



PowerCrimper

& Accessories



Setup and Operation Manual



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INTRODUCTION

This manual has been prepared to aid you in the operation of your KEBBY POWER CRIMP.

The Kebby “Power Crimp” is a pneumatically controlled crimping tool. It has been designed to increase the speed, ease, pressure and repeatability of crimping for most sizes of bottles and caps.

Kebby Industries is very well-known for the high quality of all their crimping and de-capping tools. The Power Crimp is no different. The quality of the Power Crimp is easily seen in the top grade fittings, high quality regulator assembly, stainless steel hose, and the corrosion-resistant finish. The variety of accessories will enhance the ease and function of the Power Crimp.

This unit has been designed for ease in set-up and operation. The Power Heads are easily removed from the Power Crimp so that size changes can be accomplished quickly. The Kebby “Power Crimp” and Power Heads will provide a smooth, fast and accurate crimp. The quickness and quality of the crimp makes the Power Crimp very cost effective.

Kebby Industries feels that once you have used the Kebby “Power Crimp” and accessories, you will not want to go back to hand crimping.

PROPRIETARY AGREEMENT

This manual discloses information in which Kebby Industries has proprietary rights. Neither receipt nor possession of this manual confers or transfers any right to the client, and by its retention hereof, the client acknowledges that it will not reproduce or cause to be reproduced, in whole or in part, any such information except by written permission from Kebby Industries. The client shall have the right to use and disclose to its employees the information contained herein for the purpose of operating and maintaining the Kebby “Power Crimp”, and for no other purpose.


The information contained in this manual is believed to be accurate. In spite of continuous review, there is always a possibility of error, misapplication of content, or individual misunderstanding.

Kebby Industries assumes no liability for unsatisfactory safety or machine performance that might result from such error, misapplication or misunderstanding.

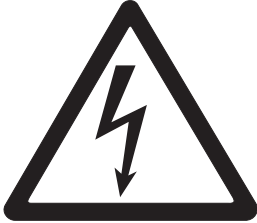
SAFETY PRECAUTIONS

This precision tool and accessories have been designed to ensure the maximum safety for the operator. Only qualified technicians should use this equipment. Alignment, operation, and maintenance of this unit with all its attached power operated devices are potentially hazardous if safety precautions are not followed.

Throughout this manual you will be reminded of safety factors:

<p>WARNING</p> 	<p>THIS WARNING SIGN IS A REMINDER THAT THERE IS DANGER TO PERSONNEL. BE VERY CAREFUL!</p>
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<p>CAUTION</p> 	<p>THIS CAUTION SIGN DENOTES: CARE MUST BE TAKEN OR EQUIPMENT MAY BE DAMAGED.</p>
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<p>CAUTION</p>  <p>STORED ENERGY</p>	<p>THIS SIGN IS USED WHEN DANGEROUS STORED ENERGY MAY BE PRESENT. THIS WILL REQUIRE ADDED CAUTION AND A WELL THOUGHT OUT PLAN BEFORE REPAIR BEGINS. BE PREPARED TO CHECK OR HAVE CHECKED ANY PRESSURIZED LINES.</p>
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SAFETY RECOMMENDATIONS

For your safety and to prevent equipment damage, thoroughly study this manual and follow these recommendations:

1. Keep the tool and accessories properly maintained. Perform all maintenance in accordance with the manual provided.
2. Understand how the unit operates. Study the operation manual prior to the general start-up sequence. If you have any questions, see the proper authority.
3. Never allow untrained personnel to operate the unit or conduct tests.
4. Never operate the unit unless proper maintenance routines have been regularly performed and the unit is known to be in good working order.
5. Ensure that all guarding, interlocks and safety equipment are in good condition and in place during the operation of the unit.
6. Be certain tools are properly mounted and locked, and the workpiece is securely positioned before starting the unit.
7. Never operate any unit beyond its rated speed or capacity.
8. Never reach across or under any moving machine part.
9. Do not wear loose clothing or jewelry that could become entangled in the moving parts of the unit.
10. Never lay tools or tooling on the unit where it might interfere with the operation of the unit.
11. Always wear properly designed impact resistant safety glasses and safety shoes.
12. Be alert for loose, worn or broken parts. When suspected, do not operate the unit. Report these items and any unusual noise or action of the unit to the proper authority.
13. Never overload the unit. This is potentially dangerous to both the operator and the unit.
14. When returning to the unit after an absence, always check the setup. The equipment may have been used and not replaced correctly.
15. Never operate unit while any personnel are near hazardous areas.

