La-Pha-Pack®

Werner Reifferscheidt GmbH

USER MANUAL

Pneumatic Hand-held Crimping Tool

“ Pneumatic Crimper “

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La-Pha-Pack® Werner Reifferscheidt GmbH, Am Parir 20, D-52379 Langerwehe,
Tel.: (+49) 2423 / 94 31-0, Fax: (+49) 24 23 / 94 31-33, e-Mail: Service@La-Pha-Pack.com

Dear Customer,

we appreciate your decision to buy our pneumatic La-Pha-Pack® Hand-held Crimping Tool **"Pneumatic Crimper".** We are convinced that you can crimp small manufacturing series efficiently with this equipment.

In order to facilitate installation and handling of the Crimping Tool, we have set up the following manual that should be read carefully before putting the tool into operation. Please strictly keep to sequence and content of the described instructions, as only then a safe and correct installation and usage of the tool can be guaranteed. For further questions, please do not hesitate to contact us under the below-mentioned address.

Safety Instructions for Set-up, Conversion and Operation

- Read the complete manual carefully before starting the installation of the Crimping Tool and proceed with the installation in accordance to sequence and content of the manual
- Make sure, that your main air supply corresponds to the specified minimum and maximum limits. Make sure that the necessary parts you will use for connecting the Crimping Tool to your main air supply hose are appropriate for the air pressure (connectors for main air supply hose, hose for main air supply, etc.)
- Wear safety glasses and proper attire

Keep out of the crimping area when using the crimping push button. Otherwise there is the risk of crushing your hands through the movement of the crimping or decapping head. During the whole set-up or conversion process no third person besides the set-up person should be entering the area of the Crimping Tool, in order to avoid being injured accidentally.

- Before servicing or converting the Crimping Tool (e.g. exchange of crimping heads, etc.) disconnect air supply
- Make sure that the operator is instructed carefully in the correct handling of the machine
- The tool can be operated only by one person. Any third persons should keep out of the area of the crimper
- Set-up and conversion processes should only be carried out through the set-up person who should be in possess of the manual and should consider the safety instruction for these processes.
- Inlet pressure of regulator should never exceed 250 lbs. (17.2 bar)

SETTING UP OF THE PNEUMATIC CRIMPER

The Pneumatic Crimper consists of the Pneumatic Basic Crimping Tool with changeable screw thread for the installation of different crimping and decapping heads, the pressure regulator with Nylon spiral hose (upon request also available as steel flex hose) and the crimping/decapping heads. Optionally a hanging device with balancer Art-No. 00 00 0120 is available. In order to use the Pneumatic Crimper correctly, and to obtain the best crimp, please follow the following steps:

STEP 1: Connect the pressure regulator to your existing main air supply. For That purpose you have an air supply fitting ¼" N.P.T. (female) at your pressure regulator. Here a tube connector, a quick fitting coupler or similar with G ¼", R ¼" or ¼" NPT pipe thread can be adapted.

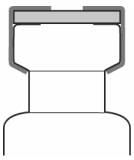
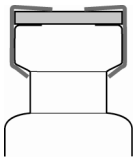
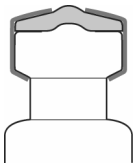
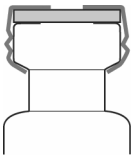
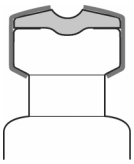
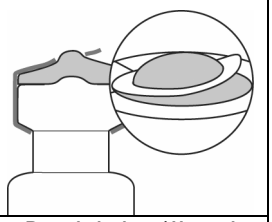
STEP 2: Screw in appropriate La-Pha-Pack® Crimping or decapping head.

STEP 3: Connect the quick fitting coupler at the spiral hose of the pressure regulator with the connector at the handle end of the Pneumatic Crimper and adjust the regulator to 1.0 – 1.4 bar respectively 15 – 20 psi. If the knob will not turn, it may be in the locked position. If in locked position, pull up on the knob to unlock and push down on knob to re-lock.

STEP 4: Insert bottle and cap assembly as centric as possible in the crimping/decapping head and start the Pneumatic Crimper by pushing the button. Wait approximately 1-2 seconds before releasing button. Inspect cap for proper seal. If seal is not crimped to your specifications, increase the air pressure by turning the knob clockwise in steps of approximately 0.2 – 0.3 bar respectively 3 – 5 psi until proper seal meets your specifications.
Remove crimped seal or partially crimped seal, replace with new seal and stopper if necessary, before crimping at increased pressure. Repeat until crimped seal meets your specifications.
Similar is valid in case you use a decapping head.

STEP 5: If crimp is unsatisfactory and you need to change the pressure, always remember to unlock pressure knob to change pressure. When the seal of the cap meets your specifications, push down on the regulator knob to lock it in place. This will avoid pressure variation and accidental adjustment throughout the run. Same is valid for decapping.

In case of non-conventional handling, especially when putting your finger/hand in the area of the crimping/decapping tool during operation, there is a risk of injury by clamping/crushing.

Correct Crimp Flat cap surface Flat septa surface  Tight fitting of the Aluminium edge Plain + undeformed cap sides	 **Untight Aluminium edge**	 **Upward bulge of the crimp cap**	 **Deformation of the crimp cap side**	 **Convex looking liner**	 **Rounded edges / Upward bulge of the Cap/Liner**
	Increase crimping pressure with the knob at the pressure balance **(undercrimped)**	Decrease crimping pressure with the knob at the pressure balance **(overcrimped)**	Decrease crimping pressure with the knob at the pressure balance **(overcrimped)**	Decrease crimping pressure with the knob at the pressure balance **(overcrimped)**	Especially with Headspace Caps it is important not to overcrimp them. If the Aluminium is stretched too much under the crimp neck, the bridges of the scorelines suffer too much stress and can break open at even low pressure (below 3 bars) **(overcrimped)**

SETTING UP FOR A NEW CAP WITH REGULATOR AND GAUGE ASSEMBLY

In order to use your Pneumatic Crimper correctly, and obtain the best crimp, please follow these steps:

STEP 1: The regulator needs to be turned down to zero pounds of pressure. Turn the regulator adjustment knob counter-clockwise to decrease the air pressure to zero, (if the knob will not turn, it may be in the locked position). If in locked position, pull up on the knob to unlock and push down on knob to re-lock.

Now you separate the Pneumatic Crimper from the pressure regulator with the quick fitting coupler.

STEP 2: Screw in appropriate La-Pha-Pack® Crimping or Decapping Head.

STEP 3: Connect the Pneumatic Crimper and the pressure regulator and increase air pressure to approximately 1.0 – 1.4 bar respectively 15 / 20 psi for crimping / decapping.

STEP 4: Assemble stopper and cap on top of bottle and operate as described under "Setting Up" step 4 and 5.

Technical Data:

Minimum input pressure:	90 psi / 6.2 bar
Maximum input pressure:	250 psi / 17.2 bar
Air supply fitting:	G ¼" (female). Connection to the customer's specific main air supply has to be supplied by customer

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