

HOSE & PIPE CRIMPING MACHINES

USER MANUAL



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Thanks for choosing **PRESS OLEOCON** Hose Crimping Machines.

PRESS OLEOCON is a 2" hose crimping machine which is optimal for your small and medium size crimping works. This handbook will guide you during installation and operation stages.

TECHNICAL SPECIFICATIONS

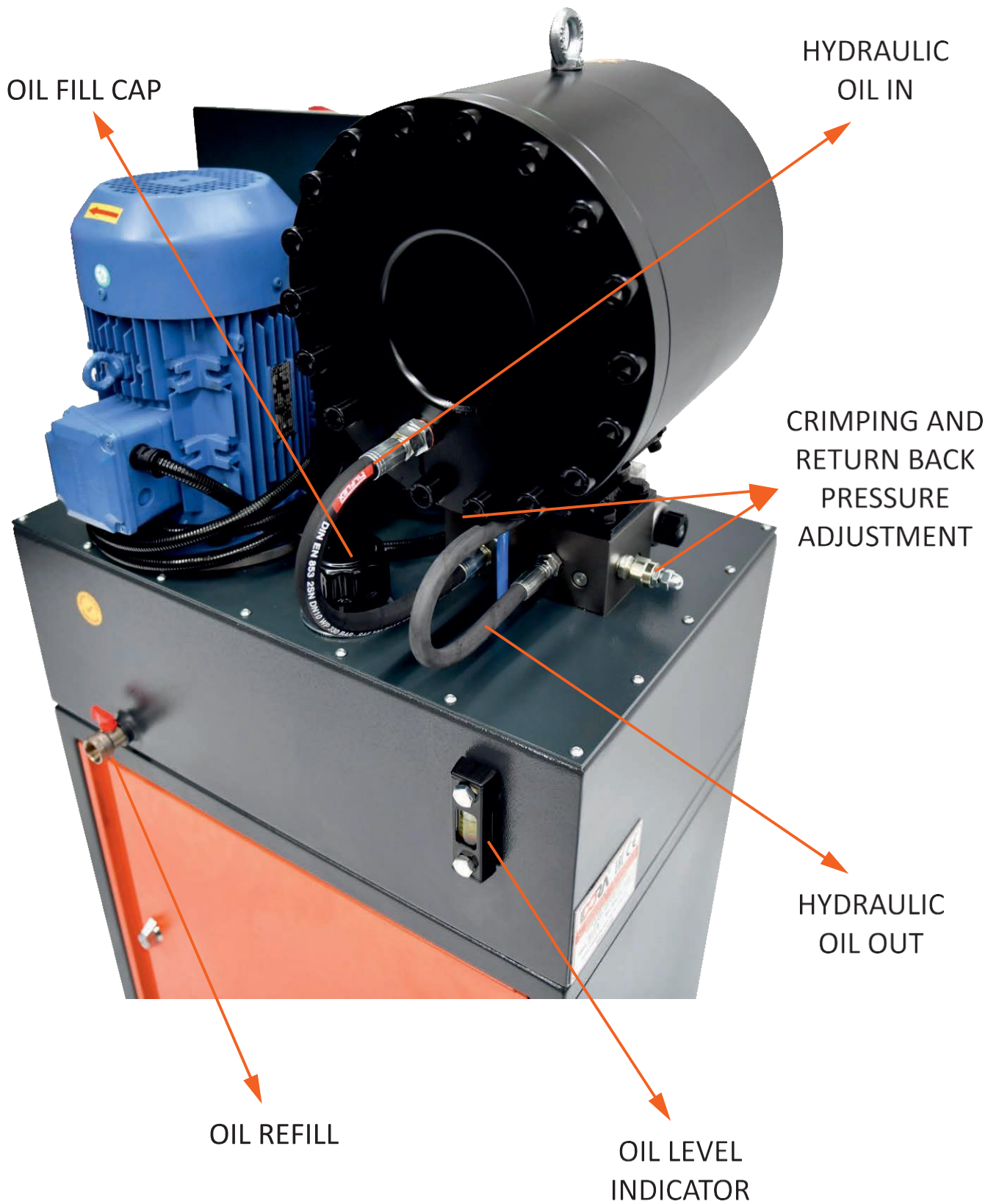
Crimping Capacity	3/16" To 2"
Power Supply	380V - 3PH - 4 KW
Jaw Opening Capacity	34 mm
Molds	15-18-21-24-27-33-39-45-51-57-66 mm
W * L * H (Without Cabinet)	700 * 450 * 750 mm
W * L * H (With Cabinet)	700 * 450 * 1500 mm
Weight (Without Cabinet)	260 Kg.
Weight (With Cabinet)	310 Kg.

