

SM 32 MC



TECHNICAL SPECIFICATIONS

Max hose size	1 1/2" 1SN, 1 1/4" 2SN, 1" 4SP
Crimping force (kN):	1450
Max crimping Ø (mm):	61
Max opening (mm):	die diameter + 20
Standard motor:	2,2kW 400V 3-Ph
Different voltage versions available	
Control	Manual vernier
Master dies opening / Length(mm):	95/66
Crimping range (mm):	6 – 61
Weight (kg)	110 (without oil)
Dimensions (LxWxH mm)	640 x 430 x 590
Quick Change-set	Optional
Stand for machine	Optional

Optional STANDARD DIE SETS

	RANGE (mm)	LENGHT
32-06	6-16	40
32-08	8-18	40
32-11	11-21	40
32-14	14-24	40
32-17	17-27	40
32-20	20-30	45
32-23	23-33	50
32-26	26-36	50
32-31	31-41	55
32-34	34-44	60
32-39	39-49	60
32-43	43-53	65
32-45	45-55	65
32-51*	51-61	65

* Max. ferrule diameter before crimping 61 mm

OPTIONS



Quick Change Set: including storage rack & handle



Solid stand with ability to mount the Quick Change set and machine

GENERAL INSTRUCTIONS

General Information

The SM 32 MC is delivered with a fully filled oil tank and electricity cable with plug. The machine has to be installed on a solid desk or on the optional Rack with M8 Bolts. The optional Quick Change Tool can also be installed on the desk or on the optional Rack with M8 bolts.

This machine is designed for crimping hose fittings only!

Usage for other purposes at user's own risk!

Rotation direction check of the motor (3-phase models)

1. Check whether the machine voltage and the supply voltage are similar
2. Plug in the machine with the 16 A plug.
3. Switch the electricity on (1)
4. Start the motor (3)
5. Make sure that the motor rotates clockwise in accordance with the markings
6. Stop the motor (4)
7. In case that the motor rotates in wrong direction, switch the electricity wires of the cable L1 to L2 and L2 to L1

NOTE! Only an authorized electrician can do this operation.

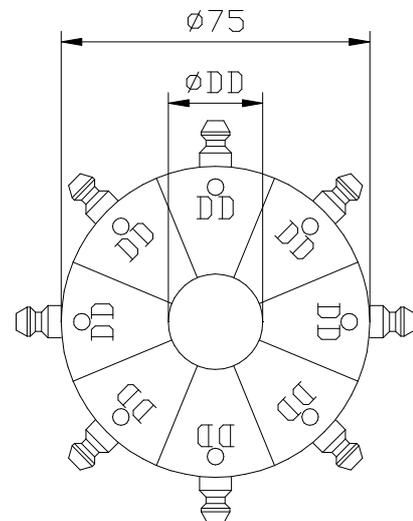
Rotation direction check is not required on single phase models.

Die set pin mounting

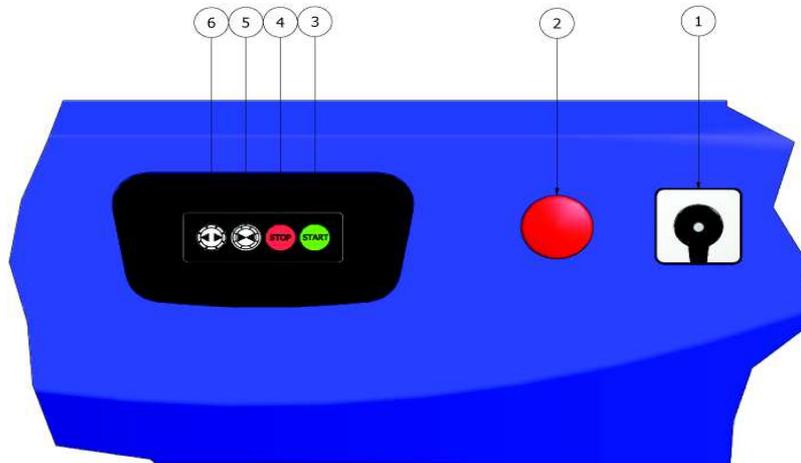
Each die set is delivered with 8 pcs of the die set pins. Carefully check whether all die set pins are firmly tightened onto the die set. Use thread locker glue (Loctite or similar) to fix the die set pins. Incorrect tightened die set pins can prevent solid mounting of the die sets.

