

MI-92S-B manual hose crimping machine is our new product. Considering the non convenience of working outdoor, our technologists developed this new portable type. This type machine absorbs the advantage technical in the world with using high quality material and high pressure hand pump so that the machine has a steady and permanent system.

Meanwhile, In view of appearing many special shaped bend for crimping, we increased the opening and passing performance. The machine efficiency is improved for the returning speed is very fast, it is very suitable for using in outdoors. We choose the special material that have high strength performance and the glossiness of work surface reach a highest level after CNC and heat treatment, the machine has high mechanical efficiency of transmission and its two stage crimping conversion structure, with these the machine can meet dies opening 28mm and large swager force.



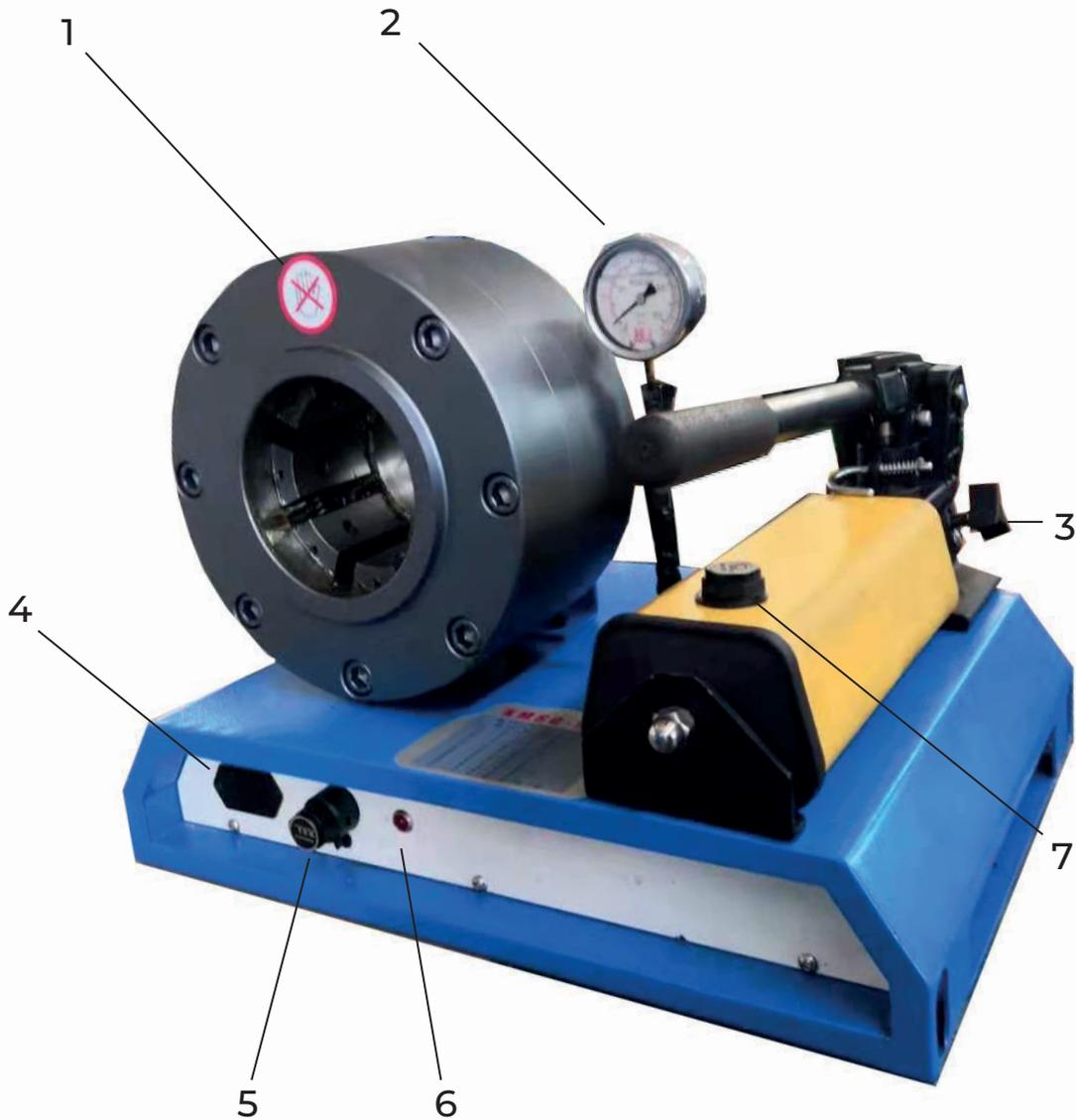
Notice:

Don't operate the machine before add the hydraulic oil!!!