CAUTIONS AND WARNINGS

<p>WARNING</p> 	<p>THIS WARNING SIGN IS A REMINDER THAT THERE IS DANGER TO PERSONNEL. BE VERY CAREFUL!</p>
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<p>CAUTION</p> 	<p>CARE MUST BE TAKEN OR EQUIPMENT MAY BE DAMAGED.</p>
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- Inlet pressure should never exceed 250 psi.
- Operator is recommended to disconnect air prior to changing Power Heads, Power Crimp, or cleaning.
- Do not place fingers, hands, or anything in pinch areas.
- All hoses must be kept away from sources of heat that may cause them to melt.
- Hoses must not be a trip hazard.
- Warning labels must be left on the machine.

OCCUPATIONAL SAFETY AND HEALTH ACT

This unit complies with the Occupational Safety and Health Act of 1970 standards where the requirements are specific. The balance of the standards are complied with as interpreted by Kebby Industries. Since these standards are continually evolving, and since they are subject to considerable interpretation by a third party, Kebby Industries cannot guarantee or warrant compliance with the provisions or standards of O.S.H.A. or any regulations issued under that statute.

INDIVIDUAL ACCESSORY ITEMS

Individual accessory items available for purchase.



Power Crimper Unit
P/N A10001



Regulator Assembly
P/N A10002



SS Regulator Assembly
P/N A10003



Air Supply Hose
P/N A10007



Air Supply Hose
P/N A10008



Air Supply Hose SS Braided
P/N A10009



Power Crimper Stand
P/N A10010
Stainless Steel Base Model
P/N A10010-1



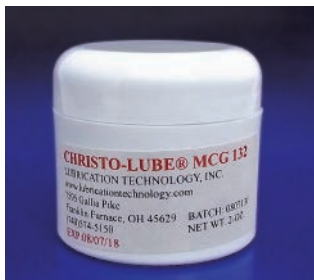
Foot Pedal Assembly w/ hose
P/N A10011



Hanger Assembly
P/N A10012



Verification Gauge Assembly
P/N A10013



Lubricating Grease
P/N A10024



Inter-Changeable Crimping and Decapping Heads available for a wide variety of cap sizes and styles from 7.5mm to 32mm.

