Operating Manual



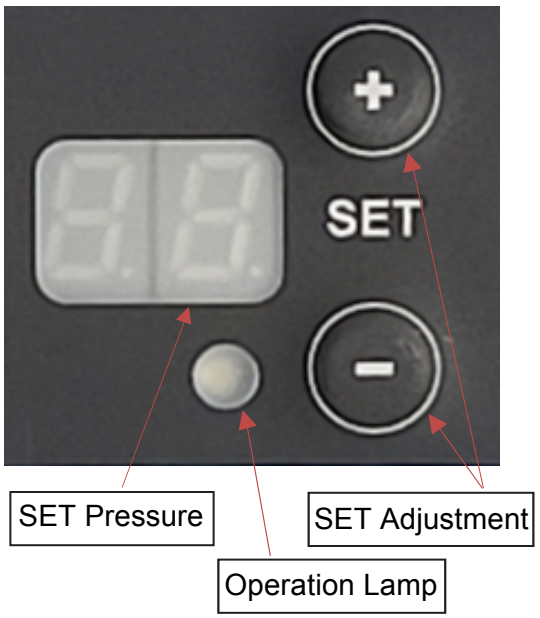
Hy-Lok Pre-Swaging Gun-II

R1.0_EN

Apr. 2024

1. Operation

1.1 Description of the Controls





1.2 Pre-Swaging Pressure Adjustment

Set Pressure(Hy-Lok Tube Fitting)														
in.	1/4	5/16	3/8	1/2	5/8			3/4		7/8	1	1-1/4		1-1/2
mm	6.0	8.0	10.0	12.0	14.0	15.0	16.0	18.0	20.0	22.0	25.0	30.0	32.0	38.0
Dial No.	3	4	5	6	7			11		12	13	15	16	18

1.3 Standard Tightening Mode

- The machine handle must be aligned in a Vertical position.



Vertical Position.

1.4 Snug Tightening Mode

- The machine handle must be aligned in a Horizontal position.

  If high pressure Gas service or high safety is required.



Horizontal Position.

2. Set up Pre-Swaging Gun II

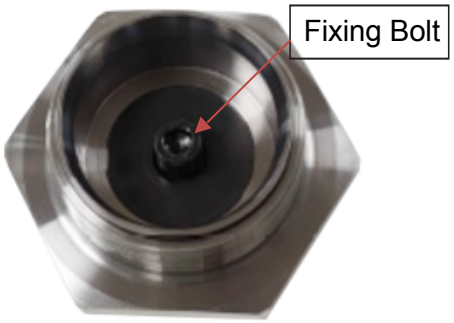
- Power ON.

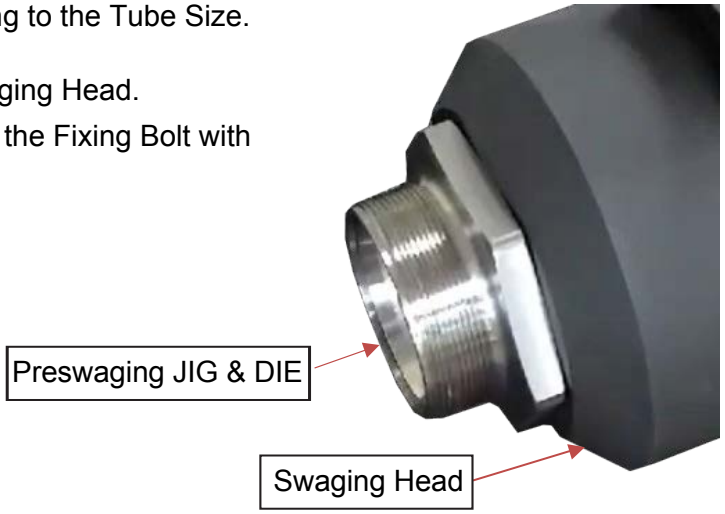
  Unlock the Locking Lever.
  Press Power Button for a second.
  SET Pressure Display will be ON.





- Select the preswaging JIG & DIE according to the Tube Size.
- Install preswaging JIG & DIE into the Swaging Head.
  Tighten the JIG with a wrench and tighten the Fixing Bolt with the allen key.





- Adjust SET Pressure according to the Tube size in the table attached on the machine.
  Example : 1/2 inch Tube size SET Pressure is 6

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mm	6.0	8.0	10.0	12.0	14.0	15.0	16.0	18.0	20.0	22.0	25.0	30.0	32.0	38.0
Dial No.	3	4	5	6	7			11		12	13	15	16	18



3. Pre-Swaging Procedure

Step 1. Repeat Pre-Swaging Procedure

- Changing the Standard Tightening Mode

  The machine handle must be aligned in a Vertical position.



Vertical Position.

- Hand Tight the Nut & Ferrule set
  Insert the Tubing until it is Bottomed up in the preswaging JIG.

  (CAUTION)
  If Tubing is Not Bottomed up in the Pre-Swaging JIG.
  Leakage may occur when the Fitting is being Installed.



- Unlock the Locking Lever.
- Press the START Button.
- Squeeze START Button until the automatic release happens.
  Release the START Button when Green Light Flash.





- Firmly press Release Button and release the internal pressure.

  (CAUTION)
  If the pressure is not fully released, the START Button will not start a new cycle.(Red Light Flash)



Step 2. Assembly Procedure

- Remove the preswaged Tubing from the preswaging JIG.
  Check the preswaged Tubing.
  Adjust SET pressure again if needed.

  Install the preswaged Tubing into the Fitting.
  Hand tighten the Nut, then with a wrench tighten 1/2 turn to complete the installation.

