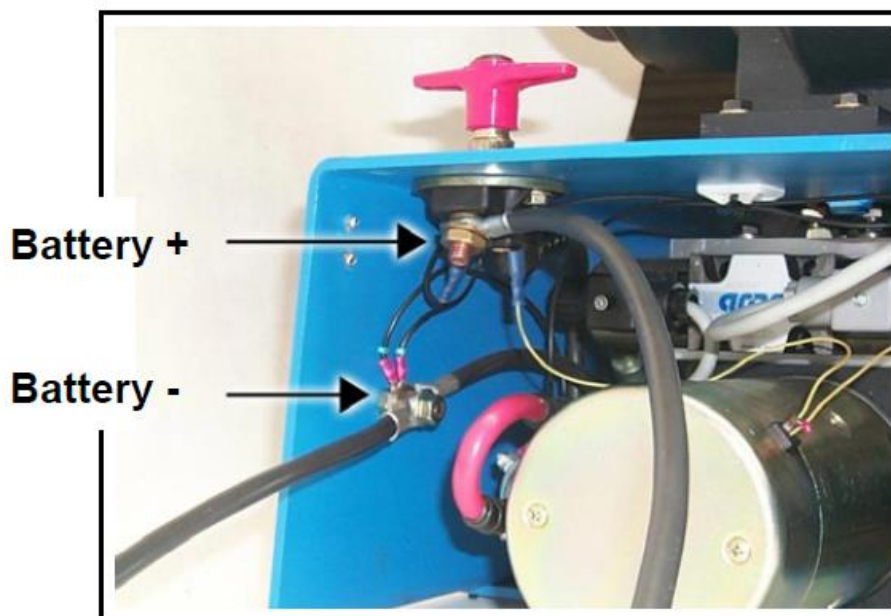
## C2. TAKE OFF THE OIL CAP PLUGS

- Remove the transport cap and replace it with the breather cap supplied with the machine.



## C3. ELECTRIC CONNECTION

- Connect the machine to a 12V battery with two 35mm<sup>2</sup> cables having battery terminals diam. 10mm.
- Please note that the battery and cables are not supplied with the machine.



**NOTE:**

The current amp level at 340bar is 300 A.

It is necessary to use a battery which has at least the following specifications:

- Direct current capacity: 100 A / hour
- Peak current capacity: 450 A

#### C4. START

- Turn the battery disconnect to the “ON” position as shown on (pic 1).
- Check that the emergency stop button is unlocked by turning it in the arrows direction (pic 2).



## D. OPERATING INSTRUCTIONS

### D1. CHOOSING THE RIGHT DIE SET

- To determine the correct final crimp OD (Outside Diameter), please refer to the parameters which you should have been supplied with.
- Choose the die set which is the closest to your final crimp OD. The die set (diameter) must be inferior or Equal to your final crimp OD.
- You can also refer to the spreadsheet of die sets which would have been delivered along with the machine.

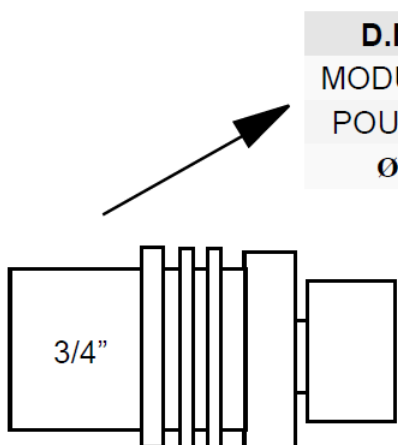


Diagram showing a crimping machine with a die set labeled 3/4". An arrow points from the die set to the table below.

