



PowerCrimper

& Accessories



Set up and Operation Manual

Kebby Resources

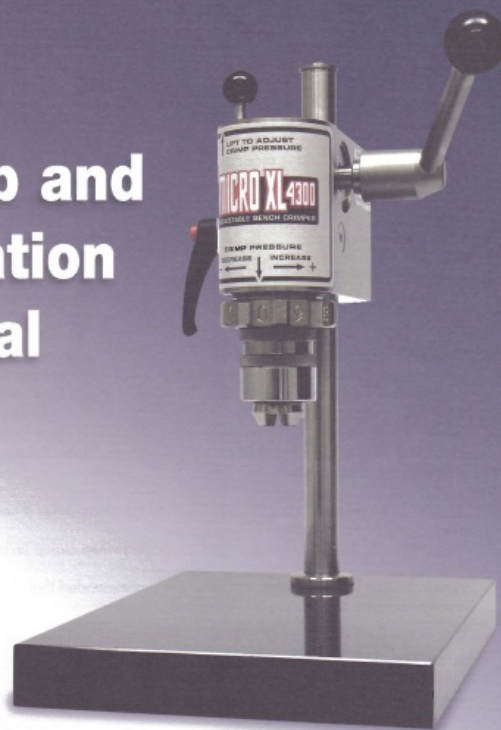
Caps / Seals Example (Kebby)
FAQS



MICRO-XL 4300

Adjustable Bench Crimper

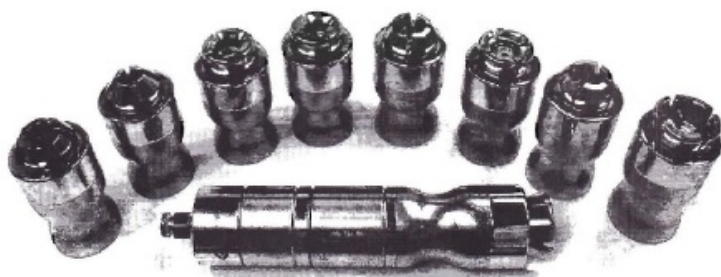
Set up and Operation Manual



Product Manual

Vertical Air Crimper

By Kebby Industries, Inc.



HROMalytic +61(0)3 9762 2034
ECHnology Pty Ltd

Australian Distributors
Importers & Manufacturers
www.chromtech.net.au

Website NEW : www.chromalytic.net.au E-mail : info@chromtech.net.au Tel: 03 9762 2034 . . . in AUSTRALIA



PowerCrimper

& Accessories



Set up and Operation Manual



KEBBY INDUSTRIES INC.

4075 Kilburn Ave., Rockford, IL 61101 U.S.A.

Phone: 815-963-1466 • Fax: 815-962-3490

www.kebhvindustries.com

HRMalytic +61(0)3 9762 2034 Australian Distributors
 Importers & Manufacturers
 www.chromtech.net.au **12/13**
ECHnology Pty Ltd
 Website NEW : www.chromalytic.com.au E-mail : info@chromtech.net.au Tel: 03 9762 2034 . . . in AUSTRALIA

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INTRODUCTION AND SAFETY

I.0 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 size 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 ~~in the Power Crimp~~ will provide a smooth, fast and accurate crimp. The quickness and quality of the crimp makes the Power Crimp very cost effective.

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

I.1 PROPRIETARY AGREEMENT

This manual discloses information in which Kebby Industries Inc. 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 Inc. 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 Inc. assumes no liability for unsatisfactory safety or machine performance that might result from such error, misapplication or misunderstanding.

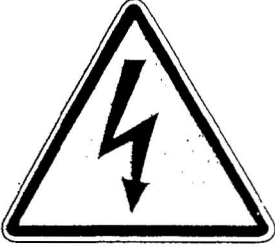
I.2 SAFETY PRECAUTIONS

This precision tool and accessories have been designed to ensure the maximum safety for the operator. Only qualified technicians should work on 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>
---	---

<p>CAUTION</p> 	<p>THIS CAUTION SIGN DENOTES: CARE MUST BE TAKEN OR EQUIPMENT MAY BE DAMAGED.</p>
--	--


<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>
---	--


I.3 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.

I.4 CAUTIONS AND WARNINGS

<p>WARNING</p> 	<p>THIS WARNING SIGN IS A REMINDER THAT THERE IS DANGER TO PERSONNEL. BE VERY CAREFUL!</p>
---	--

<p>CAUTION</p> 	<p>CARE MUST BE TAKEN OR EQUIPMENT MAY BE DAMAGED.</p>
---	--

- 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.

I.5 CUSTOMER COMMENTS

Comments concerning the information contained within this manual are welcome.

Please contact:

Kebby Industries, Inc.

4075 Kilburn Avenue
Rockford, Illinois 61101
The United States of America

Phone (815) 963-1466
FAX (815) 962-3490

I.6 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, Inc. Since these standards are continually evolving, and since they are subject to considerable interpretation by a third party, Kebby Industries, Inc. cannot guarantee or warrant compliance with the provisions or standards of O.S.H.A. or any regulations issued under that statute.

CHAPTER 1

ASSEMBLY INSTRUCTIONS

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1.0 INTRODUCTION

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

1.1 ACCESSORY LIST

The following accessories are available with the Kebby POWER CRIMP. These accessories will further enhance the performance and convenience of the Power Crimp.

- Foot Pedal Assembly - P/N A10011
- Brass Gauge/Regulator Assembly - P/N A10002
- Stainless Steel Gauge/Regulator Assembly - P/N A10003
- Power Crimp Stand Assembly - P/N A10010
- Air Pressure Verification Assembly - P/N A10013
- Supply Air Hose Assembly - P/N A10005
- Braided Stainless Steel Hose Assembly - P/N A10009
- Polyurethane Straight Hose Assembly - P/N A10008
- Polyurethane Self-storing Hose Assembly - P/N A10007
- Pro-Seal (refer to Figure 4-9)

1.2 KEBBY POWER CRIMP AND ACCESSORIES

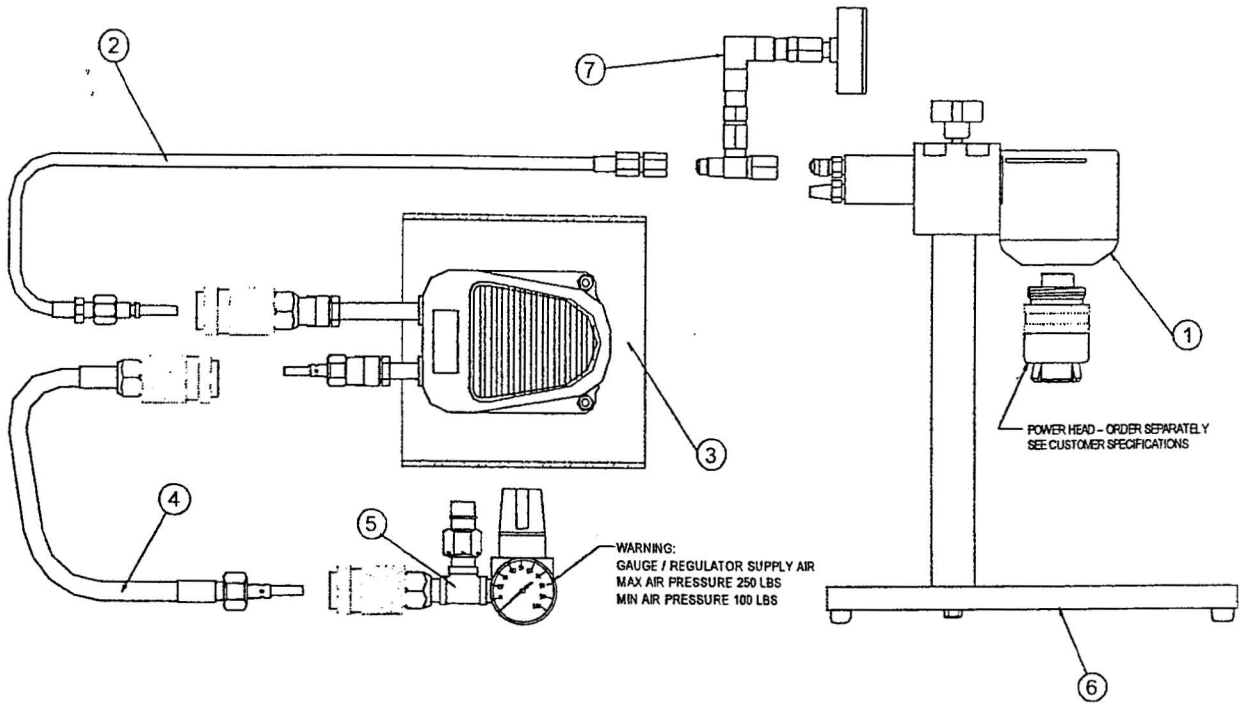


FIGURE 1-1 KEBBY POWER CRIMP AND ACCESSORIES

NUMBER	QTY	DWG. NO.	PART NUMBER	DESCRIPTION
1	1	A-19001-1	A10001	POWER CRIMP
2	1	A-19005-1	SEE DWG.	POWER CRIMP HOSE ASSEMBLY
3	1	A-19007-1	A10011	FOOT PEDAL ASSEMBLY
4	1	A-19004-1	A10005	SUPPLY AIR HOSE ASSEMBLY
5	1	A-19002-1	SEE DWG.	GAUGE/REGULATOR ASSEMBLY
6	1	A-19006-1	A10010	POWER CRIMP STAND ASSEMBLY
7	1	A-19003-1	A10013	AIR PRESSURE VERIFICATION ASSEMBLY

TABLE A

1.3 ASSEMBLY INSTRUCTIONS

1.3.1 BASIC ASSEMBLY

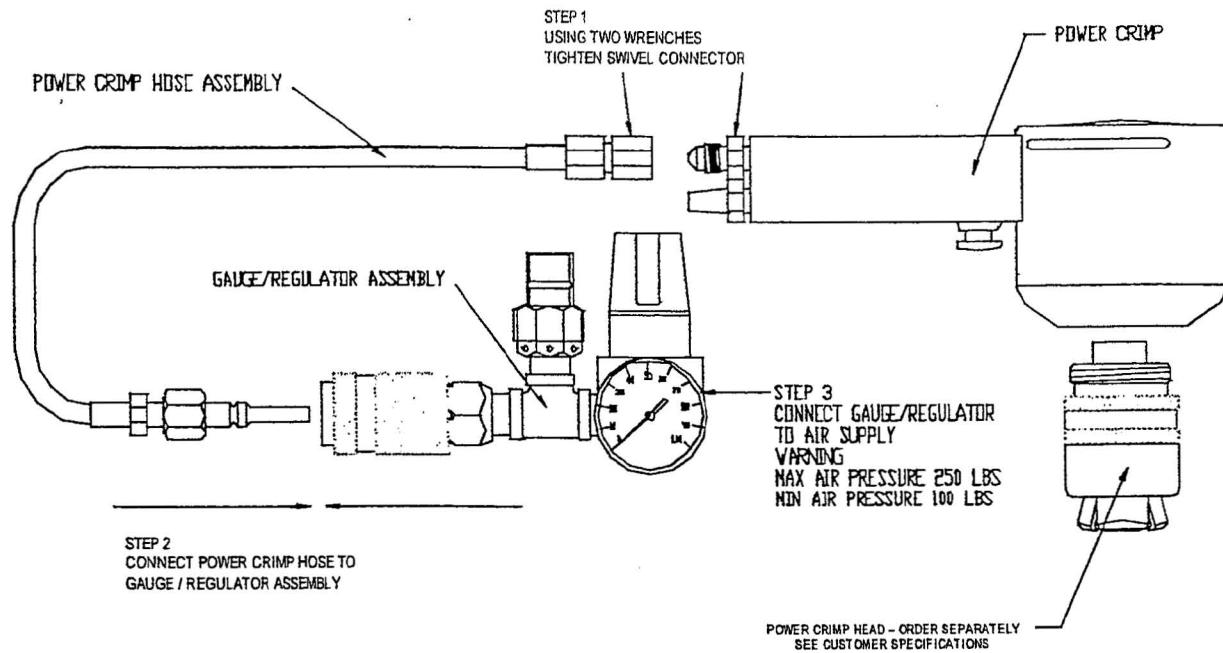


FIGURE 1-2

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 / Regulator.

