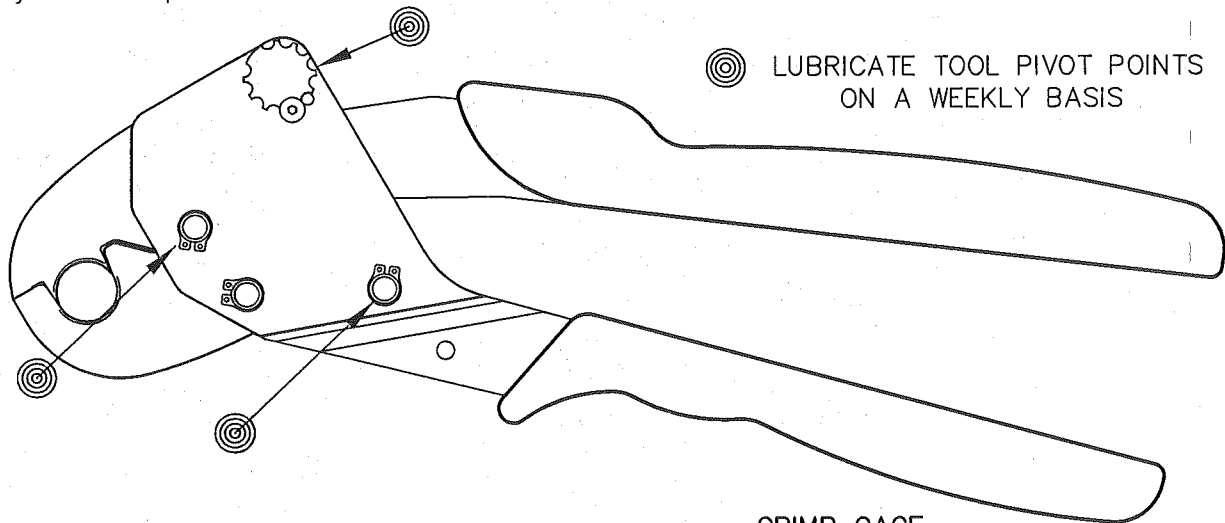


### HANDLE PRE-LOAD ADJUSTMENT PROCEDURE

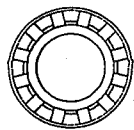
- 1) Handle pre-load adjustment is performed after it has been determined that the crimped sleeve/fitting connection no longer meets the industry standard by measuring with a caliper or the supplied gage. In either case do not measure across the flashed portion of the sleeve. See Fig 1.
- 2) Prior to adjusting the tool, measure the handle opening with jaws butting for later reference. The tool should measure between 4"-4 1/2" for 1/2" fittings as shown above.
- 3) To adjust the tool, remove the retaining ring from the adjustment cam on the back side of the tool.
- 4) Remove the #6 lock screw and push up the notched eccentric lock plate from below and rotate to the next available notch as shown above. Opening the handles slightly to remove spring tension will make turning the eccentric easier. Rotate counter-clockwise to increase pre-load and clockwise to decrease pre-load as shown above if originally to the right side of the \*. If originally to the left side of the \* rotate in the opposite direction as shown. Do not pre-load any more than necessary to meet crimp gaging as crimping effort and tool wear will increase as well.
- 5) Push the eccentric lock down flush to engage half-punch and replace the #6 lock screw and retaining ring.
- 6) Check the handle load and subsequent crimps to ensure crimps are within specifications.
- 7) Re-adjust as required.



### GAGE ALL CRIMPS!!

CRIMP SLEEVE GAGING (1/2")  
AFTER CRIMPING ON PIPE/FITTING ASSEMBLY

1/2" MAXIMUM, in (mm)  
.639 (16.23)



1/2" MINIMUM, in (mm)  
.624 (15.85)

AVOID THIS AREA (SEAM)  
WHEN GAGING CRIMPED SLEEVE

### CRIMP GAGE

