



# PNEUMO-HYDRAULIC PRESS WITH FLEXIBLE HOSE AND METAL FITTINGS



## USER MANUAL

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TECHNICAL DETAILS	
Pressing force	100 TON (110 US TONS)
Air supply	MAX. 7 bar (100 Psi)
Sound pressure level (noise)	≤ 75 dB (A)
Overall dimensions (L x P x H)	380 x 430 x 400 mm
Maximum temperature during usage	from -5 to + 40 °C
Maximum humidity level allowed	80%
Weight	38 kg

## notes

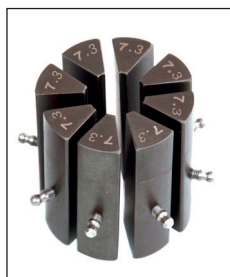
- 1) Do not press different fittings to the ones supplied exclusively by Special Springs
- 2) Consult the manufacturer's installation and maintenance manual

SUPPLY INCLUDES	check list
I) Hose press	cod.39PR06 (std.) <input type="checkbox"/>
II) Clamps 7,3 (Micro 32° e JIC 37°- tubo Ø 5,5 / Minimesse / TSM)	cod.39MTR10 (optional) <input type="checkbox"/>
III) Clamps 9,2 (JIC 37° - tubo Ø 8,0)	cod.39MTR11 (optional) <input type="checkbox"/>
IV) Clamps 12,2 (EO 24°)	cod.39MTR12 (optional) <input type="checkbox"/>
V) Clamps 14,5 (ORFS)	cod.39MTR13 (optional) <input type="checkbox"/>
VI) Shears	cod.58UT001A (optional) <input type="checkbox"/>
VII) Magnet tool to remove clamps	cod.58UT022A (std.) <input type="checkbox"/>
VIII) Led lamp with magnet	cod.58UT023A (optional) <input type="checkbox"/>
IX) User manual - Special Springs	cod.9807135602018 (std.) <input type="checkbox"/>
X) Operating and maintenance manual - o+p	cod. - (std.) <input type="checkbox"/>
XI) Manufacturer's declaration of conformity	cod. - (std.) <input type="checkbox"/>

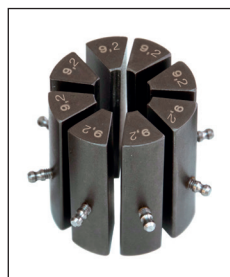
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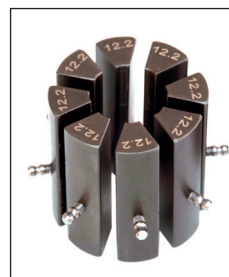
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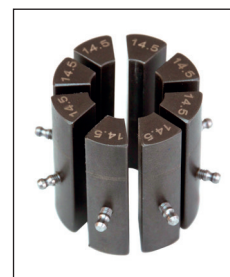
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IV



V



VI



VII



VIII



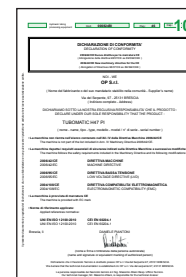
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X

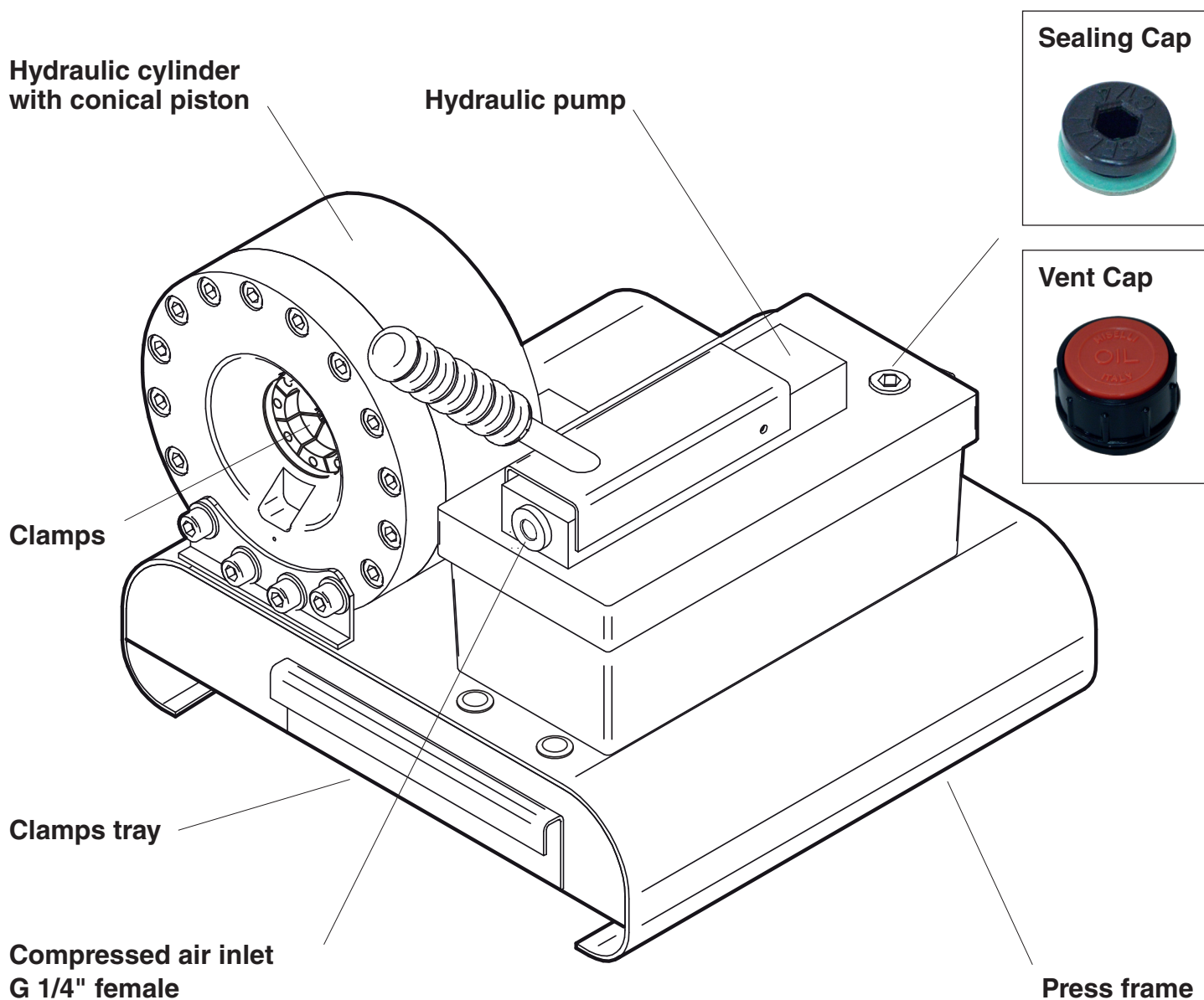


XI



# PRESS INSTALLATION AND INITIAL CHECKS

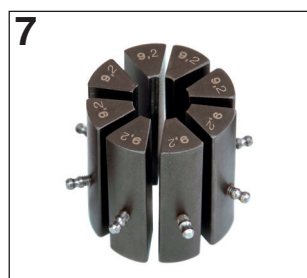
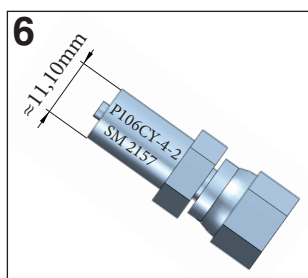
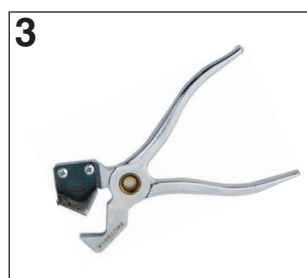
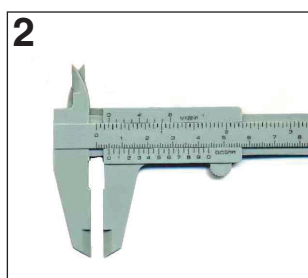
- 1) Make sure that the work surface is stable and able to bear the weight of the press.
- 2) Place the press in an environment with adequate safety distances to perform normal working / maintenance operations.
- 3) Remove the sealing cap from the oil tank.
- 4) Check the presence and quantity of the hydraulic oil (ISO 46), and restore the level if needed.
- 5) Mount the vent cap on the oil tank.
- 6) Make sure there are no foreign objects on the machine or between moving parts.
- 7) Clean and lubricate the moving parts (see manufacturer's manual).
- 8) Mount the adaptor for the compressed air entrance (G1/4" not supplied).
- 9) Connect compressed air to the system, range 5 ÷ 7 bar for correct operation.
- 10) Make sure the system does not emit disruptive vibrations during machining.



The sealing cap is **exclusively** used for the transport of the press to avoid oil leakages. Keep it after the replacement for any possible transports.

# CONNECTING INSTRUCTIONS TNC - JIC 37° - HOSE Ø 8.1

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (Transfer oil)	cod.36TNC
5) Lubricant	-
6) Fitting (P106CY-4-2 SM 2157)	cod.NCREP 7/16
7) Clamps 9,2	cod.39MTR11
8) Magnet tool to remove clamps	cod.58UT022A



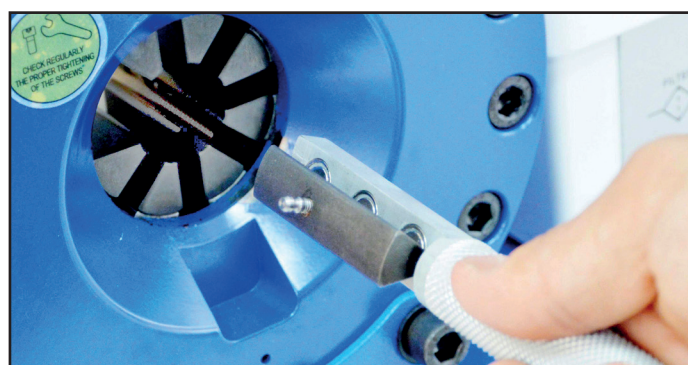
## OPERATING INSTRUCTIONS



Make sure clamps 9,2 - cod.39MTR11 are installed.



Make sure all clamps have the same number.

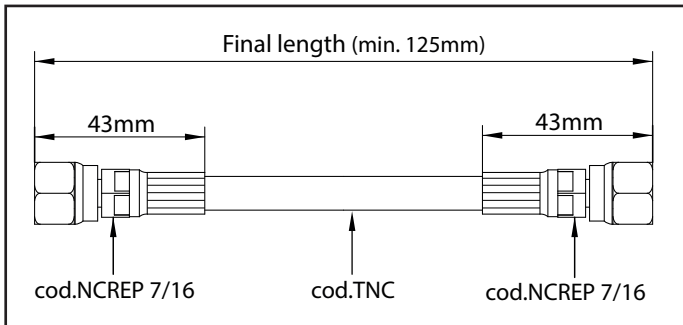


If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

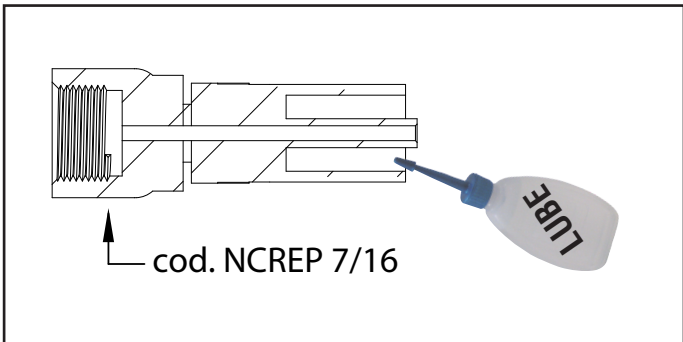
- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



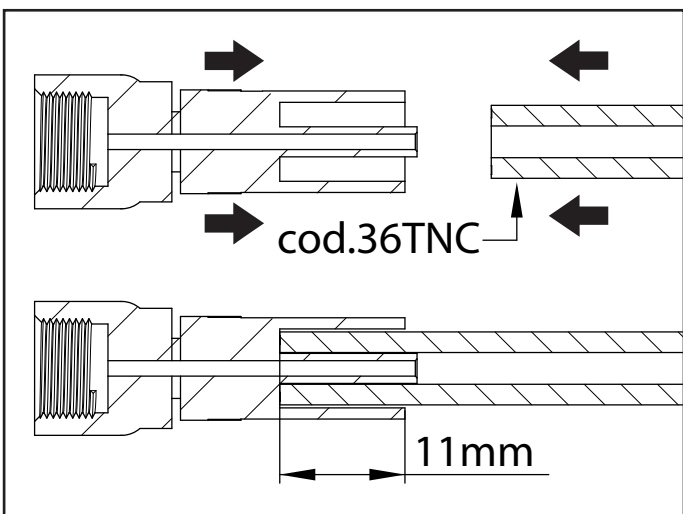
Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



The length of the hose needs to be cut **55mm shorter** than the final length (including clamps).



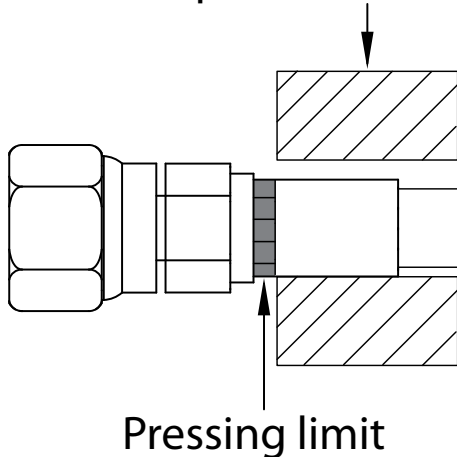
Lubricate the inlet of the fitting to be clamped cod.NCREP 7/16.



Insert the hose cod.36TNC into the fitting to be clamped cod.NCREP 7/16 and make sure it is at a complete stop within the fitting.

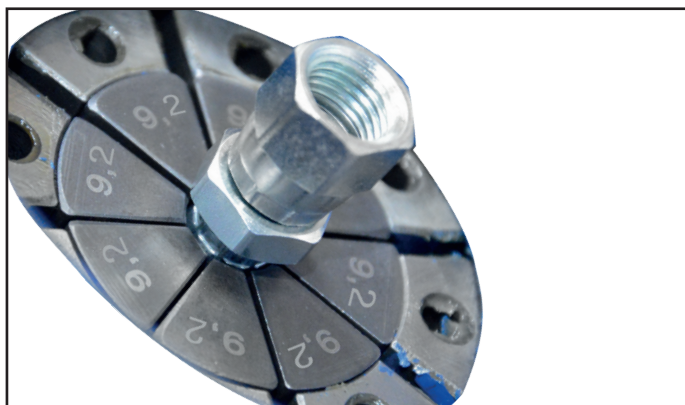


Clamps 9,2 cod.39MTR11



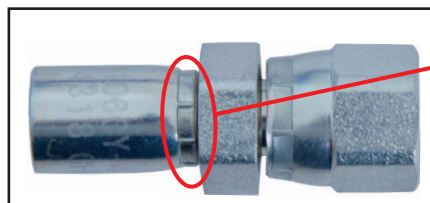
Pressing limit

Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **up until the indicated pressing limit**.



**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the pressing limit.**



Pressing limit



Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact.



Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.

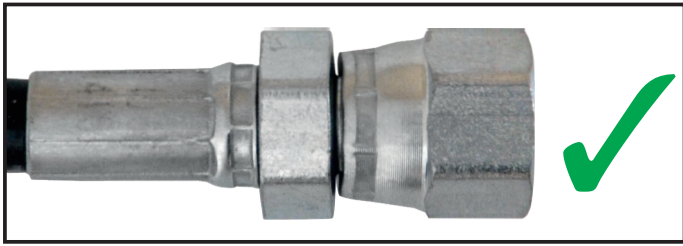


To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



Before pressing the other end of the hose, make sure the clamps are in the correct position.

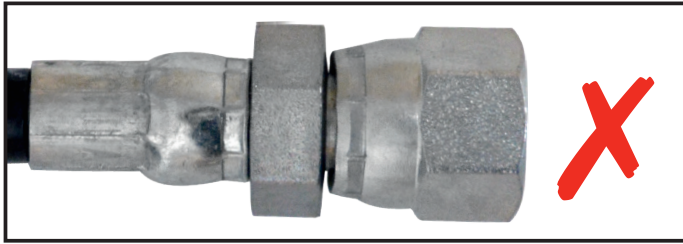




Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 9,00 mm and 9,53 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

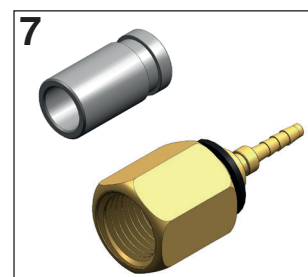
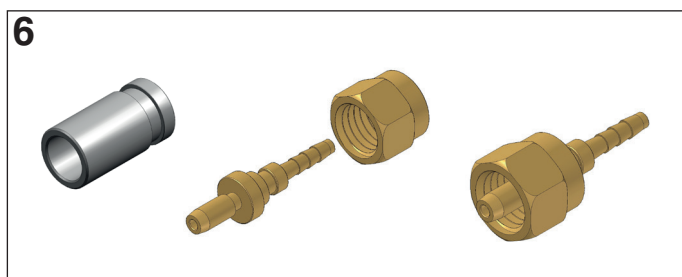
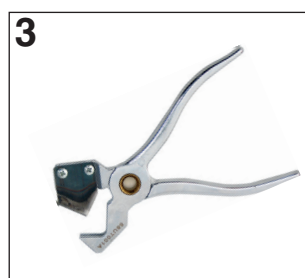
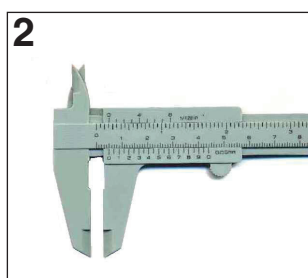
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

# CONNECTING INSTRUCTIONS TSM - MICRO 32° e JIC 37° - HOSE Ø 5,5

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (Special Springs Micro hose)	cod.36TSM
5) Lubricant	-
6) Fitting	cod.SMREPM8
7) Fitting	cod.SMREP 7/16
8) Clamps 7,3	cod.39MTR10
9) Magnet tool to remove clamps	cod.58UT022A



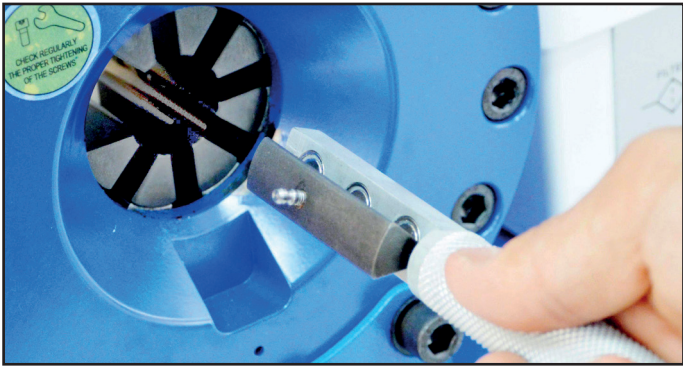
## OPERATING INSTRUCTIONS



Make sure clamps 7,3 - cod.39MTR10 are installed.



Make sure all clamps have the same number.

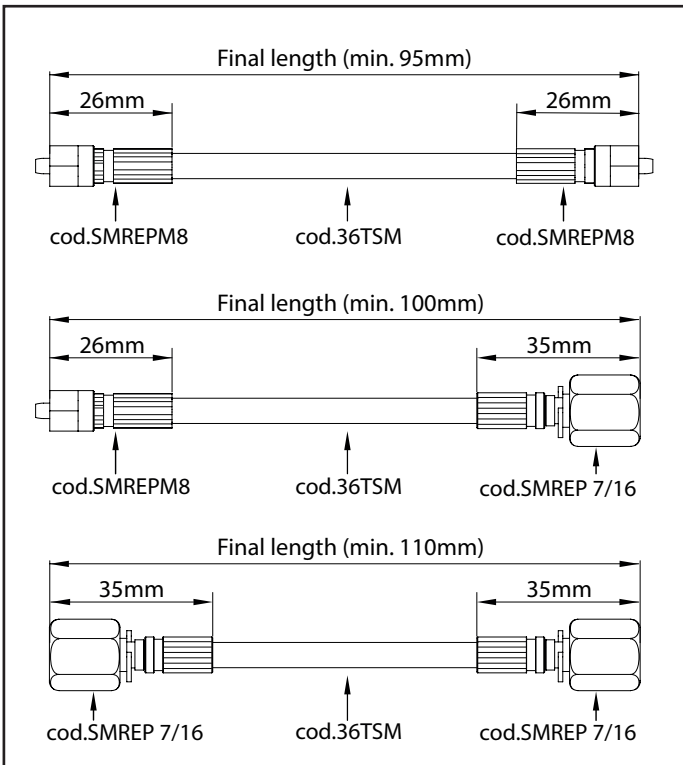


If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



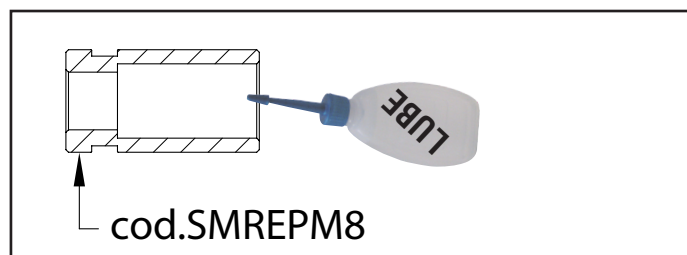
Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



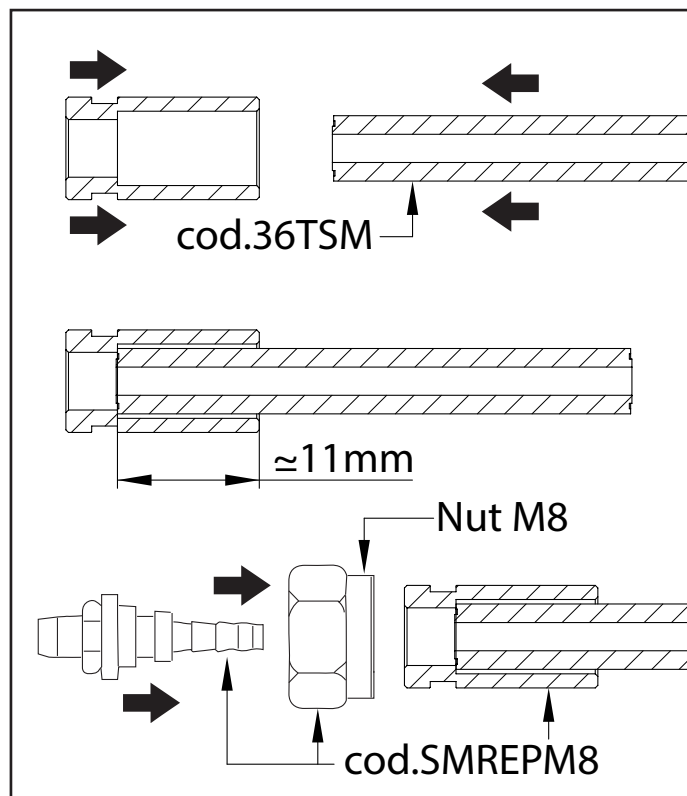
The cut length of the hose must be **shorter than  $\Delta$  (mm)** (including clamps).