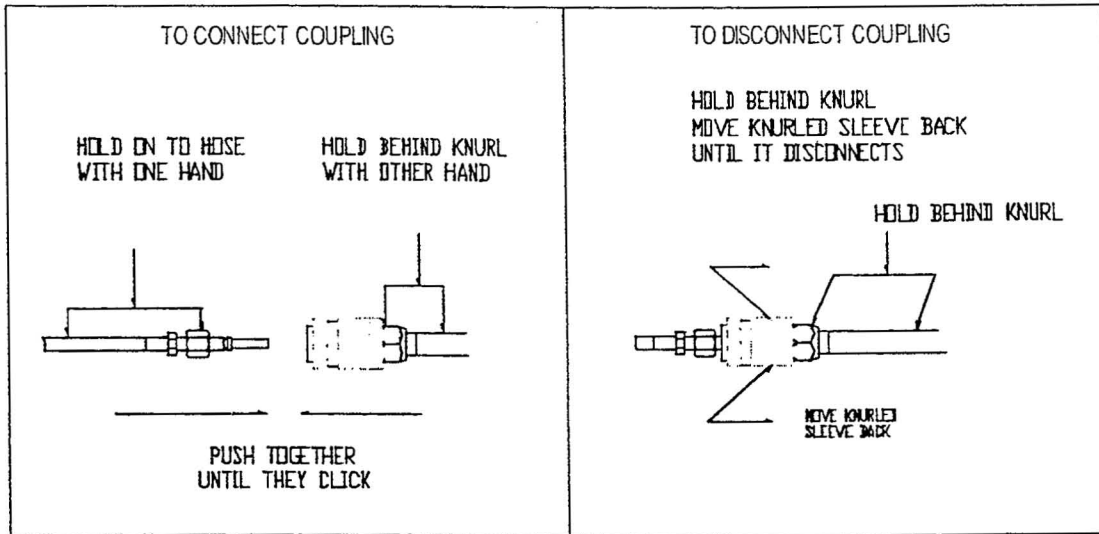



FIGURE 1-3

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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1.3.2 POWER CRIMP STAND ASSEMBLY

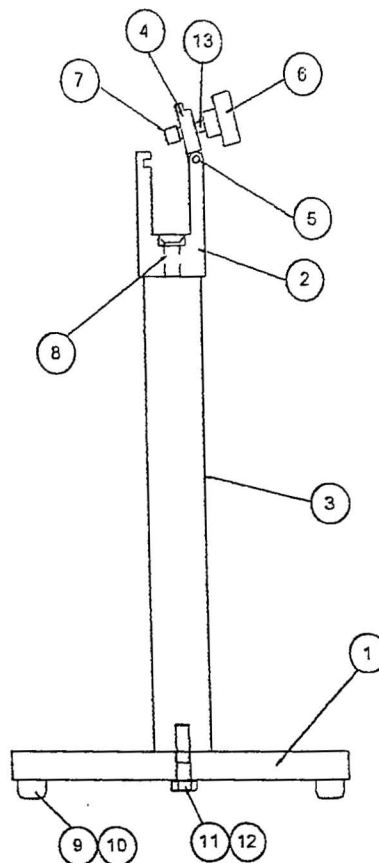


FIGURE 1-4

STEP 1:

Attach Column (3) to Base Plate (1) using Hex Head Cap Screw (11) and Flat Washer (12). Tighten Hex Head Cap Screw (11) securely.

1.3.3 ASSEMBLE POWER CRIMP TO CRIMP STAND

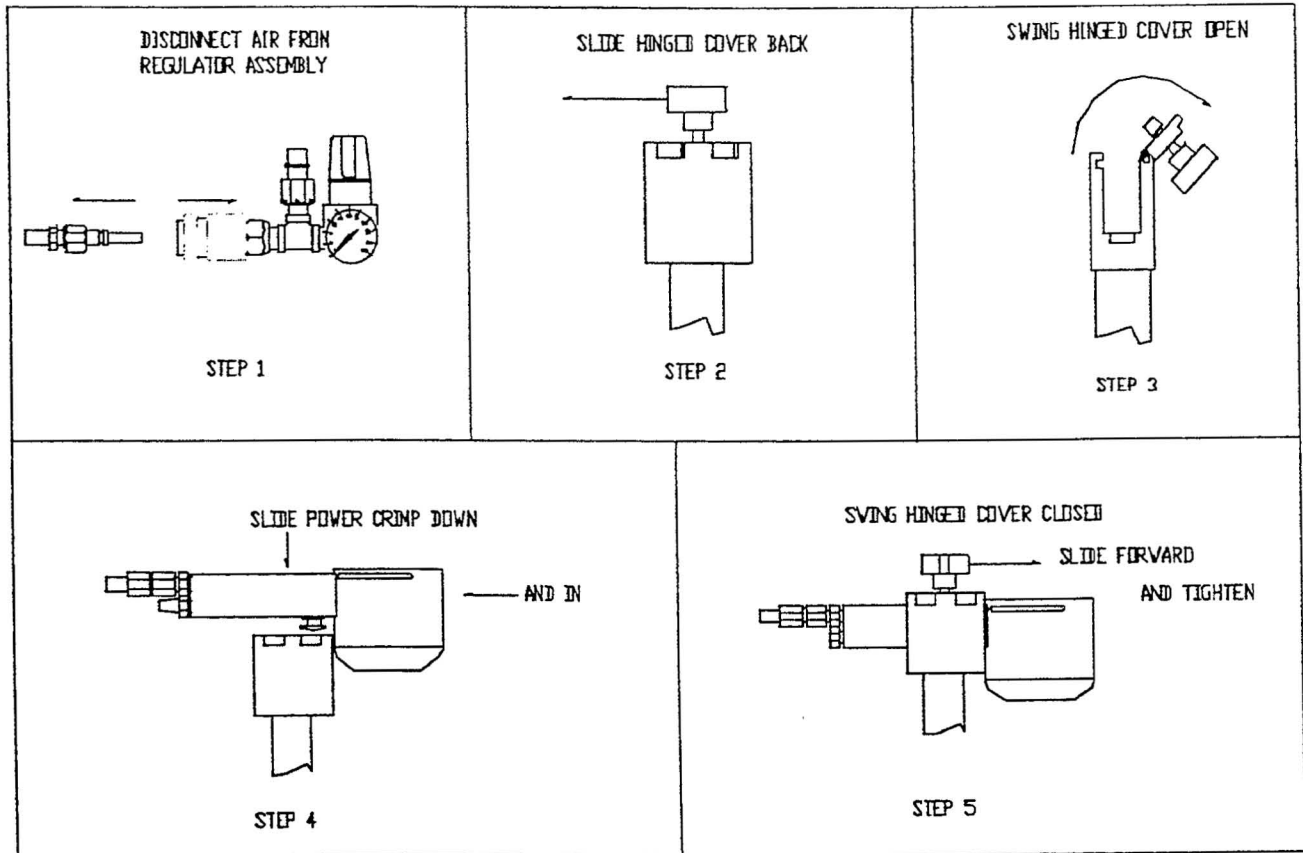


FIGURE 1-5

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.

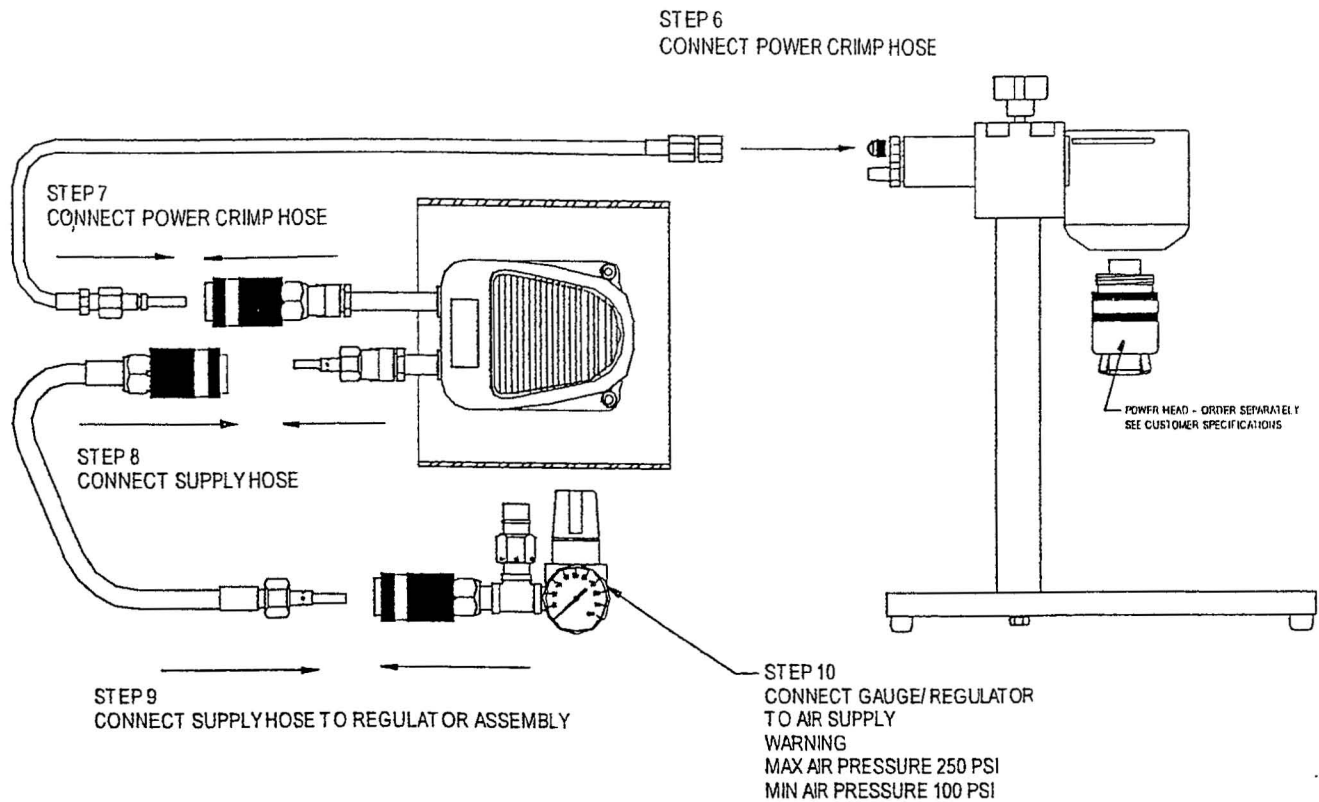


FIGURE 1-6

STEP 6:

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 7:

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

STEP 8:

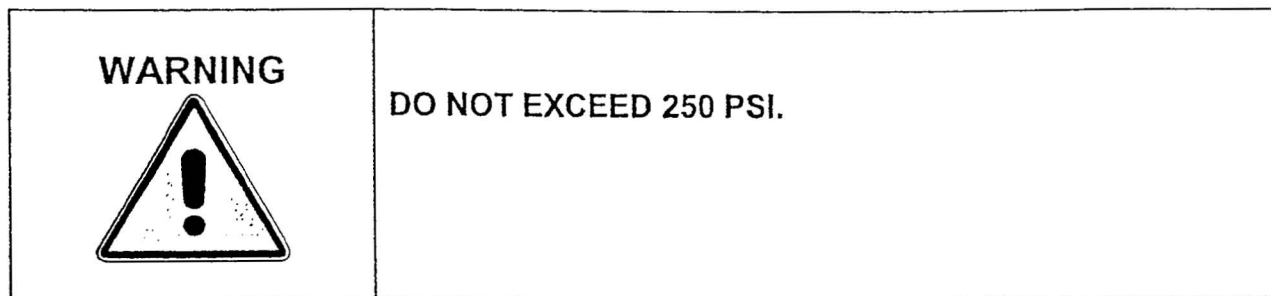
Connect the Supply Hose to the quick disconnect fitting on the Foot Pedal Assembly.

STEP 9:

Connect the Supply Hose Assembly to the Gauge/Regulator Assembly.

STEP 10:

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



1.3.4 POWER CRIMP HEAD INSTALLATION

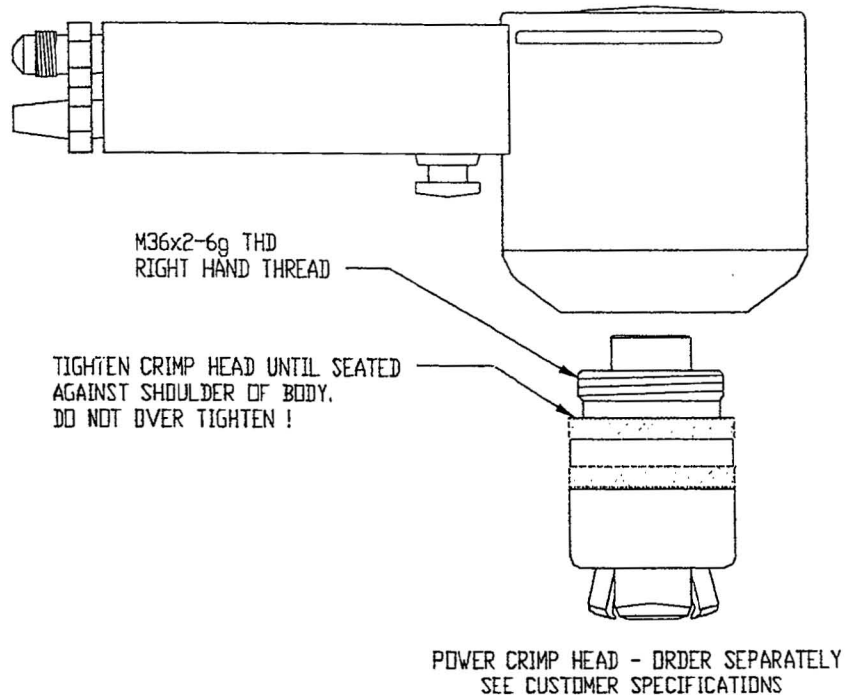



FIGURE 1-7

<p>WARNING</p> 	<p>WHEN INSTALLING OR REMOVING POWER CRIMP HEAD, SET AIR PRESSURE TO 0 PSI.</p>
---	--

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.

1.3.5 INSTALLATION OF VERIFICATION GAUGE

The verification gauge (Figure 1-1) is mounted on a swivel fitting allowing it to be placed on the right or left side of the Kebby Power Crimp.

Step 1:

Place a 1/2" open-end wrench on the adapter of the Kebby Power Crimp. Hold the 1/2" wrench stationary and loosen the retaining nut on the hose. Remove the fitting from the adapter.

Step 2:

Install the verification nut onto the Kebby Power Crimp adaptor. Hold the 1/2" wrench stationary and tighten the nut using a 9/16 open-end wrench.

Step 3:

Install the hose fitting onto the back of the verification gauge adaptor. Place a 1/2" open-end wrench on square block of verification gauge adaptor. 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.

CHAPTER 2
SET-UP AND OPERATING
INSTRUCTIONS

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2.2	CAP REMOVAL SET-UP AND OPERATING INSTRUCTIONS	3

2.0 INTRODUCTION

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

2.1 CRIMP SET-UP AND OPERATING INSTRUCTIONS

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 1-5) 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 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.

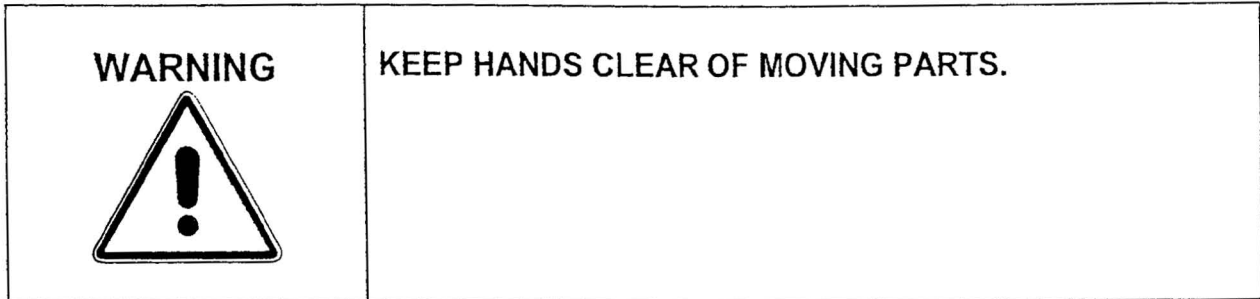
Inspect cap for proper seal. If seal is not crimped to meet your requirements, increase the air pressure by turning the knob clockwise at approximately 2 to 3 psi increments until seal meets your requirements.

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.



2.2 CAP REMOVAL SET-UP AND OPERATING INSTRUCTIONS

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.

<p>WARNING</p> 	<p>KEEP HANDS CLEAR OF MOVING PARTS.</p>
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CHAPTER 3

PREVENTIVE MAINTENANCE

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3.0 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 Inc., 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.

Call or write:

KEBBY INDUSTRIES INC.
4075 KILBURN AVENUE
ROCKFORD, ILLINOIS 61101, USA
PHONE: (815) 963-1466
FAX: (815) 962-3490

3.1 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.

3.2 ADDITIONAL MAINTENANCE

Refer to the vendor manuals supplied with this unit. These manuals provide specific technical data on periodic maintenance and repair of these components. Read and become familiar with the maintenance required for each piece of vendor supplied equipment. Note vendor recommendations on spare parts.

3.2.1 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.

3.2.1.1 CRITICAL CLEANLINESS AREA

NOTE: CLEANING SHOULD BE DONE ON A DAILY BASIS.

For the purpose of preventive maintenance, this category involves an area where excessive dirt accumulation inhibits normal machine movement.

3.2.1.2 NONCRITICAL BUT DETRIMENTAL

NOTE: CLEANING SHOULD BE DONE ON A WEEKLY BASIS.

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

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

3.2.2 HOUSEKEEPING

NOTE: CLEANING SHOULD BE DONE ON A MONTHLY BASIS.

This category applies to areas around the machine, regardless of their condition, that will not directly affect machine performance.

NOTE: SAFETY AND ACCESS TO MACHINE WORK AREAS MAY BE AFFECTED.

For example:

- Areas between work stations
- Floors and work benches

MACHINE CLEANING (cont.)

MAINTENANCE PROCEDURE	DAILY	WEEKLY	MONTHLY	QRTL	SEMI-ANNUALLY	ANNUALLY
Keep the operator's area free of clutter.	EVERY SHIFT					
Painted surfaces as well as stainless steel and aluminum should be cleaned with a cloth or paper towel and rubbing alcohol. NOTE: Do not wipe hoses with rubbing alcohol.	EVERY SHIFT					
Inspect hoses. Replace if necessary.	INSPECT					
Clean excess grease residue from surfaces. (Those surfaces not covered)	CLEAN					
Gently clean and dry hoses with damp towel.	CLEAN					

TABLE A

3.3 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.

3.3.1 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
Clean and inspect internal components of air valves.					CHECK

TABLE B

3.3.2 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.

CHAPTER 4

ILLUSTRATED PARTS LIST

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4.0 INTRODUCTION

The illustrated parts list is provided as a reference only. Please refer to the following drawings when maintaining the machine or ordering replacement parts.

