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"YOUR SOURCE FOR WORKPLACE SOLUTIONS"

PREVENTATIVE MAINTENANCE RECOMMENDATIONS

MODEL # HY-250, HY-500, HY-750 & HY-1.0
DESCRIPTION: Hydraulic / Pneumatic Pinch-Off Tool
APPLICATIONS: Pinch-Off and hermetically seal OFHC copper tubing

Preventative maintenance on these tools is important to insure long term performance and unscheduled down time. These tools will perform well for many years if normal wear components are checked and / or replaced on a periodic time schedule.

Initial Setup

- The handset is fully assembled and ready to connect to the hydraulic hose (provided).
- Install the hydraulic pressure gauge by simply connecting the "T" assembly to the quick-disconnect fitting on the pump. Install the hydraulic hose to the other end of the "T" fitting. Install the handset to the quick-disconnect fitting on the hydraulic hose.
- If you supplied us with samples of your tubes being processed with this tool prior to shipment, the pump pressure has been adjusted properly and no further adjustments should be necessary. If you have a problem with the tube pinch-off process, contact our technical support before changing the pump settings.
- Connect your air source hose to the quick disconnect air fitting supplied with the pump. You may change this fitting if it does not match your standard air fitting.
- Install a filter / regulator / lubricator to your air source line within 10-15 ft. from the hydraulic pump. This will remove moisture from your compressed air and will supply air tool oil to the internal air motor inside the hydraulic pump for proper lubrication.
- Set your input air pressure to 100 – 120 psi.
- The system is now ready to use.
- Install supplied air hose to the power pack. Wrap hose fitting threads with Teflon sealant.

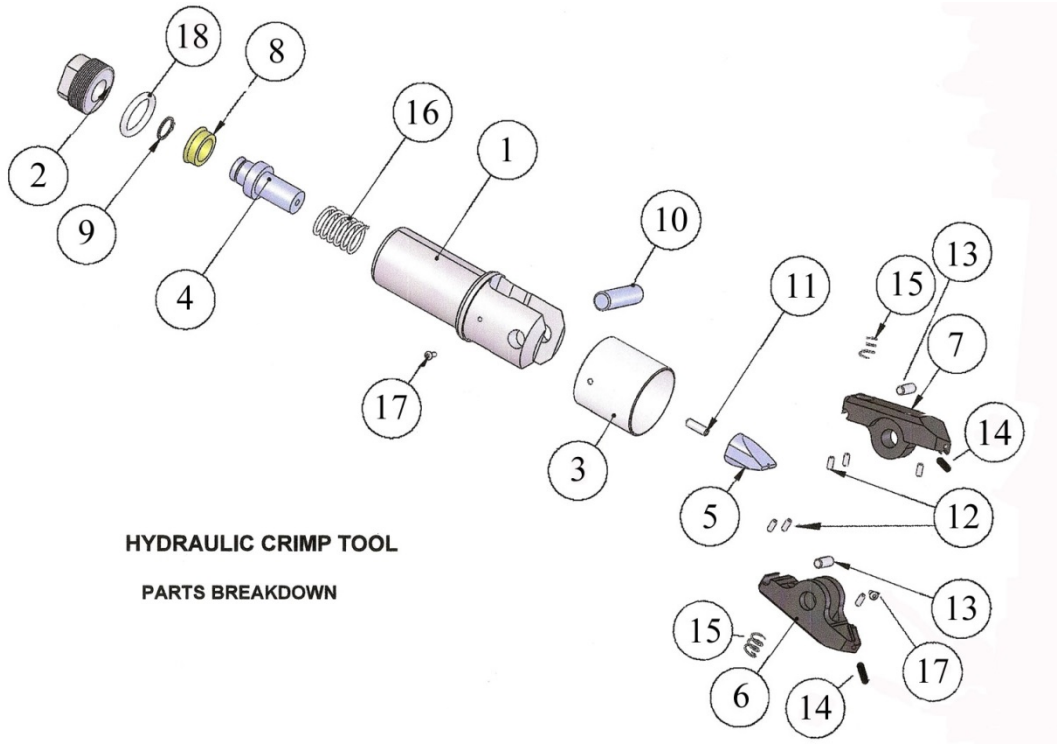
Weekly Maintenance

(Reference exploded view drawing below)

- Using a light machine oil, place a couple of drops on the jaw rollers (#13 back end of jaws) and also apply to the carbide pinch-off rollers.
- Clean and remove any copper transfer contamination on the carbide rollers (#14) with alcohol or very fine emery cloth.
- Light machine oil can be used to lubricate any metal-to-metal surfaces in the jaw area.
- Make certain the FRL is injecting oil into the power pack. Very little oil is required to keep the internal O-rings lubricated. If oil is expelling through the trigger valve, you can reduce the amount of oil being injected.

3-6 Month Maintenance (or 20,000 + cycles)

- Periodically, remove the carbide rollers (#14) from the jaws to clean the machined channel and lubricate with light oil. This will insure the carbide rollers move freely in the channel.
- The carbide rollers only need to be replaced if they are chipped or show signs of a flat, worn area. These rollers are rarely replaced.
- Replace Jaw Rollers (if your tubes are NOT sealing) and lubricate with light machine oil.
- Replace both internal jaw springs (#15). Refer to our website for the proper technique when replacing these springs. They can be damaged if installed improperly which may restrict proper jaw closure.



Component Parts for ALL HY-Series Hydraulic Pinch-Off Tool Handsets

Items shown in RED should be replaced as recommended in the body of this document

DRG #	HY-250	HY-500	HY-750	HY-1.0	DESCRIPTION	QTY
1	HYP-6	HYP-6-500	HYP-6-750	HYP-6-100	Housing	1
2	HYP-7	HYP-7-500	HYP-7-750	HYP-7-100	Plug	1
3	HYP-8	HYP-8-500	HYP-8-750	HYP-8-100	Jaw Guard	1
4	HYP-9	HYP-9-500	HYP-9-750	HYP-9-100	Piston Shaft	1
5	HYP-10-500	HYP-10-500	HYP-10-750	HYP-10-100	Cam	1
6	HYP-2	HYP-2-500	HYP-2-750	HYP-2-100	Right Side Jaw	1
7	HYP-1	HYP-1-500	HYP-1-750	HYP-1-100	Left Side Jaw	1
8	HYP-13	HYP-13-500	HYP-13-750	HYP-13-100	Piston Cup	1
9	HYP-14	HYP-14-500	HYP-14-750	HYP-14-100	Snap Ring	1
10	HYP-16	HYP-16-500	HYP-16-750	HYP-16-100	Pivot Pin	1
11	30-01	22-CLP	20-CLP-2000	20-CLP-2000	Piston Shaft Screw	1
12	HYP-18	HYP-18-500	HYP-18-750	HYP-18-100	Roller Stop	4
13	HYP-17	4-20A-K2	HYP-17-750	HYP-17-100	Roll Pin	2
14	HYP-4	HYP-4-500	HYP-4-750	HYP-4-100	Carbide Inserts	2
15	HYP-12-K2	HYP-12-K2	HYP-12-750	HYP-12-100	Jaw Springs	2
16	HYP-11	HYP-11-500	HYP-11-750	HYP-11-100	Piston Spring	1
17	HYP-25	HYP-25-500	HYP-25-750	HYP-25-100	Mounting Screw	2
18	18-MSP	15A-01	15A-003	15A-003	Housing O-Ring	1
19	HYP-25	28-01-K10	32-01	32-01	Screw	3