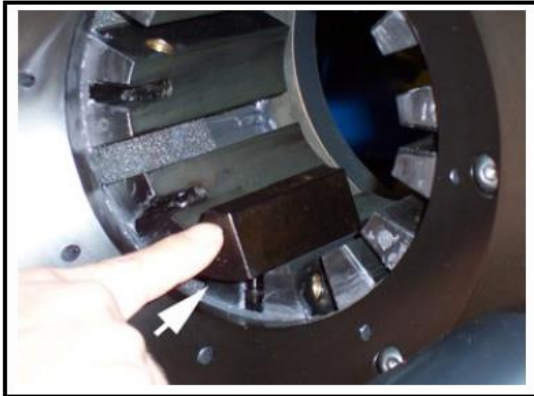
D.N	20	Ø	000	Ø	000
MODULE	12	33, 0	000	36, 0	300
POUCE	3/4"	33, 1	010	36, 1	310
Ø	33.4	33, 2	020	36, 2	320
		33, 3	030	36, 3	330
		33, 4	040	36, 4	340
		33, 5	050	36, 5	350
		33, 6	060	36, 6	360
		33, 7	070	36, 7	370
		33, 8	080	36, 8	380

## D2. INSTALLATION OF THE DIES

### WITH MANUAL TOOL

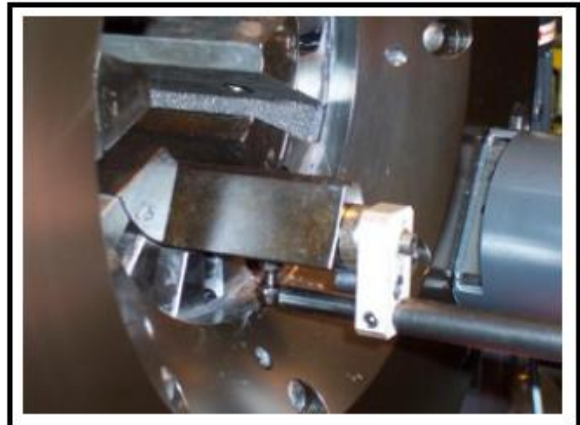
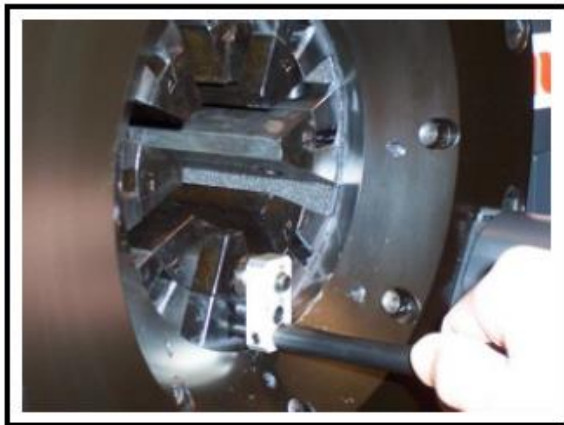
#### Mounting the dies

1. Slide the die and push it until it is firmly locked.
2. Make sure to have the number of the dies facing the operator.



#### Dismounting the dies

1. Close the dies until the position of the dies allows the introduction of the manual tool.
2. Push the tool until the magnet contacts the face of the die. Pull the die out.



### WITH SRC QUICK CHANGE TOOL (Optional)

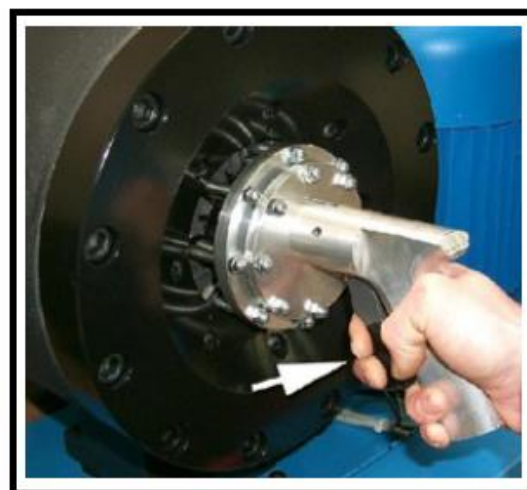
□ Dies  $\varnothing 4$  to  $\varnothing 66$

#### Mounting of the dies

1. Adjust the set stop on 050 and close the dies.

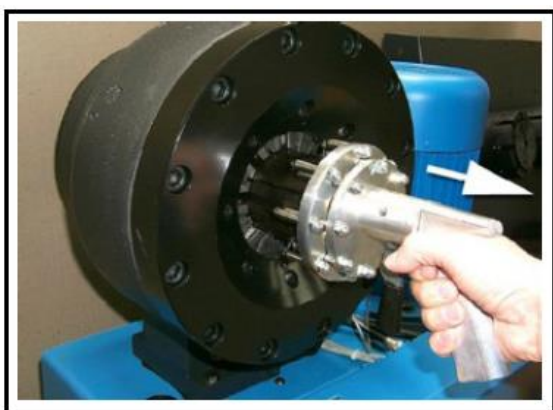
**Warning:** the adjustment is 090 for dies  $\text{Æ}4$  to  $\text{Æ}10$ .

