

# Operation Book

(P20, P32, P38, P45)



P32

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**SAMWAY**

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# GENERAL

SAMWAY crimping machines are electrically operated hydraulic crimping machines for hydraulic hose assemblies.

The crimping machine comprises a crimping head and a hydraulic unit mounted on the oil tank which serves as machine frame.

SAMWAY crimping machine is normally delivered with a 3-phase electric motor. On request it can be equipped with a single phase motor.

## Transport

The packed machine is transported on a pallet, which is easy to move and lift by a fork-lift truck. After unpacking, the machine can be lifted using a hoisting belt.

Size of package for P51-models:

x = 102, y = 82, z = 113 cm.

Size of package for other models:

x = 77, y = 62, z = 81 cm.

## Storage

The manufacturer has protected the machine against corrosion by using the Zerust method. The machined parts have been treated with Axxatec 77C protective agent. A Zerust vapor capsule has been put into the electric box, and the machine has been packed into a bag made of Zerust film.

The protection is effective for months if the package is not opened. After opening it, the protection of the wrapping film ceases. If the machine is not yet brought into use, it must be reprotected against corrosion. The machine is to be stored in dry indoor conditions.

Remove the protective agent according to the instructions enclosed in the package.

## Mounting

The adjacent picture shows an appropriate way to lift the machine after it has been unpacked.

It is recommended to mount the machine on a SAMWAY table. Before mounting, the table must be screwed on the floor with four M12 wedge anchors. Boreholes in the floor: Ø 12 mm, depth 55 mm.

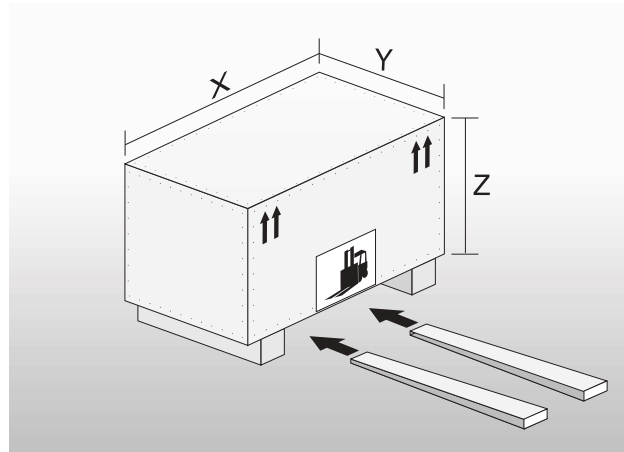
When the machine is mounted on a SAMWAY table, the four shoes under the machine are removed.

The table with assembly instructions is packed separately.

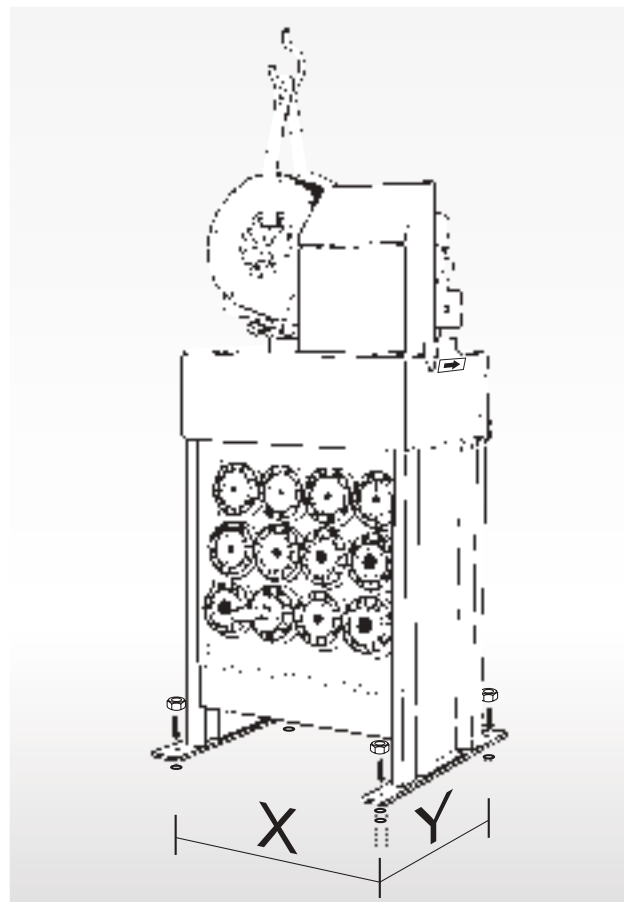
The crimper may be installed on some other table as well, provided it is sturdy and broad enough or it has been fastened on the floor so that it cannot fall over. Furthermore, there must be a hole in the table to enable emptying the oil tank through the drain plug.

