

HYDRALOK 扣压机用户使用手册

型号: H25ME



承蒙选购本公司的胶管扣压设备，深表感谢！为使您能有效使用本设备，

请在使用之前仔细阅读本说明书并妥善保管好！

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1. Note that all machines undergo strict testing before shipment.
所有机器装运前都经过严格检测。
2. All machines are warranted against any defects for a period of 6 MONTHS starting from the date of delivery to the customer. The company reserves the right to require a copy of the sales invoice.
自购买之日起，所购机器享有 6 个月的质保期。本公司保留要求客户出示销售发票副本的权力。
3. We must verify defects. Therefore, each defective item must be returned to our address with SHIPPING CHARGES PREPAID. We will return the item with CARRIAGE FORWARD. ANY DELIVERIES TO OUR COMPANY WITH CARRIAGE FORWARD WILL BE SENT BACK TO THE SENDER.
有缺陷的零件请寄回我司维修部，但请标明运费已付。我司会发送完好零件至客户。
4. This warranty covers replacement and repair of any component found to be defective.
该质保声明包括在质保期内享有维修和更换任何确实存在缺陷的零部件的权益
5. Replacements and repairs completed under this warranty cannot extend its 6 months validity.
该质保声明下的维修和更换在 6 个月质保期满后不再延续。
6. This warranty does not cover any damages caused by deterioration from use.
该质保声名不包括正常损耗下的损坏。
7. This warranty is not valid for damage resulting from incorrect operation, or use not in compliance with the machine instructions.
该质保声明不包括由于使用不当或未能按照机器使用说明进行操作而引起的损坏。
8. This warranty is not valid in case of unauthorised machine modification.
该质保声明不包括用户私自改装以后的机器。该质保声明不包括用户私自改装以后的机器
9. This Instruction Manual is also to be considered as a warranty certificate, with validity commencing from the date indicated on the freight bill.
该指南应当被作为产品质量保证的证明被保留。

MANUFACTURER

MACHINERY DESCRIPTION.

MODEL :- H25ME

SERIAL NO.

Engineering Director.

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必须保证机器安放在平稳适当的工作平台上。 **Place the machine on a stable and appropriate working surface**

1. 未详细阅读此用户手册之前，**请您不要使用机器**。DO NOT USE the equipment before reading the user manual.
2. **请注意危险！** 如果使用不当，机器有可能造成损伤。请不要触碰任何 处于工作状态的机器部件。CAUTION! If improperly used, the equipment may be dangerous and may cause injury. Do not touch any moving parts.
3. **请注意！** 所有操作应当由一人来完成。CAUTION! It is absolutely essential that all working operations are carried out by one operator only
4. 操作人员必须阅读本手册。This manual must be provided for the machine operator
5. 防护装置不可去除或更改。Guards must never be removed or tampered with.
6. 如有可能，应当由能胜任的电工连接适合的电源。(Where applicable) A fully trained and competent electrician must connect the machine to the appropriate electricity supply.
7. 请始终穿戴工作服，保护手套，和防护眼镜。Always wear protective gloves, safety glasses and appropriate clothing.
8. 如有可能，在打开机盖或进行机器维修之前，请先切断电源。(Where applicable) Disconnect the power supply before removing any covers, or attempting any maintenance of the machine
9. 只有原装配件才能用于机器的维修。Only original spare parts can be used in the maintenance of the machine.

TECHNICAL/DIMENSIONAL DATA	H25ME
规格 Capacity	3/16 英寸-11/4 英寸 (两层钢丝软管 2 wire) R1AT & R2AT 3/16 英寸-1 英寸 (四层 钢丝软管 4 wire) R9R/4SP
包装后尺寸 (mm) Packed Dimensions in mm (不包括可选的压力系统 Excluding optional power packs)	520x730x800
控制 Controls	变速手动加压杆操纵 Twin speed hand pump (10,000 psi)
可选用气/液压压力系统的压力 Pressure requirements for optional air/hydraulic power pack	7 bar (100 psi)
重量不包括可选的压力系统 Weight (Kg) without optional power pack	60
噪音量 Noise level	不超过 Not exceeding 70dB