KEBBY POWER CRIMP AND ACCESSORIES

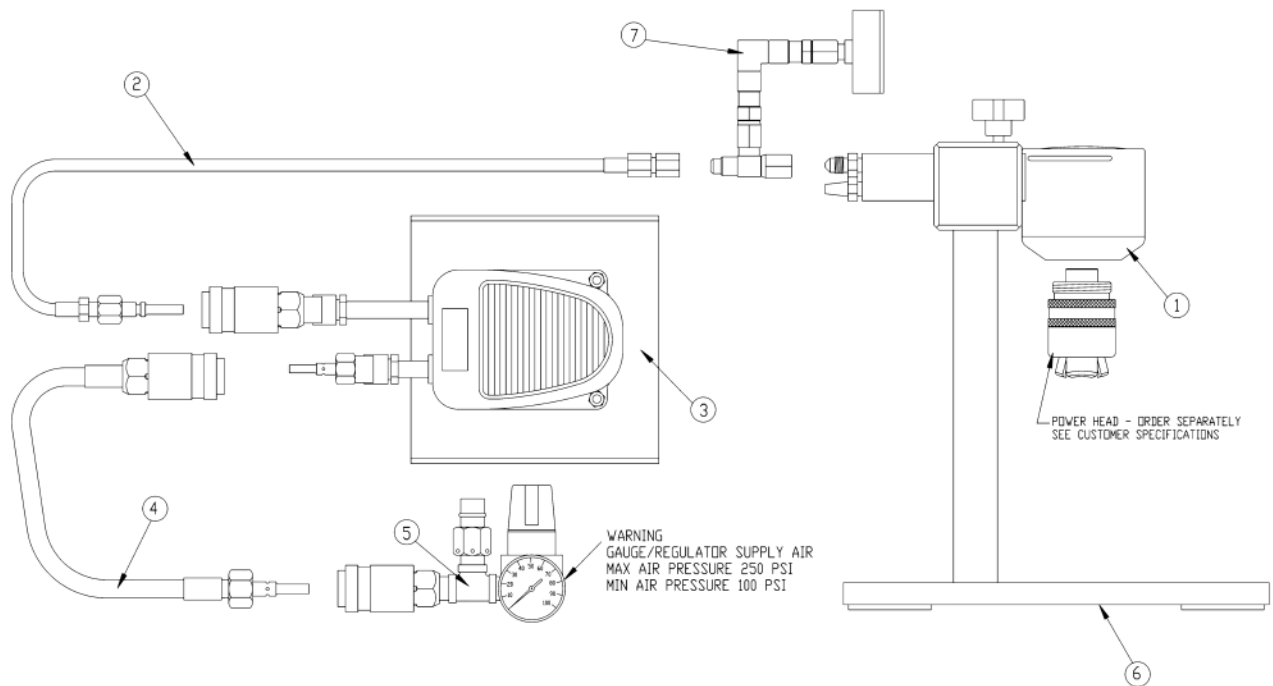


FIGURE 1-1 KEBBY POWER CRIMP AND ACCESSORIES

NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	A10001	POWER CRIMP
2	1		POWER CRIMP HOSE ASSEMBLY
	1	A10007	POLYURETHANE SELF-STORING HOSE ASSEMBLY
	1	A10008	POLYURETHANE STRAIGHT HOSE ASSEMBLY
	1	A10009	BRAIDED STAINLESS STEEL HOSE ASSEMBLY
3	1	A10011	FOOT PEDAL ASSEMBLY
4	1	A10005	SUPPLY AIR HOSE ASSEMBLY
5	1	A10002	GAUGE/REGULATOR ASSEMBLY
6	1	A10010	POWER CRIMP STAND ASSEMBLY
7	1	A10013	AIR PRESSURE VERIFICATION ASSEMBLY

ASSEMBLY INSTRUCTIONS

This manual has been prepared to aid you in the setup and operation of your KEBBY POWER CRIMP. The following chapter will guide you through the assembly.