INSTALLATION

1. Open the box carefully and place the machine on a smooth and durable surface.
2. Open the hydraulic oil tank cover (picture 2) and add at least 45 liters of HLP68 hydraulic oil to the tank through the filter. The tank capacity is 67 liters.
3. Connect the power cable to 380 V – 3 phases electrical supply. Please check that your electric line is sufficient for 4 kW power consumption.
4. Turn the main power switch on (picture 1), release the emergency stop button and push the “engine start” button. Be sure that the engine is turning clockwise as shown on the engine. If the engine turns counterclockwise, change the phases of the electrical connection. Otherwise, the hydraulic pump can not generate the sufficient power.
5. Before first use, follow these steps in order to release air in the hydraulic circulation system;
 - a. Start the engine
 - b. Close and open the clamps in manuel mode. During these stages, the oil pressure must be at lower levels. Because of that do not force the system during closing and openin the housings by pushing the buttons for a long time. Do not crimp anything at these stages.
 - c. Stop the engine with emergency button
 - d. Release the emergency button
 - e. Repeat these steps at least 10 times. Be sure that all the air in the oil circulation system have been removed.



Picture 1: Front View of D02 Hose Crimping Machine



Picture 2: Back View of D02 Hose Crimping Machine

MONTAGE AND SELECTION OF DIES

Before mounting the dies open the housings to the maximum diameter. Select the appropriate die set from the dimension table (Table 1). By using the quick change tool, pick the die group from the cabinet (Picture 3). Place the die set on the housing carefully. All the pins on the dies must be fully seated on their sockets (Picture 4).



Picture 3: Picking the die set from the cabinet



Picture 4: Placing the Dies to the housing

DAI SET

15 (1/8"-3/16")	15	16	17	18	19	Please grease the sliding parts every 4 hours, prevent the damages of the machine. Keep the cone surface clean		
18 (1/4")	18	19	20	21	22			
21 (5/16"-3/8")	21	22	23	24	25			
24 (1/2")	24	25	26	27	28			
27 (5/8")	27	28	29	30	31	32	Use next di size!	
33 (3/4")	33	34	35	36	37	38		
39 (1")	39	40	41	42	43	44		
45 (1"3/8)	45	46	47	48	49	50		
51 (1"1/4)	51	52	53	54	55	56		
57 (1"1/2)	57	58	59	60	61	62	63	64
66 (2")	66	67	68	69	70	71	72	73
Masterdies	105	106	107	108	109	110	111	112

For example, if you need to crimp 1" 4SP hydraulic hose to 42 mm (original size is 47 mm), you have to choose die set #39 of working interval is between 39-44 mm.

In the first crimping operation of different brand hoses or couplings, you have to check the dimension after crimping

Important Note: Die sets have to be mounted according to the numerical sequence on each die.

Important Note: In order to achieve the desired quality, please get the crimping dimensions from hose producer/supplier. The crimping dimensions differs from brand to brand.

During serial operations, please check/measure each part in first 10 pieces, and then check/measure one part in every 20 pieces.



MACHINE CONTROL PANEL

WORKING ISTRUCTIONS

1. “Engine Start” Button: This button starts the haydraulic pump and gets the machine ready for crimping. Be sure that emergency button is released before starting the engine.
2. “Emergency Stop” Button: This button stops the engine and operation abruptly and disables the control panel buttons
3. “Close” Button: This button moves the die set inwards and reduced the diameter. By pressing this button you can start crimping operation both in manuel or automatic mode. The crimping operation stops automatically when it reaches to the determined diameter.
4. “Open” Button: This button moves the die set outwards and releases the hose. In order to remove the die set, press and hold this button until the movement stops.
5. Foot Pedal: Foot pedal is used for operating in automatic mode.

Important Note: Be careful while using foot pedal. Careless usage of foot pedal may cause accidents and injuries.



