

Installation & Operating Instructions for 5000-V Vacuum Crimper:

Check Items:

- 1 pc. 5000-V Vacuum Crimper
- 4 pcs. Mounting Fasteners
- 1 pc. Vented Flow Valve
- 1 pc. Red Hat Solenoid Valve
- 1 pc. Vacuum Hose
- 1 pc. Pressure Gauge 0-160 PSI
- 2 pcs. $\frac{3}{4}$ Barbed Hose Fittings
- 1 pc. Extra 5000-V-NP Nosepiece (optional)
- 1 pc. 5/16 Allen Key
- 1 pc. Special 3/16 Allen key
- 1 pc. Special Torx key
- 1 pc. Power Cord

Screw the pedestal handle in the counter lever hole. Place crimper on surface it is to be used on. Trace with a pencil a line around the base of the crimper. Then remove the crimper. First drill a 9/16 hole for the solenoid valve wires to go through the surface. Then replace the crimper carefully place the sheathed wire and connectors through the hole. Then take a 17/64 drill and drill through the 4 mounting holes in the base and into the table. After drilling each hole install a screw, washer & nut. Drill a 1 $\frac{1}{4}$ inch hole next to the crimper for the hose to go through. Attach the vented flow valve. Screw the vented end into the nosepiece. On the other end on the valve, screw a barbed fitting. Attached the hose on the barbed fitting. Place the hose through the hole in the table. Attach another barbed fitting on the other end of the hose. Screw the solenoid valve on to the hose. Make sure the hose is on the end of the valve marked IN, the end marked OUT and attach to your vacuum source. Now connect the wires from the pedestal, solenoid & 110 volt power cord. They are color-coded. All the wires should be carefully harnessed under the table in a cabinet or electrical box safely out of the way. Plug into 110-volt power outlet. Next install the pressure gauge in the side of the pneumatic regulator, make sure the gauge is facing the operator. Attach you air supply to the rear of the regulator. The regulator should be set at 120 PSI. Make sure there is a lubricator at the source of your air supply. To adjust the crimper height to the can place the can and valve on the pedestal. With one hand support the crimping head, with the other hand loosen the clamping bolt on the head with the 5/16 Allen key supplied. Lower the crimping head till there is about a 1/4-inch of space. Just enough room to remove & replace the can. You may have to tilt the can to install the can & valve. This adjustment is important. If it is too high the crimp height will not be correct. Make sure the pedestal still has some travel when the can is pushed up against the nosepiece by looking at the cam roller on the pedestal. When adjusting the vented flow control valve start with it open all the way. Then adjust until to the desired vacuum level. When the correct level is achieved you can mark on the yellow slide adjuster with a pencil. Now you're ready to crimp. Make sure your air and vacuum is on. Place the can and valve on the pedestal. Press the lever on the pedestal down,

raising the can to the crimper. It will automatically open the solenoid valve for vacuum, the nosepiece will grab the can. Follow it with the pedestal and push the can up against the rubber seal with the pedestal until it stops. Make sure the can is straight and it is against the seal evenly. Now with the other hand pull the crimping lever forward to crimp and then release. Let the pedestal down this will shut off the vacuum and release the can. The crimp diameter has already been adjusted for you to 1.070 the depth is preset for .185 +/- .005. To change crimping nosepiece use the special torx wrench to loosen the 2 countersunk screws behind the rubber seal. After loosening the screws remove by hand. Be careful & make sure the O-ring is seated properly. To adjust the crimp diameter loosen the 2 small set screws in the side of the plunger adjust by screwing it up for smaller diameter or down larger diameter.

Maintenance: Apply high pressure grease on a O-tip, sparingly apply inside the collet. Put some mineral oil on your fingertip & apply to the nosepiece seal, it will seal better, easier and add life to the seal.

If you have any questions please call
(417) 533-5552 or email us info@aerotechlab.com

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