2. Insert the dies in the head with the gun tool, with a frank and quick movement (pic 1.)
3. To extract the tool and release the dies, pull the trigger (pic 2).



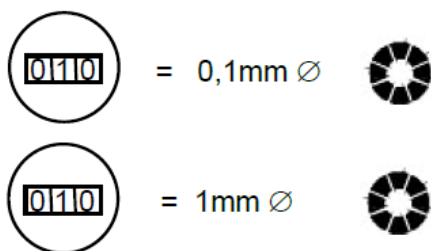
## DISMOUNTLING THE DIES

1. Adjust the set stop on 050 and close the head.
2. Warning: the adjustment is 090 for dies  $\text{Æ}4$  to  $\text{Æ}10$ .
3. Only when the head is closed, slide the gun tool in the head until the magnets are in contact with the dies.
4. Pull the gun tool towards you (pic 3).
5. Store the die set into one of the plastic racks.
6. Release the tool by pulling the trigger and pulling the tool upwards (pic 4);



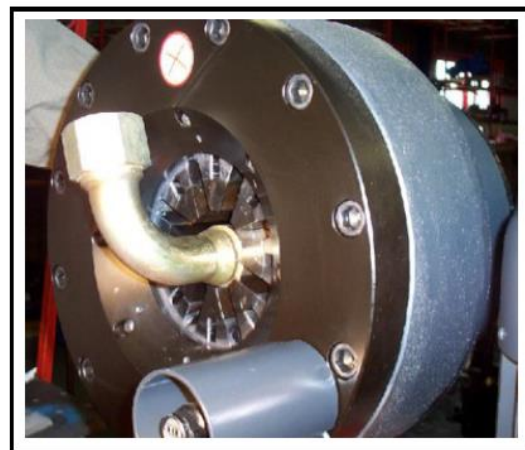
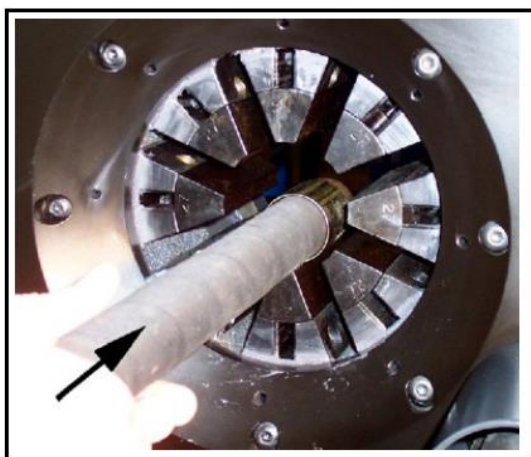
## D3. ADJUSTMENT OF THE SET STOP

The adjustment of the set stop determines the crimping diameter according to die set installed in the machine.



#### D4. CRIMPING

1. Insert the hose to be assembled in the machine. We advise to place the ferrule in the middle of the dies for a better result.



