

## **Instructions For Adjusting and Replacing Bottle Crimping Collet:**

First remove broken collet. Take the collet stop, set screws and mandrel from the broken collet and place them in the new collet.

**Adjusting the collet stop:** Be very careful adjusting the stop. Miss-adjusting the stop will damage the collet. If you feel any obstruction when crimping STOP. Place the collet in the nosepiece and screw it on the swing bolt. With out any bottle in the collet pull the crimping handle down just until the collet disappears into the nosepiece, forcing the handle down any more than necessary will cause damage to the handle. When crimping a bottle it should feel about the same. Unscrew the collet from the swing bolt and remove it from the nosepiece. Adjust the stop so it is screwed all the way in. Now with the valve placed on the bottle insert it in the collet. The collet teeth when crimping must clear the rim of the bottle and contact the skirt of the valve only. If the teeth of the collet contact the rim of the vessel when crimping, upon entering the nosepiece they will have no where to collapse and they will break. Adjust the stop so the depth of crimp is to deep, then slowly adjust it until the crimp is uniform. About a 1/8 turn at a time. When correct depth is acquired tighten the set screw. Place the new collet in the nosepiece and screw it on the swing bolt. If you use a different valve, bottle or gasket is used,

**YOU MUST RE-ADJUST THE COLLET!**

**For Parts Or Service Please Call:**

**Aero-Tech Laboratory Equipment Company**

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