4.1 KEBBY POWER CRIMP AND ACCESSORIES

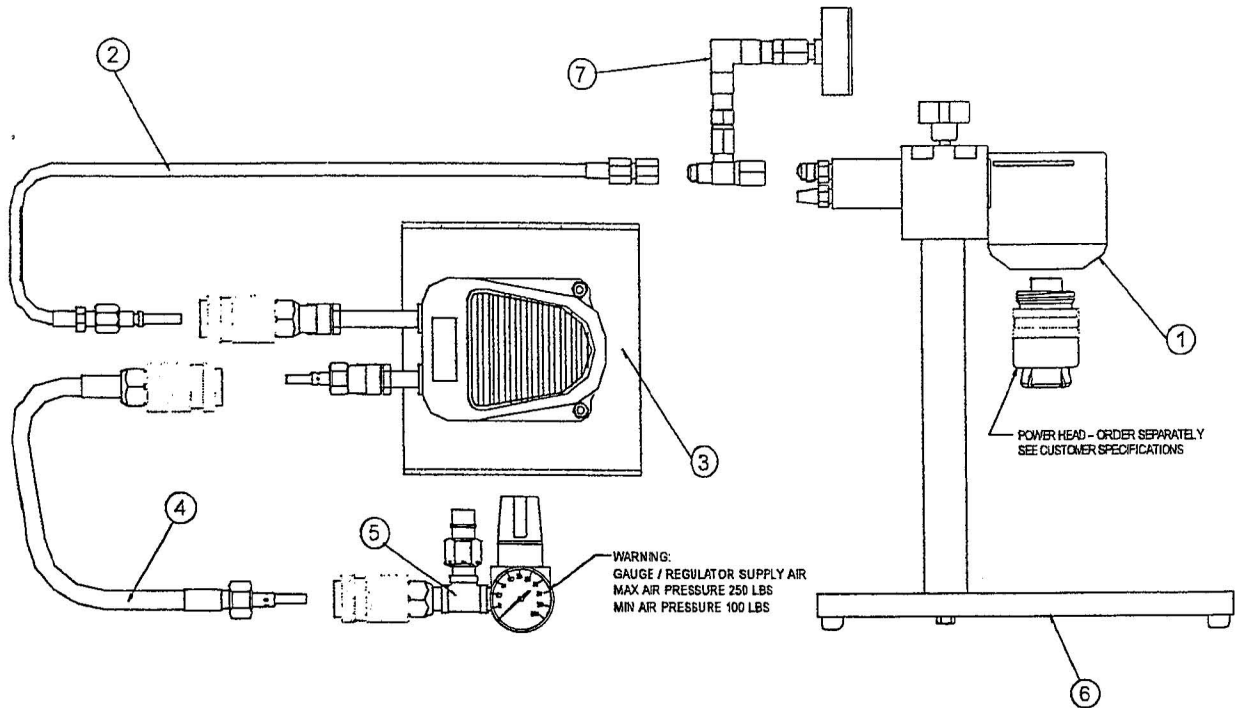


FIGURE 4-1 KEBBY POWER CRIMP AND ACCESSORIES

NUMBER	QTY	DRWG. NO.	PART NUMBER	DESCRIPTION
1	1	A-19001-1	A10001	POWER CRIMP
2	1	A-19005-1	SEE DWG.	POWER CRIMP HOSE ASSEMBLY
3	1	A-19007-1	A10011	FOOT PEDAL ASSEMBLY
4	1	A-19004-1	A10005	SUPPLY AIR HOSE ASSEMBLY
5	1	A-19002-1	SEE DWG.	GAUGE/REGULATOR ASSEMBLY
6	1	A-19006-1	A10010	POWER CRIMP STAND ASSEMBLY
7	1	A-19003-1	A10013	AIR PRESSURE VERIFICATION ASSEMBLY
8	1		SEE DWG.	PRO-SEAL (Shown Separately)

TABLE 4-1 KEBBY POWER CRIMP AND ACCESSORIES

4.2 POWER CRIMP

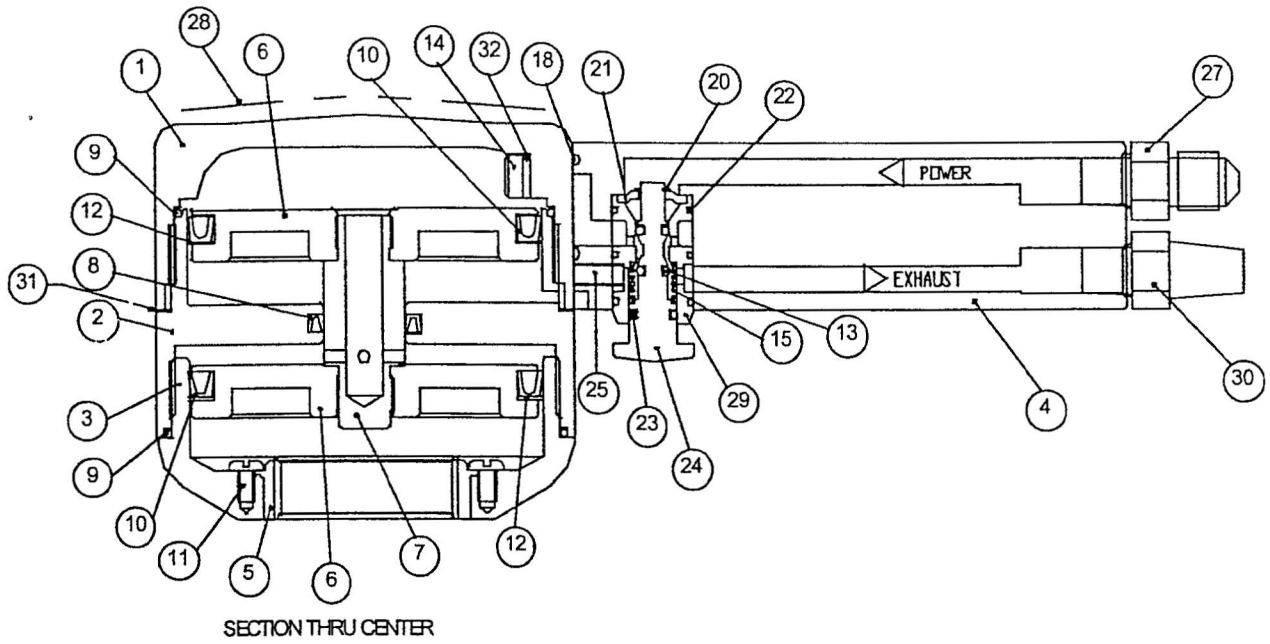


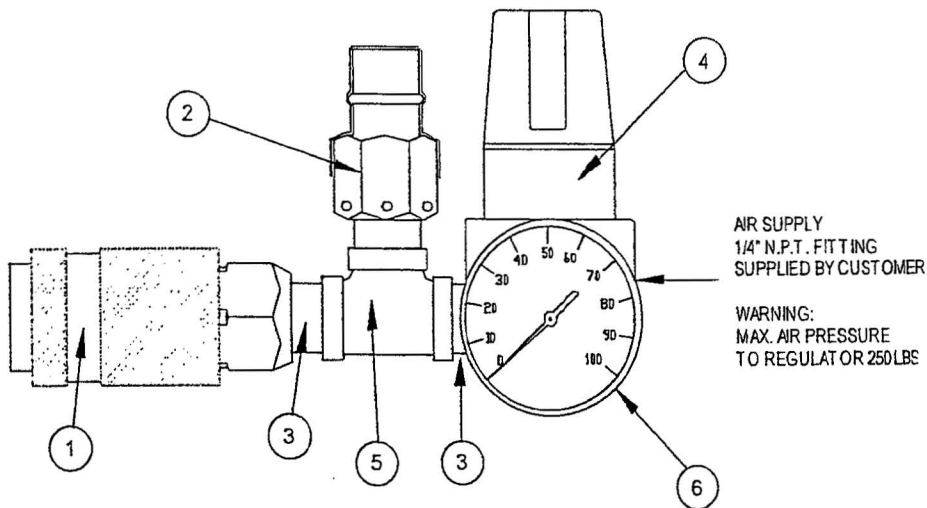
FIGURE 4-2 DWG-A19001-1

NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	A30032	TOP CASE
2	1	A30033	CENTER CASE
3	1	A30034	BOTTOM CASE
4	1	A30035	HANDLE
5	1	A30036	INSERT (THREAD)
6	2	A30037	PISTON
7	1	A30038	ROD (PISTON)
8	1	A30039	SEAL (1/8 X 5/8 ID)
9	2	069-040	O-RING (-040)
10	2	A30040	SEAL (3/16 X 2 3/8 ID)
11	2	91-0632-A-025-A	SCREW
12	2	A30041	SPACER (TEFLON)
13	1	069-006	O-RING (-006)
14	2	91-1032-8-075-A	SCREW
15	1	A30043	RETURN SPRING
18	2	069-014	O-RING (-014)
20	1	76-3100-18	RETAINING RING
21	1	A30102	POPPET GUIDE
22	1	069-0063-01	O-RING
23	1	069-010	O-RING (-010)
24	1	A30100	POPPET (SPOOL)
25	3	91-8C31SSCS	SET SCREW SS
27	1	A30050	ADAPTER
28	1	A30051	NAMEPLATE
29	1	A30101	POPPET VALVE BODY
30	1	A30063	BREATHER/VENT
31	1	A30400	GASKET, CYLINDER
32	1	A30083	WASHER, COPPER

TABLE 4-2 POWER CRIMP P/N A10001

4.3 GAUGE/REGULATOR ASSEMBLY

BRASS GAUGE / ZINC REGULATOR ASSEMBLY - P/N A10002



(OPTIONAL) STAINLESS STEEL GAUGE / REGULATOR ASSEMBLY - P/N A10003

FIGURE 4-3 DWG-A-19002-1

NUMBER	QTY	PART NUMBER	DESCRIPTION
BRASS GAUGE/REGULATOR ASSEMBLY P/N A10002			
1	1	A30002	1/4" FEMALE COUPLER (ZINC CHROMATE FINISH)
2	1	A30003	1/4" AIR RELIEF VALVE
3	2	A30004	1/4" HEX NIPPLE
4	1	A30005	1/4" REGULATOR
5	1	A30006	1/4" FEMALE TEE
6	1	A30007	AIR PRESSURE GAUGE
(OPTIONAL) STAINLESS STEEL GAUGE/REGULATOR ASSEMBLY P/N A10003			
1	1	A30002	1/4" FEMALE COUPLER (ZINC CHROMATE FINISH)
2	1	A30008	1/4" AIR RELIEF VALVE
3	2	A30009	1/4" HEX NIPPLE
4	1	A300010	1/4" REGULATOR
5	1	A30011	1/4" FEMALE TEE
6	1	A30012	AIR PRESSURE GAUGE

TABLE 4-3 GAUGE / REGULATOR ASSEMBLY
P/N A10002 AND P/N A10003

4.4 AIR PRESSURE VERIFICATION GAUGE ASSEMBLY

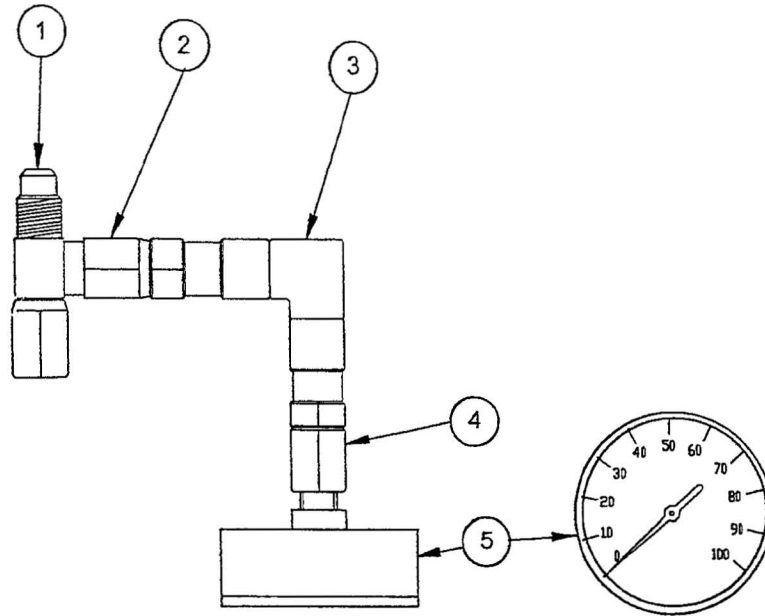


FIGURE 4-4 DWG-A-19003-1

NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	A30066	SWIVEL NUT RUN TEE
2	1	A30068	SWIVEL NUT TO MALE PIPE ADAPTER
3	1	A30020	1/4" NPT ELBOW
4	1	A30067	SWIVEL 1/4-1/4 NPT
5	1	A30092	AIR PRESSURE GAUGE 1/4 NPT MALE

