

P400 Swaging Conversion Tooling Procedures

Quick Start Guide

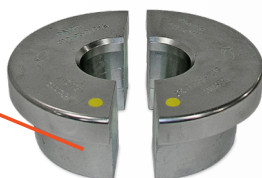
Adjustable
Pusher Holder



Pusher



Die Set



Cone
Adapter



P400SCTP1119

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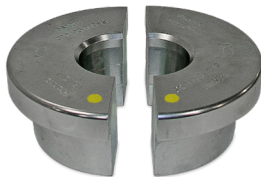
Equipment Needed:



Hose Assembly



Cone Adapter



Die Set



Pusher



Adjustable Pusher Holder

Step 1:

Place a thin layer of light oil on the surface of the machine bowl.

CAUTION: Failure to lubricate the cone adapter and die set could result in the die seizing in the machine bowl.



Step 2:

Insert the Cone Adapter into the machine bowl.



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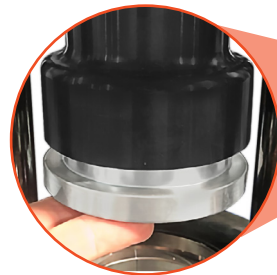
Step 3:

Insert the Adjustable Pusher Holder fully retracted.



Step 4:

Place Pusher into the Adjustable Pusher Holder where it will be held in by magnets.



Step 5:

Place a thin layer of oil on the swaging surfaces of the dies, then guide the hose through the Cone Adapter and place Die Halves into it, one at a time.



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Step 6:

While holding the top of the Adjustable Pusher Holder, spin the bottom so that it extends until the pusher covers the nut on the fitting and the bottom of the fitting is touching the Die halves.



Step 7:

Activate the machine (if using hand pump or pneumatic pump apply pressure) and continue until the face of the pusher is touching the face of the Die.

Note: If the face of the pusher does not touch the face of the dies release pressure and extend the Adjustable Pusher Holder so that it has a longer stroke.



Step 8:

Once the faces touch release pressure so that the pusher retracts. If necessary remove the Adjustable Pusher Holder for ease of access. Push the Hose up so that the dies will come out with it. Break the Dies free from the fitting usually by hand or a light tap of a rubber mallet. Pull the Hose back through the Cone Adapter.

Notes:

- Check the final swage diameter with calipers to confirm that it is within manufacturer's specifications.
- Always consult with your hose and fitting manufacturer to obtain the most current swage specifications.



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Kuriyama of America, Inc.

Headquarters, Sales Office and Warehouse Location

360 E. State Parkway, Schaumburg, IL 60173-5335

Phone: (847) 755-0360 • Toll-free FAX: (800) 800-0320

International FAX: (847) 885-0996

Web Site: www.kuriyama.com

E-Mail: sales@kuriyama.com

Disclaimer: Always check your swage results. Kuriyama of America, Inc. is not responsible for failure of the power unit. Always check the power unit is putting out the proper pressure recommended by the machine manufacturer. Extension cords could also cause low voltage affecting the hydraulic pump performance.