Technical data

Type	MI-92S-B
Swaging force	1370 KN
Pump	Manual pump
Systematic pressure	30 MPa
Opening	≥28 mm
Opening without dies	Ø108 mm
Oil box	4.5 L
Hydraulic oil	Winter: YB-N32 Summer: YB-N46
Crimper range	Ø6 — Ø32
Outside measurement	550×600×404 mm

Diagram



Explain:

1. Machine head	2. Pressure gage	3. Unloading valve handwheel
4. Battery compartments	5. Regulator	6. Indicator light
7. Tank filler		

Instructions for use and maintenance
Operation

1. Store the machine: When you open the package, please put the machine in the ventilation and dry house whose temperature is above 10 °C.
2. Add the hydraulic oil: The oil port is on the oil box (nylon cover). Open the cover and add the hydraulic oil to the oil box as instruction in technical data.
3. Systematic pressure: The systemic pressure had been adjusted before the machine leaving the factory (rated pressure is 30Mpa). so the user should not adjust it by himself in case of damaging the machine.
4. Choose the dies: The user shall select the corresponding die according to different rubber hose when crimping the hose, and the prefix number of the end face of the die is the diameter of the closed inner hole of the die (see Figure 41).

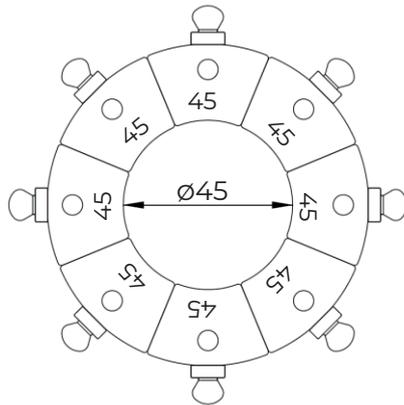
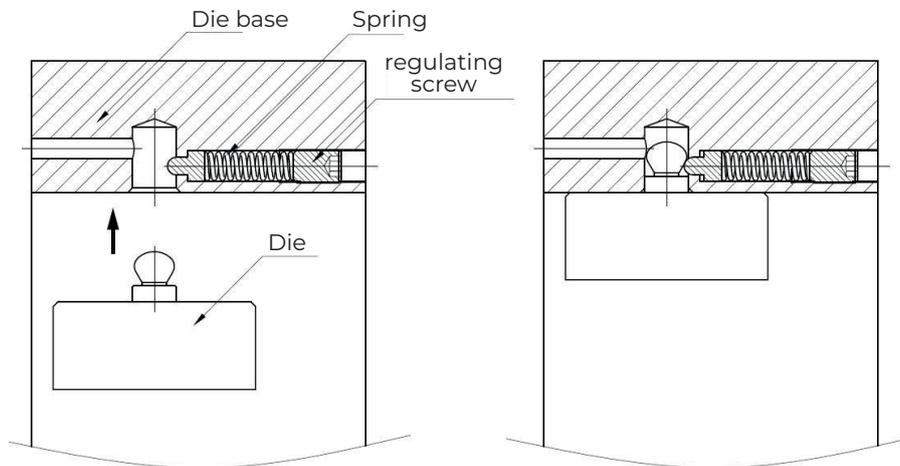


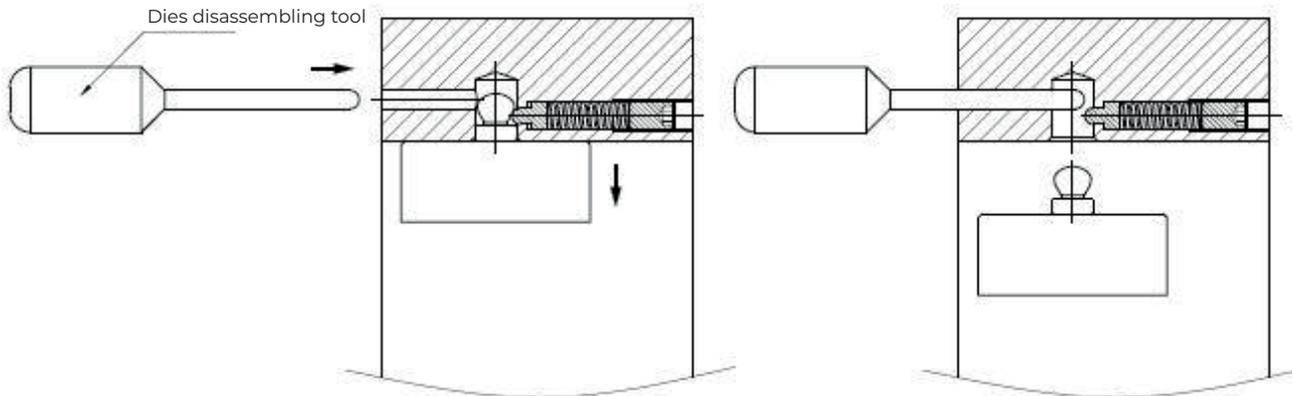
Figure 4-1

5. Lubricate the die base: When the machine begins to crimp the hose, it should first add lithium base grease into the die seat of the machine head to make the working face (cone face) fully lubricated and in good working condition.
6. Dies installation: The die is installed in the die base. Let the machine head open completely. And then install and uninstall the dies by using the special pole for dies.