TABLE 4-4 AIR PRESSURE VERIFICATION GAUGE ASSEMBLY P/N A10013

4.5 SUPPLY AIR HOSE ASSEMBLY

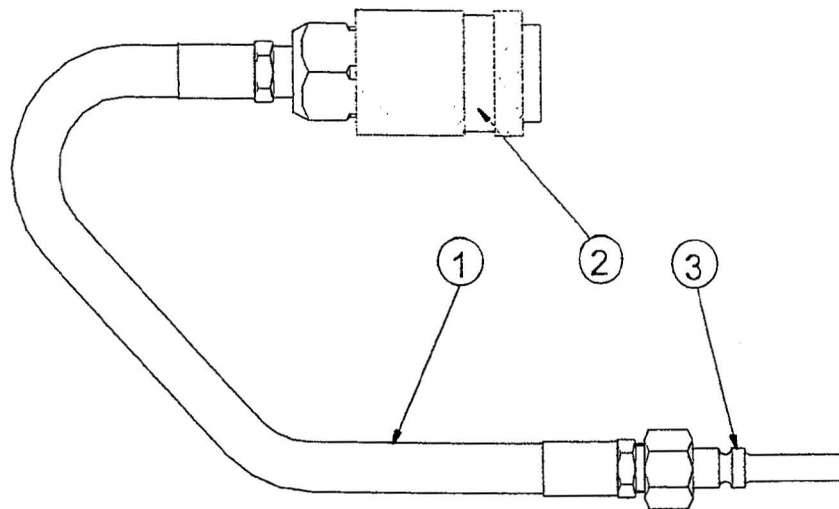
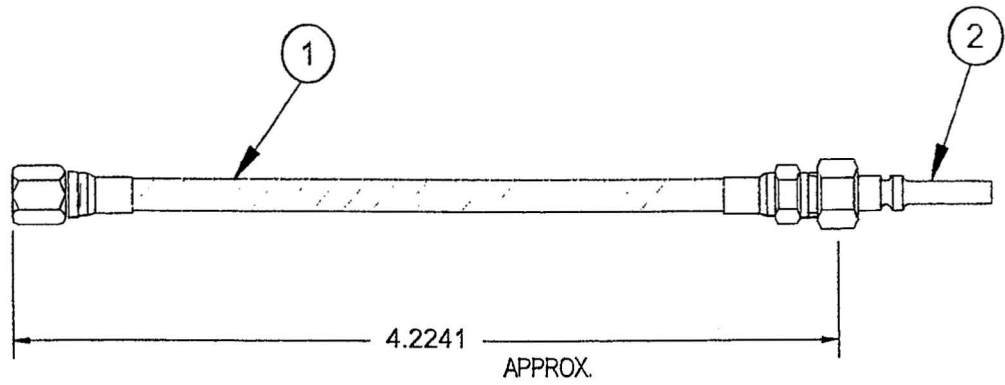


FIGURE 4-5 DWG-A-19004-1

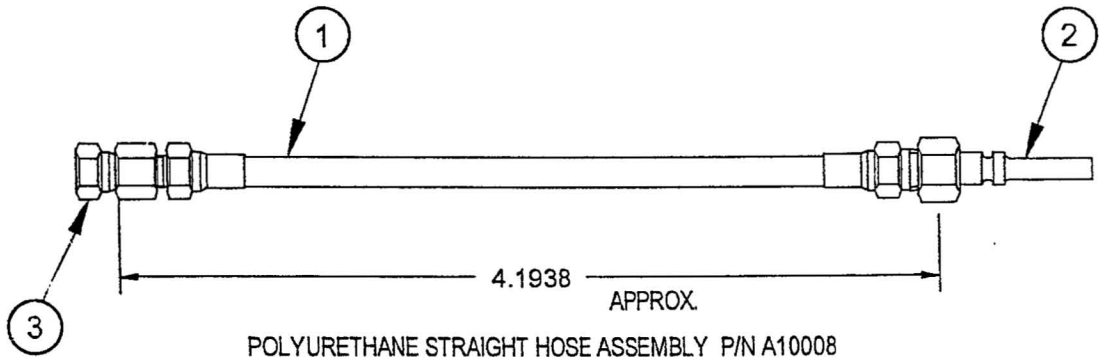
NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	A30026	"BUNA-N" RUBBER HOSE (8 FT) W/BRASS FITTINGS
2	1	A30002	1/4" FEMALE COUPLER (ZINC CHROMATE FINISH)
3	1	A30017	1/4" FEMALE COUPLER (ZINC CHROMATE FINISH)

TABLE 4-5 SUPPLY AIR HOSE ASSEMBLY P/N A10005

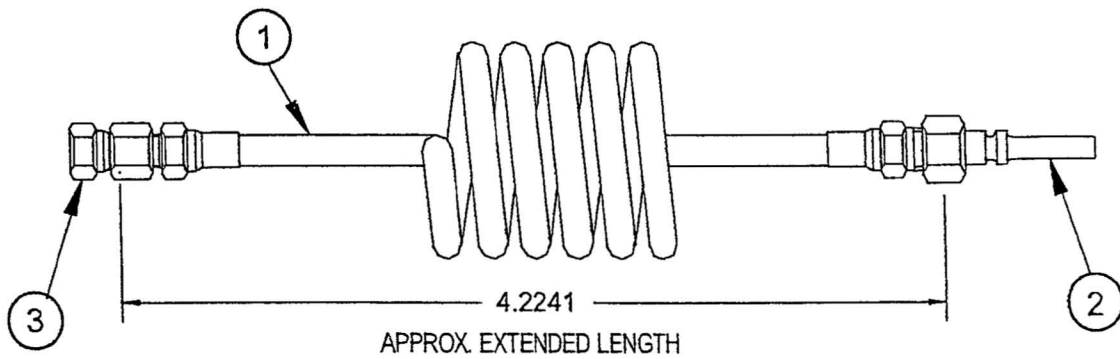
4.6 POWER CRIMP AIR SUPPLY HOSE ASSEMBLY



BRAIDED STAINLESS STEEL HOSE ASSEMBLY P/N A10009



POLYURETHANE STRAIGHT HOSE ASSEMBLY P/N A10008



POLYURETHANE SELF-STORING HOSE ASSEMBLY P/N A10007

FIGURE 4-6 DWG. A-19005-1

NUMBER	QTY	PART NUMBER	DESCRIPTION
BRAIDED STAINLESS STEEL HOSE ASSEMBLY P/N A10009			
1	1	A30027	S.S. BRAIDED/TEFLON HOSE W / S.S. FITTINGS
2	1	A30017	FEMALE CONNECTOR (ZINC CHROMATE FINISH)
POLYURETHANE STRAIGHT HOSE ASSEMBLY P/N A10008			
1	1	A30062	INNER-BRAIDED POLYURETHANE HOSE W / BRASS FITTINGS
2	1	A30017	FEMALE CONNECTOR (ZINC CHROMATE FINISH)
3	1	A30058	FEMALE PIPE TO SWIVEL NUT ADAPTER (ZINC CHROMATE FINISH)
POLYURETHANE SELF-STORING HOSE ASSEMBLY P/N A10007			
1	1	A30025	POLYURETHANE SELF-STORING HOSE W / BRASS FITTINGS
2	1	A30017	FEMALE CONNECTOR (ZINC CHROMATE FINISH)
3	1	A30058	FEMALE PIPE TO SWIVEL NUT ADAPTER (ZINC CHROMATE FINISH)

TABLE 4-6 POWER CRIMP AIR SUPPLY HOSE ASSEMBLY
P/N A10009, P/N A10008, AND P/N A10007

4.7 POWER CRIMP STAND ASSEMBLY

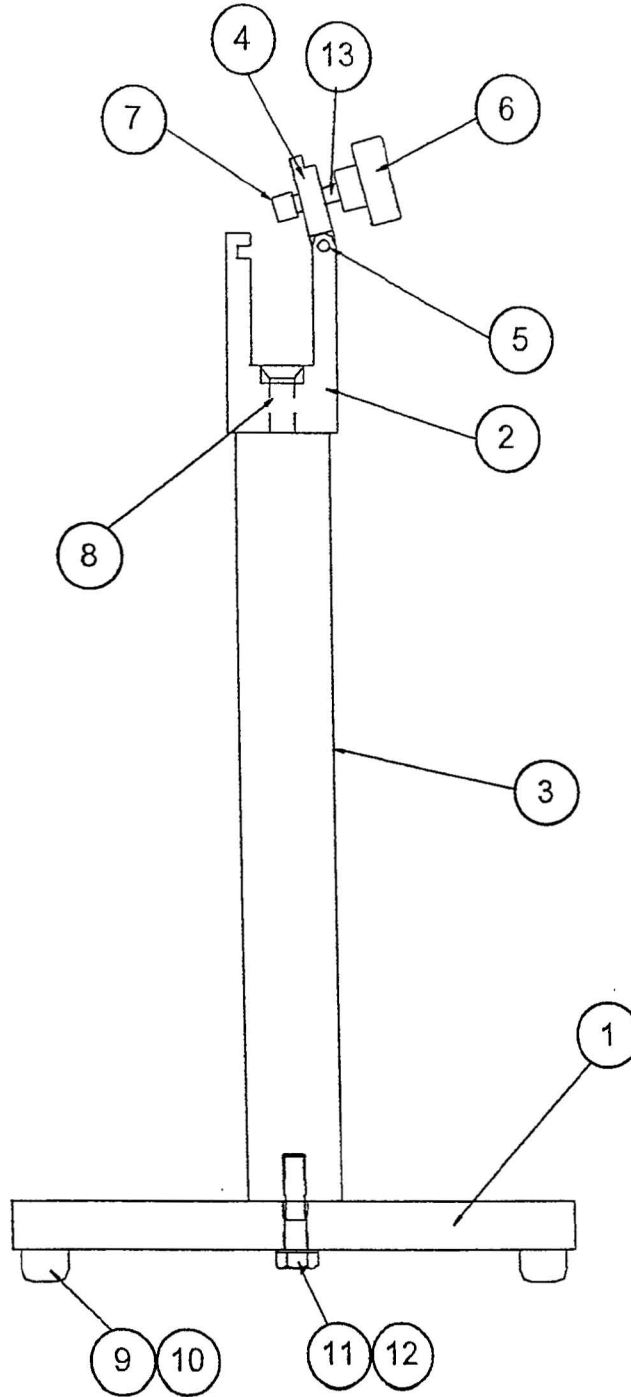


FIGURE 4-7 POWER CRIMP STAND ASSEMBLY - DWG-A19006-1

NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	A30013	BASE PLATE
2	1	A30014	HANDLE SUPPORT BLOCK
3	1	A30015	POST
4	1	A30023	COVER PLATE
5	1	A30024	HINGE PIN
6	1	A30016	PLASTIC KNOB
7	1	A30059	SCREW CAP
8	1	91-3716-C-175-C	F.H.C.S.
9	4	A30060	STAND PAD
10	4	91-0832-J-050-C	R.H.M.S.
11	1	91-3716-P-175-C	H.H.C.S.
12	1	91-4062-F-000-C	FLAT WASHER
13	1	A30064	1/4-20 X 1" SS SHCS