Fitting	Fitting	$\Delta$ (mm)
SMREPM8	SMREPM8	30
SMREPM8	SMREP 7/16	40
SMREP 7/16	SMREP 7/16	50

# ASSEMBLY, PRESSING AND FITTING CHECK **SMREPM8**

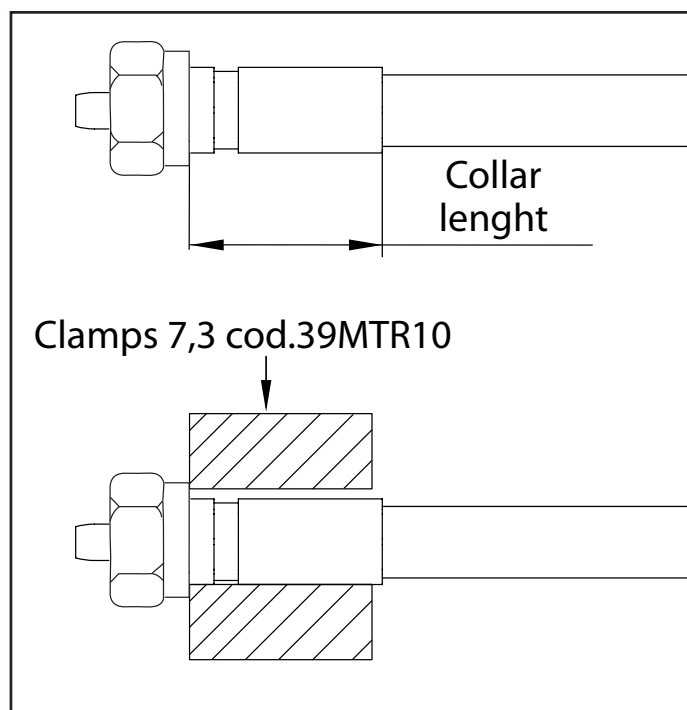


Lubricate the inlet of the fitting to be clamped cod.SMREPM8.



Insert the hose cod.36TSM into the fitting to be clamped cod.SMREPM8 and make sure it is at a complete stop within the fitting.

Assemble the remaining parts of the fitting cod.SMREPM8 like shown.



Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **up until the indicated pressing limit of the nut M8.**







**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the pressing limit of the nut M8.**



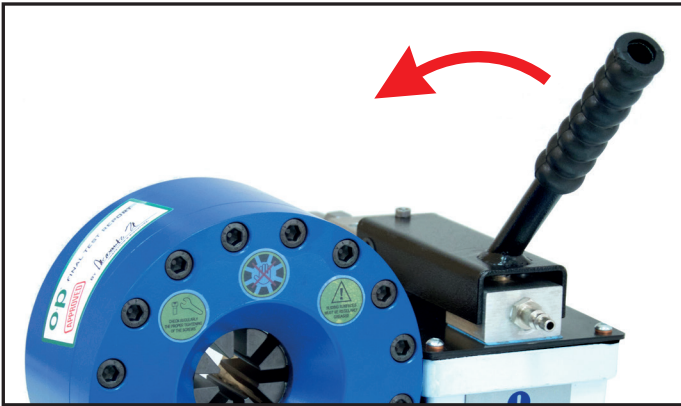
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact.



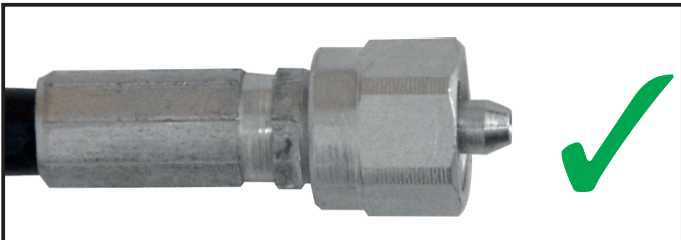
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



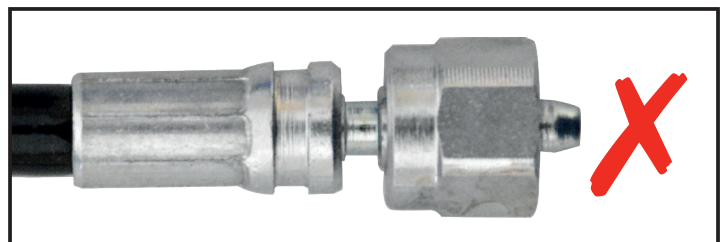
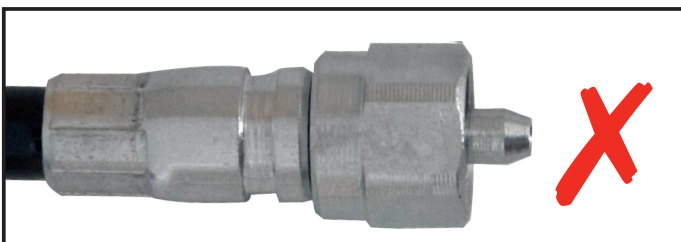
Before pressing the other end of the hose, make sure the clamps are in the correct position.



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.







Make sure the diameter of the clamped fitting is **between 7,00 mm and 7,30 mm.**



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

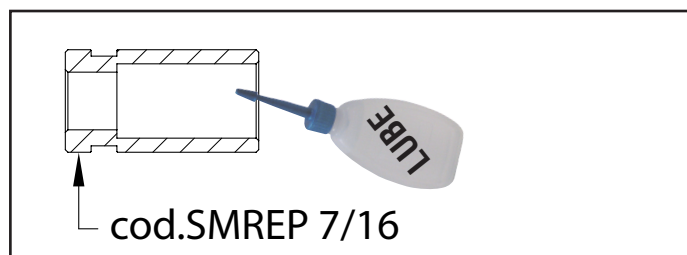
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**If the size of the crimped component does not comply with the indicated tolerances, check the following:**

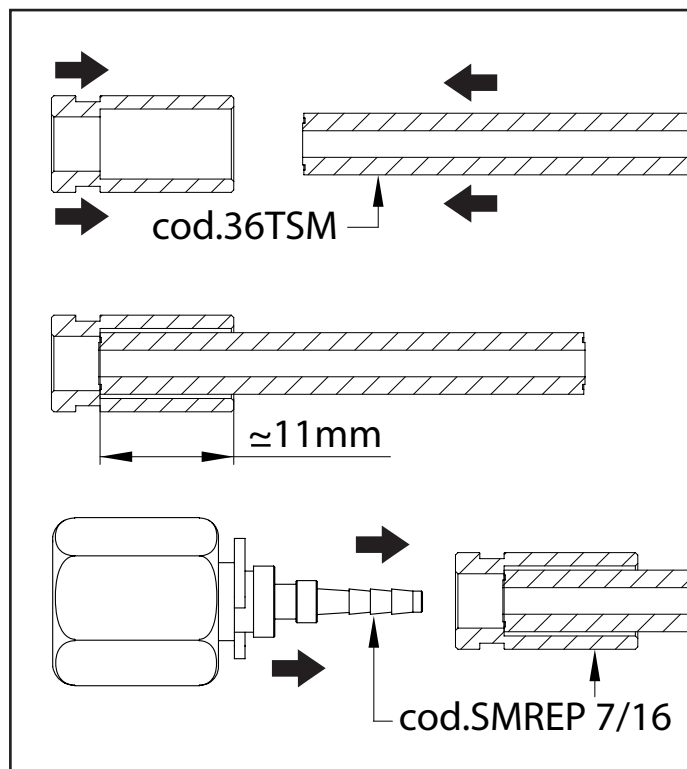


- make sure the clamps are the correct ones for the fittings and hose used.
  - make sure the clamps are mounted properly.
  - make sure the clamps are not damaged.
  - double check the pressure of the compressed air.
-

## ASSEMBLY, PRESSING AND FITTING CHECK **SMREP 7/16**

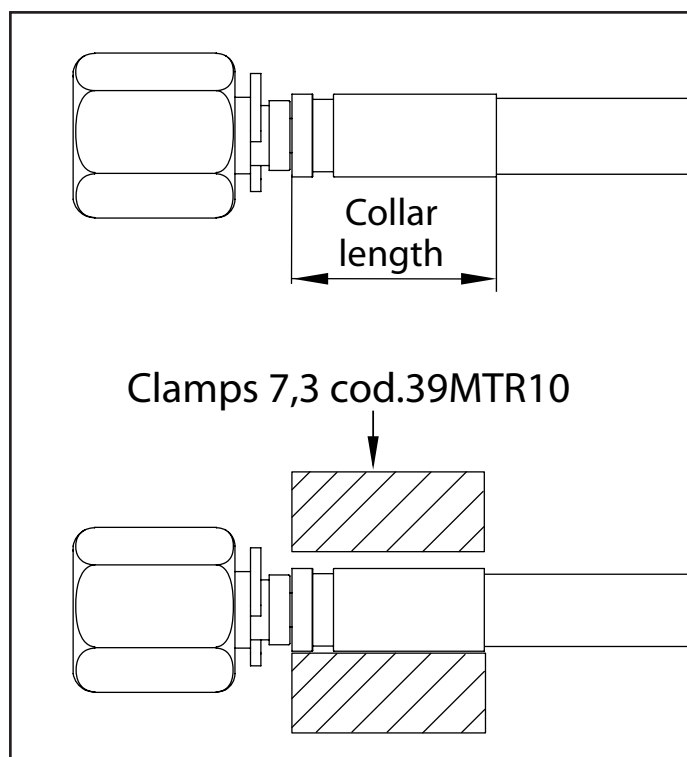


Lubricate the inlet of the fitting to be clamped  
cod.SMREP 7/16.



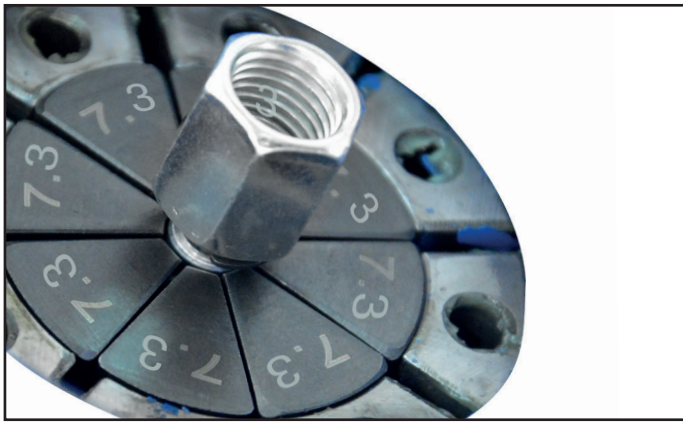
Insert the hose cod.36TSM into the fitting to  
be clamped cod.SMREP 7/16 and make sure  
it is at a complete stop within the fitting.

Assemble the remaining parts of the fitting as  
shown.



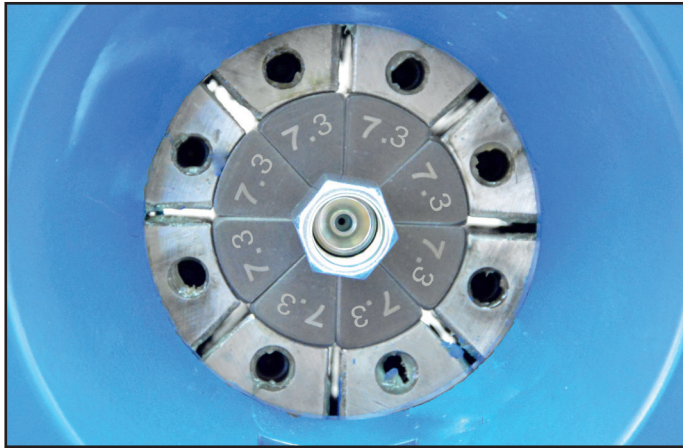
Keep the hose-fitting match unchanged and  
insert the pair into the space inside the clamp,  
**for all the collar length.**





**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the correct position of the collar.**



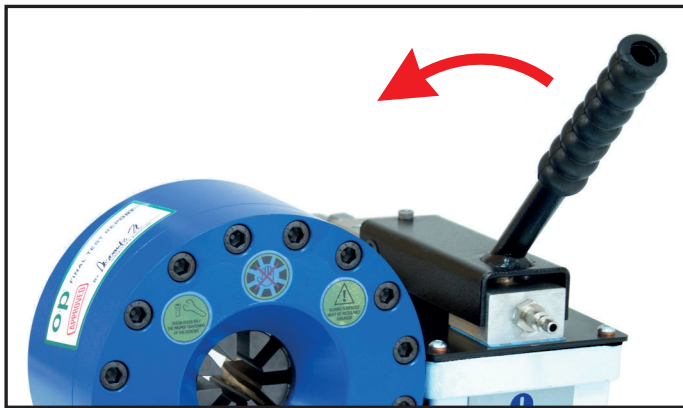
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



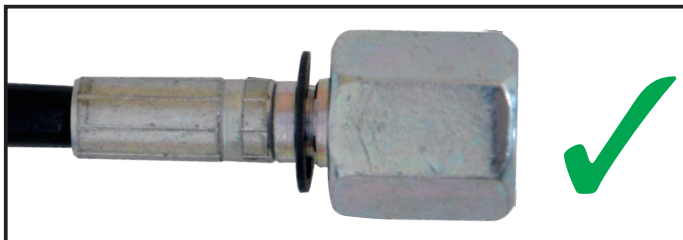
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



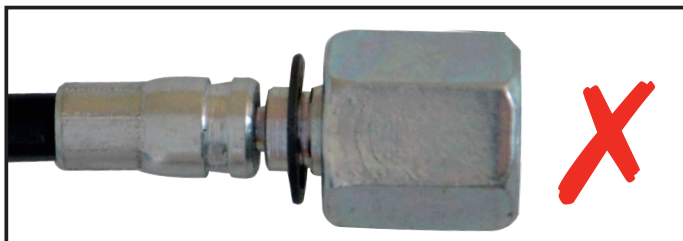
Before pressing the other end of the hose, make sure the clamps are in the correct position.

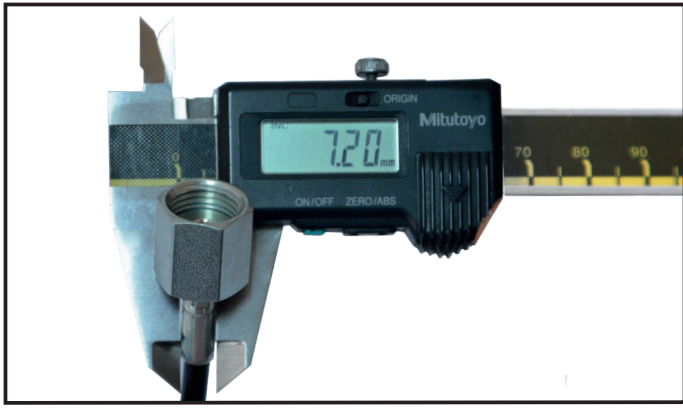


Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.





Make sure the diameter of the clamped fitting is **between 7.00 mm and 7.30 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

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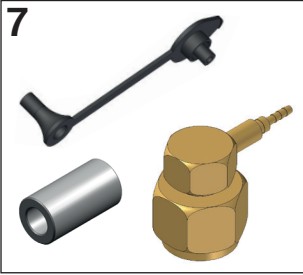
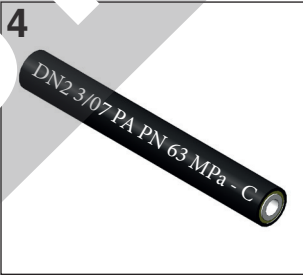
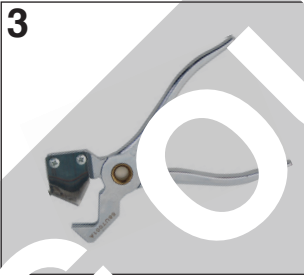
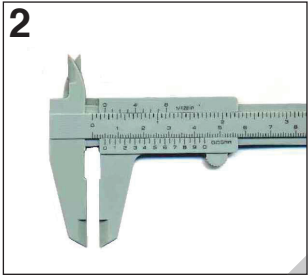
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



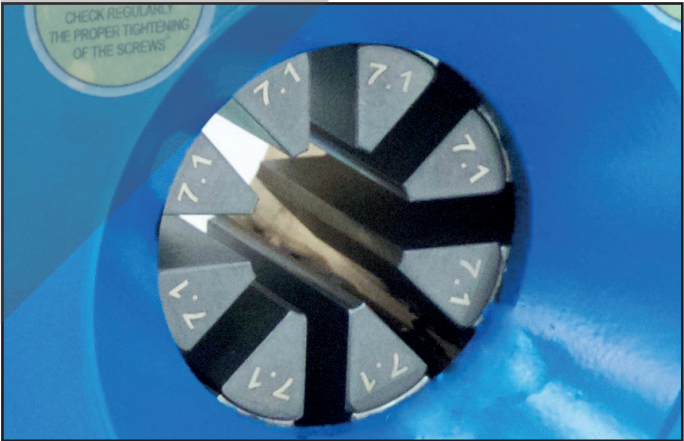
- make sure the clamps are the correct ones for the fittings and hose used.
  - make sure the clamps are mounted properly.
  - make sure the clamps are not damaged.
  - double check the pressure of the compressed air.
-

# LINKING INSTRUCTIONS FOR MINIMESS - HOSE Ø 5,1

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Tubo (DN2 3/07 PA PN 63 MPa - C)	cod.36TM
5) Lubricant	-
6) Fitting	cod.36MREPD
7) Fitting	cod.36MREPR
8) Clamps 7,1	cod.39MTR10
9) Magnet tool to remove clamps	cod.58UT001A



## OPERATING INSTRUCTIONS

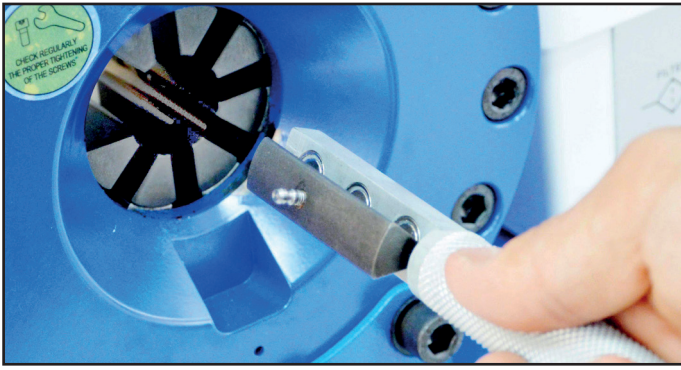


Make sure clamps 7,1 - cod.39MTR10 are installed.



Make sure all clamps have the same number.



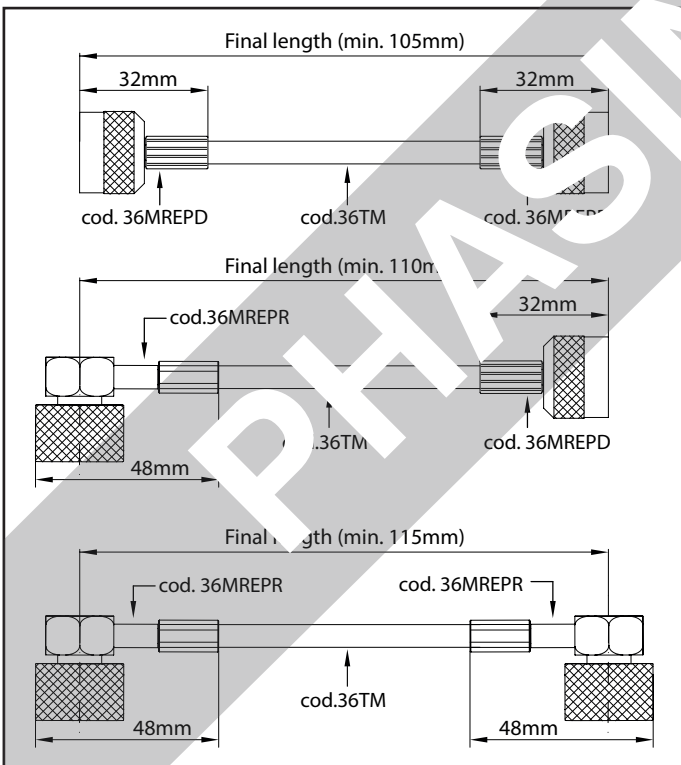
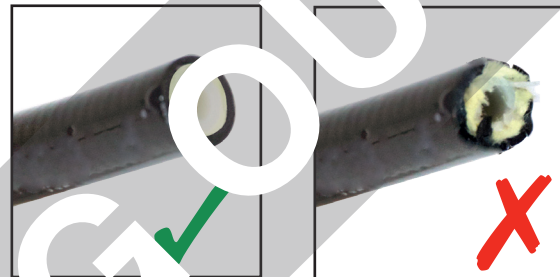


If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



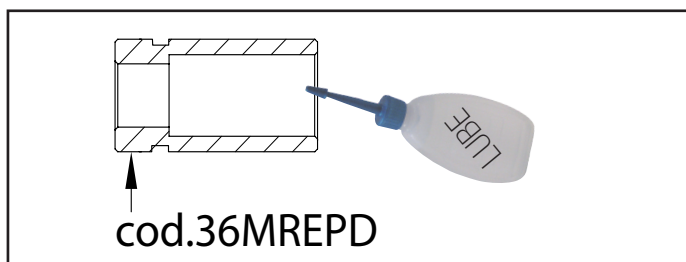
Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



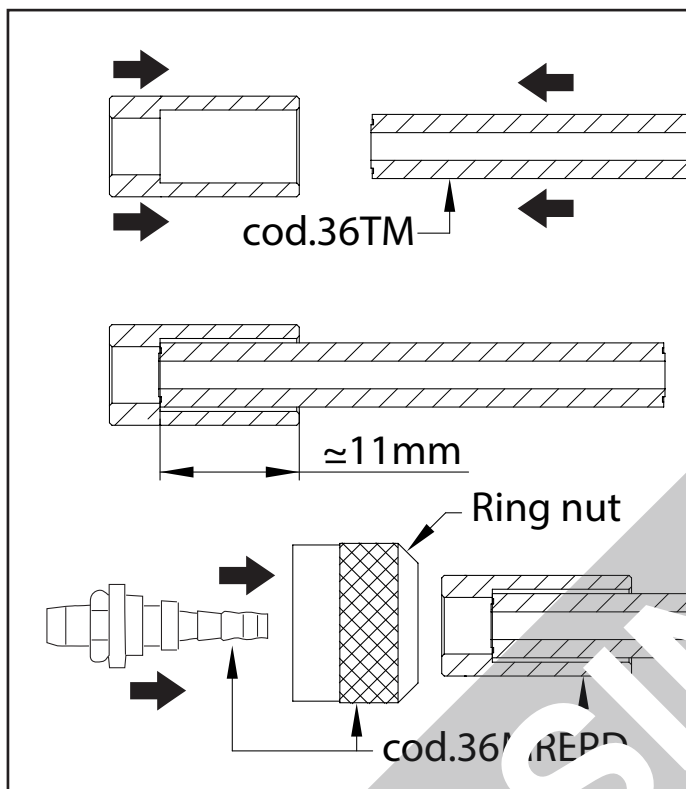
The cut length of the hose must be **shorter than  $\Delta$  (mm)** (including clamps).