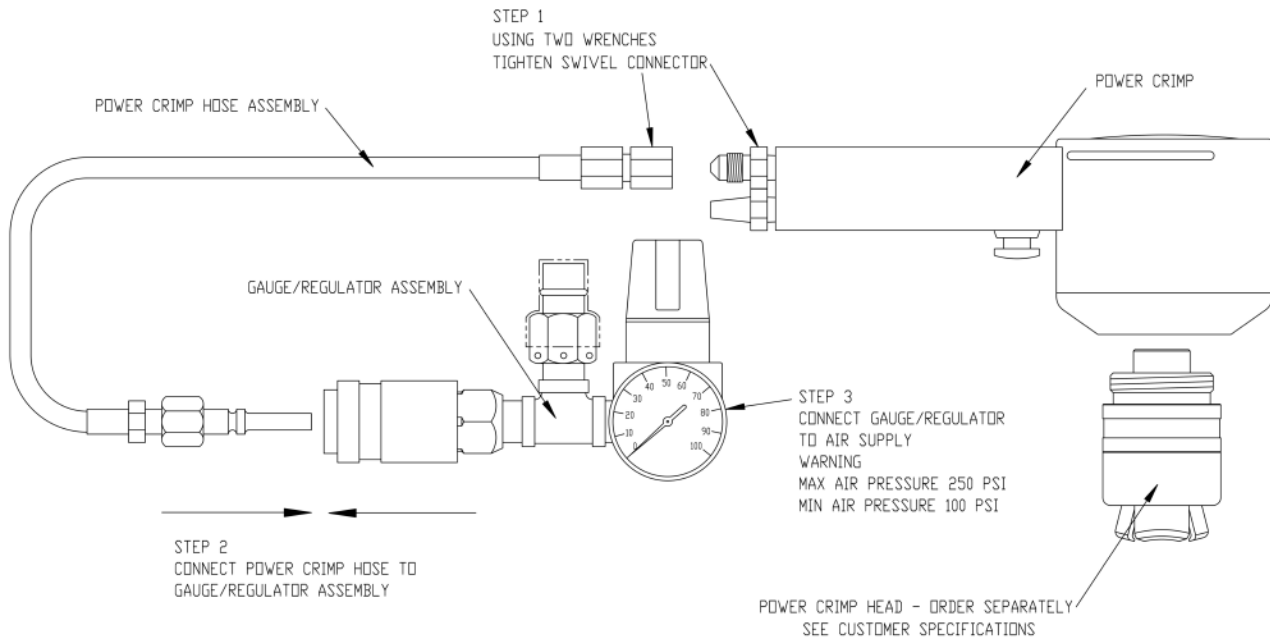


FIGURE 1-2

STEP 1: Connect the Power Crimp Hose Assembly to the Power Crimp as follows:

Step #1: Install the hose fitting onto the Power Crimp adapter.

Step #2: Place a 1/2" open-end wrench on the adapter of the Kebby Power Crimp. Hold the 1/2" wrench stationary and tighten the hose fitting.

NOTE: Do not over tighten the fitting. Minimum pressure is needed to secure the fitting.

STEP 2: Connect the Power Crimp Hose Assembly to the Gauge I Regulator.

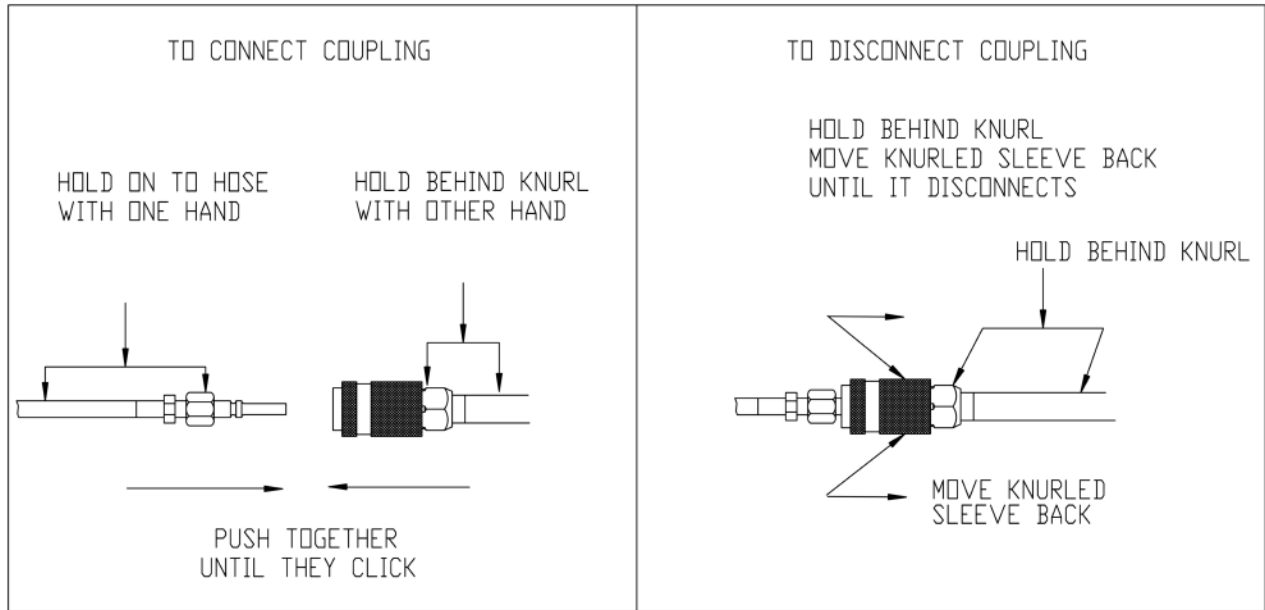



FIGURE 1-3

STEP 3: Attach main supply air (less than 36% relative humidity @ 60 degrees F) to the Gauge/Regulator.