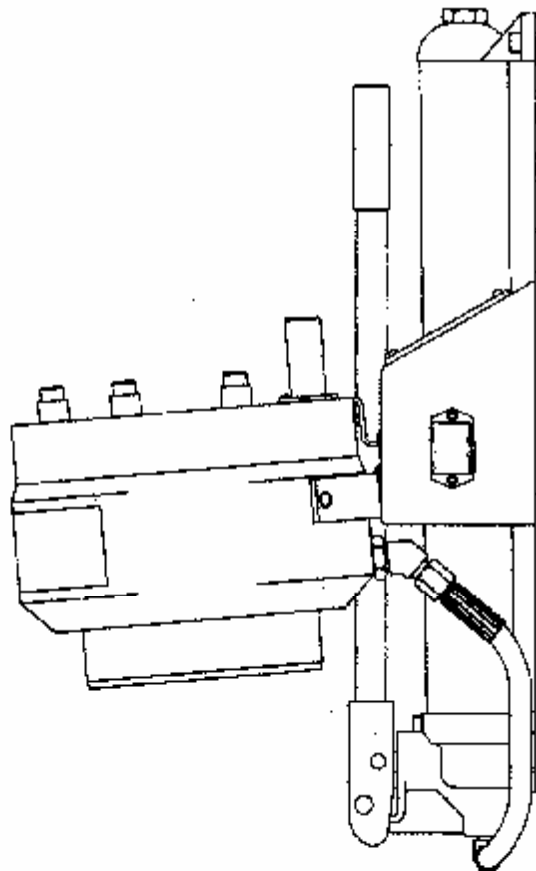
机器通常封装在木箱之中。将机器的封定装置拆除后应当使用合适的起重设备将机器置于工作平台之上。The machine will normally be shipped bolted to a wooden pallet. The bolts should be removed and the machine lifted onto the work place using suitable lifting equipment.

将机器置于平稳的工作平台之上。Place the machine on a stable surface.

照明 LIGHTING

机器正常使用下建议每月检查油位。要检查油位，首先应确保扣压机头完全扩开，然后打开操纵杆背面的油箱塞子。油位应当与？顶部在同一水平面上，油通过操纵杆流入中央。如果需要，可填加型号为 SAE 10 的液压油，**但请注意填加时不要将油溢出。** For machines in regular use it is recommended that a monthly check on the oil level in the pump be carried out. To check oil level, first ensure the machine is fully open and then remove the oil filler plug at the rear of the pump. The oil should be level with the top of the tie rod running centrally through the body of the pump. If required add SAE 10 hydraulic oil. **DO NOT OVER FILL.**

建议每年重新校验扣压机头。以下提供校验指南。At yearly intervals it is recommended that the calibration of the machine be checked in accordance with the calibration instructions.



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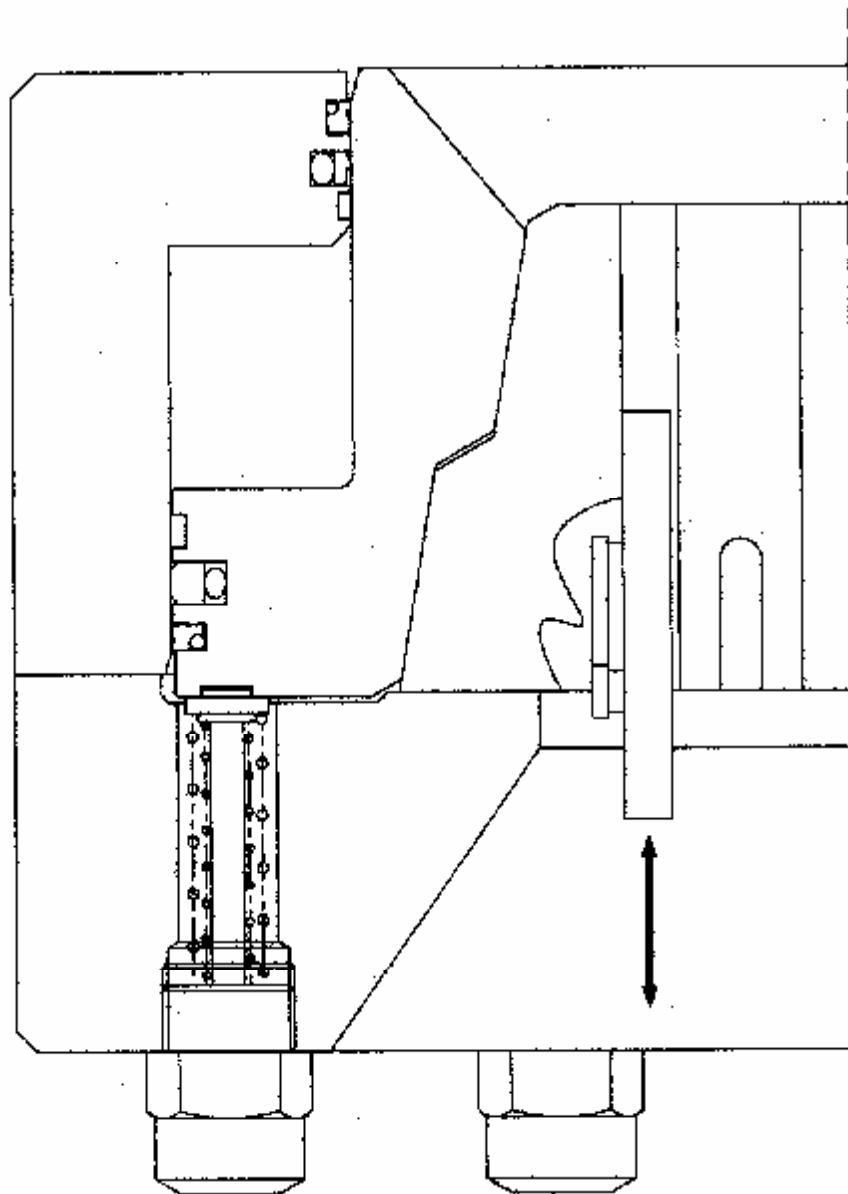
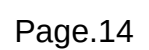