TABLE 4-7 POWER CRIMP STAND ASSEMBLY – P/N A10010

4.8 FOOT PEDAL ASSEMBLY

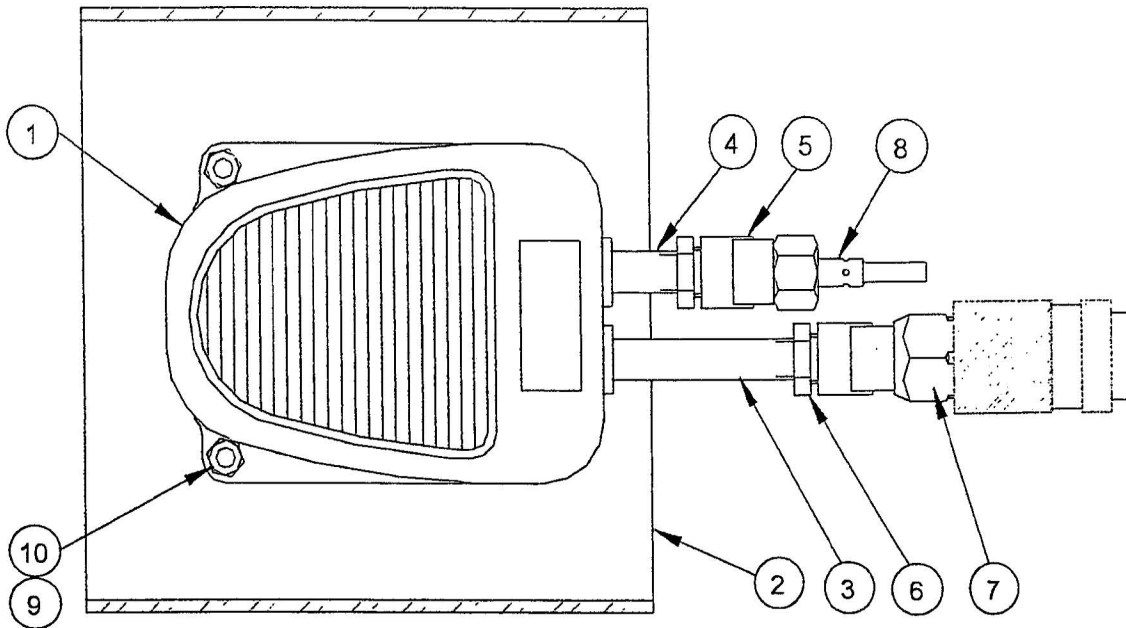


FIGURE 4-8 FOOT PEDAL ASSEMBLY - DWG-A-19007-1

NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	A30052	FOOT PEDAL
2	1	A30053	FOOT GUARD
3	1	A30054	4" LONG PIPE NIPPLE
4	1	A30055	2-1/2" LONG PIPE
5	2	A30056	45 DEGREE STEEL ELBOW
6	2	A30057	HEX. REDUCER BUSHING
7	1	A30002	1/4" FEMALE COUPLER
8	1	A30017	1/4" FEMALE CONNECTOR
9	2	91-1024-N-000-C	NUT
10	2	91-1024-C-075-B	FLAT HEAD SCREW

TABLE 4-8 FOOT PEDAL ASSEMBLY - P/N A10011

4.9 KEBBY PRO-SEAL

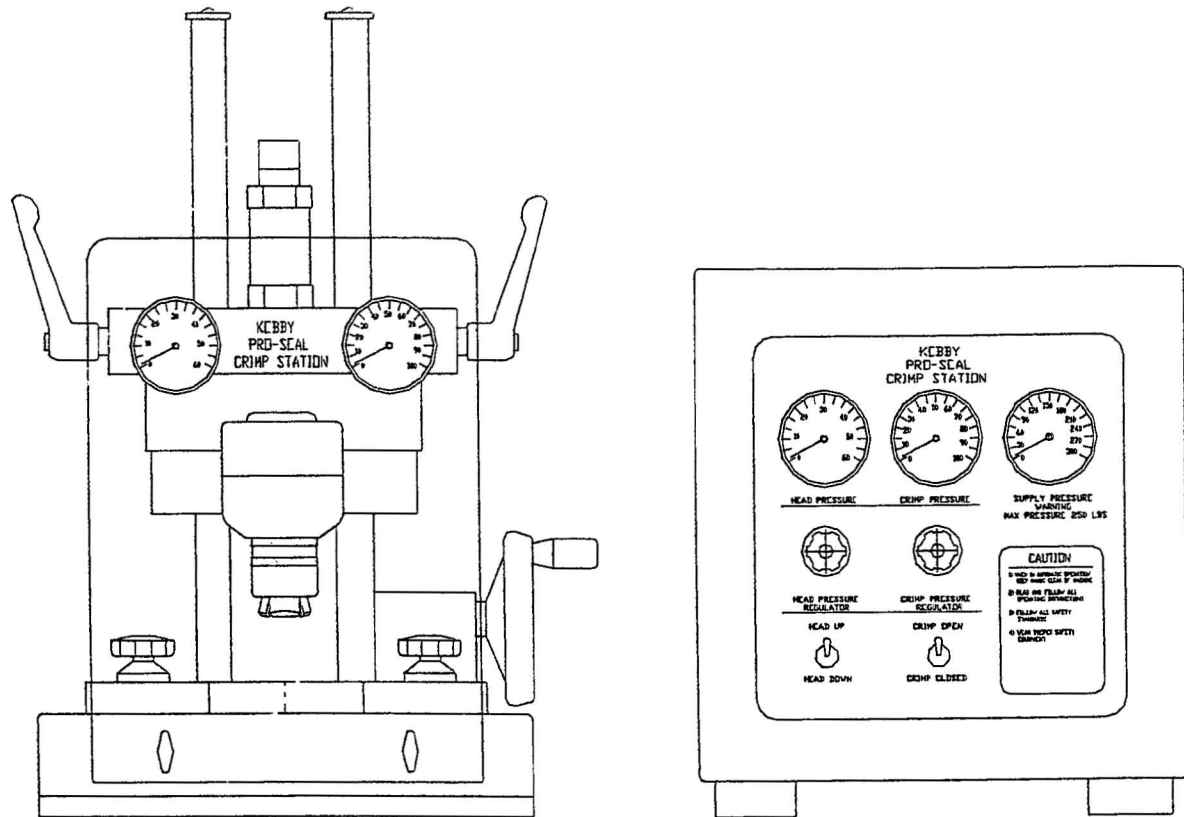


FIGURE 4-9 KEBBY PRO-SEAL

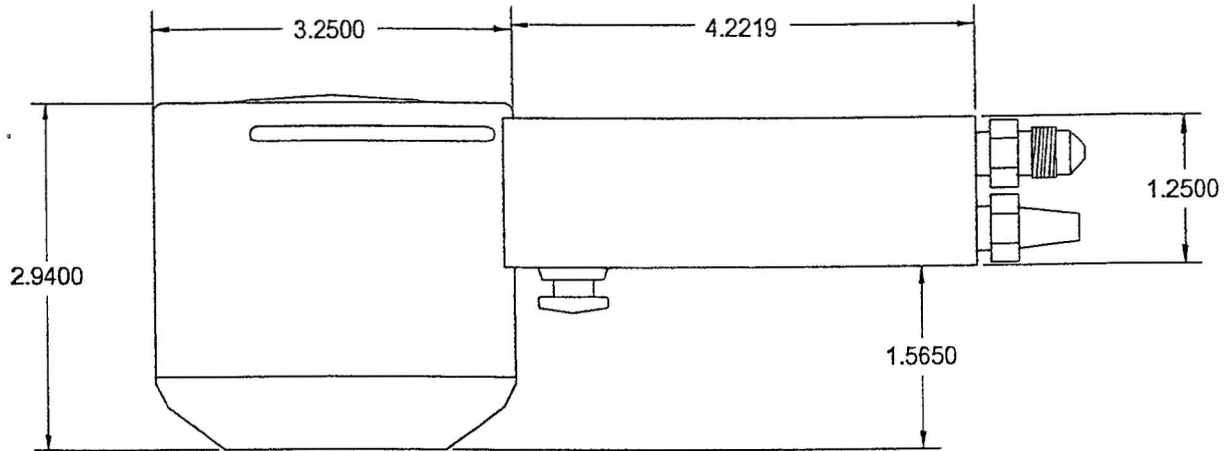
The Kebby "Pro-Seal" is a pneumatically controlled crimping station. It has been designed to increase the speed, ease, pressure and repeatability of crimping for most size bottles and caps.

The Kebby Pro-Seal is the ideal choice when a large quantity of crimp operations is necessary. The Pro-Seal can be set to a specific crimp pressure as well as downward pressure providing a perfect crimp every time.

For more information contact:

Kebby Industries Inc.
4075 Kilburn Avenue
Rockford, IL 61101, USA
Phone: (815) 963-1466
Fax: (815) 962-3490

4.10 POWER CRIMP DIMENSIONS



WEIGHT EACH APPROX: 2.04 LBS

FIGURE 4-10 POWER CRIMP DIMENSIONS - DWG-A-1009-1



MICRO-XL 4300

Adjustable
Bench
Crimper

Set up and Operation Manual



KEBBY INDUSTRIES INC.