FOOT PEDAL

DIGITAL CONTROL PANEL OPERATIONS

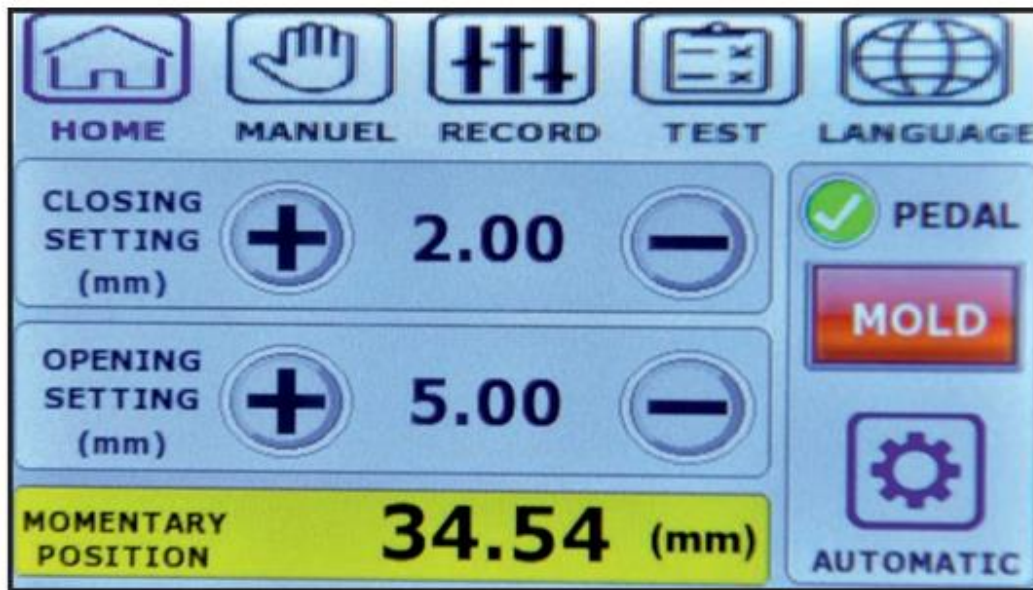
1. “HOME” SCREEN

In this menu, you can adjust the crimping diameter by pressing “+” and “-” buttons or by directly entering the desired value to the screen.

You can choose either manuel or automatic mode in this screen.

“Mold” button on the screen moves the housings to the die set changing position automatically.

In this screen you can see whether the foot pedal is mounted or not.

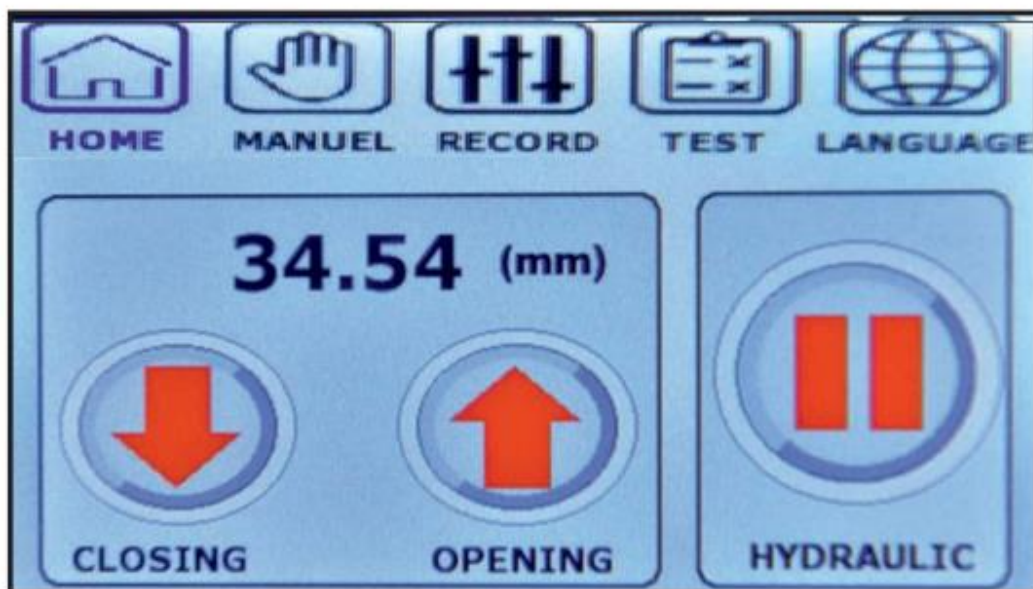


Picture 6: "HOME"
Screen

2. "MANUEL" SCREEN

In this menu, you can use the machine manually by pushing arrow buttons on the screen.

