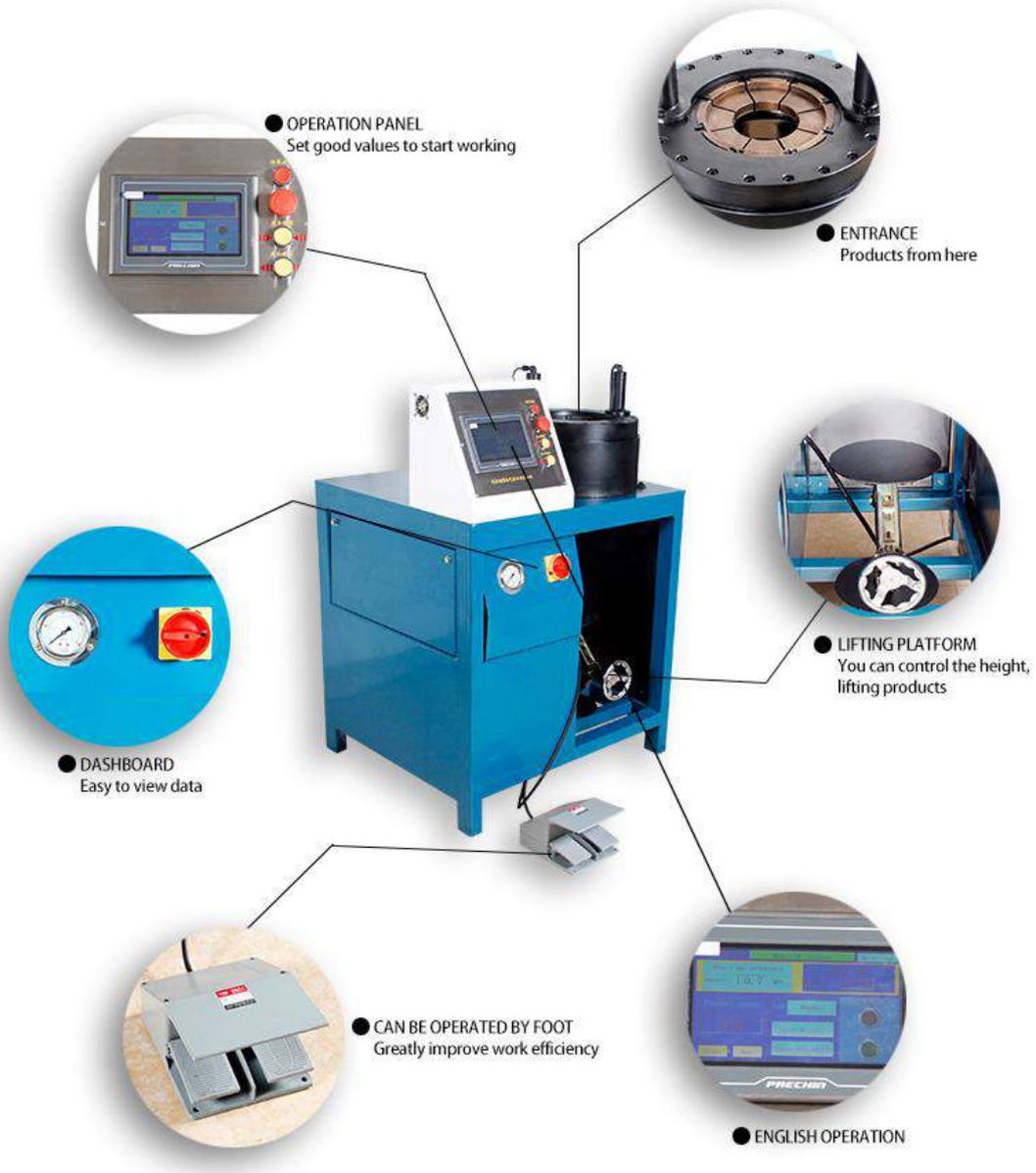


1. Introduction

This crimping machine is specially design for repair air suspension(AUDI, BMW, MERCEDES-BENZ, LAND ROVER, PORSCHE and etc.) , connect the rubber parts, plastic parts, metal rings through the hydraulic power. With this machine, You can fix air suspension leak easily.



2. Safe Operating Procedure

1. The operator must operate according to standard.
2. When you stop using the machine, you must turn off the power.
3. When you want to change the mold or tooling, you must stop the machine and turn off the power.
4. You must keep clean for the mold base and connected face between mold base and mold, metal chip and other hard objects are not allowed.
5. Before you start the machine, Please pour in lubrication oil onto the mold base.
6. Keep balance before installing module.
7. The adjusting valve must work under the Prescribed pressure.
8. When machine works, it is prohibited to reach into the interior.



3. Matters need attention

1. Add enough 46# antiwear hydraulic oil when the first use.
2. Connect the power and test the motor, make sure the motor fan in clockwise direction.
3. When you finish above steps, you can start the machine.

4. Equipment transport and Maintenance

1. When you move the equipment, Please be careful in case of any collision
 2. In order to increase the lifetime of the equipment and avoid accident, Please make sure to use the genuine 46# antiwear hydraulic oil.
 3. Before you use the machine, Please brush some lubrication oil onto the machine head.
 4. Don't crimp the rusted connectors & pipes to avoid any impurities fall into the machine head.
- For a better maintenance, the operator should pay more attention as following:
1. Pour in lubrication oil onto the mold base regular.
 2. If you don't use the crimping machine, Please cover the machine by a piece of cloth or something else to prevent dust.
 3. If the hydraulic oil in the fuel tank is expired or the hydraulic oil is oxidized and become black, replace the oil.

5. How it works

1. Take dual hydraulic circuit operating principle, that is forward and backward of piston, and opening and closing of the mold to crimp .
2. The hydraulic system consists of motor, fuel pump, solenoid valves, pressure regulators and hydraulic valve which form an “advance and retreat movement“ dual hydraulic circuit , but also in this dual hydraulic circuit from a rapid increase in the oil drain valve, in order to achieve more rapid return purposes, noise and system pressure is reduced .
3. In the electrical control system, the control circuit suitable for PLC circuit, it is easy to repair the circuit, easy maintenance and replacement simply.
4. Mold and mold base take cumulative error-free machining process to ensure product with same spaced lines crimping, no different sizes.
5. In order to increase the permanent mechanical precision and lifetime of the crimping machine, in the locking mechanism parts, not only select the high-quality steel materials, and also adapt a unique heat treatment process. So the long lifetime of crimping machine is related to: the material selection, heat treatment, machining process and reasonable structure.
6. Crimping Standard
Theory requirement: rings no loose, no damage the products.
If the crimping pressure too low rings may get loose and if too high it may damage the parts.
If you don’ t want to damage the connected parts, then the crimping pressure must be small.
7. When crimping use proper crimping pressure and keep the mold move parallel, no tilt. If not, it would cause one side of the connected parts with too high pressure and damaged.

6. How to Crimp

1. Install the mold,
2. Turn on the machine, set the crimping pressure and time,
3. Put the prepared parts into crimping machine, press Buckle button until it finish crimp.
4. Press Open mold button and take away the finished part.
5. Press Stop motor and turn off the machine.

Pressure setting reference:

If the thickness of the rubber is 3mm, the realtime pressure Please use 0.8MPa-0.85MPa

If the thickness of the rubber is 2mm-2.5mm, the realtime pressure Please use 0.6MPa-0.7Mpa.