Fitting	Fitting	$\Delta$ (mm)
36MREPD	36MREPD	40
36MREPD	36MREPR	45
36MREPR	36MREPR	55

# ASSEMBLY, PRESSING AND FITTING CHECK **36MREPD**

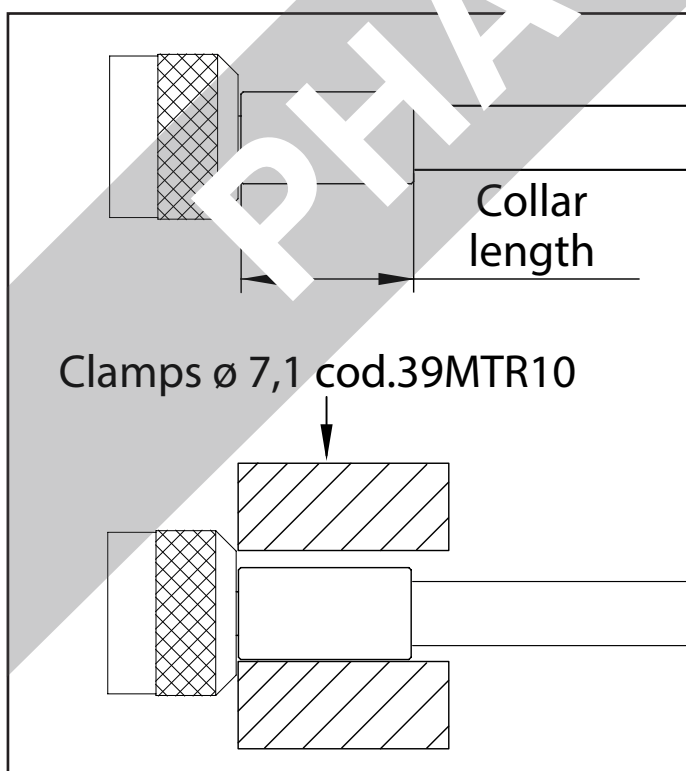


Lubricate the inlet of the fitting to be clamped cod.36MREPD.



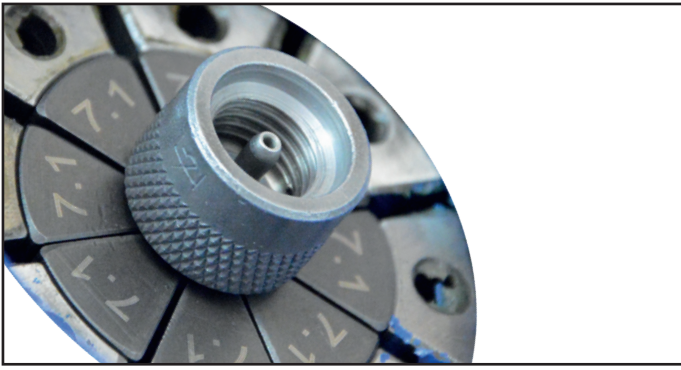
Insert the hose cod.36TM into the fitting to be clamped cod.36MREPD and make sure it is at a complete stop within the fitting.

Assemble the remaining parts of the fitting cod.36MREPD as shown.



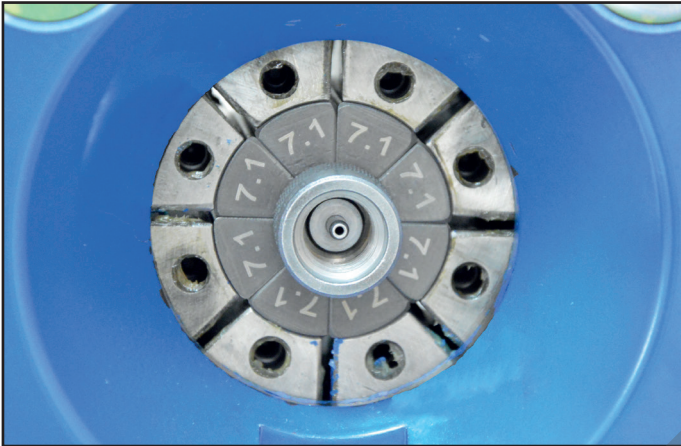
Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **for the full length of the collar until the ring nut.**





**Sit** the clamp near the fittings by acting on the hydraulic pump.

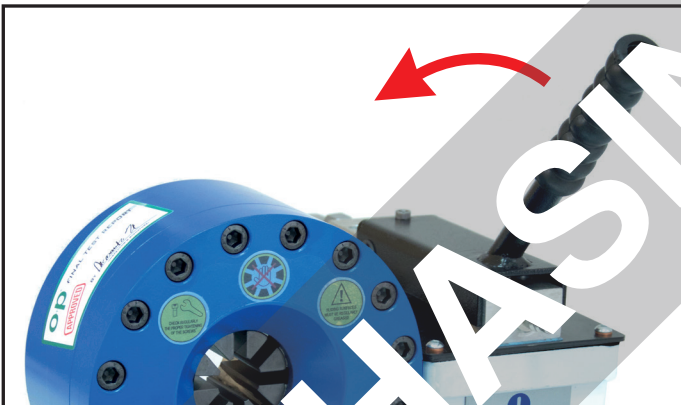
**Double check the position of the ring nut.**



Then **press** the pump handle until the clamps are in **full contact**.



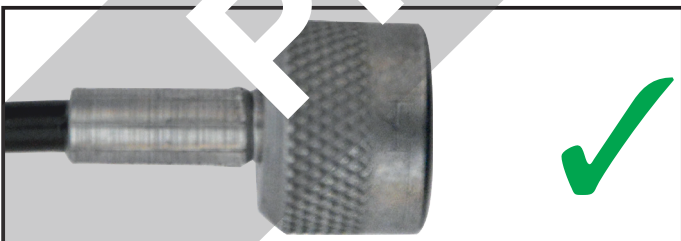
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To remove the fittings and remove the clamped hose, press the pump lever in the opposite direction.



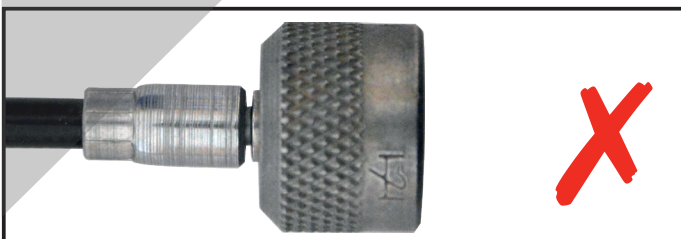
Before pressing the other end of the hose, make sure the clamps are in the correct position.

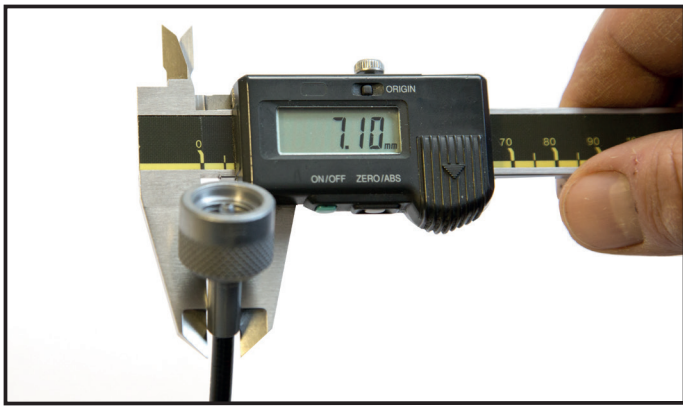


Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.





Make sure the diameter of the clamped fitting is **between 6.90mm and 7.30mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

**If the size of the crimped component does not comply with the indicated tolerances, check the following:**

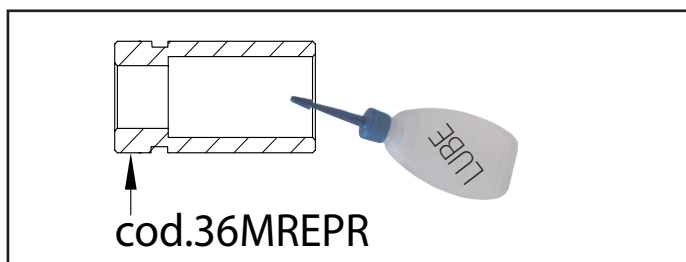


- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

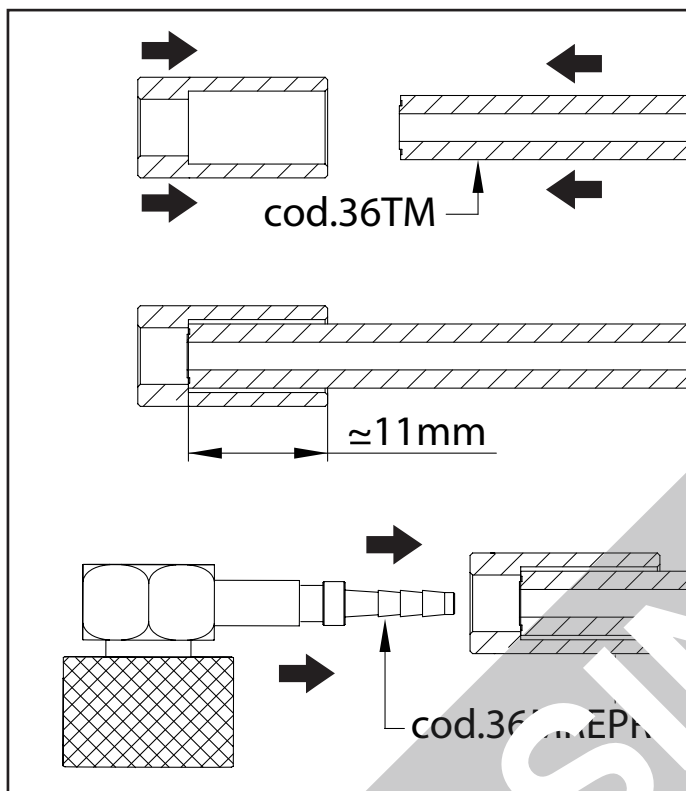
PHASING OUT



## ASSEMBLY, PRESSING AND FITTING CHECK **36MREPR**

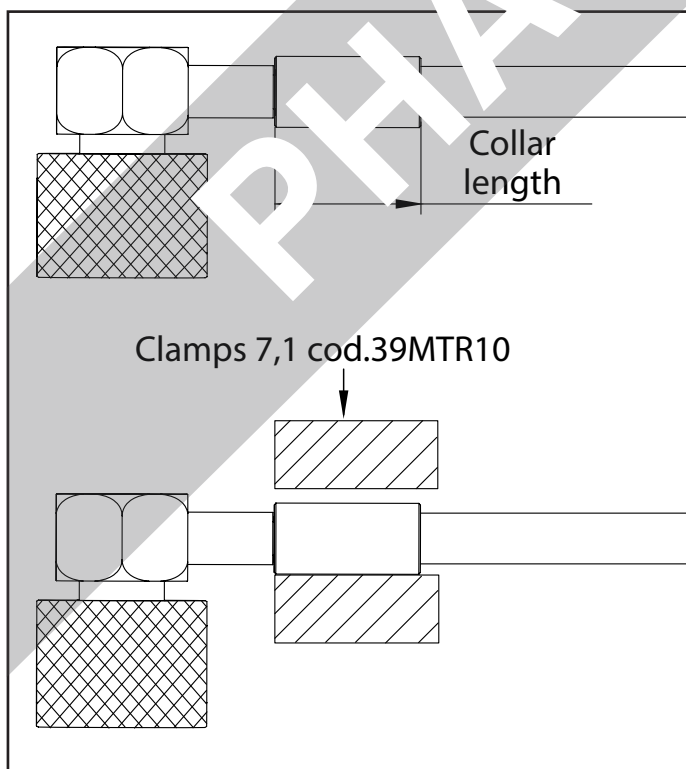


Lubricate the inlet of the fitting to be clamped cod.36MREPR.



Insert the hose cod.36TM into the fitting to be clamped cod.36MREPR and make sure it is at a complete stop within the fitting.

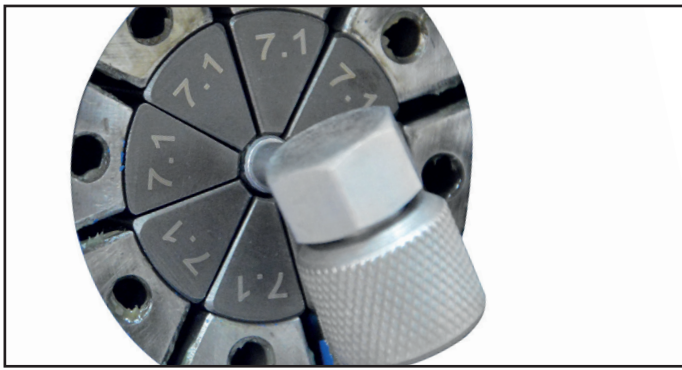
Assemble the remaining parts of the fitting cod.36MREPR as shown.



Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **for the full length of the collar.**

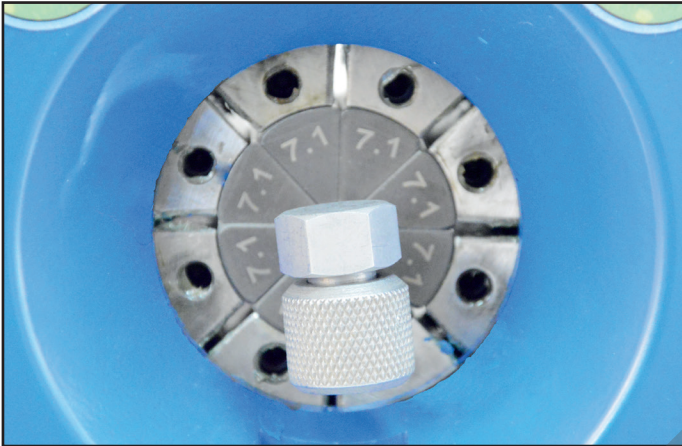






**Sit** the clamp near the fittings by acting on the hydraulic pump.

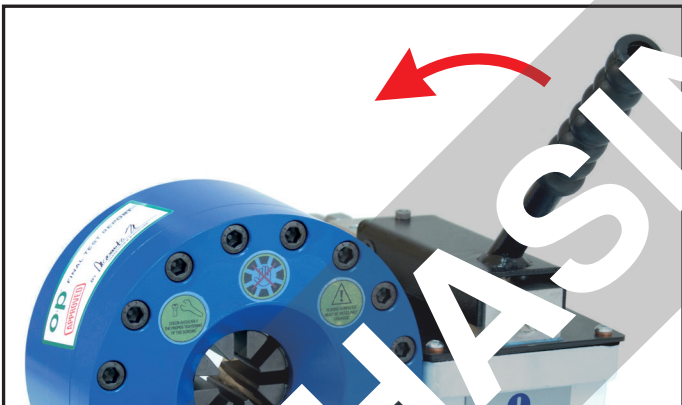
**Double check the position of the collar.**



Then **press** the pump handle until the clamps are in **full contact**.



**Warning:** Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.

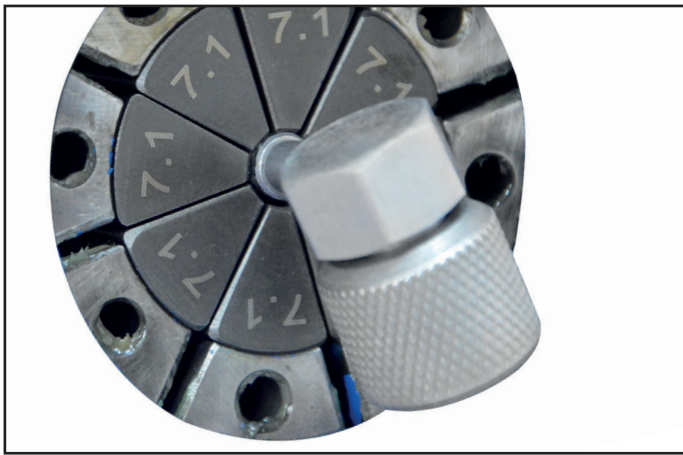


To move the fittings and remove the clamped hose, press the pump lever in the opposite direction.

**Warning:** Before pressing the other end of the hose, make sure the clamps are in the correct position.



In order to press a fitting cod.36MREPR, on a hose with an already clamped end, **remove at least two clamps**.



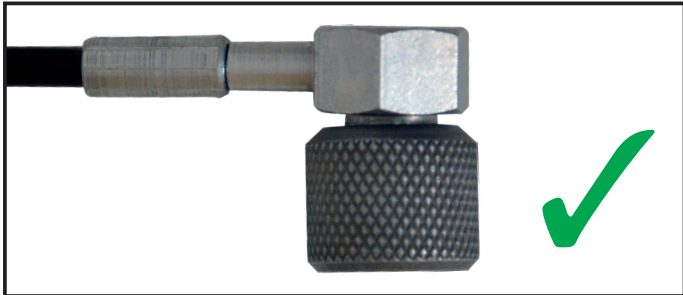
Reassemble the clamps (previously removed) and proceed with the pressing.

Then **press** the pump handle until the clamps are in **full contact**.

**Double check the correct position of the collar.**



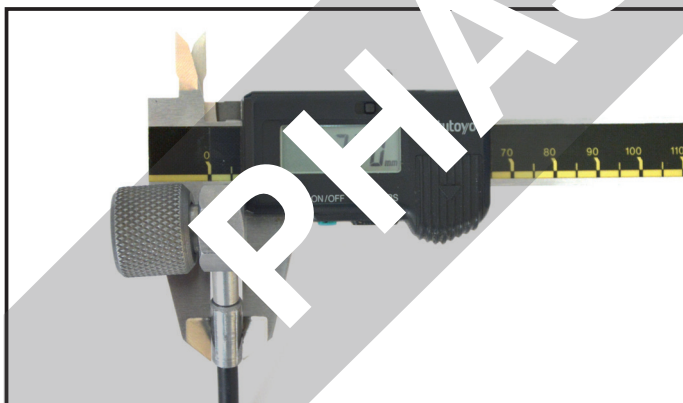
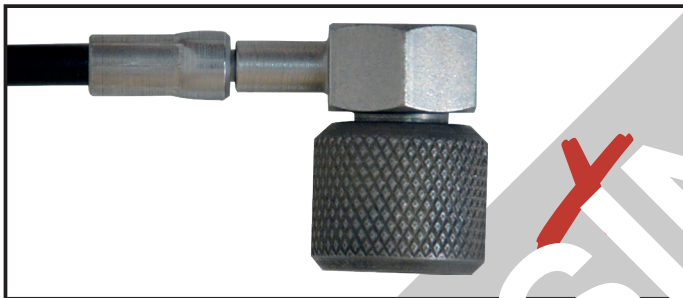
Clamps at full contact



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new one on the hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 6.90 mm and 7.30 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

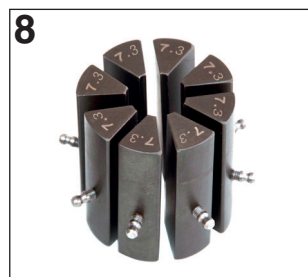
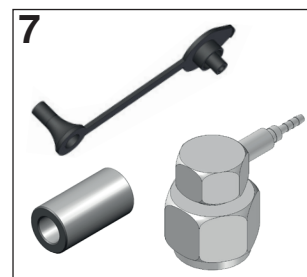
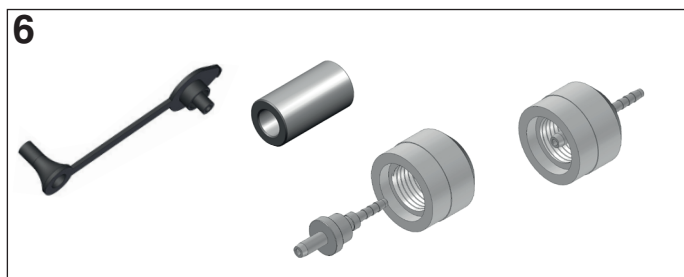
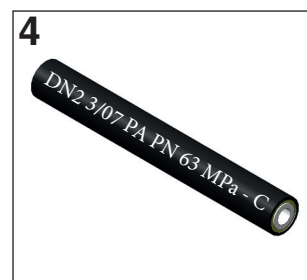
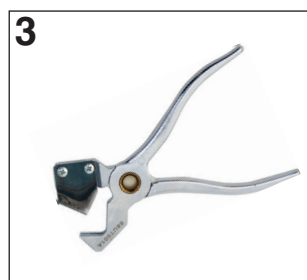
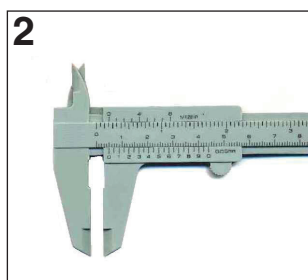
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

# LINKING INSTRUCTIONS FOR TMA - FLEXFLOW - HOSE Ø 5,1

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (DN2 3/07 PA PN 63 MPa - C)	cod.36TM
5) Lubricant	-
6) Fitting	cod.36MREPDA
7) Fitting	cod.36MREPRA
8) Clamps 7,3	cod.39MTR10
9) Magnet tool to remove clamps	cod.58UT022A



## OPERATING INSTRUCTIONS

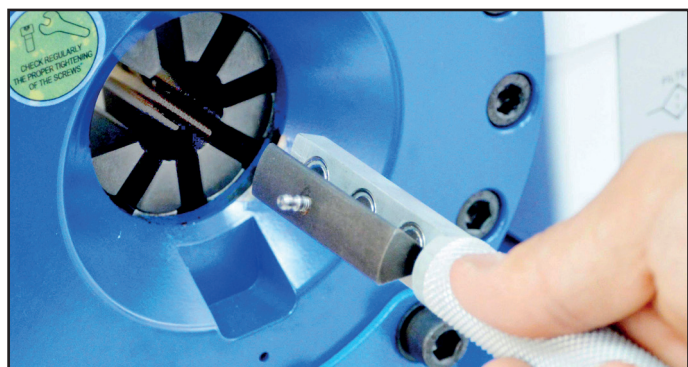


Make sure clamps 7,3 - cod.39MTR10 are installed.