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MICRO-XL 4300 Adjustable Bench Crimper

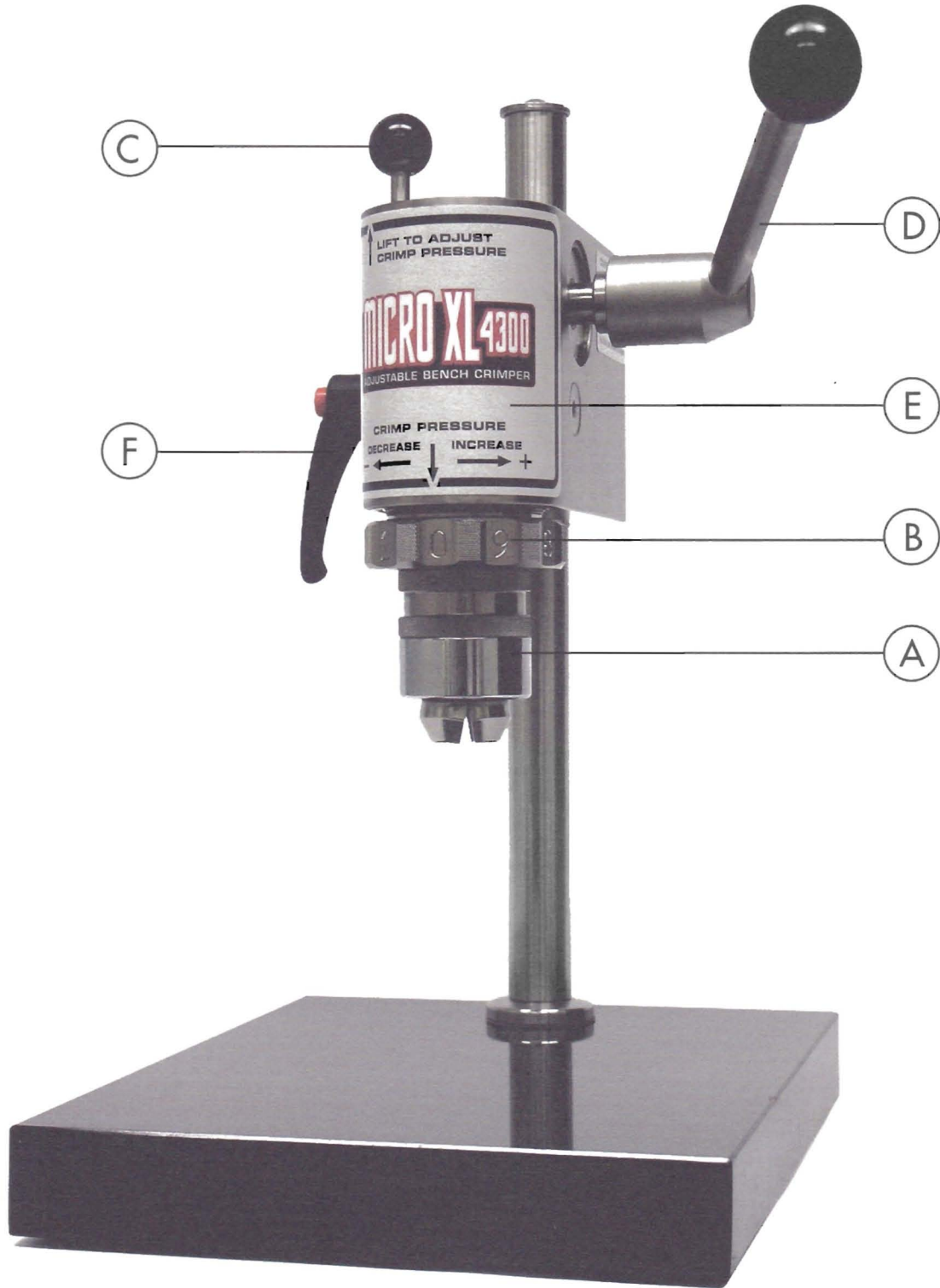
SET-UP INSTRUCTIONS

1. Screw the Crimper or Decapper Head (A) into the crimp pressure adjustment collar (B). The Head should screw in easily; do not over tighten. (Note: Lever arm (D) may move up when screwing in the head)
2. The adjustment collar (B) is set at the lowest possible setting when shipped from the factory. At this point we recommend that you pull the lever handle (D) to get an idea of where the handle stop is located. Avoid letting the handle spring back.
3. Insert the bottle with cap into head and pull the lever handle (D). It is likely that this crimp will not be tight enough. Lift up the collar locking pin (C) and turn the adjustment collar (B) to the right to increase crimp pressure in small increments until the desired crimp is obtained. Each position on the dial adjusts the crimp by 0.15mm or .006".
4. Once you have achieved the desired crimp, you can keep track of where the adjustment collar is set. You can use the number of rings that are visible on the collar locking pin (C) as a reference for that particular size and type of cap and stopper, and return to that setting to get the exact same crimp on future runs. (see example below) The lever handle (D) can be adjusted by pulling away from the crimp body (E) and rotating to a comfortable operating position. Note: Rotating the handle will not affect the crimp settings.
5. To raise and lower the crimp body (E), loosen the clamp lever (F) and adjust to the desired height and reclamp.
WARNING: Crimp body will fall if not supported when clamp lever is released.
6. When changing heads, sizes, or types, it is recommended that the crimp pressure is lowered and the same process is repeated.

Setting Example:

Number of visible rings on locking pin (C)	Number setting on adjustment collar (B)
2	4

Cap size	Cap type	Septum	Bottle	Crimp setting
*	*	*	*	2-4



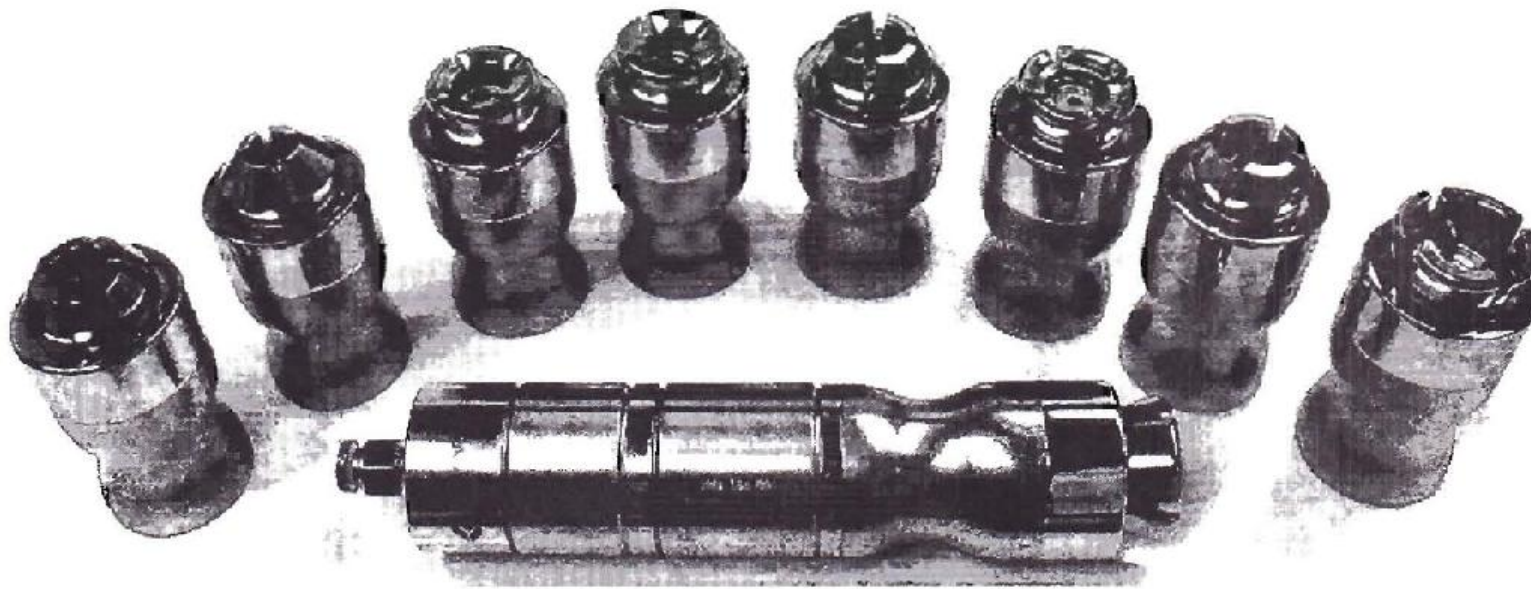


KEBBY INDUSTRIES INC

Product Manual

Vertical Air Crimper

By Kebby Industries, Inc.



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ECH*nology* Pty Ltd

Australian Distributors
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www.chromtech.net.au

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Warranty

All goods and materials shall conform to Kebby Industries Inc. specifications at the time of shipment from our plant. Kebby Industries Inc. warrants this product to be free from defects in material and workmanship for a period of one (1) year from the date of shipment. If repair or adjustment is necessary within the Warranty period, and has not been the result of mishandling, abuse, or incorrect operation or alteration by any person not authorized to perform such alterations, Kebby Industries Inc. will perform service on, or replace any non-conforming goods or materials at no charge to the original purchaser. All claims of product non-conformity must be made within ten (10) days of discovery to Kebby Industries Inc. at 815-963-1466. All claims of damage during shipment must be made within ten (10) days of shipment of the product from Kebby Industries Inc. at 815-963-1466. Caller should expect to provide the Model and Serial Number of the product. Items returned to Kebby Industries Inc. should be packaged in a manner so as to prevent damage and preserve the state of the product during shipment.

Kebby Industries Inc. makes no other Warranty, implied or express, statutory or otherwise concerning materials or goods supplied, including without limitation, ANY WARRANTY of fitness for a particular purpose or any warranty of merchantability. The warranties given are exclusive of all other warranties expressed or implied. Kebby Industries Inc. shall not be liable for consequential, special, or incidental damages.



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Introduction

The Vertical Air Crimper is designed for small to medium volume crimping and decapping of aluminum seals and aluminum flip style seals on crimp top vials. Interchangeable crimping or decapping heads can accommodate vial seal sizes of 8, 11, 13, and 20 millimeters.

One Time Set Up

Attach desired crimping or decrimping head to Vertical Air Crimper unit.

Attach pneumatic hose (FLU1106) to regulator and Vertical Air Crimper.

Attach regulator to incoming shop air supply (maximum 200 PSI).

Adjust regulator to 40 PSI.

Begin trials at 40 PSI, adjust regulator as needed (maximum 100 PSI) to obtain a tight crimp seal.

Specifications

Operating Pressure	Nominal 40 – 80 PSI
Incoming Air Supply	Pneumatic 90 - 100 PSI
Cap Sizes	8, 11, 13, 20, 13 Flip, 20 Flip
Unit Size (head attached)	Height = 6 ½" Diameter = 1 ½"
Weight	1.5 Lbs.
Cycle Time	.75 seconds to 1.5 seconds, adjustable



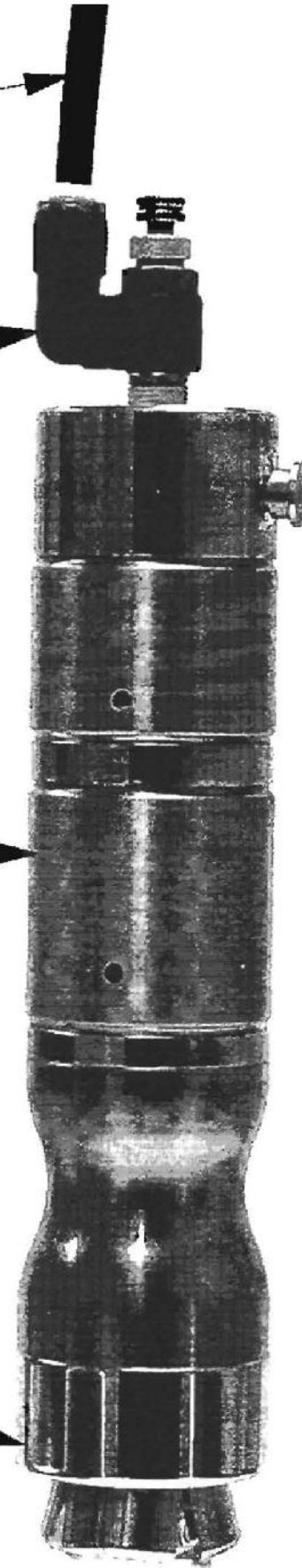
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1. Hose
Part No. FLU1106

2. Fitting / Adj. Needle Valve
Part No. V10003

3. Pneumatic Crimper Tool
Part No. V10001

4. Crimper or Decrimper Head
(sold separately)



Crimping Instructions

Connecting or replacing the crimping/decrimping head

STOP – Make sure the air supply is disconnected from the Vertical Air Crimper regulator unit! Never insert fingers or other foreign objects other than vial/cap assemblies into or near the crimping head jaws.