<p>WARNING</p> 	<p>DO NOT EXCEED 250 PSI.</p>
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ASSEMBLE POWER CRIMP TO CRIMP STAND

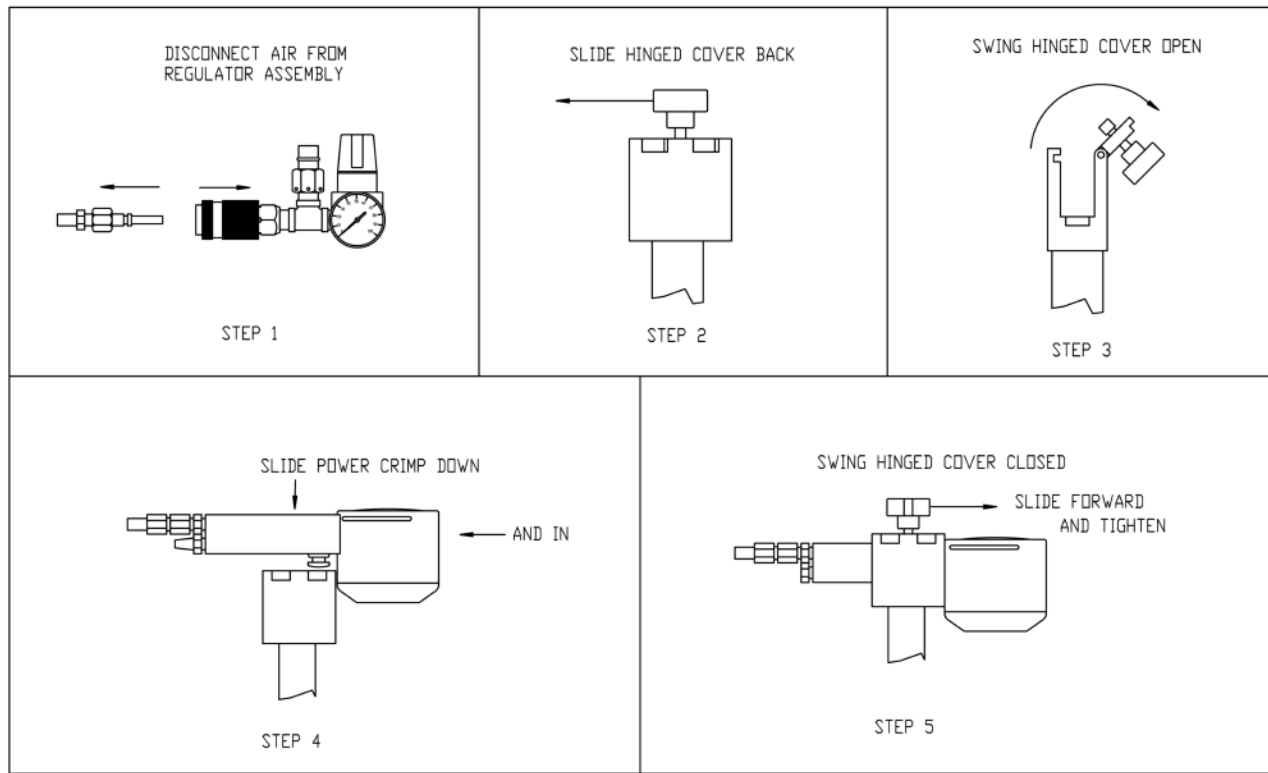


FIGURE 1-5

- STEP 1:** Disconnect the air supply from the Gauge/Regulator Assembly.
- STEP 2:** Loosen the thumb-screw and slide the hinged cover back on the Crimp Stand Assembly.
- STEP 3:** Swing the hinged cover open on the Crimp Stand Assembly.
- STEP 4:** Align the Power Crimp with the Crimp Stand and slide the Power Crimp down and into the Crimp Stand Assembly.
- STEP 5:** Hold the Power Crimp in place and swing the hinged cover closed. Finger-tighten clamp thumb-screw.
- STEP 6:** Install the verification nut onto the Kebby Power Crimp adapter. Hold the 1 /2" wrench stationary and tighten the nut using a 9/16 open-end wrench.

