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"Your source for workplace solutions"

HY-SERIES, HYDRAULIC PINCH-OFF TOOLS OPERATION AND ASSEMBLY

The HY-Series tools are designed to pinch-off and hermetically seal OFHC copper or soft aluminum tubing in diameters ranging from 0.187" - 0.500". The hydraulic pumps are activated by compressed air (80 p.s.i. Maximum).

Models include:

- HY-187 and HY-187-F* (for tube diameters 0.187" or smaller)
 - HY-250 and HY-250-F* (for tube diameters 0.250" or smaller)
 - HY-500 and HY-500-F* (for tube diameters 0.375" - 0.500")
- * = Hydraulic pump with remote, pneumatic footswitch option

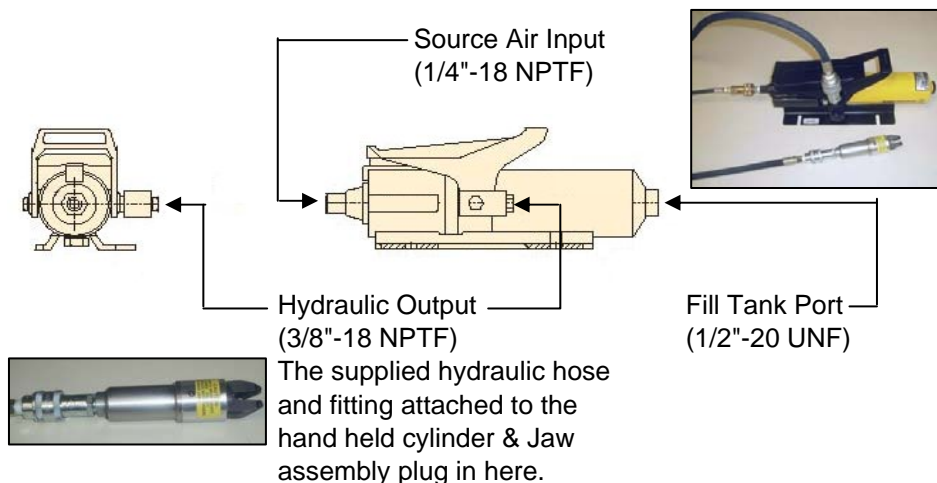
When ordered as a complete system, the pump is preset with the proper hydraulic pressure.
DO NOT ALTER THE PUMP PRESSURE. Doing so will void the warranty on the tool.

Each HY-series tool includes:

- (1) Hydraulic / Pneumatic Pump (Select standard or remote footswitch model)
 - (1) Hand-held power pack and (1) set of pinch-off jaws
 - (1) Hydraulic hose and quick disconnect fittings to connect power pack to hydraulic pump.
- The air hose and fittings to connect the source air to the pump are not included.*

Below is a schematic that details the connection ports for the source air and the hand-held power pack & jaw assembly.

STANDARD "PA-SERIES" PUMP Foot Peddle mounted on top of pump



**HY-SERIES, HYDRAULIC PINCH-OFF TOOLS
OPERATION AND ASSEMBLY**

PA-Series Pump / Tool Operation

The HY-series tools are shipped completely assembled and ready to use

The customer will need to install a Quick-Disconnect nipple in the "Source Air Input" port.
Your source air hose will then be installed onto the nipple.

Minimum air pressure to the pump: 80 p.s.i. **Maximum** air pressure: 125 p.s.i.

Minimum air volume (entering the pump): 12 SCFM

Minimum air input hose diameter: 1/4"

IMPORTANT: These hydraulic / pneumatic pumps are powered via an internal air motor.
You **MUST** install an FRL (filter, regulator, lubricator) within 10-15 ft. from the air input port on the pump. Air entering this pump must be free of moisture, and air tool oil (or light weight oil) must be injected into the air motor (via the air input hose) to prevent premature failure.

Once the source air is connected to the pump, the tool is ready for use.

To activate the tool, rock foot peddle forward to engage the hydraulic valve.
The pump will "pulsate" while it builds pressure and the jaws will close. (3-5 second cycle)
Pressure is released and the jaws will open when the foot peddle is rocked in the opposite direction.

If the jaws fail to close when the pump is activated, it's possible that there is air in the hydraulic line.
To expel the air from the system, place the pump on your workbench top. Lower the hand-held tool to a position "lower" than the pump, and cycle the pump several times (5-7 second cycles). Once the air is expelled, the jaws will close and open normally.

PINCHING YOUR TUBING

The best quality pinch-off will be accomplished by locating the tubing near the center of the jaw.
The carbide rollers will meet at the tip before they meet at the throat (back) of the jaw.
The excess tubing will separate completely and be expelled from the tool.

If possible, the best results will be achieved by wetting the pinch rollers with light machine oil. If oil is not acceptable, water will often work as well. This helps reduce friction and heat during the pinch-off process and helps to prevent residue from building up on the rollers. The rollers should be cleaned frequently to eliminate any residue. Very fine steel wool often works best.

CUSTOMER SERVICE

If you have any questions or issues regarding this tool, please contact us immediately.

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