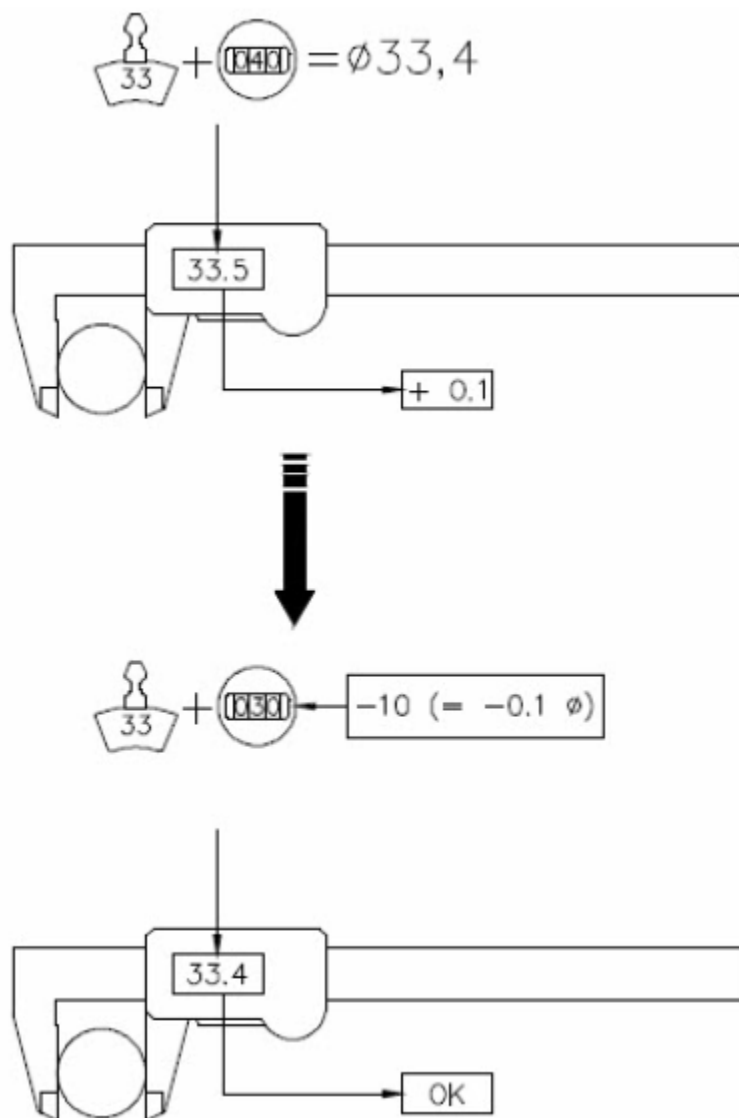
*For large elbow fittings*

2. Press closing button until the machine stops.
3. To release the hose assembly, press the opening button



**IMPORTANT:** This crimper is meant for intermittent use. To avoid the motor overheat the machine must be left "OFF" for at least one and half minutes after 30seconds of work.

## D5. CHECK THE CRIMP DIAMETER



## E. MAINTENANCE

### E1. LUBRICATION

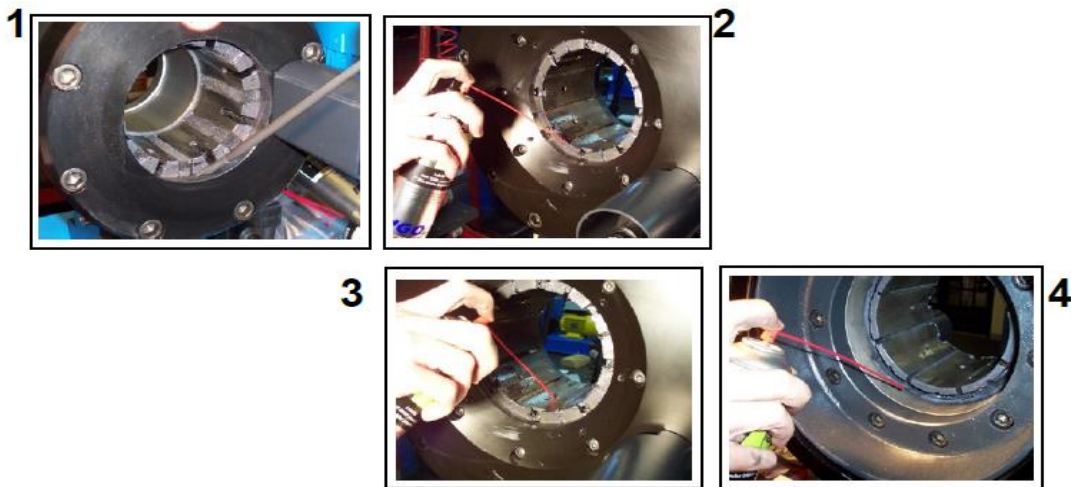
**Grease type:** Aerosole Molcote Grease.