Attach the correct crimping head by screwing it into the main unit.

Reattach air supply to the Vertical Air Crimper regulator unit.

Place the appropriate cap on the vial.

Crimping

Place the Vertical Air Crimper unit over the cap and vial assembly. Make sure the unit sits flush upon the top of the vial.

Depress and release the operation button to crimp the cap onto the vial.

Tips for a Good Seal

Properly test and set up your Vertical Air Crimper and regulator assembly and make any pressure adjustments before use.

- Lower air pressure will produce a looser seal, higher pressure will produce a tighter seal. It is important to test and adjust to the ideal pressure setting to ensure that the cap is sealed properly without damaging the cap or vial. A proper seal may appear slightly domed, but will not be damaged. A proper seal will be tight enough that it cannot be twisted.

Make sure you have the Vertical Air Crimper and Crimp head properly seated on the cap/vial assembly.

- If the Vertical Air Crimper is not seated on the cap flushly a proper seal may not be achieved.

Ensure you are using the proper crimping head for the cap and vial assembly you are sealing.

- Caps and vials come in many sizes and styles. Please call www.chromtech.net.au if you believe you have the wrong size crimping or decapping head for your application.



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Decapping Instructions

Connecting or replacing the crimping/decrimping head

STOP – Make sure the air supply is disconnected from the Vertical Air Crimper regulator unit! Never insert fingers or other foreign objects other than vial/cap assemblies into or near the decrimping head jaws.

Attach the correct decrimping head by screwing it into the main unit.

Reattach air supply to the Vertical Air Crimper regulator unit.

Decapping

Place the Vertical Air Crimper unit over the cap and vial assembly. Make sure the unit sits flush upon the top of the vial.

Depress and hold the operation button.

Lift the Vertical Air Crimper unit straight up to remove cap from the vial.

Release the operation button.

Care and Cleaning

To reduce risk of injury, never insert fingers or other foreign objects other than cap/vial assemblies into the crimping or decapping head jaws.

To ensure the longest life for your Vertical Air Crimper, perform the following care and maintenance on a regular schedule.

Clean dust and debris from the Vertical Air Crimper unit. Wipe with a clean, damp cloth for normal dust and debris, use alcohol wipes to remove any grease or oil from the unit.

It is not necessary to lubricate your Vertical Air Crimper. Do not immerse in any liquid or let any liquid penetrate the tool.

Do not disassemble unit. If liquid penetrates unit, call
for service. Do not use solvents such as gasoline, turpentine, paint thinner, ammonia or household cleansers on the Vertical Air Crimper.



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Troubleshooting Problems

NEVER ATTEMPT TO PERFORM REPAIRS ON THE VERTICAL AIR CRIMPER UNIT! Service should be performed by authorized Kebby Industries Inc. service personnel only.

Unit will not operate –

Cause: Air Supply hose not connected to regulator or unit.
Remedy: Ensure air supply is connected to regulator and regulator is connected to unit.

Cause: Operation button not fully depressed or held long enough for the unit to engage.
Remedy: Fully depress operation button and hold for up to one second to engage unit.

Unit not crimping tightly –

Cause: Unit not adjusted to proper air pressure
Remedy: Test and adjust the air pressure settings on the air pressure regulator.

Unit crimps too tightly, deforms, or over crimps cap –

Cause: Unit not adjusted to proper air pressure
Remedy: Test and adjust the air pressure settings on the air pressure regulator

Unit jams when crimping –

Cause: Cap has likely been over crimped or deformed.
Remedy: Test and adjust the air pressure settings on the air pressure regulator.

Cause: Defective or poor quality caps.
Remedy: Run job with different batch or brand of caps.

Unit jaws lock and will not release:

Cause: Cap has likely been over crimped or deformed.
Remedy: Disconnect air supply from air supply regulator, lift Vertical Air Crimper off vial.



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Accessories and Part Numbers

V10001-00	Vertical Air Crimper Body
V10002-00	Air Pressure Regulator for VAC
FLU1106	Air Hose for VAC
V10003-00	Adjustable Needle Valve for VAC
V-11001-00-D	Decapping Head
V-13001-00-D	Decapping Head
V-20001-00-D	Decapping Head
V-08001-00-C	Crimping Head for 8 mm CRIMP SEALS
V-11001-00-C	Crimping Head for 11 mm CRIMP SEALS
V-13001-00-C	Crimping Head for 13 mm CRIMP SEALS
V-13002-00-C	Crimping Head for 13 mm FLIP-OFF CRIMP
V-20001-00-C	Crimping Head for 20 mm CRIMP SEALS
V-20002-00-C	Crimping Head for 20 mm FLIP-OFF CRIMP

Frequently Asked Questions and User Issues

How tight is tight? And when is it too tight?

A correctly crimped vial is neither over-crimped nor under-crimped. Over-crimping may cause coring or poor septum resealing, while under-crimping can cause evaporation problems.

With proper adjustment a tight seal can be achieved every time. In most cases, when the vial is crimped perfectly, the cap should not be able to rotate and the septum should appear smooth and level.

Note: The smaller vials and seals will normally have a more pronounced crown or dome effect when the seal is crimped when compared to the 20mm and larger sizes. An indication that the seal is over-crimped will be coring of the stopper or septa, or there may be indentations on the side of the seal or skirt. Another consideration when determining the tightness of a seal is the stopper or septa material. If the stopper or septa material is Teflon, it is likely that the seal can still be turned, even when it is over crimped.

There are many factors that will affect the seal crimp, such as length of the skirt, the thickness and rigidity of the stopper, the stopper or septa material. The type of lip or mouth on the vial. (For instance, flat vs. beveled). How well the components fit together, etc.

The side of the cap is denting when it is crimped onto the vial

Are you using the right crimper for the seal being crimped? For example, a 20mm flip-off crimper will not work for a standard 20mm seal.

Am I crimping the vial too far?

The seal may be over crimped, or too far. Try backing off on the distance or pressure the cap is being crimped at.

The cap looks crooked.

The seal may be crooked. The crimper jaws will correct for this in most situations, by centering and straitening the seal during the crimp process. However, if the cap is handing off the stopper alt more on one side than the other, the jaws may not center and straighten the seal completely.

Over time there will be aluminum or enamel build up on the inside of the jaws, where the seal is formed or wrapped. Normally this occurs after crimping between 1,000 and 3000 seals. If used in a clean room environment, build up of aluminum occurs much faster and more often, due to the lack of moisture and particulates in the air which act as a lubricant to some extent. To check to see if there is aluminum or enamel build up on the jaws, use a swab to wipe the inside radius of the jaws. If the swab has a grey tone to it after wiping, the jaws will need to be cleaned, using a swab and alcohol. It is then recommended that clean room or food grade grease be wiped inside the jaws. A thin film is all that is needed.

Are you crimping in a clean room environment?

When used inside a clean room or hooded environment, you may begin to see a degradation in the finished crimped seal. In an ambient environment, there is moisture along with dust particulates in the air. The dust particulates and moisture in the air act as a lubricant. ((Continual rubbing, or wearing of aluminum as it is formed, will begin to cause a build up a combination of lacquer and possibly aluminum particulates. (The crimp seals are normally processed with a film or coating when they are manufactured.))

Normally this occurs after crimping between 1,000 and 3000 seals. If used in a clean room environment, build up of aluminum occurs much faster and more often, due to the lack of moisture and particulates in the air which act as a lubricant to some extent. To check to see if there is aluminum or enamel build up on the jaws, use a swab to wipe the inside radius of the jaws. If the swab has a grey tone to it after wiping, the jaws will need to be cleaned, using a swab and alcohol. It is then recommended that clean room or food grade grease be wiped inside the jaws. A thin film is all that is needed.

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Are you crimping in a clean room environment?

When used inside a clean room or hooded environment, you may begin to see a degradation in the finished crimped seal. In an ambient environment, there is moisture along with dust particulates in the air. The dust particulates and moisture in the air act as a lubricant. ((Continual rubbing, or wearing of aluminum as it is formed, will begin to cause a build up a combination of lacquer and possibly aluminum particulates. (The crimp seals are normally processed with a film or coating when they are manufactured.))

Normally this occurs after crimping between 1,000 and 3000 seals. If used in a clean room environment, build up of aluminum occurs much faster and more often, due to the lack of moisture and particulates in the air which act as a lubricant to some extent. To check to see if there is aluminum or enamel build up on the jaws, use a swab to wipe the inside radius of the jaws. If the swab has a grey tone to it after wiping, the jaws will need to be cleaned, using a swab and alcohol. It is then recommended that clean room or food grade grease be wiped inside the jaws. A thin film is all that is needed.

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It will be necessary to clean and lubricate the crimper jaws periodically. (See preventative maintenance or care)

How do I tell what crimper I need?

Measure the inside diameter of the seal to determine the size. The type can be determined by visual comparison on the crimp seal cross reference chart. See the [Cap Sizes & Styles](#) page for more information.

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MICRO-XL 4300 Adjustable Bench Crimper

VIAL CRIMPER & DECAPPER HEADS

Additional sizes and styles available for use with other seals not shown here.
Custom sizes and styles also available. Contact us for more details.



KEBBY PART #	CRIMP HEAD SIZE	CAP TYPE
07501-00-K01E	7.5mm	Crimp caps
08001-00-K01E	8mm	Crimp caps
11001-00-K01E	11mm	Crimp caps
13001-00-K01E	13mm	Crimp caps
20001-00-K01E	20mm	Crimp caps
28001-00-K01E	28mm	Crimp caps
30001-00-K01E	30mm	Crimp caps
32001-00-K01E	32mm	Crimp caps
13002-00-K01E	13mm	Flip-off seals
16502-00-K01E	16.5mm	Flip-off seals
20002-00-K01E	20mm	Flip-off seals
28002-00-K01E	28mm	Flip-off seals
30002-00-K01E	30mm	Flip-off seals
32002-00-K01E	32mm	Flip-off seals
32002-01-K01E	32mm	Flip-off-tear-off seals with shorter shell or skirt length
13003-00-K01E	13mm	Flip-tear-off seals
20003-00-K01E	20mm	Flip-tear-off seals
13016-00-K01E	13mm	Crimp style spray pumps
15016-00-K01E	15mm	Crimp style spray pumps
18016-00-K01E	18mm	Crimp style spray pumps
20016-00-K01E	20mm	Crimp style spray pumps
28008-00-K01E	28mm	2 pc Tear off Crimp Head for unit dose packaging

KEBBY PART #	DECAPPING HEAD SIZE
08001-00-L01E	8mm
11001-00-L01E	11mm
13001-00-L01E	13mm
20001-00-L01E	20mm
28001-00-L01E	28mm
30001-00-L01E	30mm
32001-00-L01E	32mm

To place an order or to obtain more information, call, fax, or visit our website.
We ship all products UPS.
Billing is available with an open account, C.O.D. UPS, or Visa/Mastercard.



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