Die installation drawing

Insert the die knob into the knob hole of the die base, and the installation is completed

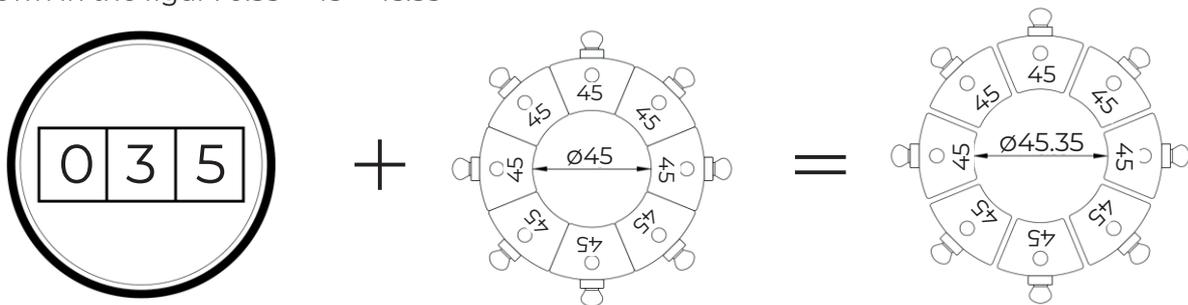


Insert the dies disassembling tool into the disassembly hole of the die base until the die falls off, and then the die is disassembled.

Note: The spring compression can be adjusted through the regulating screw when the die is loose, so as to make the die more fit.

7. Adjust size: The final crimped size can come true by adjusting the regulator. The usage of regulator is the same as micrometer, moving scale unit is 0.01 mm. Choose suitable dies and adjust regulator to achieve the crimping computing method: die bore + regulator = final crimping size.

As shown in the figure : $0.35 + 45 = 45.35$



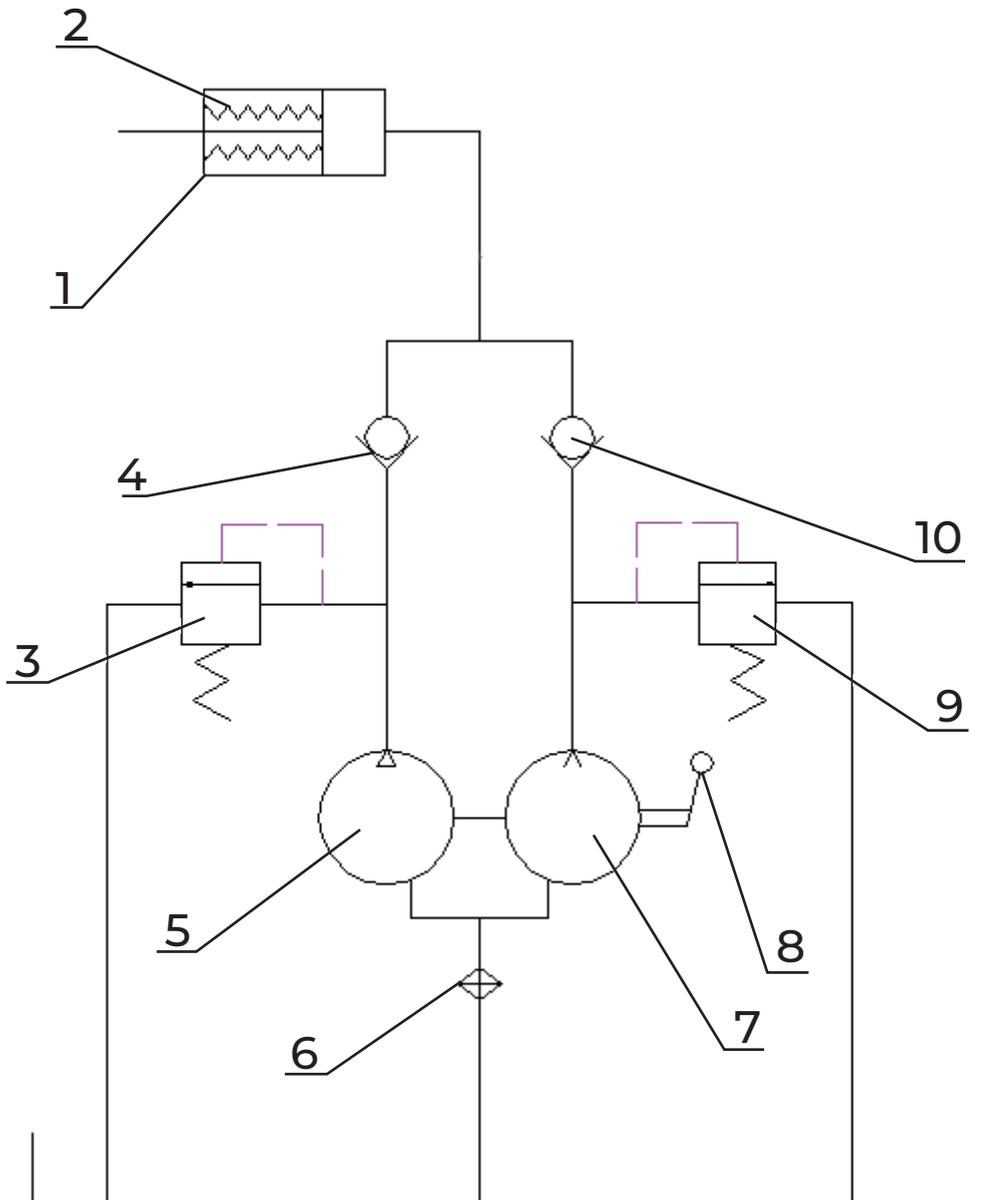
8. Operation:

1. Revolve the hand wheel of pressure valve.
2. Start the machine by pressing the hand.
3. When crimping to the preset size, indicat or light will be on.
4. If you want to open the dies, please revolve the hand wheel of pressure valve.

Maintenance

1. High strength screw at front&back of the machine head should be regularly tightened, requiring at least once a quarter, tightening torque to $120 \pm 20\text{Nm}$.
2. The working surface of the machine should keep clean (If the machine was not used for a long time). You ought to inject enough grease lubricant before the machine operates.
3. Please clean the resin gasket regularly, and change new ones in.
4. Check the fittings, if loose, please change in time.
5. Clean oil filter and internal tank regularly and filter the oil once six months.

Elements diagram of hydraulic pressure



1. work cylinder	2. return spring	3. high pressure safety valve
4. high pressure check valve	5. high pressure pump	6. oil filter
7. low pressure pump	8. pressure lever	9. low pressure safety valve
10. high pressure check valve		

Troubleshooting

Fault	Reason	Rectify
The hydro-cylinder don't work after the hand pump was pressed	<ol style="list-style-type: none"> 1. Check the hand valve of hand pum is in a right positon or not. 2. Check the handwheel of spillove valve is loosen or not. 	<ol style="list-style-type: none"> 1. Adjust the hand valve to a right positon. 2. Screw the handwheel of spillover valve.
The hydro-cylinder has not the pressure.	<ol style="list-style-type: none"> 1. Check the pump is broken or not. 2. Check the spillover valve is loosen or not. 3. Check the cylinder is leakage or not 	<ol style="list-style-type: none"> 1. Adjust or change 2. Adjust or change 3. Change the oil seal
The noise is too much	<ol style="list-style-type: none"> 1. Check the hand pump and oil seal. 2. Check the oil filter is blog 3. Check the hydraulic oil is right or not. 	<ol style="list-style-type: none"> 1. Change the oil seal 2. Clean the oil filter 3. Change the hydraulic oil
The die base is joggling when operating	<ol style="list-style-type: none"> 1. The lubrication is not enough 2. There is air in the system 	<ol style="list-style-type: none"> 1. Add the enough oil 2. Operating the machine for 10 mins without crimping

Attention

1. The use procedures and operation procedures of this machine is for hydraulic rubber hose assembly crimping if your products' condition is different, please timely communication with the company related personnel. We disclaim all responsibility for operating under conditions of uncertainty, and thus for equipment and other aspects caused by damage and damage.
2. When the device is in a non-working state, the device should be in the mouth, in order to avoid the internal spring compression fatigue.
3. Please use semi-automatic operation mode in the reasonable conditions permit. The operator does not have the same level of proficiency, the operation is not recommended to use the operation.
4. The dies are not suitable for pressing division line, if there are special requirements, please customize the dies.
5. Before and after the flange high strength screw in the condition of the defect is strictly prohibited equipment operation. It is strictly prohibited to replace the high strength screw without permission, if needed, please consult to us or the company designated by the manufacturer.
6. It is strictly prohibited in the absence of the mold to make the machine completely closed, resulting in damage to the equipment for illegal operations, the company does not assume any loss.
7. In extreme circumstances, such as extreme cold or high temperature, please select the hydraulic oil, so that the equipment is more suitable for operation.
8. Warm tip: electrical fault don't secretly maintenance, it should be requested by professional personnel or under the guidance of the relevant personnel of the company to deal with.