Make sure all clamps have the same number.



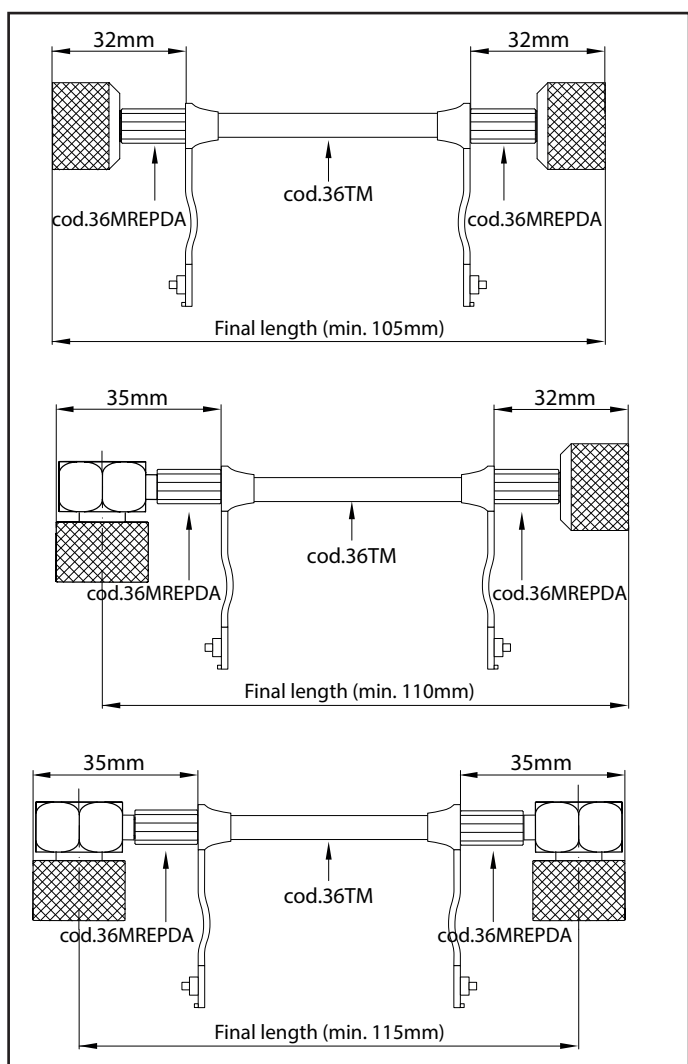


If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



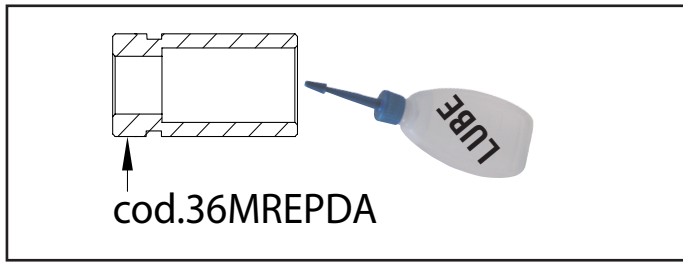
The cut length of the hose must be **shorter than  $\Delta$  (mm)** (including clamps).

Fitting	Fitting	$\Delta$ (mm)
36MREPDA	36MREPDA	<b>44</b>
36MREPDA	36MREPRA	<b>39</b>
36MREPRA	36MREPRA	<b>34</b>

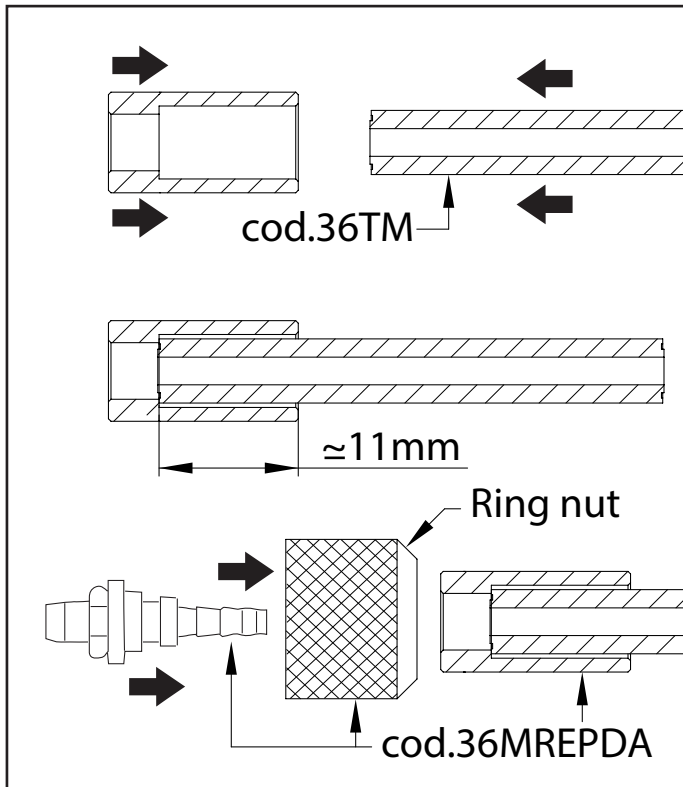
Fitting	Fitting	$\Delta$ (mm)
36MREPD (MINIMESS)	36MREPDA	<b>42</b>
36MREPD (MINIMESS)	36MREPRA	<b>37</b>
36MREPDA	36MREPR (MINIMESS)	<b>50</b>
36MREPRA	36MREPR (MINIMESS)	<b>45</b>



## ASSEMBLY, PRESSING AND FITTING CHECK **36MREPDA**

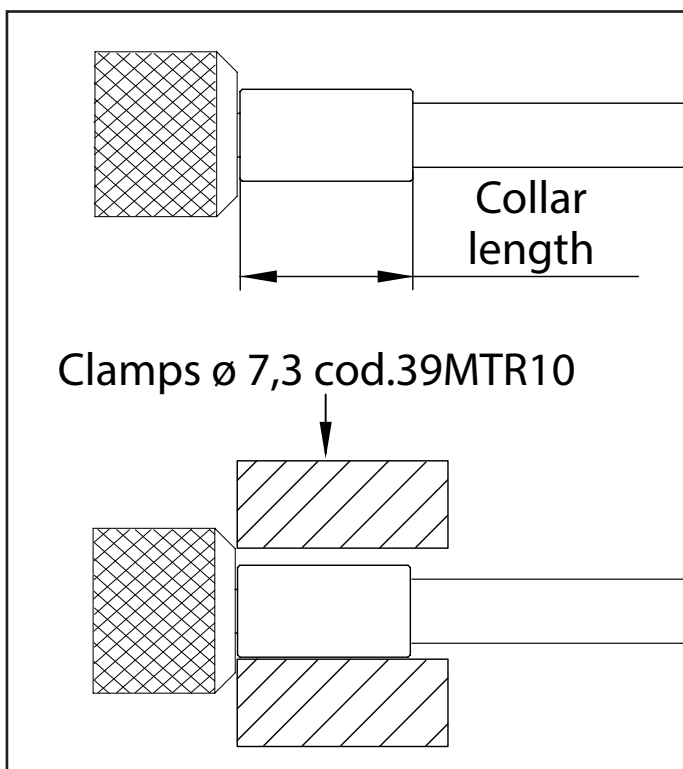


Lubricate the inlet of the fitting to be clamped cod.36MREPDA.



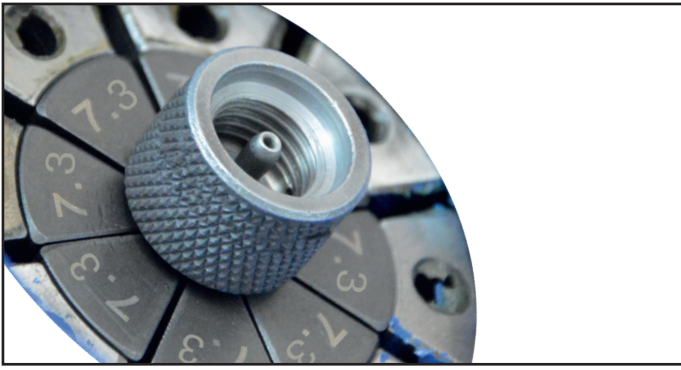
Insert the hose cod.36TM into the fitting to be clamped cod.36MREPDA and make sure it is at a complete stop within the fitting.

Assemble the remaining parts of the fitting cod.36MREPDA as shown.



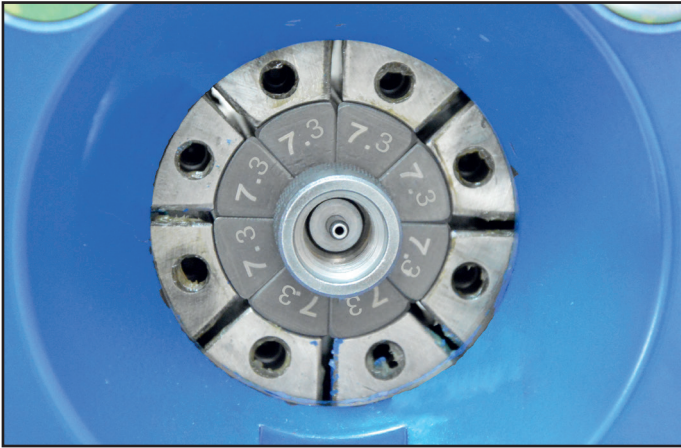
Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **for the full length of the collar until the ring nut.**





**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the position of the ring nut.**



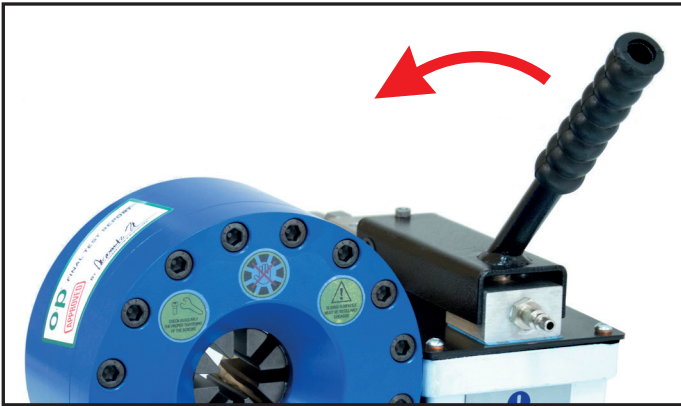
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



Before pressing the other end of the hose, make sure the clamps are in the correct position.

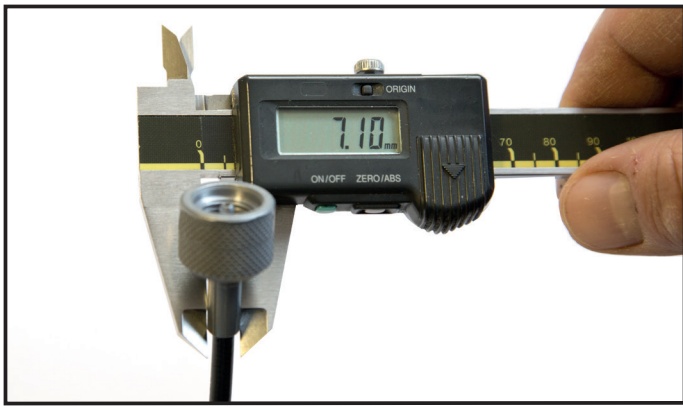


Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.





Make sure the diameter of the clamped fitting is **between 6.90mm and 7.30mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

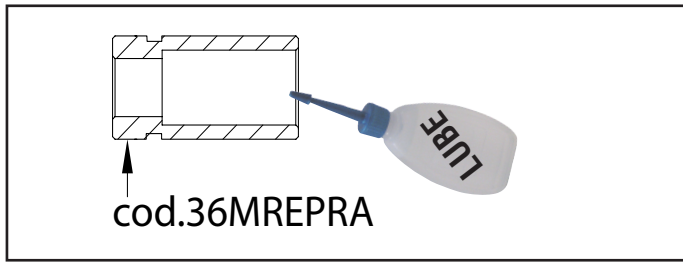
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**If the size of the crimped component does not comply with the indicated tolerances, check the following:**

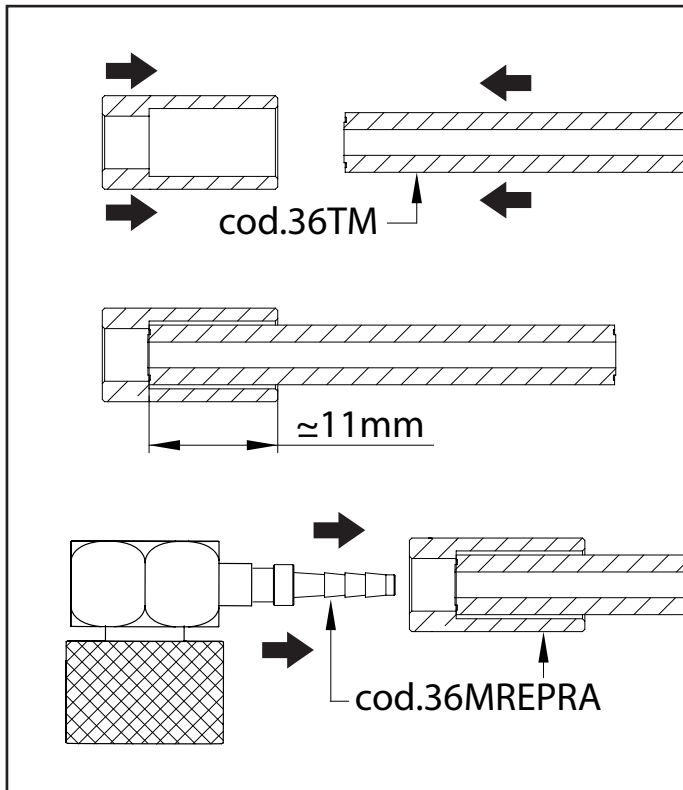


- make sure the clamps are the correct ones for the fittings and hose used.
  - make sure the clamps are mounted properly.
  - make sure the clamps are not damaged.
  - double check the pressure of the compressed air.
-

## ASSEMBLY, PRESSING AND FITTING CHECK **36MREPRA**

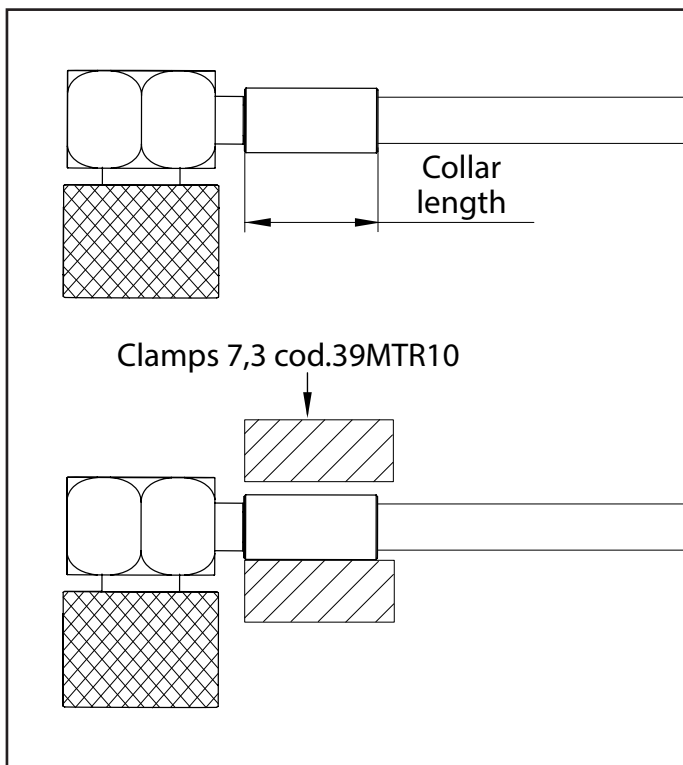


Lubricate the inlet of the fitting to be clamped cod.36MREPR.



Insert the hose cod.36TM into the fitting to be clamped cod.36MREPRA and make sure it is at a complete stop within the fitting.

Assemble the remaining parts of the fitting cod.36MREPRA as shown.



Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **for the full length of the collar.**

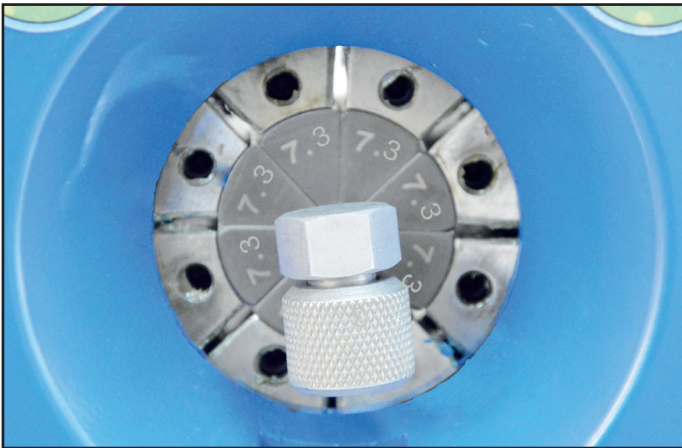






**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the position of the collar.**



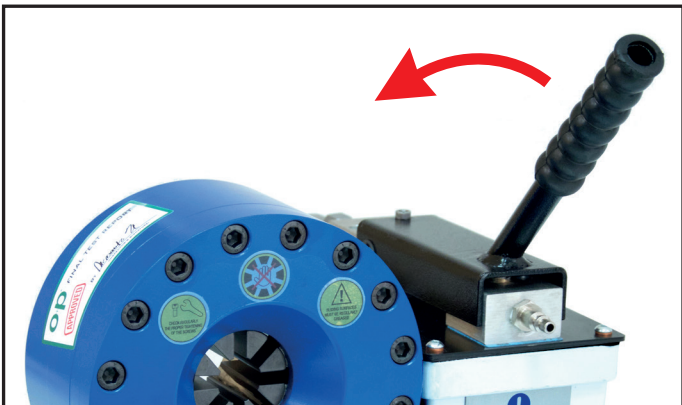
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



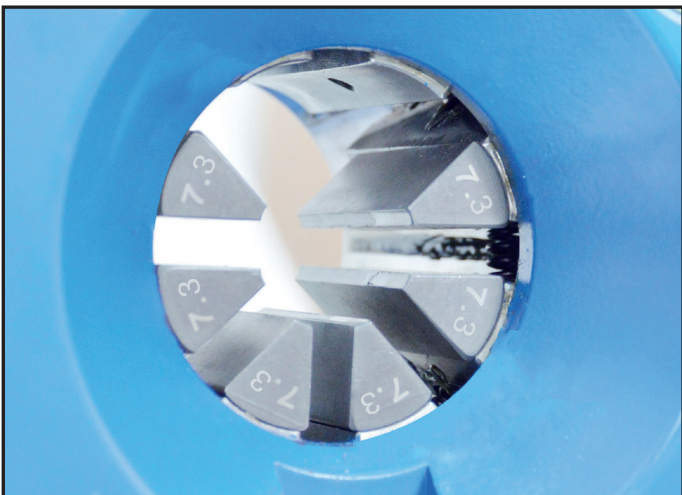
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



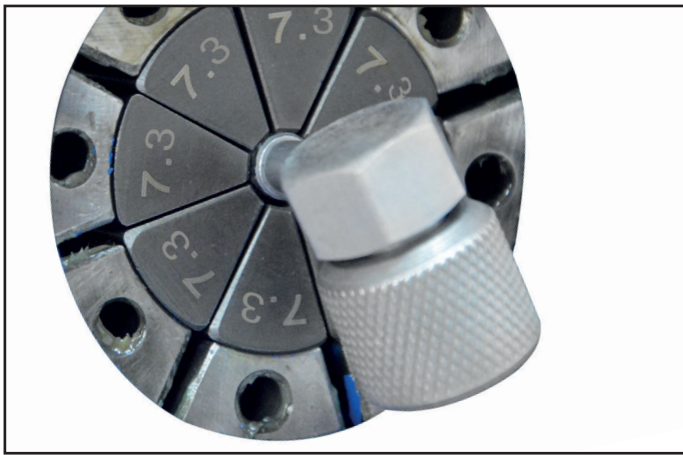
To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



Before pressing the other end of the hose, make sure the clamps are in the correct position.



In order to press a fitting cod.36MREPPRA, on a hose with an already clamped end, **remove at least two clamps**.



Reassemble the clamps (previously removed) and proceed with the pressing.

Then **press** the pump handle until the clamps are in **full contact**.