You can start or stop the engine in this mode.



Picture 7: "MANUEL"
Screen

3. "RECORD" Screen

In this menu, you can save your setting for different diameters, brands or customers.

You can save up to 100 records for your further works. By pressing "INSTALL" button, the machine will automatically move to the assigned position.



Picture 8: "RECORD"
Screen

4. "TEST" SCREEN

In this menu, if you press "RESET" button and enter the total number of crimping operation, the machine starts to count the nubers of the operation. You can see the numbers of completed and the number of remaining crimping actions. When the entered number is completed, the machine will stop crimping automatically. By pressing "ON/OFF" button you can activate or disactivate this feature.



Picture 9: "TEST"
Screen

5. "LANGUAGE" SCREEN

In this menu you can select the language of user interface. Turkish, English, Arabic and Russian Languages are available in PRES DORA D02 Model.



Picture 10:
“LANGUAGE” Screen

MAINTENANCE & LUBRICATION

Before first use and periodically the housings have to be lubricated. Please follow these steps during lubrication.

- Dismount the die sets from housings.
- Be sure that the housings are at die changing position (maximum diameter).
- Check and clean the gaps between housings and the conical surface from any dusts.
- Lubricate the housings and the conical surface with spray-grease lubrication oil.
- Move the housings front and back several times to be sure that all the surfaces are lubricated.



Picture 11: Sample
Lubrication

Important Note: The conical surface has to be cleaned from dusts every week. This is very important operation in order to prevent the abrasion of the sliding surfaces.

If you feel any irregularity during operation, please check and clean the housings and conical surfaces.

Please check the hydraulic oil level at least at every 10.000 operation or once at 6 months. If needed add HLP68 hydraulic oil.

TROUBLESHOOTING

If you face problems about the machine please follow the below instructions:

- Be sure that the main power switch in front of the machine (Picture 1) "ON" position
- Be sure that the emergency button is released
- Check if the engine operates clockwise. Otherwise change the phases at the power line connection point
- Check your power line. The incorrect connections and low power supply may lead damages to the engine. Do not use very long or insufficient extension power cables
- Check the thermal contactor and the circuit switches in the electrical panel
- Check the surfaces of housings and the conical surface. Clean the surfaces from dust and re-lubricate
- Check the dimensions of the die sets
- Check the hydraulic oil level and add if needed. Check the hydraulic pump

!!! SAFETY CAUTIONS !!!