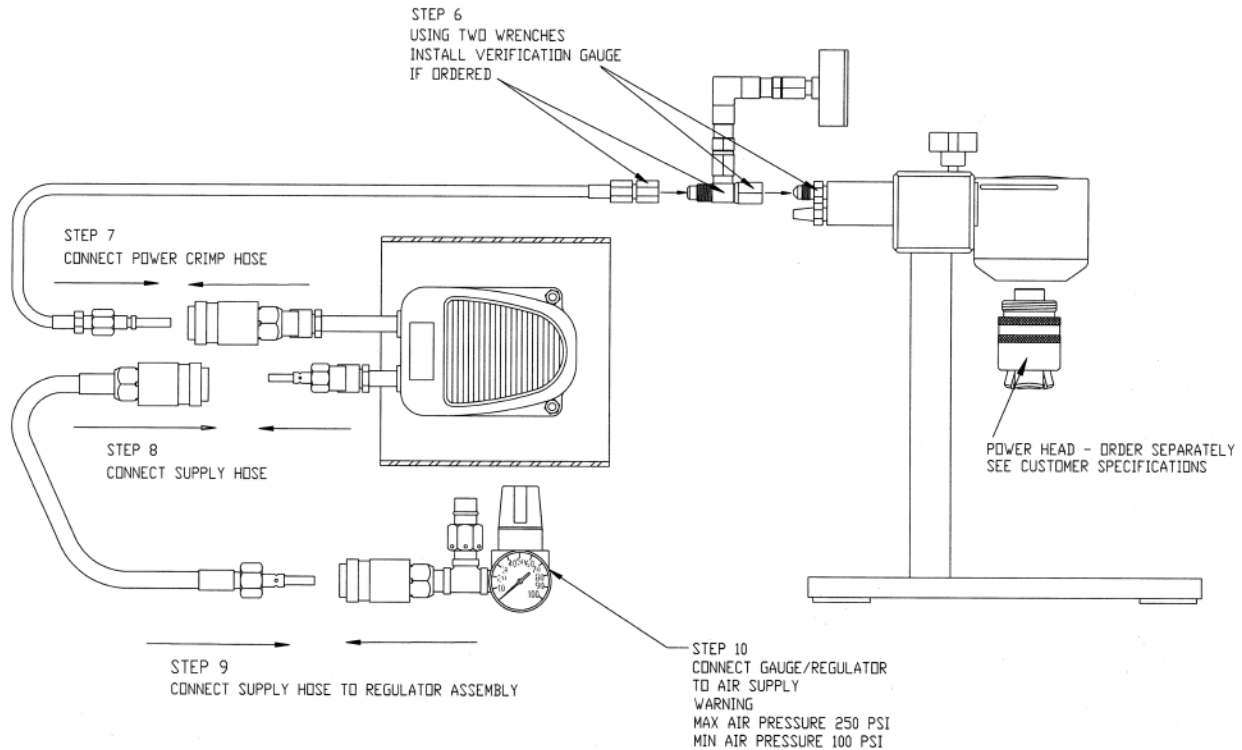


FIGURE 1-6

STEP 7: Install the hose fitting onto the back of the verification gauge adapter. Place a 1/2" open-end wrench on square block of verification gauge adapter. Hold the 1/2" wrench stationary and tighten the hose fitting.

NOTE: Do not over tighten the fitting. Minimum pressure is needed to secure the fitting.

STEP 8: Connect the Power Crimp Hose fitting to the quick disconnect of the Foot Pedal Assembly.

STEP 9: Connect the Supply Hose to the quick disconnect fitting on the Foot Pedal Assembly.

STEP 10: Connect the Supply Hose Assembly to the Gauge/Regulator Assembly.

STEP 11: Attach main air supply (less than 36% relative humidity @ 60 degrees F) to the Gauge/Regulator.

POWER CRIMP HEAD INSTALLATION

STEP 1: Insert appropriate Power Head (sold separately) by turning to the right to tighten, left to loosen.

NOTE: Do not over tighten the Power Head. Minimum pressure is needed to secure the Power Head.