**Double check the correct position of the collar.**



Clamps at full contact



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 6.90 mm and 7.30 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

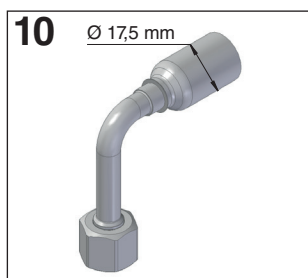
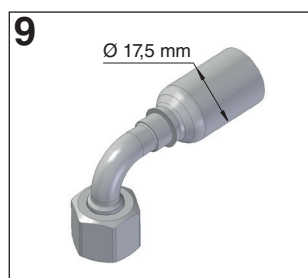
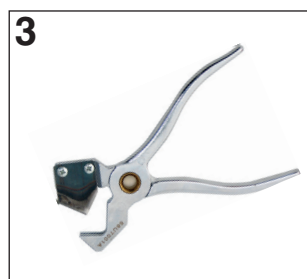
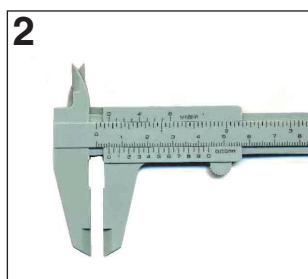
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

# LINKING INSTRUCTIONS FOR HY 400 - ORFS - HOSE Ø 12,7

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (Parker Parflex 520 N-4)	cod.36HY400
5) Lubricant	-
6) Fitting	cod.36P9/1604
7) Fitting	cod.36P9/1605
8) Fitting	cod.36P9/1608
9) Fitting	cod.36P9/1607
10) Fitting	cod.36P9/1606
11) Clamps 14,5	cod.39MTR13
12) Magnet tool to remove clamps	cod.58UT022A



## OPERATING INSTRUCTIONS

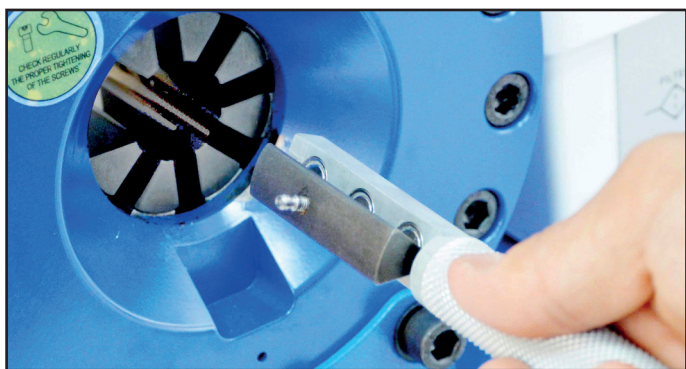


Make sure clamps 14,5 - cod.39MTR13 are installed.



Make sure all clamps have the same number.





If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



The cut length of the hose must be  $\Delta$  (mm) **shorter** than the final length of the hose including fittings.



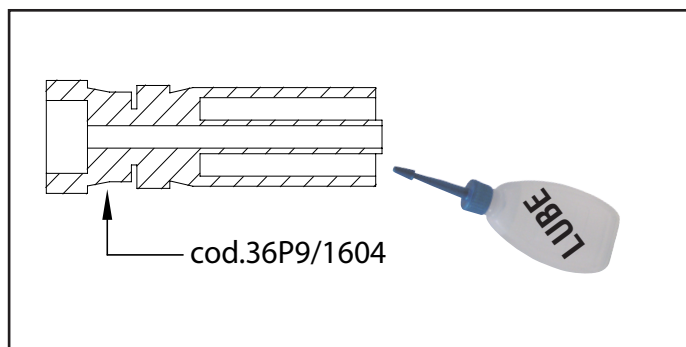
Hose model	$\Delta$ (mm)	
36HY40016...	70	
36HY40017...	65	
36HY40018...	80	



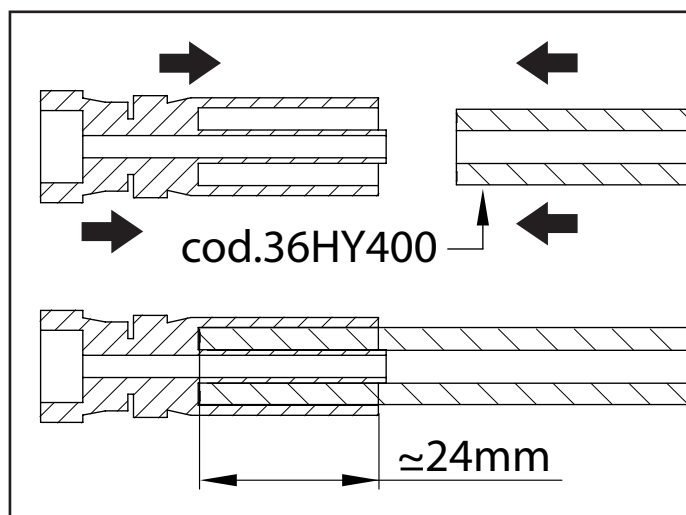
Hose model	$\Delta$ (mm)	
36HY40019...	80	<p>56mm 56mm</p> <p>S 18 9/16 - 18</p> <p>cod.36P9/1608 cod.36HY400 cod.36P9/1608</p> <p>Final length (min. 175mm)</p>
36HY40020...	65	<p>55mm 52mm</p> <p>S 18 9/16 - 18</p> <p>cod.36P9/1604 cod.36HY400 cod.36P9/1607</p> <p>Final length (min. 170mm)</p>
36HY40021...	75	<p>55mm 59mm</p> <p>S 18 9/16 - 18</p> <p>cod.36P9/1604 cod.36HY400 cod.36P9/1606</p> <p>Final length (min. 165mm)</p>
36HY40022...	75	<p>55mm 56mm</p> <p>S 18 9/16 - 18</p> <p>cod.36P9/1604 cod.36HY400 cod.36P9/1608</p> <p>Final length (min. 170mm)</p>
36HY40023...	73	<p>52mm 59mm</p> <p>S 18 9/16 - 18</p> <p>cod.36P9/1607 cod.36HY400 cod.36P9/1606</p> <p>Final length (min. 170mm)</p>
36HY40024...	73	<p>52mm 56mm</p> <p>S 18 9/16 - 18</p> <p>cod.36P9/1607 cod.36HY400 cod.36P9/1608</p> <p>Final length (min. 175mm)</p>

Hose model	$\Delta$ (mm)	
36HY40025...	80	<p>Technical drawing of hose model 36HY40025... The drawing shows a horizontal hose assembly with two 90-degree elbows. The left elbow is labeled 'S 18' and '9/16 - 18'. The right elbow is labeled '9/16 - 18'. The central hose section is labeled 'cod.36HY400'. The two intermediate fittings are labeled 'cod.36P9/1606' and 'cod.36P9/1608'. Dimensions are given as 59mm for the first section, 56mm for the second, and a 'Final length (min. 185mm)' for the entire assembly.</p>
36HY40026...	85	<p>Technical drawing of hose model 36HY40026... The drawing shows a horizontal hose assembly with two straight fittings. Both fittings are labeled 'cod.36P9/1605'. The central hose section is labeled 'cod.36HY400'. The left fitting is also labeled 'S 18' and '9/16 - 18'. Dimensions are given as 63mm for each side section and a 'Final length (min. 185mm)' for the entire assembly.</p>
36HY40027...	78	<p>Technical drawing of hose model 36HY40027... The drawing shows a horizontal hose assembly with two straight fittings. The left fitting is labeled 'S 18' and '9/16 - 18'. The right fitting is labeled 'cod.36P9/1604'. The central hose section is labeled 'cod.36HY400'. The two intermediate fittings are labeled 'cod.36P9/1605'. Dimensions are given as 63mm for the first section, 55mm for the second, and a 'Final length (min. 175mm)' for the entire assembly.</p>
36HY40028...	75	<p>Technical drawing of hose model 36HY40028... The drawing shows a horizontal hose assembly with two 90-degree elbows. The left elbow is labeled 'S 18' and '9/16 - 18'. The right elbow is labeled '9/16 - 18'. The central hose section is labeled 'cod.36HY400'. The two intermediate fittings are labeled 'cod.36P9/1605' and 'cod.36P9/1607'. Dimensions are given as 63mm for the first section, 52mm for the second, and a 'Final length (min. 180mm)' for the entire assembly.</p>
36HY40029...	83	<p>Technical drawing of hose model 36HY40029... The drawing shows a horizontal hose assembly with two 90-degree elbows. The left elbow is labeled 'S 18' and '9/16 - 18'. The right elbow is labeled '9/16 - 18'. The central hose section is labeled 'cod.36HY400'. The two intermediate fittings are labeled 'cod.36P9/1605' and 'cod.36P9/1606'. Dimensions are given as 63mm for the first section, 59mm for the second, and a 'Final length (min. 175mm)' for the entire assembly.</p>
36HY40030...	83	<p>Technical drawing of hose model 36HY40030... The drawing shows a horizontal hose assembly with two 90-degree elbows. The left elbow is labeled 'S 18' and '9/16 - 18'. The right elbow is labeled '9/16 - 18'. The central hose section is labeled 'cod.36HY400'. The two intermediate fittings are labeled 'cod.36P9/1605' and 'cod.36P9/1608'. Dimensions are given as 63mm for the first section, 56mm for the second, and a 'Final length (min. 175mm)' for the entire assembly.</p>

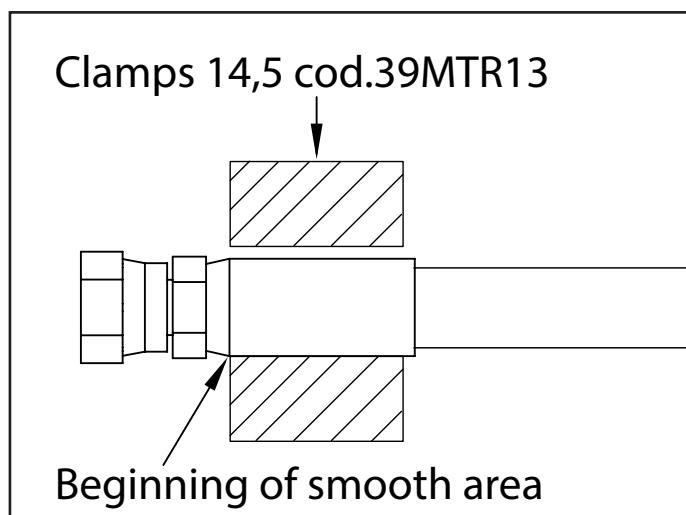
# ASSEMBLY, PRESSING AND FITTING CHECK **36P9/1604**



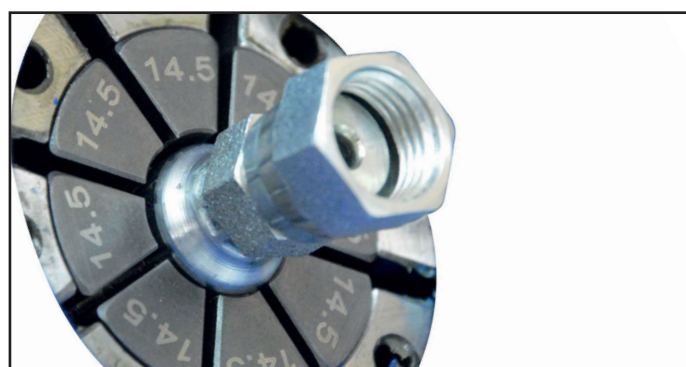
Lubricate the inlet of the fitting to be clamped cod. 36P9/1604.



Insert the hose cod.36HY400 into the fitting to be clamped cod. 36P9/1604 and make sure it is at a complete stop within the fitting.

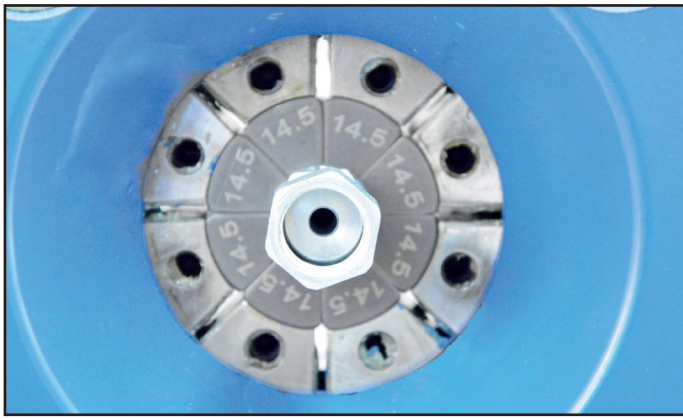


Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, up until the **beginning of the smooth area**.



**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the correct position of the smooth area.**



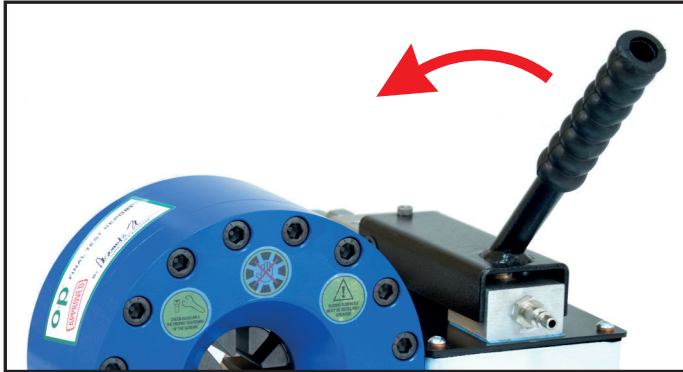
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



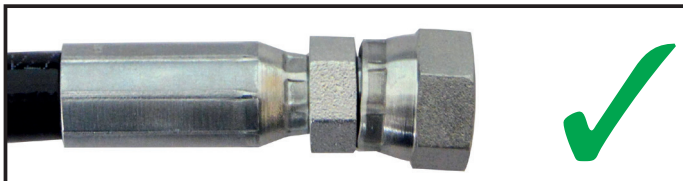
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



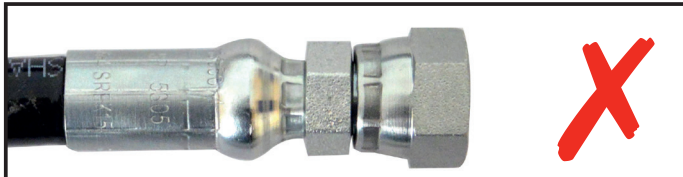
Before pressing the other end of the hose, make sure the clamps are in the correct position.



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 14.22 mm and 14.73 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

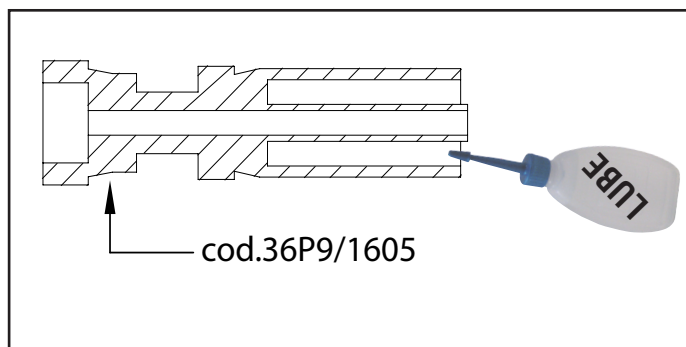
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



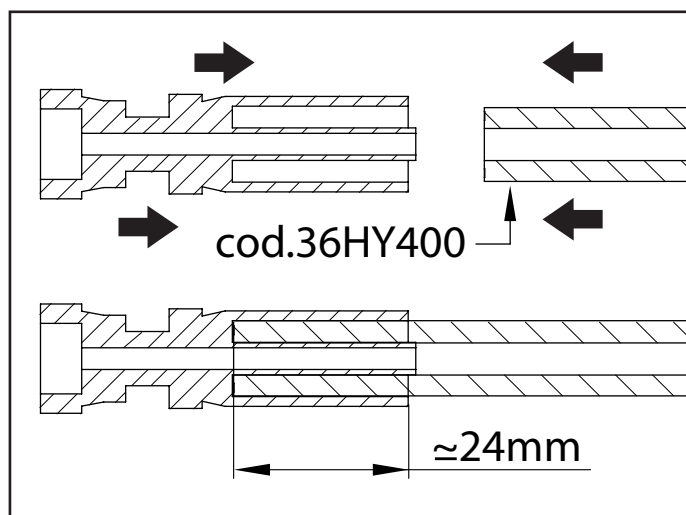
- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.



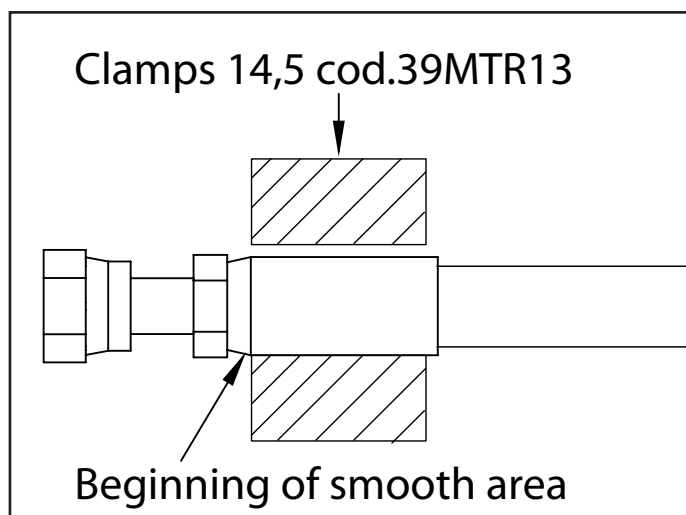
# ASSEMBLY, PRESSING AND FITTING CHECK **36P/1605 - 36P/1608**



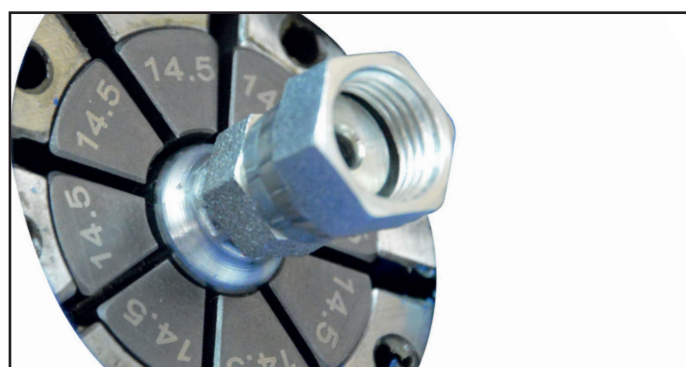
Lubricate the inlet of the fitting to be clamped  
cod. 36P9/1605 - 36P9/1608.



Insert the hose cod.36HY400 into the fitting to  
be clamped cod.36P9/1605 - 36P9/1608 and  
make sure it is at a complete stop within the  
fitting.

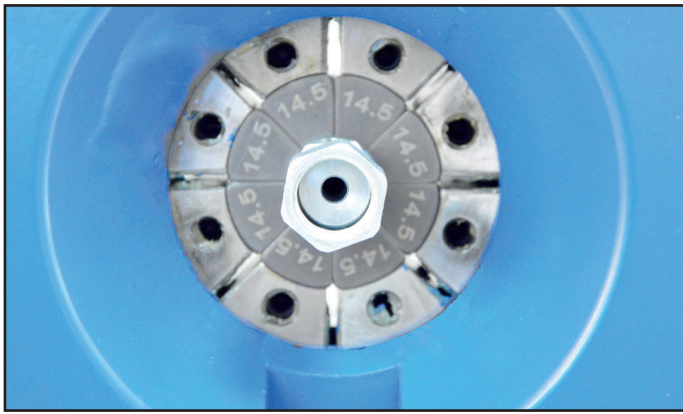


Keep the hose-fitting match unchanged and  
insert the pair into the space inside the clamp,  
**up until the knurling / black mark.**



**Sit** the clamp near the fittings by acting on the  
hydraulic pump.

**Double check the correct position of the  
knurling / black mark.**



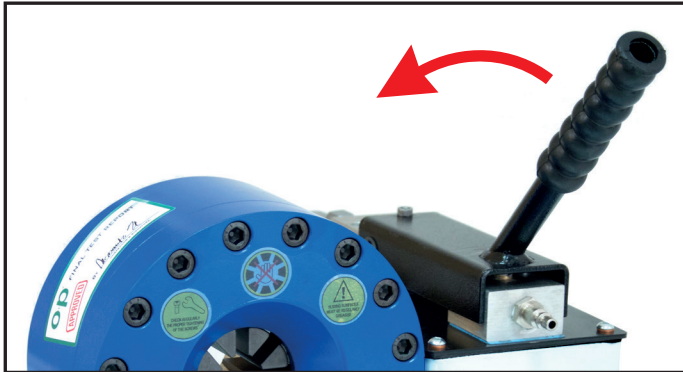
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



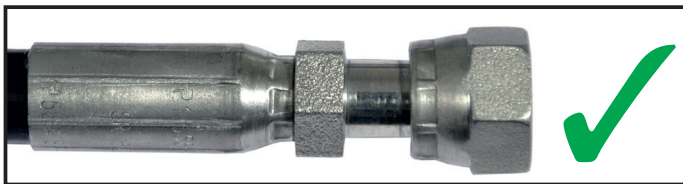
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



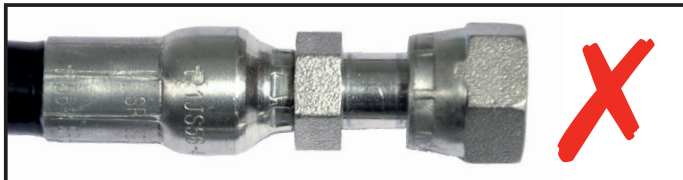
Before pressing the other end of the hose, make sure the clamps are in the correct position.



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 14.22 mm and 14.73 mm**.



Use compressed air to make sure the hose is not clogged.