- The greasing of the die carriers is very important.
- A lack of lubrication could cause a loss of up to 40% of the machine capacity.

**Advice:** A regular lubrication is advised every 100 cycles.

#### For PE 28

1. Take off all the dies.
2. Close the master-dies halfway (pic 2).
3. Apply the grease (supply lubricant) on 3 points.
  - a. At the front of the master dies (pic 2).
  - b. Under each master die through the hose located in the middle of the master dies (pic 3).
  - c. At the back, between master dies and the piston (pic 4).
4. We advise an annual revision and greasing of the head with dismantling of the front flange. The flange must be tightened with a torque wrench.



#### **E4. OIL CHANGE**

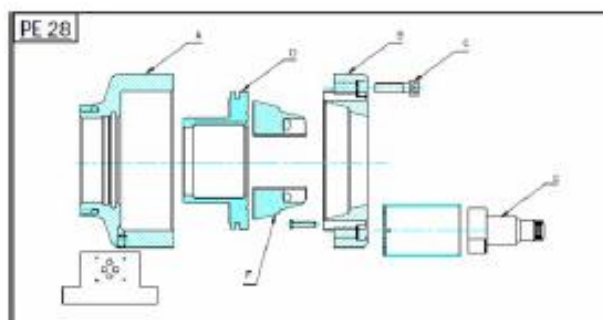
***Advice:***

- Change oil every year.
- Type of oil: ISO HV 32
- Change the suction filter when you change the oil.

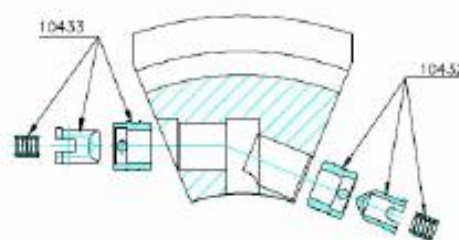
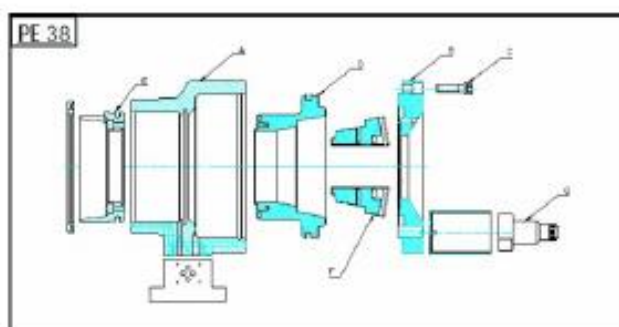
## F. SPARE PARTS