Diagram of the control panel for the 1000 Series Sewing Machine. The panel features a digital display showing '0000', a 'D' button, and four indicator lights labeled 'ENTER SIZE', 'FIT DIE SET', 'MACHINE READY', and 'COMPLETE'. Below the display are four buttons: a power button, and three buttons with arrows pointing up, down, and left. A callout box labeled 'OPERATING INSTRUCTIONS' lists: 1. SWITCH ON. 2. ENTER DESIRED SIZE. 3. FIT DIE SET AS INDICATED. 4. OPERATE MACHINE. Callout numbers 1 and 2 point to the power button and the 'D' button respectively.

H25M SWAGING MACHINE				
DIE SET	SETTING RANGE	LENGTH	FERRULE Ø MAX.	
1. 54	05.0-07.5	40.00	18.00	
1. 08	09.0-09.9	40.00	20.00	
1. 10	10.0-12.9	40.00	22.00	
1. 13	13.0-15.9	40.00	25.00	
1. 15	16.0-18.9	40.00	28.00	
1. 18	19.0-21.9	40.00	31.00	
1. 22	22.0-25.9	50.00	34.00	
1. 26	26.0-28.9	50.00	38.00	
1. 38	30.0-33.9	50.00	42.00	
1. 34	34.0-38.9	80.00	46.00	
1. 40	40.0-45.9	70.00	52.00	
1. 48	46.0-51.9	70.00	58.00	
1. 52	52.0-57.9	70.00	64.00	

1. Fit die set size H40 to the machine.选一台 H40 模具安装到机器。
2. Switch on the electronic calibrator unit.打开电子显示器装置。
3. Press and hold the **CAL** button and at the same time press **both** the Up and Down arrow buttons together.长按 CAL 按钮，同时一起按 UP 和 DOWN 按钮。
4. Open the release valve on the hand pump and place the larger end of the calibration mandrel (not supplied) in to the machine. 打开手动泵上的释压阀，放置刻度心轴的大的一端在机器里。
5. Close the release valve and operate the die set onto the mandrel until the relief valve of the hand pump is felt to operate.关闭释压阀，用心轴操作模具直到手动泵的安全阀可以操作。
6. Press the Up arrow button. The screen should display “good”. If the “bad” is displayed repeat the operation.按上下按钮。屏幕会显示 “good”，如果显示的是 “bad”，重复上述步骤。
7. Open the release valve and remove the mandrel from the machine.打开释压阀，重新放置心轴。
8. Repeat operation 4 but place the smaller end of the calibration mandrel in to the machine.重复步骤 4，但是放置刻度心轴小的一端在机器里。
9. Repeat operation 5.重复步骤 5。
10. Press the Down arrow button. The screen should display “good”. If bad is displayed repeat the operation. 按上下按钮。屏幕会显示 “good”，如果显示的是 “bad”，重复上述步骤。
11. Open the release valve and remove the mandrel from the machine. 打开释压阀，重新放置心轴。
12. To return to normal operation press and hold the **CAL** button and at the same time press **both** the Up and Down arrow buttons together. 返回正常操作，长按 CAL 按钮，同时一起按 UP 和 DOWN 按钮。
13. Produce a trial swaged assembly and check the size.试扣压一个总成检测尺寸。

Item Number	Part Number	Description	Quantity
1	HC10349	Cylinder	1
2	HC10350	End plate	1
3	HC10347	Swaging ring	1
4	HB10348	Die holder	1 set
5	HA10521	Reader Cover	1
6	HA410351	Spring cap	8
7	HA410352	Spring pin	8
8	123-050	Spring locator	8
9		Oil seals	1 set
10	102-057	Die holder spring	1 set
11	200-054	Socket cap screw	16
12	H/A4/10207	Location pin assembly	2
13	102-055&56	Return spring	1 set
14	123-051	Finger spring washer	1
15	205-013	Screw	3
16	121-061	Transducer	1