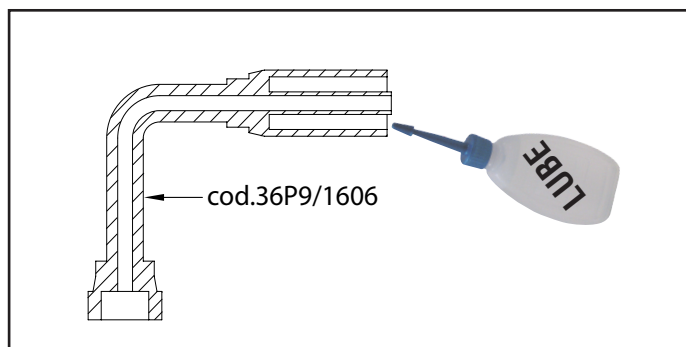
**Double check 100% of the clamped fittings.**

**If the size of the crimped component does not comply with the indicated tolerances, check the following:**

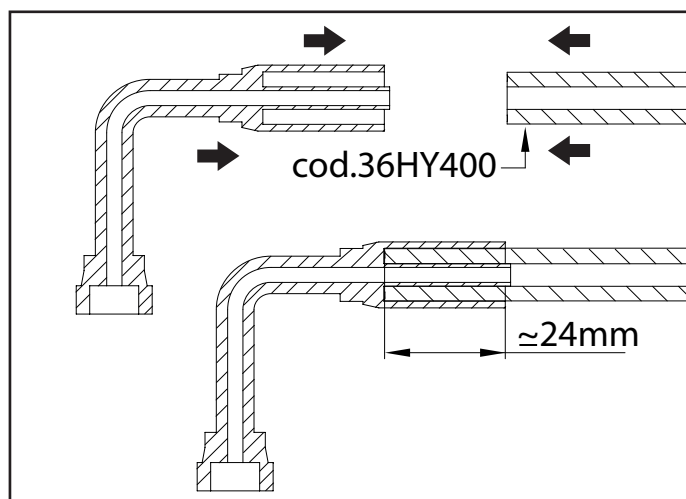


- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

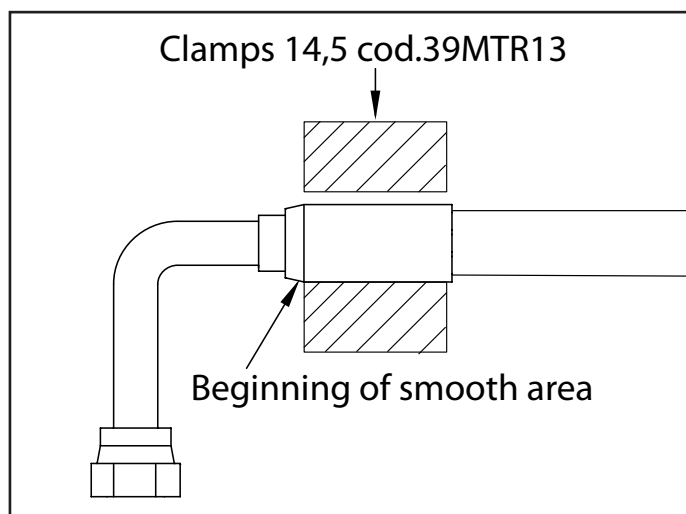
# ASSEMBLY, PRESSING AND FITTING CHECK **36P9/1607 - 36P9/1606**



Lubricate the inlet of the fitting to be clamped  
cod.36P9/1607 - 36P9/1606.



Insert the hose cod.36HY400 into the fitting to  
be clamped cod.36P9/1607 - 36P9/1606 and  
make sure it is at a complete stop within the  
fitting.



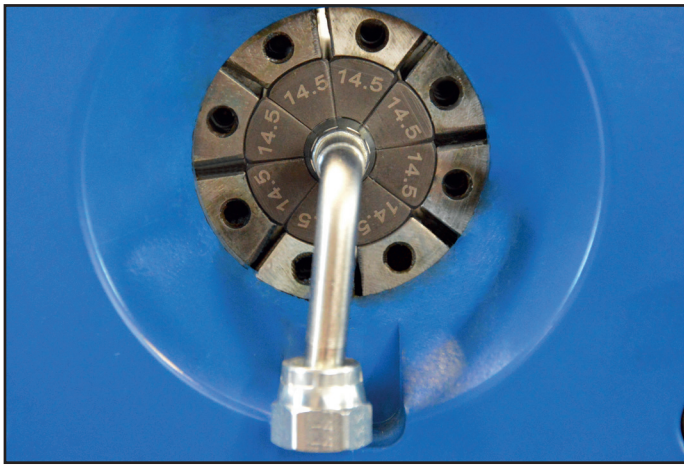
Keep the hose-fitting match unchanged and  
insert the pair into the space inside the clamp,  
**up until the knurling / black mark.**



**Sit** the clamp near the fittings by acting on the  
hydraulic pum.

**Double check the correct position of the  
knurling / black mark.**





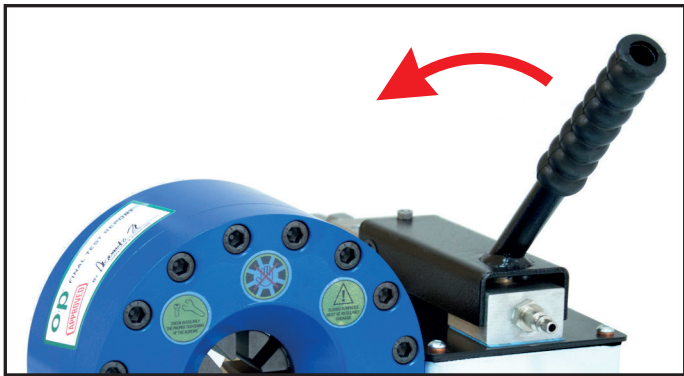
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



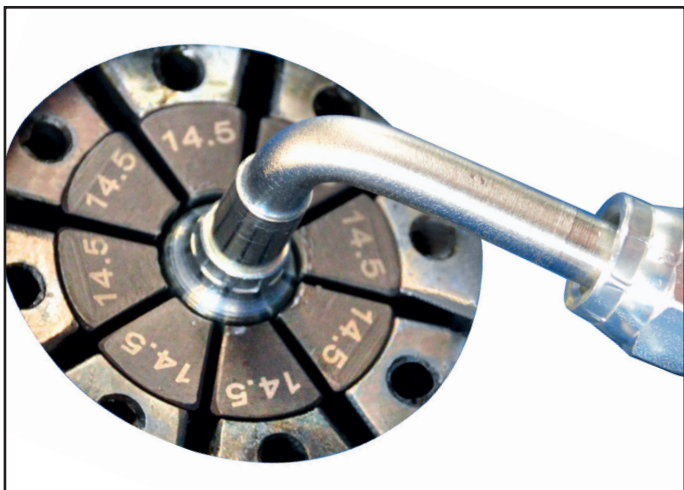
To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



Before pressing the other end of the hose, make sure the clamps are in the correct position.

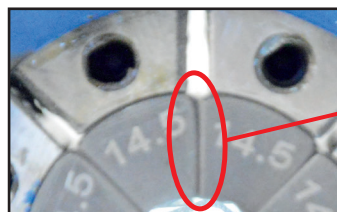


In order to press a fitting cod.36P9/1607 - 36P9/1606, on a hose with an already clamped end, **remove at least three adjacent clamps**.



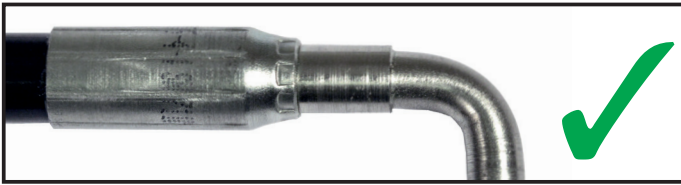
Reassemble the three clamps (previously removed) and proceed with the pressing. Sit the clamp **near** the fittings by acting on the hydraulic pump.

**Double check the correct position of the knurling / black mark**



Clamps at full contact





Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 14.22 mm and 14.73 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

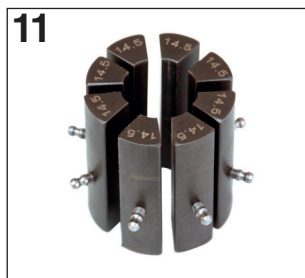
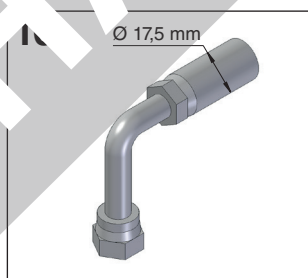
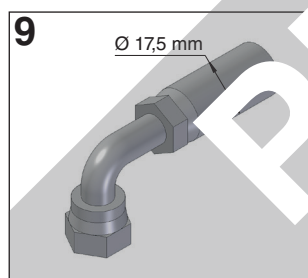
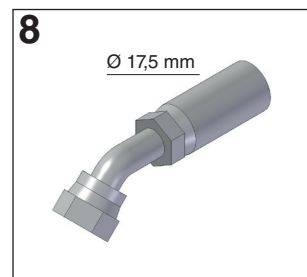
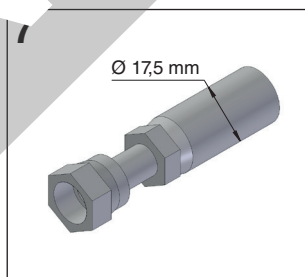
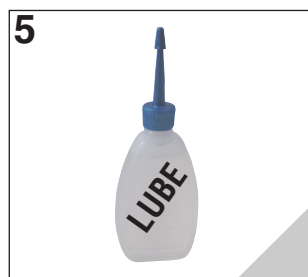
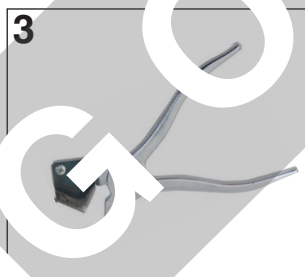
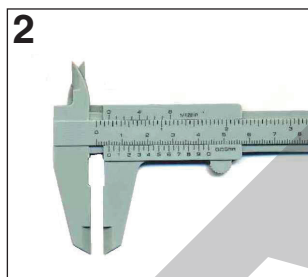
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

# LINKING INSTRUCTIONS FOR HY 400 - ORFS - HOSE Ø 12,7

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (Parker Parflex 520 N-4)	cod.36HY400
5) Lubricant	-
6) Fitting	cod.S-F
7) Fitting	cod.S-FL
8) Fitting	cod.H-F45
9) Fitting	cod.H-F
10) Fitting	cod.H-F20L
11) Clamps 14,5	cod.39MTR13
12) Magnet tool to remove clamps	cod.39MT01A



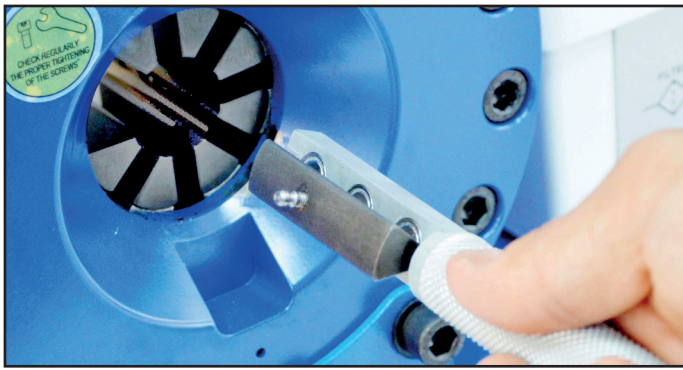
## OPERATING INSTRUCTIONS



Make sure clamps 14,5 - cod.39MTR13 are installed.



Make sure all clamps have the same number.

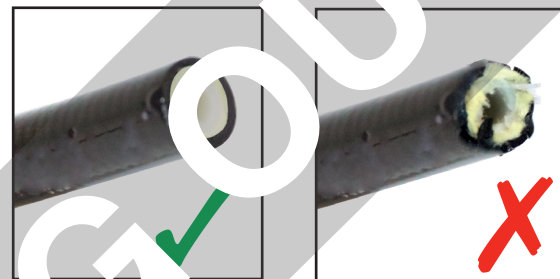


If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



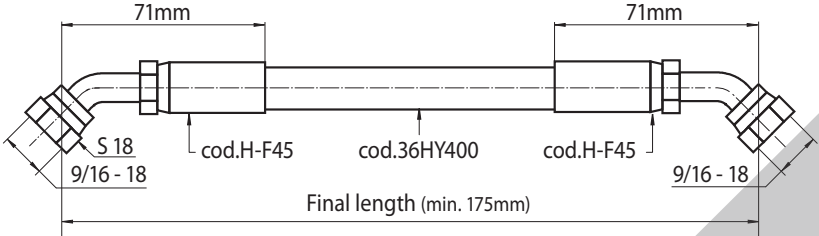
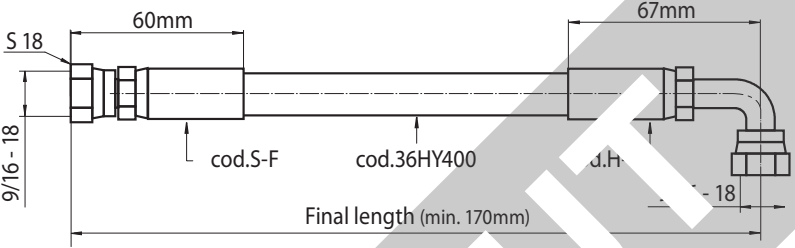
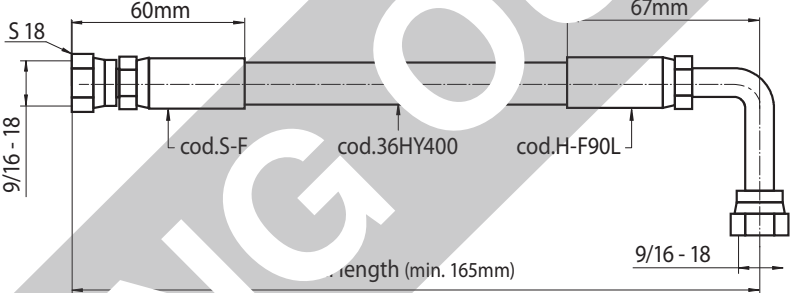
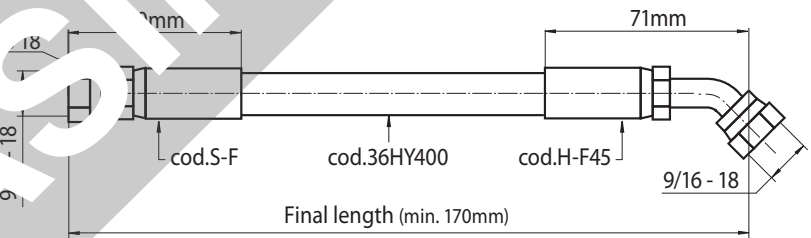
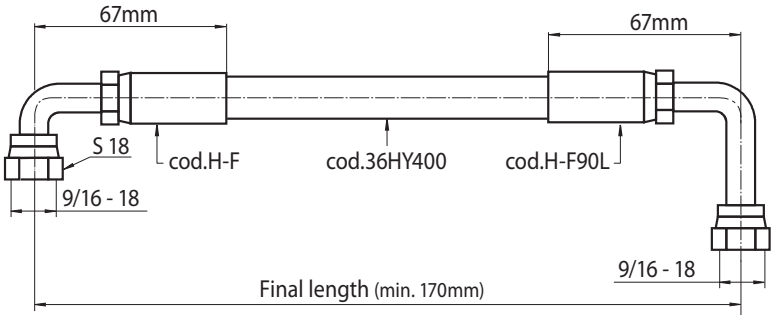
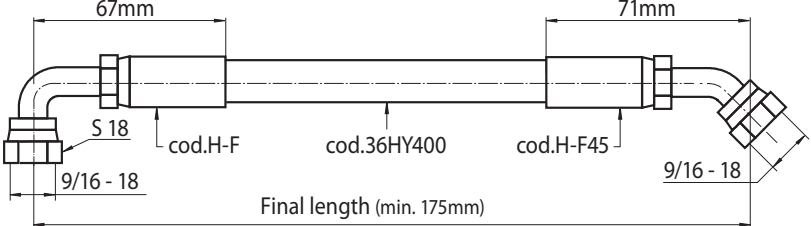
Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



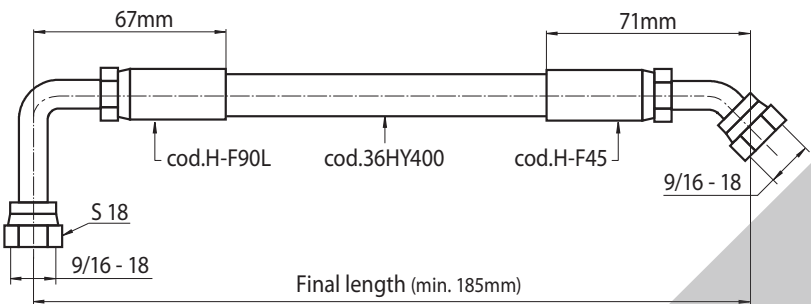
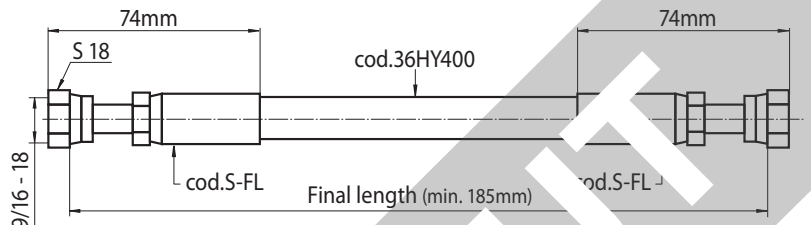
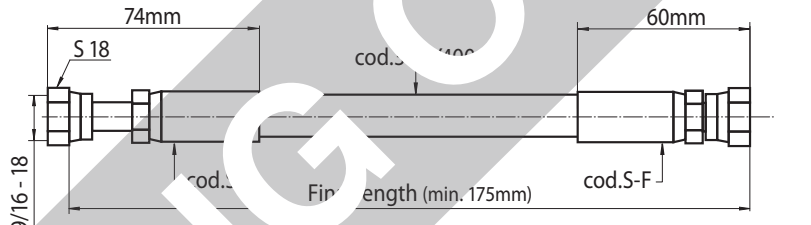
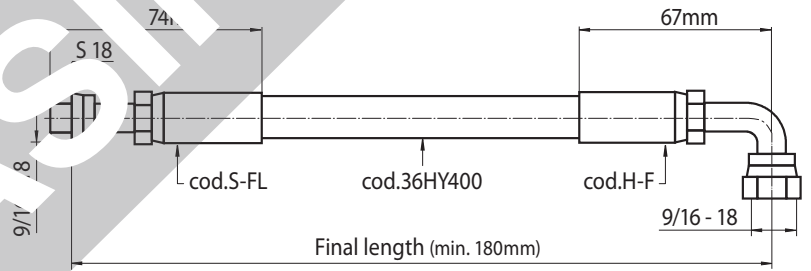
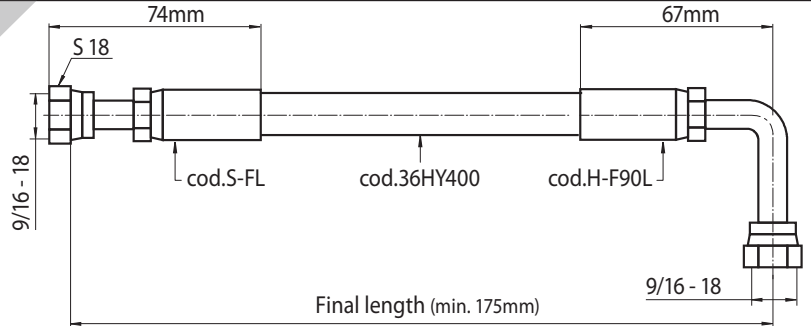
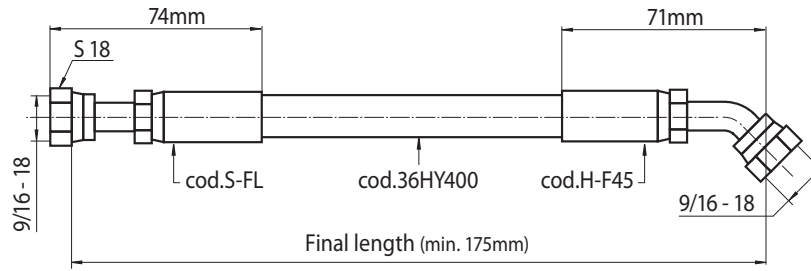
The cut length of the hose must be  $\Delta$  (mm) **shorter** than the final length of the hose including fittings.