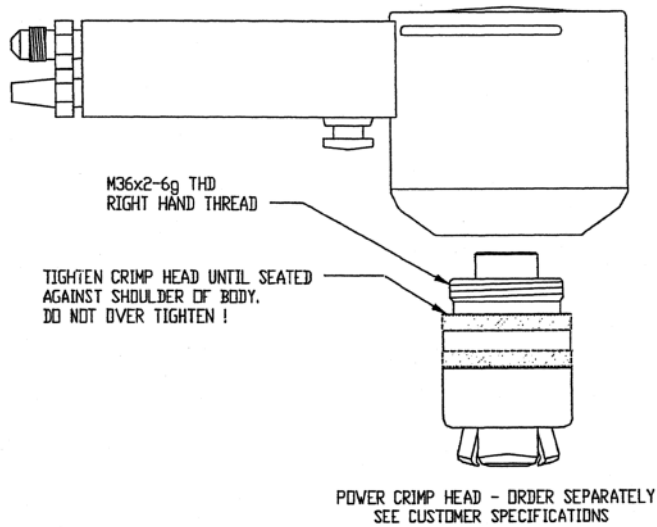


FIGURE 1-7

WARNING



**WHEN INSTALLING OR REMOVING
POWER CRIMP HEAD, SET AIR PRESSURE
TO 0 PSI.**

CRIMP SETUP AND OPERATION

NOTE: It may be necessary to clean and lubricate the crimper jaws from time to time. If an indentation begins to appear on the side of the seal being crimped, cleaning and lubricating of the jaws will usually correct the problem.

In order to use your Kebby Power Crimp correctly and obtain the best crimp, use the following steps:

STEP 1: Set the air pressure to zero psi. Turn the regulator adjustment knob (Figure 1-6) counter clockwise to decrease the air pressure to zero psi.

NOTE: The knob is a push to lock, pull to unlock knob. If the knob will not turn, it may be in the locked position. To unlock the knob, pull up on the knob and push down on the knob to lock.

STEP 2: Insert appropriate Power Head (sold separately) for crimping into the Power Crimp assembly.

STEP 3: Assemble stopper and cap on the top of the bottle.

STEP 4: Increase the air pressure to approximately 15 psi.

STEP 5: Insert the bottle and cap assembly into the Kebby Power Head Crimp with the pressure set to 15 psi and actuate the Crimp. Wait approximately 1 to 2 seconds before releasing the Crimp.

Inspect cap for proper seal. If seal is not crimped to meet your requirements, increase the air pressure by turning the knob clockwise at approximately 2 to 3 psi increments until seal meets your requirements.

Remove crimped seal or partially crimped seal, replace with new seal and stopper if necessary before crimping at increased pressure. Repeat increasing pressure approximately 2 to 3 psi until crimped seal meets your requirements.

NOTE: If a verification gauge is installed, it is used as a visual aid to determine when the crimp is complete. The crimp has been completed when the needle on the gauge has stabilized and no longer moves. The needle on the verification gauge shows the pressure at which the crimp is being performed.

STEP 6: If the crimp is unsatisfactory and the pressure needs to be adjusted, unlock the pressure knob to change the pressure and lock the pressure knob before crimping. To avoid pressure variation throughout the run, push down on the pressure knob to lock it in place.



CAP REMOVAL SETUP AND OPERATION

NOTE: Cap will be destroyed during removal procedure. In order to use your new Kebby Power Crimp correctly for cap removal, use the following steps:

STEP 1: Set the air pressure to zero psi. Turn the regulator adjustment knob (Figure 1-5) counter clockwise to decrease the air pressure to zero psi.

NOTE: The knob is a push to lock, pull to unlock knob. If the knob will not turn, it may be in the locked position. To unlock the knob, pull up on the knob and push down on the knob to lock.

STEP 2: Insert appropriate Power Head (sold separately) for de-capping into the Power Crimp assembly.

NOTE: Caps with plastic tops cannot be de-capped with plastic in place. It must be removed before de-capping can take place.

STEP 3: Insert the bottle and cap assembly into the Kebby Power Head De-capper with the pressure set to 30 psi and actuate the Power Crimp. Wait approximately 1 to 2 seconds before releasing the Power Crimp.