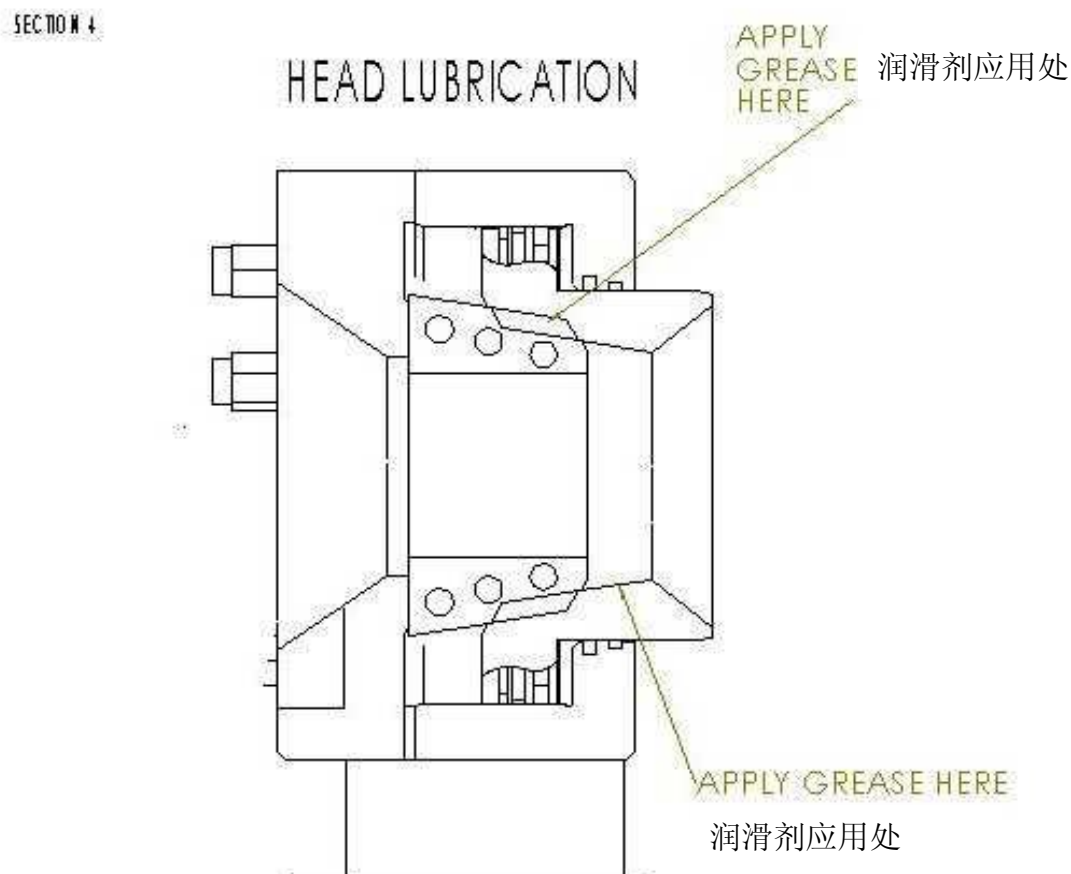
OPTIONAL AIR/HYDRAULIC POWER PACK (700 BAR.)

按照指示将胶管的一头连接扣压头，另一头连接泵的出口。确保胶管的最大加压为 700Bar。
Connect the hose from the Swaging Head to the outlet connection of the pump as indicated.
Ensure pressure rating of the hose is suitable for 700 Bar operation.

根据指南在脚踏泵的空气进口处接入空气源。Connect a suitable air supply to the air inlet connection of the foot pump as indicated.

注意：操作压的最大值限制在 7 Bar (100psig)。N.B. The air must be supplied using a filtered and lubricated supply, regulated to a MAXIMUM operating pressure of 7 Bar (100psig).

扣压机头不需要每次被完全扩开，通过松开脚踏板，可在任何位置停止扣压机头继续扩开。
The head need not be fully opened after each operation and can be stopped at any position by releasing the Foot Pedal.



3.Lubricate as indicated above, with head partly open;
 如图所示，润滑时机头必须张开一些；然后按照图示位置涂抹润滑脂，即 **8** 个模具底座之间以及银白色的缸套内部。只要涂上适量的润滑剂，机头常摩擦，易磨损的部位表面就会马上形成一层薄薄的保护膜，这时应当启动机器，使机头做“开-合-开-合”的空载运动 **10-15** 分钟，使得润滑剂得以充分接触表面。

如果模具块向外扩开时出现不规则，不均匀的现象，则说明已经缺少润滑；

如果使用非本公司提供的不恰当的润滑剂，或润滑时没有按照上述的正确方法，都会引起机器损坏，严重影响扣压。