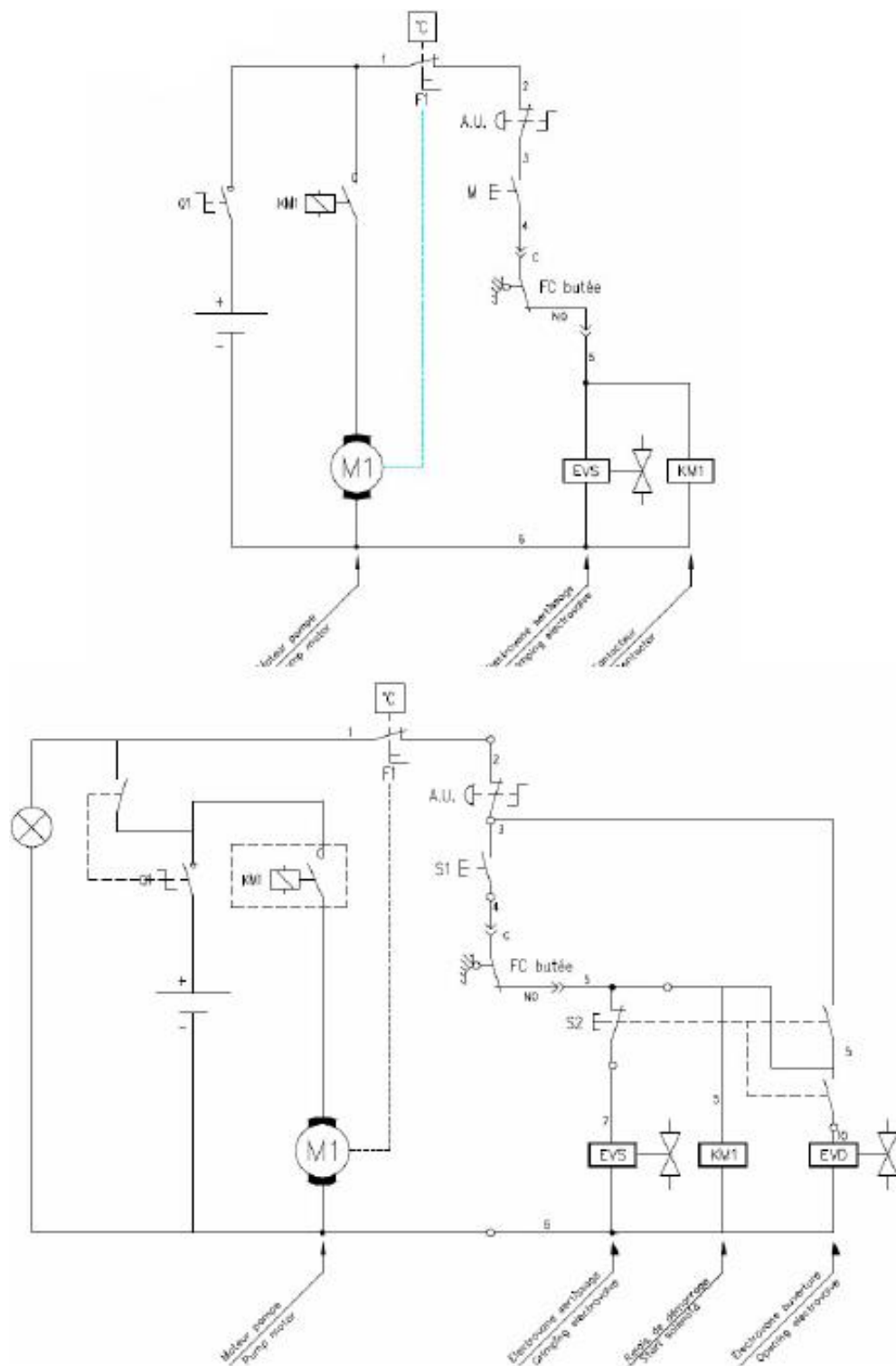
	PE28	PE38
Indicative Capacity	1 1/4" 4SP	2" 4SP
Theoretical Crimp Force	137	240
Opening (mm)	+ 28	+ 38
Opening without dies (mm)	100	119
Standard motor	2	2
Weight (kg)	75	125
Dimensions	480 x 370 x 450	500 x 400 x 580

Description	PE28	PE38
Bell housing		A
Bell housing flange		B
Front flange bolts		C
Piston		D
Piston flange		E
Die carriers		F
Set stop		G



Description	PE28	PE38
Anti-return pin-kit		10433
Maintaining pin-kit		10432
Seal kits	5389	5384
Die carrier spring		50
Set of protection foam pads	11288	10182
Die pin		54
Electro-valve	10209	
Set stop protection guard	10951	10428
Counter knob		21
Emergency stop	11425	
Green push button	11426	





## **G. WARRANTY**

- Allswage UK guarantees its machines against all material and manufacturing defects one year starting from the date of shipment of the machine (or date of invoice).
- During the warranty period, Allswage UK will repair (or replace in certain cases) free of charge these faulty elements, under the condition that the machine is returned to our workshop.
- This warranty does not apply in case of accidental damage, improper use, normal wear, or if the machine was repaired or modified by another company than Allswage UK.
- Working and travelling costs as well as freight charges caused by guarantee repairs are not covered by the guarantee.
- This warranty replaces all other warranty as well as implicit warranties.
- Allswage UK are not liable for any incidental or consequential damages, or for any other loss, damage or expense of any kind, including loss of profits.