Standard Die sets

DD= smallest swaging diameter	Die Length	Code
06	40	32-06
08	40	32-08
11	40	32-11
14	40	32-14
17	40	32-17
20	45	32-20
23	50	32-23
26	50	32-26
31	55	32-31
34	60	32-34
39	60	32-39
43	65	32-43
45	65	32-45
51	65	32-51
Die set pin	05000008	



OPERATION SWITCHES



1. MAIN ELECTRICITY SWITCH

When stopped working, switch off electricity (position 0)

2. EMERGENCY BUTTON

In case of emergency, push this button and all operations will stop immediately. Turn the button clockwise in order to return it in the up-position

3. START BUTTON

The electric motor will start, the machine is idle

4. STOP BUTTON

The motor will stop

5. SWAGING BUTTON

The machine will swage the fitting to the chosen diameter

6. OPENING BUTTON

The dies will open until the button is released, or the dies are completely opened

ANALOGUE DIAL

Turn to set the swaging diameter

NOTE do not turn the dial clockwise unless the dies are completely open!

Choosing the correct die set

The correct swaging diameter can be asked to the manufacturer of the fittings. The last two numbers of the die set, is the smallest possible swaging diameter. For swaging, choose the closest die set which is smaller than the desired diameter. Each die set has a recommended range of swaging diameters, see the white area in the table. If necessary you can use the grey area, but only if the outer diameter of the fitting does not exceed the size of the die set with 15mm. For example with the die set 32-23, you should not swage fittings which outer diameter is over 43 mm!

Die set	Swaging Diameter, mm										
	0	+1	+2	+3	+4	+5	+6	+7	+8	+9	+10
32-06	6	7	8	9	10	11	12	13	14	15	16
32-08	8	9	10	11	12	13	14	15	16	17	18
32-11	11	12	13	14	15	16	17	18	19	20	21
32-14	14	15	16	17	18	19	20	21	22	23	24
32-17	17	18	19	20	21	22	23	24	25	26	27
32-20	20	21	22	23	24	25	26	27	28	29	30
32-23	23	24	25	26	27	28	29	30	31	32	33
32-26	26	27	28	29	30	31	32	33	34	35	36
32-31	31	32	33	34	35	36	37	38	39	40	41
32-34	34	35	36	37	38	39	40	41	42	43	44
32-39	39	40	41	42	43	44	45	46	47	48	49
32-45	45	46	47	48	49	50	51	52	53	54	55
32-51	51	52	53	54	55	56	57	58	59	60	61

Installing the die sets

1. Open the master dies completely.
2. Stop the motor.
3. Install the dies so you are able to see the marks.

Removing the die sets

1. Open the master dies completely.
2. Stop the motor.
3. Remove the dies one by one

Swaging

1. Set the desired swaging diameter.
Example: desired swaging diameter 24,6. Use the die set 32-23, adjust the analogue dial to 1,6 (**23+1.6=24.6**)
2. Complete the swaging. In order to ensure the quality of the swaging, you need an Interpreter, a piece of metal with correct dimension. By pushing the interpreter into the fitting you find out whether the swaging has succeeded or not. For successful swaging the inner measurement of the fitting ought to be decreased.

Maintenance

Regularly clean the master dies and die sets when they look dirty. An old tooth brush can be helpful. The cylinder should be cleaned out from all metal dust by using a small magnet. After 8 hours of use, the master dies have to be properly cleaned and greased with our special high quality grease (molybdenum grease: Tribol Molub Alloy OG Heavy). Ask your distributor for more information and availability of our grease.

The hydraulic oil should be changed after the first 500 hours, afterwards every 1000 hours. Minimum oil level: Bottom line of the dipstick.

Technical Specifications

Max. fitting size	1 ¼"
Die opening	20 mm
Swaging force	1450 kN
Max. pressure	300 bar
Operating voltage	380 V / 220V
Motor	2,2 kW
Hydraulic oil type	TB32 lift
Oil volume	15 L

Dimensions

Height	3-phase models :590 mm Single phase: 645 mm
Width	640 mm
Depth	430 mm
Weight	125 kg