If the cap did not come off, increase Crimp pressure 3 to 5 psi and repeat this step until the bottle is de-capped. Do not use more Crimp pressure than necessary.

NOTE: START CRIMP PRESSURE AT 30 PSI. INCREASE THE CRIMP PRESSURE IN SMALL INCREMENTS UNTIL THE CAP IS FULLY REMOVED.



MAINTENANCE

PREVENTIVE MAINTENANCE

Service, reliability, and accuracy are only possible when all the notes and instructions are carefully followed.

The time intervals for suggested maintenance work are shown for standard conditions. However, the actual working conditions in a customer's plant may force some alterations in the schedule.

Irregularities and malfunctions must be taken care of immediately.

The Kebby Power Crimp embodies a combination of modern engineering skills, the finest material, and workmanship. We believe this machine to be the finest of its kind; however, its life performance depends on its proper use, care, and maintenance.

The information contained in this chapter, when used along with the machine drawings provided by Kebby Industries, will simplify the care and handling of the machine and help you obtain maximum benefits from your new machine.

Any questions or comments regarding the operation or maintenance of your machine are welcome and will be handled promptly by our service department at any time.

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STANDARD MAINTENANCE CHARTS

The following pages are the PREVENTIVE MAINTENANCE CHARTS.
These charts represent items that need periodic checking or maintenance.

NOTE: ALL SCHEDULED MAINTENANCE TIMES THAT ARE RECOMMENDED IN THIS DOCUMENT ARE BASED ON PAST EXPERIENCE AND SHOULD BE FOLLOWED UNTIL DIFFERENT TIME SCHEDULES BASED ON THE SHOP ENVIRONMENT WHERE THE MACHINE IS LOCATED CAN BE RECOMMENDED.

NOTE: WHEN THE MACHINE IS NOT IN USE, THE AIR SHOULD BE DISCONNECTED FROM THE MACHINE.

NOTE: DO NOT BEND, STRETCH OR CRUSH HOSES.

MACHINE CLEANING

The most important item in machine maintenance is the cleaning of machine components. To more specifically define the task, cleaning has been divided into three categories. Schedules for each category have also been defined.

NOTE: CLEANING SHOULD BE DONE AS NEEDED.

This category involves an area that, if not cleaned, will gradually deteriorate machine performance.

- Power Crimp
- Power Crimp Hose Assemblies
- Foot Pedal Assembly
- Gauge/Regulator Assembly
- Supply Air Hose Assembly
- Power Crimp Stand Assembly

PNEUMATIC SYSTEM

Preventive maintenance of the pneumatic system requires a clean, dry (less than 36% relative humidity @ 60 degrees F) shop compressed air supply. Experience has shown that foreign material lodging in the air supply valves is a major cause of breakdowns. This contamination of the system will occur from two sources.

The first occurs naturally inside the system. This includes rust, plus a small amount of grit, caused by the wearing of components as they perform their functions. Varnish will also form, as a result of oxygen reacting with lubrication oil.

The second includes materials such as rust, scale, and water entering the system from an outside source.

PNEUMATIC SYSTEM PREVENTIVE MAINTENANCE

MAINTENANCE PROCEDURE	DAILY	WEEKLY	MONTHLY	QRTLY	ANNUALLY
Clean and drain water from the shop air system filter. If water appears on a daily basis, a dryer may be needed on the supply line.	CHECK				
Check shop air system air lubricator and filter.		CHECK			
Check air pressure regulator.		CHECK			
Check pressure gauges for accuracy.			CHECK		
Inspect air distribution lines for leaks and damage.				INSPECT	
Check air line fittings for tightness.					CHECK

TABLE A

EFFECTS OF CONTAMINATES ON PNEUMATIC SYSTEMS

Solids in the system are abrasive. As solids pass through the system, a scouring of the components may take place. This destruction occurs over an extended period of time, and results in the gradual deterioration of the system efficiency.

NOTE: SHOP AIR SYSTEM FILTER MAINTENANCE IS THE BEST MEANS OF LIMITING THE DESTRUCTION AND CONTAMINATION BY SOLIDS AND WATER IN THE PNEUMATIC SYSTEM.



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