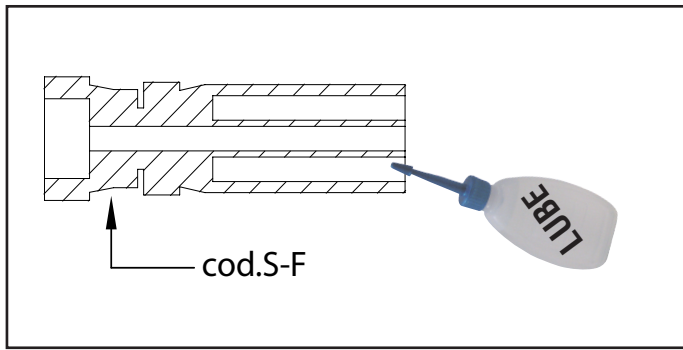
Hose model	$\Delta$ (mm)	
36HY40001...	7	
36HY40002...	85	
36HY40003...	70	

Hose model	$\Delta$ (mm)	
36HY40004...	75	
36HY40005...	75	
36HY40006...	70	
36HY40007...	70	
36HY40008...	75	
36HY40009...	75	

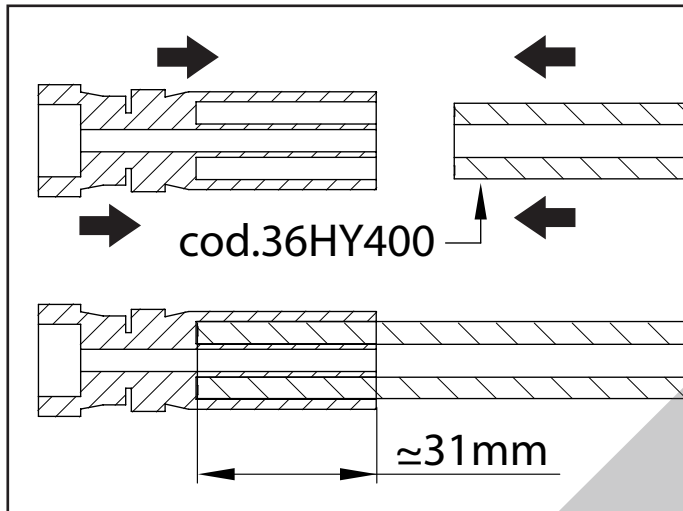


Hose model	$\Delta$ (mm)	
36HY40010...	70	
36HY40011...	85	
36HY40012...	80	
36HY40013...	90	
36HY40014...	85	
36HY40015...	85	

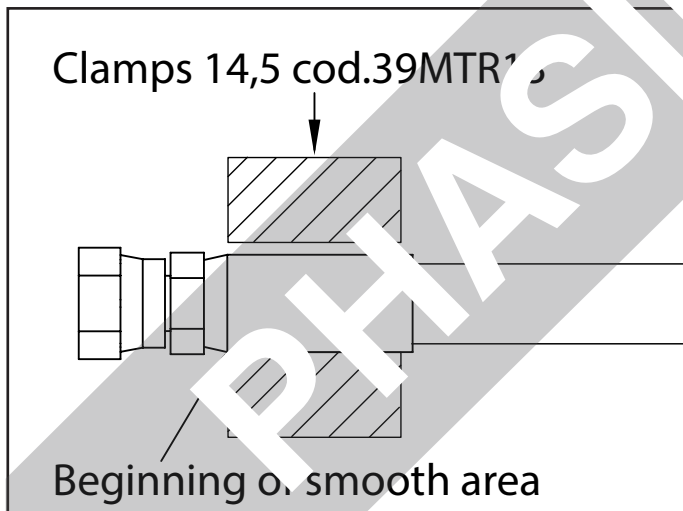
## ASSEMBLY, PRESSING AND FITTING CHECK **S-F**



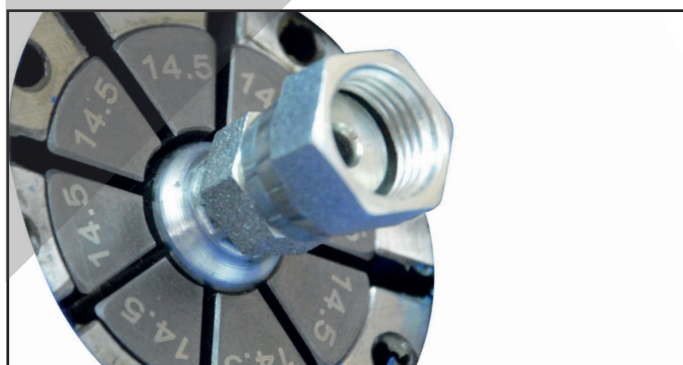
Lubricate the inlet of the fitting to be clamped cod. S-F.



Insert the hose cod.36HY400 into the fitting to be clamped cod. S-F and make sure it is at a complete stop within the fitting.



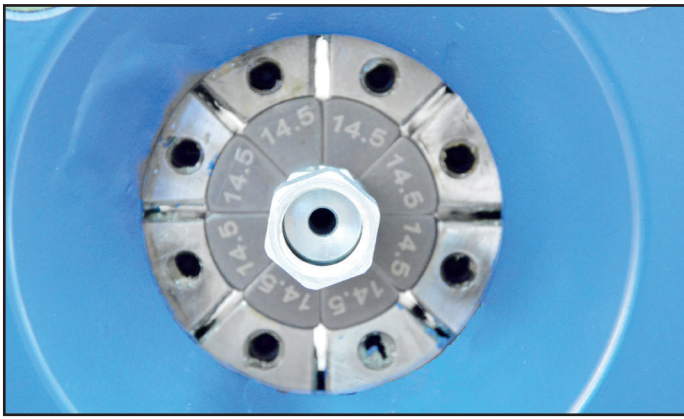
Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, up until the beginning of the smooth area.



**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the correct position of the smooth area.**





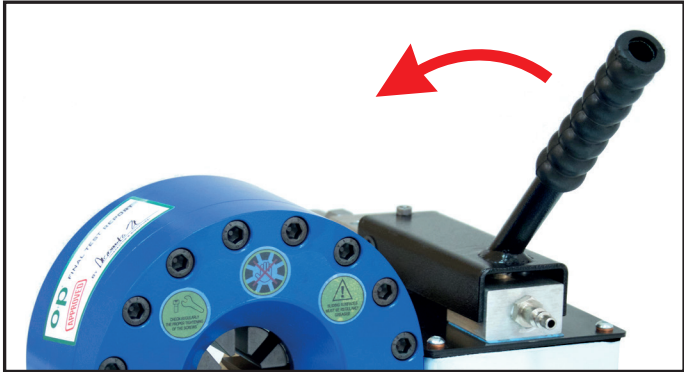
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



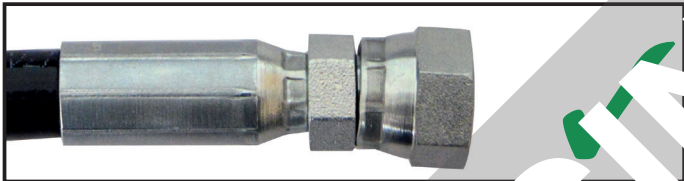
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



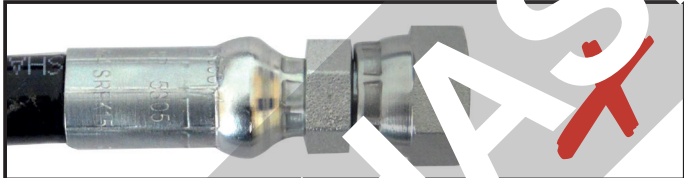
Before pressing the other end of the hose, make sure the clamps are in the correct position.



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 14.22 mm and 14.73 mm**.



Use compressed air to make sure the hose is not clogged.



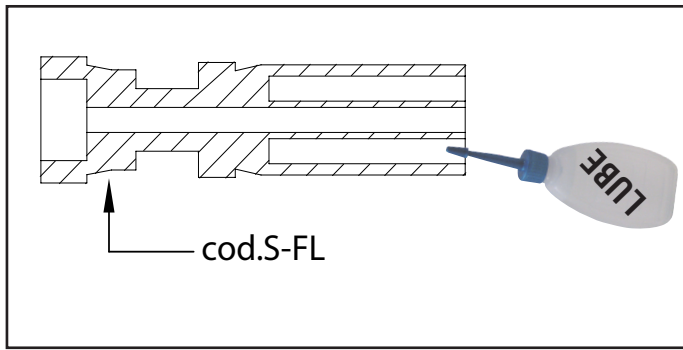
**Double check 100% of the clamped fittings.**

**If the size of the crimped component does not comply with the indicated tolerances, check the following:**

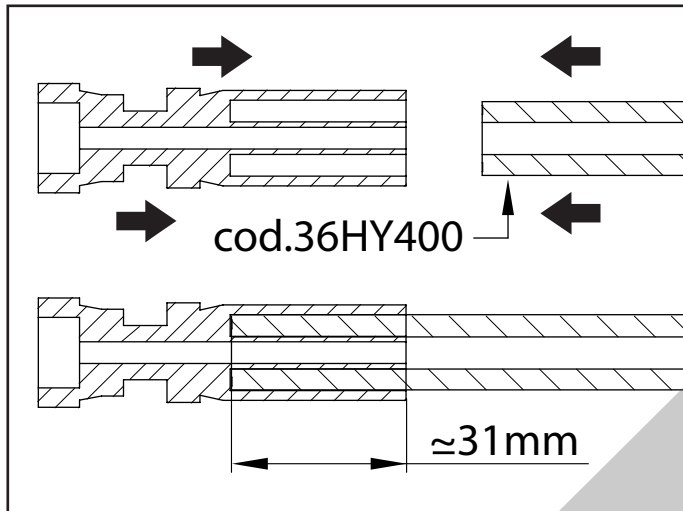


- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

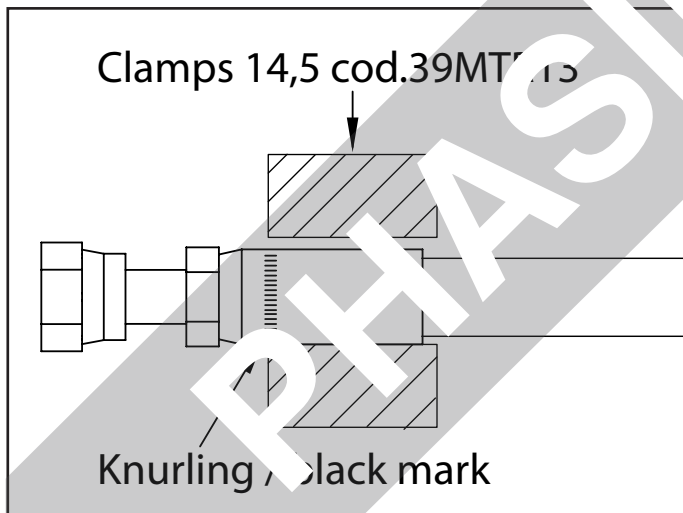
## ASSEMBLY, PRESSING AND FITTING CHECK **S-FL / HF-45**



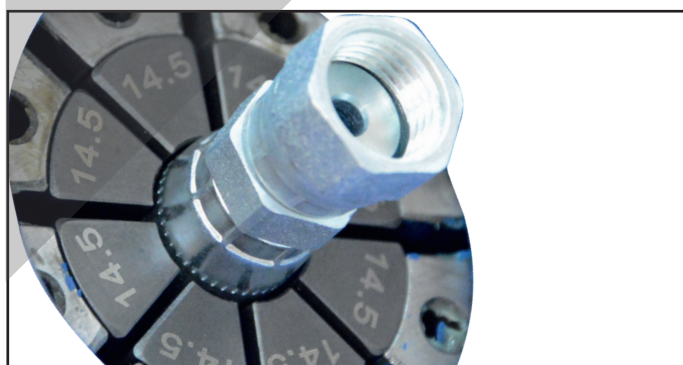
Lubricate the inlet of the fitting to be clamped  
cod. S-FL / HF-45.



Insert the hose cod.36HY400 into the fitting to  
be clamped cod.S-FL / HF-45 and make sure  
it is at a complete stop within the fitting.



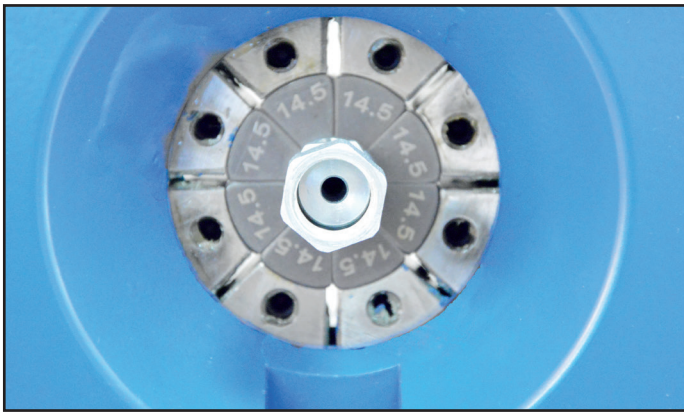
Keep the hose-fitting match unchanged and  
insert the pair into the space inside the clamp,  
**up until the knurling / black mark.**



**Sit** the clamp near the fittings by acting on the  
hydraulic pump.

**Double check the correct position of the  
knurling / black mark.**





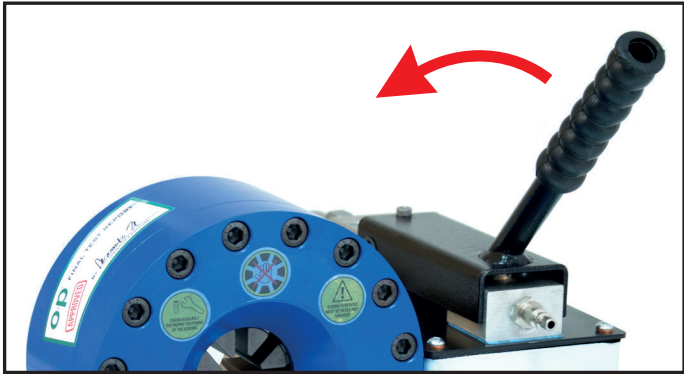
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



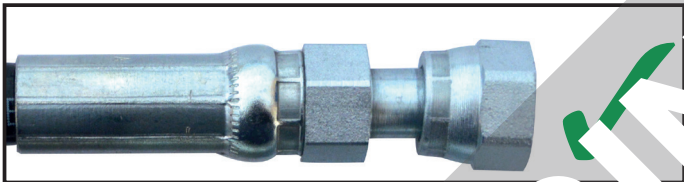
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



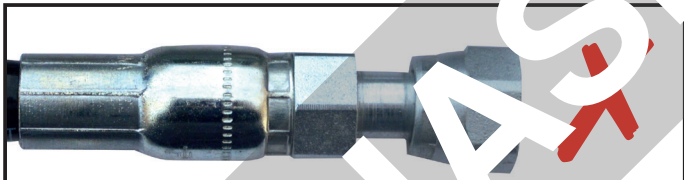
Before pressing the other end of the hose, make sure the clamps are in the correct position.



Use the images to make sure the fitting is being crimped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 14.22 mm and 14.73 mm**.



Use compressed air to make sure the hose is not clogged.



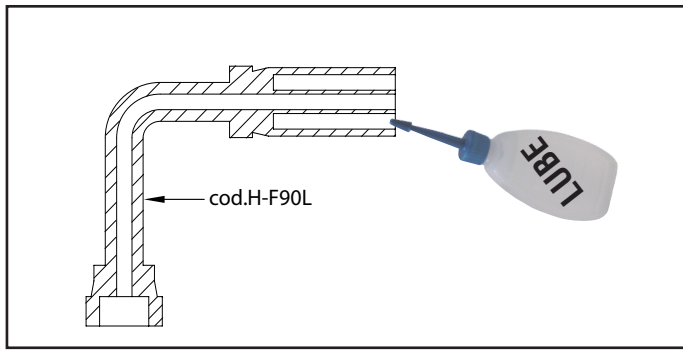
**Double check 100% of the clamped fittings.**

If the size of the crimped component does not comply with the indicated tolerances, check the following:

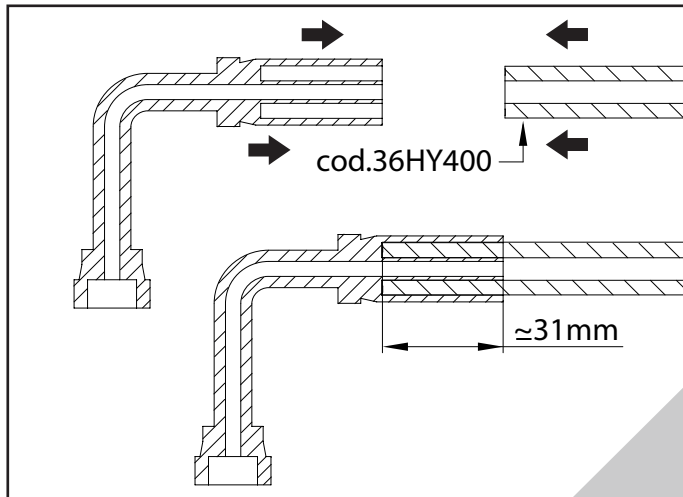


- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

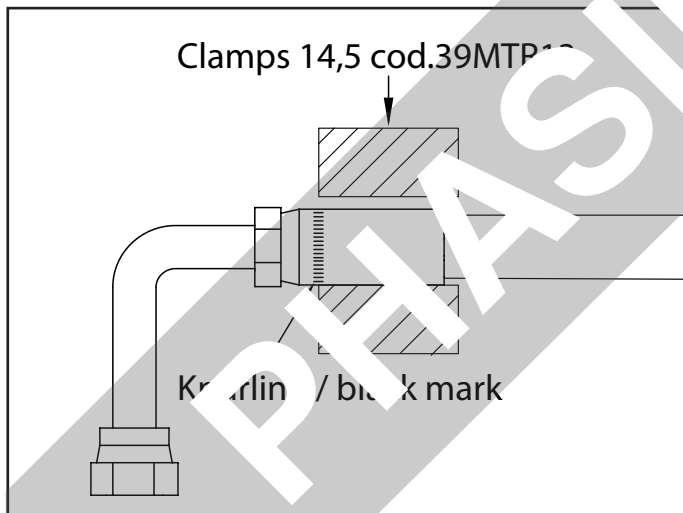
## ASSEMBLY, PRESSING AND FITTING CHECK **H-F / H-F90L**



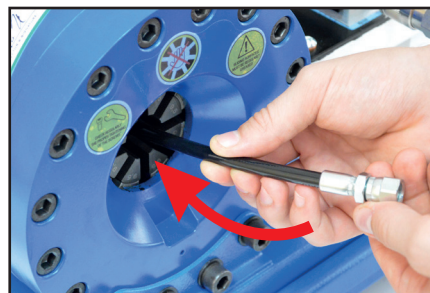
Lubricate the inlet of the fitting to be clamped  
cod.H-F / H-F90L.



Insert the hose cod.36HY400 into the fitting to  
be clamped cod.H-F / H-F90L and make sure  
it is at a complete stop within the fitting.



Keep the hose-fitting match unchanged and  
insert the pair into the space inside the clamp,  
up until the **knurling / black mark**.



**Sit** the clamp near the fittings by acting on the  
hydraulic pump.

**Double check the correct position of the  
knurling / black mark.**



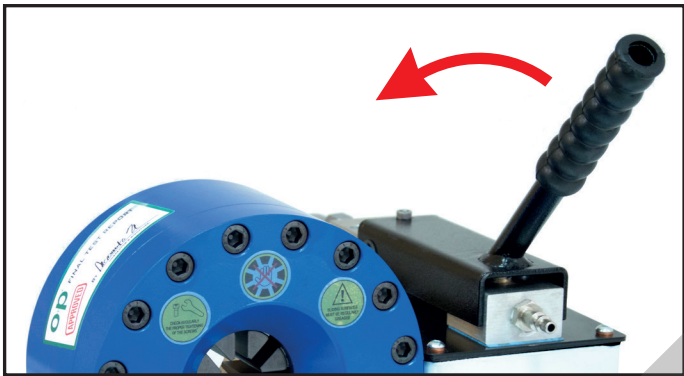
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



Before pressing the other end of the hose, make sure the clamps are in the correct position.

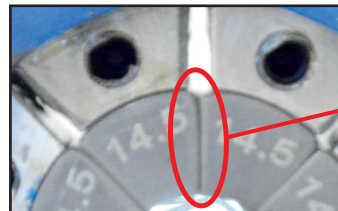


In order to press a fitting cod.H-F / H-F90L, on a hose with an already clamped end, **remove at least three adjacent clamps**.



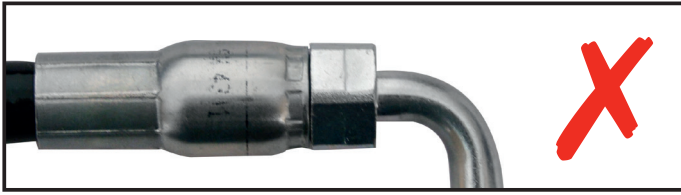
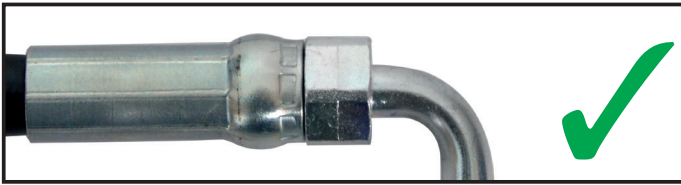
Reassemble the three clamps (previously removed) and proceed with the pressing. Sit the clamp **near** the fittings by acting on the hydraulic pump.

**Double check the correct position of the knurling / black mark**



Clamps at full contact





Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.



Make sure the diameter of the clamped fitting is **between 14.22 mm and 14.73 mm**.



Use compressed air to make sure the hose is not damaged.



Double check 100% of the clamped fittings.

If the size of the crimped component does not comply with the indicated tolerances, check the following:



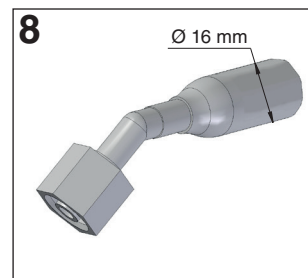
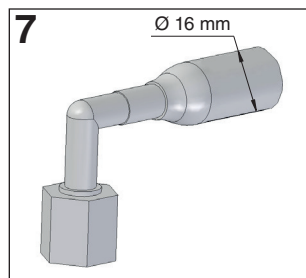
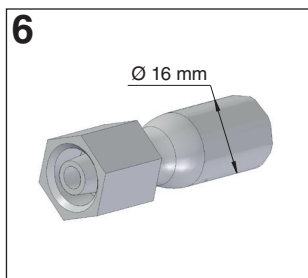
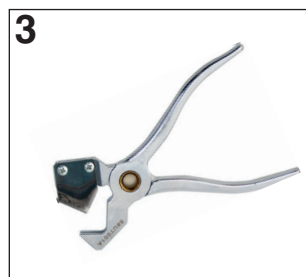
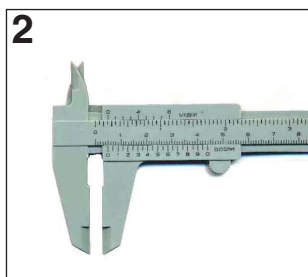
- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.



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# LINKING INSTRUCTIONS FOR HY 500 - EO 24° - HOSE Ø 11

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (Parker Parflex 520N-3 DN5)	cod.36HY500
5) Lubricant	-
6) Fitting	cod.36P2401
7) Fitting	cod.36P2402
8) Fitting	cod.36P2403
9) Clamps 12,2	cod.39MTR12
10) Magnet tool to remove clamps	cod.58UT022A



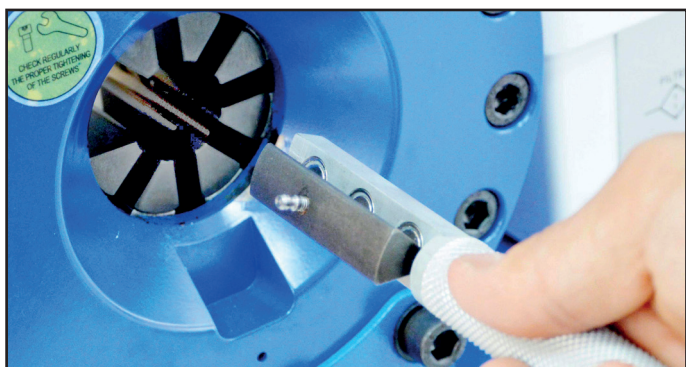
## OPERATING INSTRUCTIONS



Make sure clamps 12,2 - cod.39MTR12 are installed.