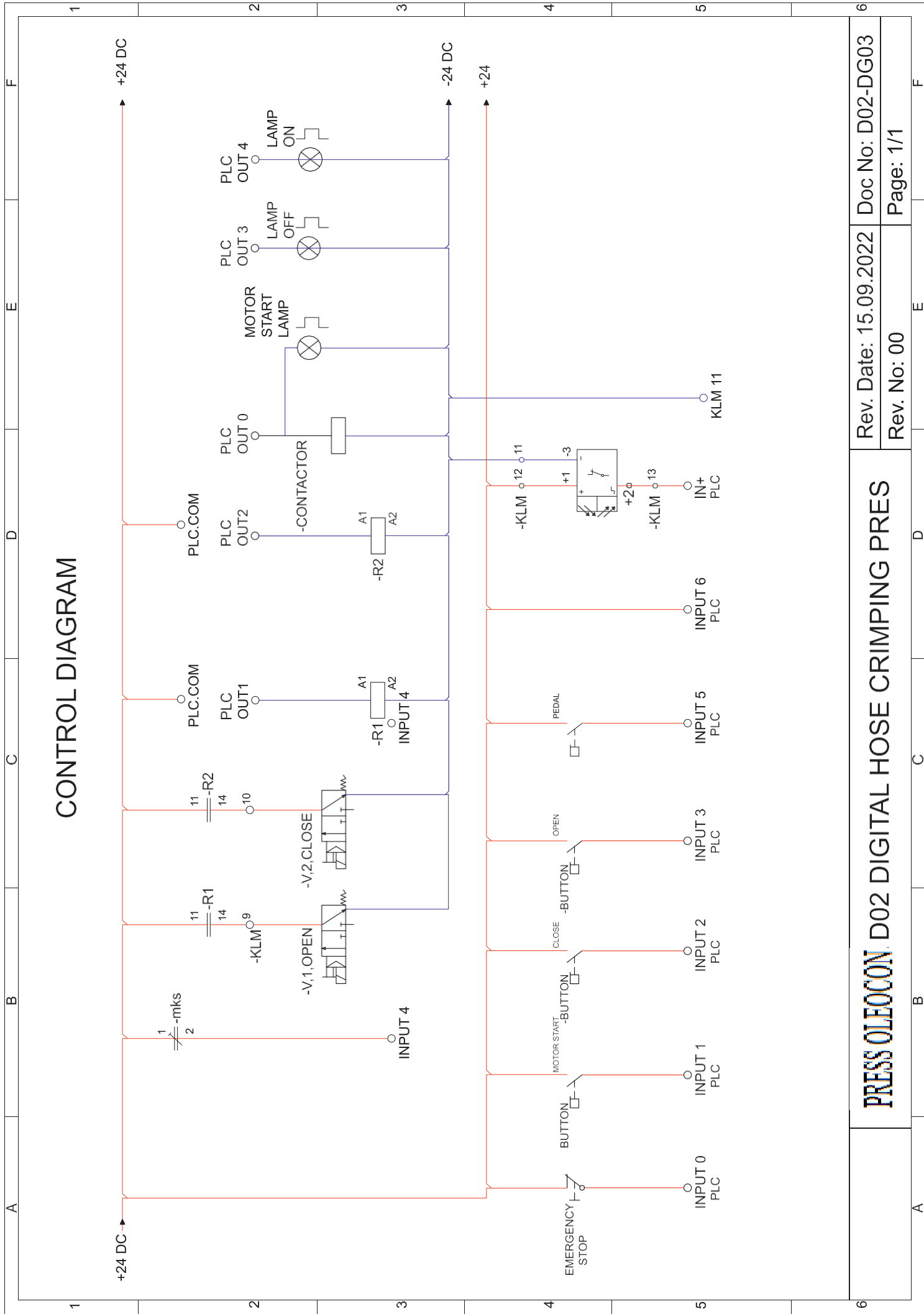
- MAXIMUM OPERATING PRESSURE OF PRES DORA D02 HOSE CRIMPING MACHINE IS 330 BARS. THE MACHINES STOPS CRIMPING AT 330 BARS
- DO NOT INCREASE THE PRESSURE LIMIT SETTINGS OF THE HYDRAULIC PUMP. IT MAY LEAD TO FAILURE OF THE MACHINE, ACCIDENTS AND INJURIES
- READ THESE INSTRUCTIONS AND USE THE MACHINE ACCORDINGLY
- DO NOT CRIMP ANY FRAGILE MATERIALS LIKE GLASS, HARDENED METALS ETC. IT MAY LEAD TO BURST OF THE MATERIAL AND HARM PEOPLE AROUND
- ALWAYS WEAR EYEGLASSES AND WORKING GLOVES DURING OPERATIONS
- ALWAYS WEAR OTHER SAFETY EQUIPMENT DURING OPERATIONS
- BE SURE THAT THERE IS NO UNCOVERED ELECTRICAL CONNECTIONS OR CABLES
- KEEP YOUR HANDS AWAY FROM DIE SETS AND HOUSINGS DURING CRIMPING

The diagram illustrates the electrical power supply for a digital hose crimping press. It features a three-phase power supply (L1, L2, L3) connected to a PAKO switch, a 3X16A fuse, and a contactor. The contactor's main contacts connect to a hydraulic motor (M). The contactor's auxiliary contacts are connected to a PLC input (INPUT 4). The diagram also shows a neutral (N) line and a ground (PE) connection. The power supply is labeled -X3 and the motor is labeled -X3. The diagram is titled 'POWER DIAGRAM'.

Doc No: D02-DG04

Rev. Date: 15.09.2022

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