Make sure all clamps have the same number.



If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



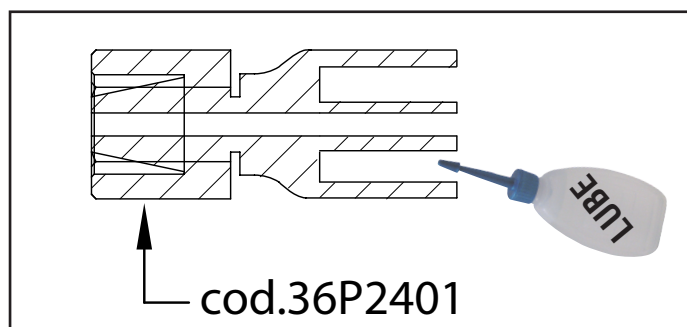
The cut length of the hose must be  $\Delta$  (mm) **shorter** than the final length of the hose including fittings.



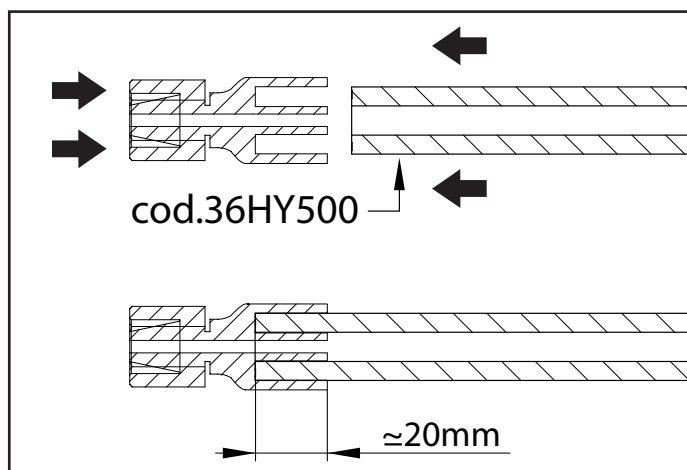
Hose model	$\Delta$ (mm)	
36HY50001...	50	
36HY50002...	70	
36HY50003...	90	

Hose model	$\Delta$ (mm)	
36HY50004...	60	
36HY50005...	80	
36HY50006...	70	

## ASSEMBLY, PRESSING AND FITTING CHECK **36P24..**



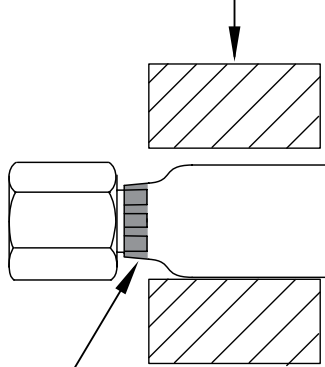
Lubricate the inlet of the fitting to be clamped  
cod. 36P24..



Insert the hose cod.36HY500 into the fitting to  
be clamped cod.36P24.. and make sure it is at  
a complete stop within the fitting.

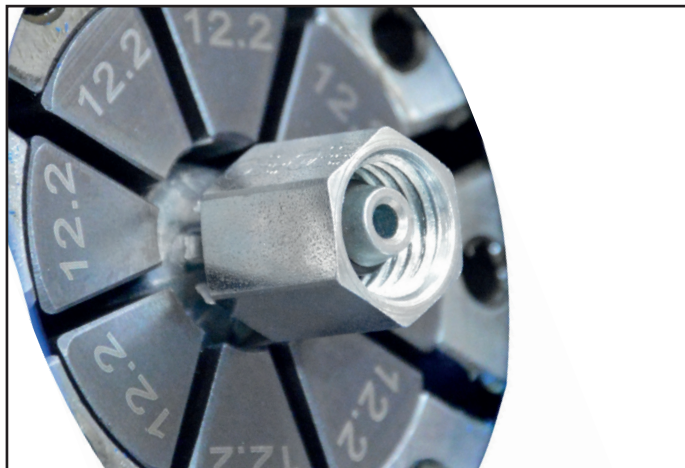
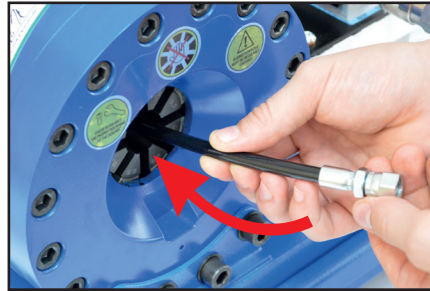


Clamps 12,2 cod.39MTR12



Pressing limit

Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **up until the indicated pressing limit.**



**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the correct fitting position.**



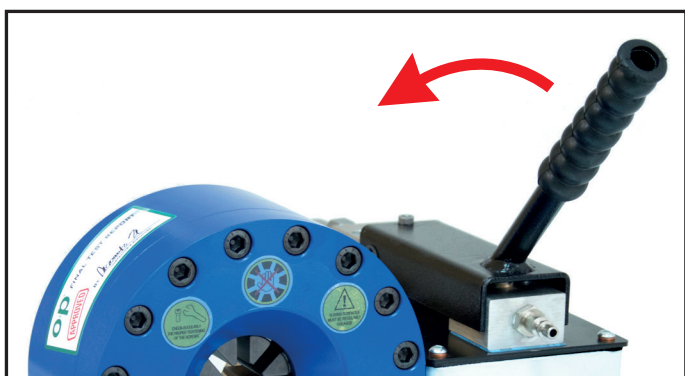
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



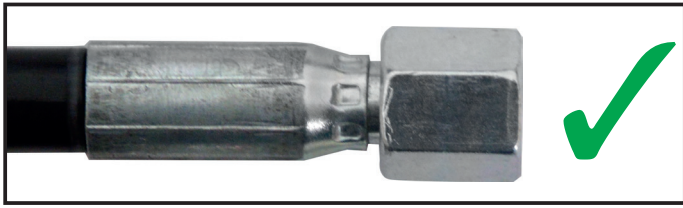
Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



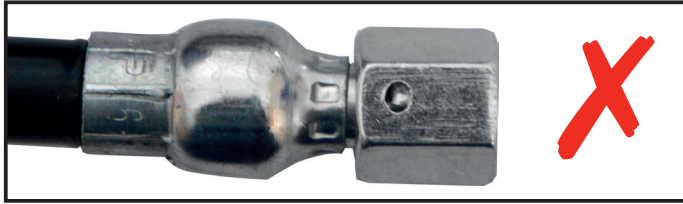
Before pressing the other end of the hose, make sure the clamps are in the correct position.



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one



Make sure the diameter of the clamped fitting is **between 12.10 mm and 12.40 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

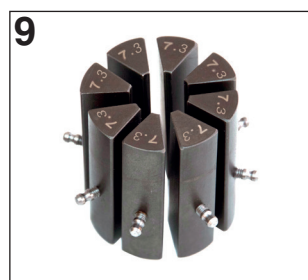
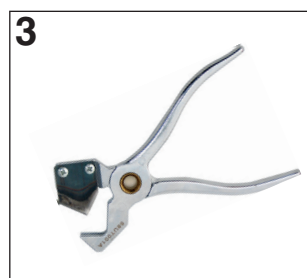
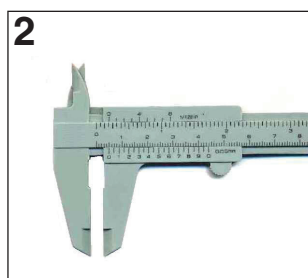
**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



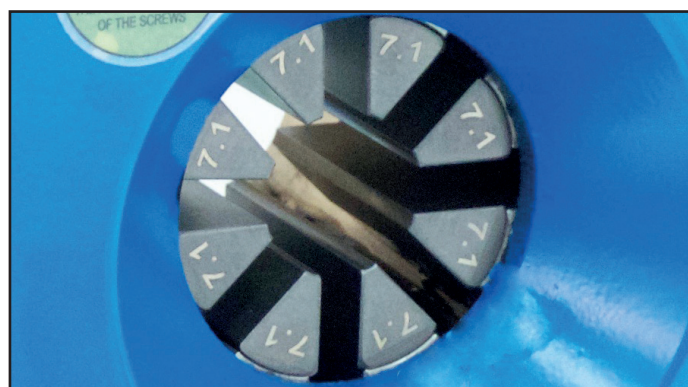
- make sure the clamps are the correct ones for the fittings and hose used.
- make sure the clamps are mounted properly.
- make sure the clamps are not damaged.
- double check the pressure of the compressed air.

# LINKING INSTRUCTIONS FOR TSM - ORFS - HOSE Ø 5,5

INSTRUMENTS NEEDED	
1) Hose press	cod.39PR06
2) Caliber	-
3) Shears	cod.58UT001A
4) Hose (Special Springs micro hose)	cod.36TSM
5) Lubricant	-
6) Fitting	cod.36P9/1601
7) Fitting	cod.36P9/1602
8) Fitting	cod.36P9/1603
9) Clamps 7,3	cod.39MTR10
10) Magnet tool to remove clamps	cod.58UT022A



## OPERATING INSTRUCTIONS:

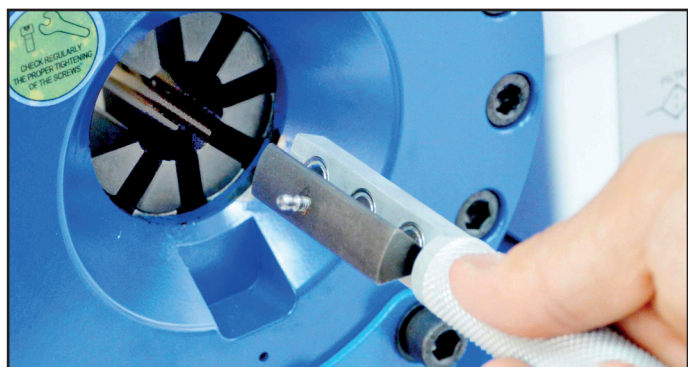


Make sure clamps 7,3 - cod.39MTR10 are installed.



Make sure all clamps have the same number.





If not, substitute them by releasing the wrong clamps with the appropriate magnet tool cod.**58UT022A**:

- 1) Clasp the clamp with the magnet tool.
- 2) Unhook the clamp from its position.
- 3) Position the correct clamp and clasp with magnet tool.



Cut the perforated hose assertively, without filaments and / or imperfections, with the appropriate shear cod.**58UT001A**.



The cut length of the hose must be  $\Delta$  (mm) **shorter** than the final length of the hose including fittings.

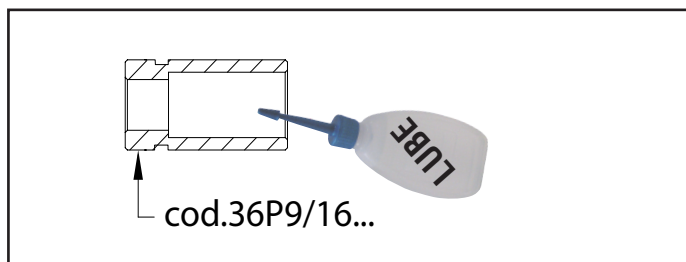


Hose model	$\Delta$ (mm)	
36TSM9/1601...	55	
36TSM9/1602...	75	
36TSM9/1603...	90	

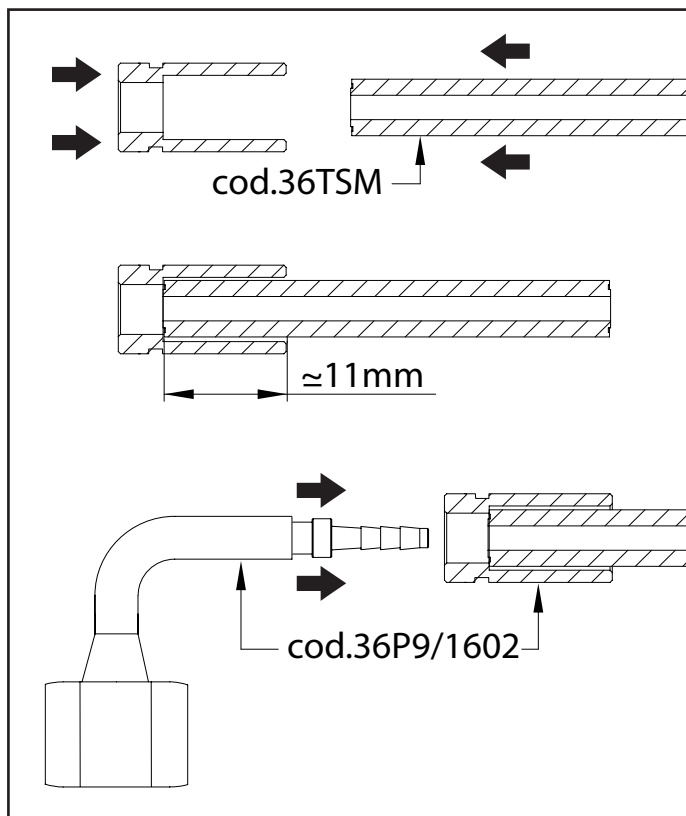


Hose model	$\Delta$ (mm)	
36TSM9/1604...	55	<p>Technical drawing of hose model 36TSM9/1604... The drawing shows a horizontal hose assembly with a 90-degree elbow on the left and a 45-degree elbow on the right. The left elbow has a vertical height of 32mm and a horizontal offset of 40mm. The right elbow has a vertical height of 32mm and a horizontal offset of 33mm. The hose is labeled with 'cod.36TSM' in the center, 'cod.36P9/1602' near the left elbow, and 'cod.36P9/1601' near the right elbow. The connection at the right elbow is labeled '9/16 - 18'. The total length is indicated as 'Final length (min. 120mm)'.</p>
36TSM9/1605...	75	<p>Technical drawing of hose model 36TSM9/1605... The drawing shows a horizontal hose assembly with 45-degree elbows on both ends. The left elbow has a vertical height of 18mm and a horizontal offset of 52mm. The right elbow has a vertical height of 32mm and a horizontal offset of 40mm. The hose is labeled with 'cod.36TSM' in the center, 'cod.36P9/1603' near the left elbow, and 'cod.36P9/1602' near the right elbow. Both connection points are labeled '9/16 - 18'. The total length is indicated as 'Final length (min. 140mm)'.</p>
36TSM9/1606...	60	<p>Technical drawing of hose model 36TSM9/1606... The drawing shows a horizontal hose assembly with 90-degree elbows on both ends. Both elbows have a vertical height of 32mm and a horizontal offset of 40mm. The hose is labeled with 'cod.36TSM' in the center, 'cod.36P9/1602' near both elbows, and both connection points are labeled '9/16 - 18'. The total length is indicated as 'Final length (min. 125mm)'.</p>

## ASSEMBLY, PRESSING AND FITTING CHECK **36P9/16..**

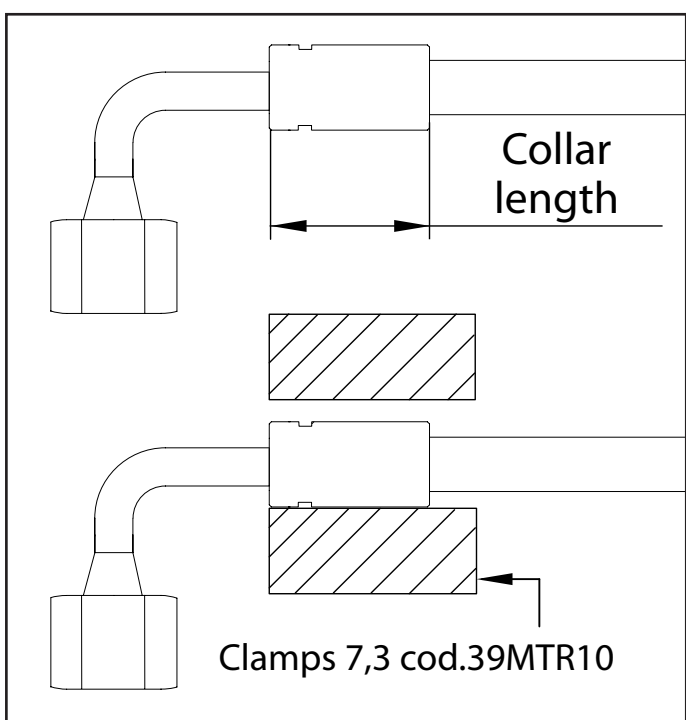


Lubricate the inlet of the fitting to be clamped cod.36P9/16...



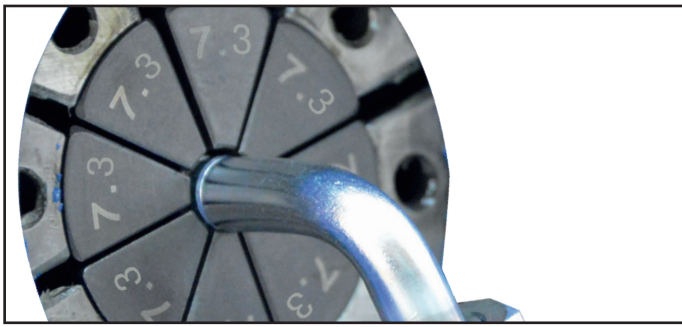
Insert the hose cod.36TSM into the fitting to be clamped cod.36P9/16.. and make sure it is at a complete stop within the fitting.

Assemble the remaining parts of the fitting cod.36P9/16 as shown.



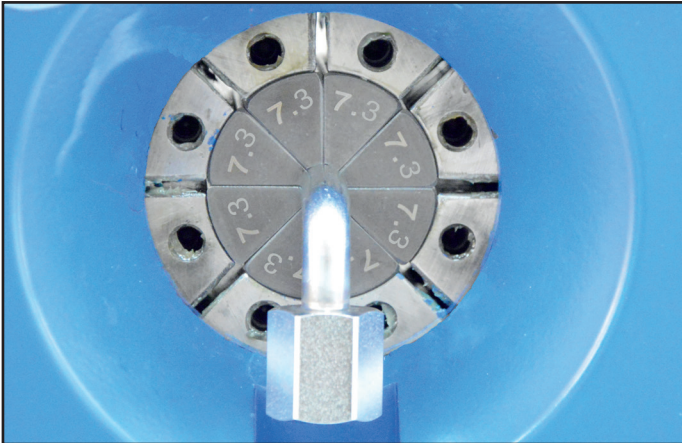
Keep the hose-fitting match unchanged and insert the pair into the space inside the clamp, **for the full length of the collar.**





**Sit** the clamp near the fittings by acting on the hydraulic pump.

**Double check the correct position of the collar.**



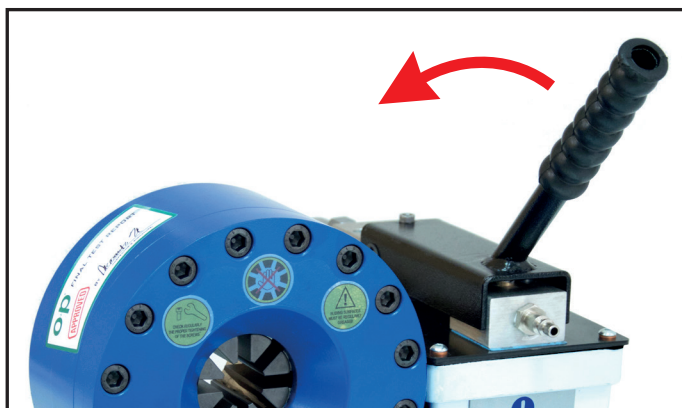
Then **press** the pump handle until the clamps are in **full contact**.



Clamps at full contact



Pressing on the pump handle, even after the full contact between clamps, may cause damage to the press.



To retract the fittings and remove the clamped hose, press the pump lever in the opposite direction.



Do the clamping again in a new piece of hose and throw the wrong one away.



Use the images to make sure the fitting is being clamped correctly.

If the pressing is incorrect the component **CANNOT** be used.

Clamp a new piece of hose and throw away the old one.





Make sure the diameter of the clamped fitting is **between 7.10 mm and 7.30 mm**.



Use compressed air to make sure the hose is not clogged.



**Double check 100% of the clamped fittings.**

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**If the size of the crimped component does not comply with the indicated tolerances, check the following:**



- make sure the clamps are the correct ones for the fittings and hose used.
  - make sure the clamps are mounted properly.
  - make sure the clamps are not damaged.
  - double check the pressure of the compressed air.
-



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## **EUROPE**

Headquarter  
Special Springs S.r.l.  
Via Nardi, 124/A  
36060 Romano d'Ezzelino (VI) - ITALY  
tel. +39 0424 539181  
email: [info@specialsprings.com](mailto:info@specialsprings.com)  
[www.specialsprings.com](http://www.specialsprings.com)

French Subsidiary  
Special Springs France  
Impasse de la Birbadière  
49650 Allonnes - FRANCE  
Ph. +33 (0)6 37 62 76 62  
email: [contact@specialsprings.fr](mailto:contact@specialsprings.fr)  
[www.specialsprings.com](http://www.specialsprings.com)

## **AMERICA**

North American Subsidiary  
Special Springs LLC  
7707 Ronda Drive, Canton  
Michigan 48187 - USA  
Ph. +1 734.892.2324  
email: [info@specialspringsna.com](mailto:info@specialspringsna.com)  
[www.specialspringsna.com](http://www.specialspringsna.com)

South American Subsidiary  
Special Springs do Brasil  
Avenida dom Pedro I, 2156 - Vila Pires  
09130-012 Santo André / SP - BRASIL  
Ph. +55 11 2324 3545  
email: [comercial@specialsprings.com.br](mailto:comercial@specialsprings.com.br)  
[www.specialsprings.com.br](http://www.specialsprings.com.br)

## **ASIA**

Indian Subsidiary  
Global Special Springs pvt. Ltd.  
Survay no. 69/2 - Chandarda, Tal. Kadi  
Dist. Mehesana (Ahmedabad - Mehesana Highway)  
Gujarat, 382705 - INDIA  
Ph. +91 2764 273065  
email: [info@globalspecialsprings.com](mailto:info@globalspecialsprings.com)  
[www.specialsprings.com](http://www.specialsprings.com)