P20, P21 and CC22 -models: x = 558, y = 560

P32 and P51 -models: x = 625, y = 560.



Pakkaus1.eps



Insta\_32.eps

# WARNINGS

## General

The machine is intended for professional use. It is to be operated only by a trained operator who has understood the dangers involved in the operation.

Openings between the dies exceed 6 mm, thus being large enough to let fingers go between the dies and get crimped. It is, therefore, **ABSOLUTELY** necessary to follow operating instructions and warnings indicated by the stickers on the machine when changing dies and crimping fittings.

## Danger zones



003199.eps

### WARNING 1

Do not put your hands inside the dies while the motor is running!



003306.eps

### WARNING 2

When crimping a fitting, hold the hose far enough to avoid crimping your hand!

### WARNING 3

Dies open and close by depressing the hand emergency push-buttons at both ends of the valve. Do not touch these push-buttons during normal operation!

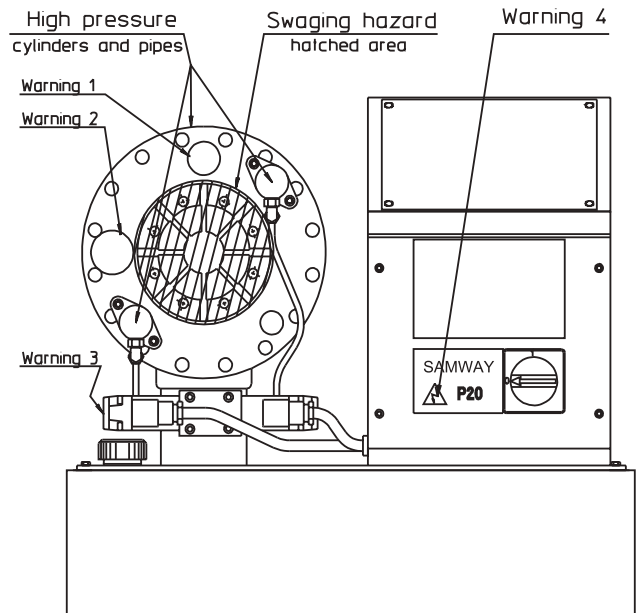


003002.eps

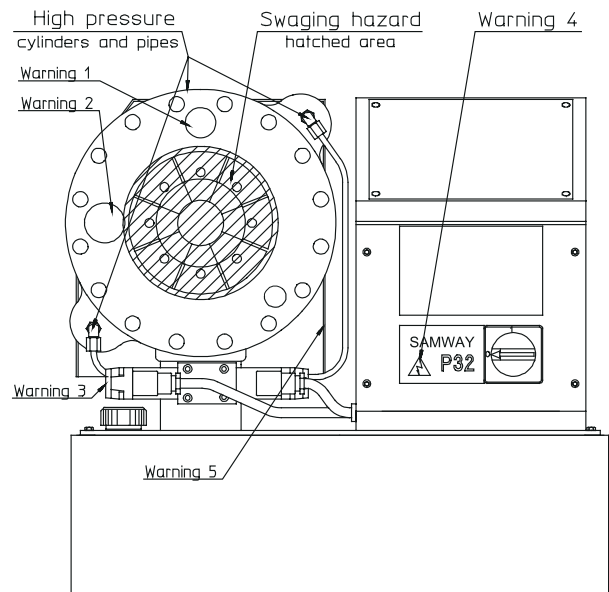
### WARNING 4

High voltage.

The electric box is to be opened only by a professional electrician!



P20dange.eps



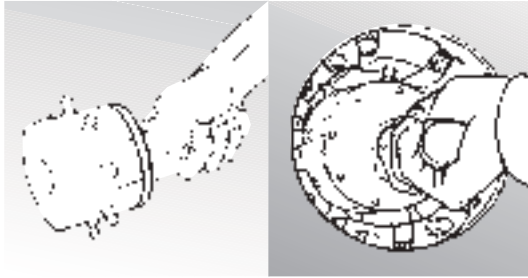
P32var.hgl

### WARNING 5 (P32 model)

The rear of the crimping head is covered by a housing protecting the operator from the crimping hazard under the housing between rear flange and cylinder.

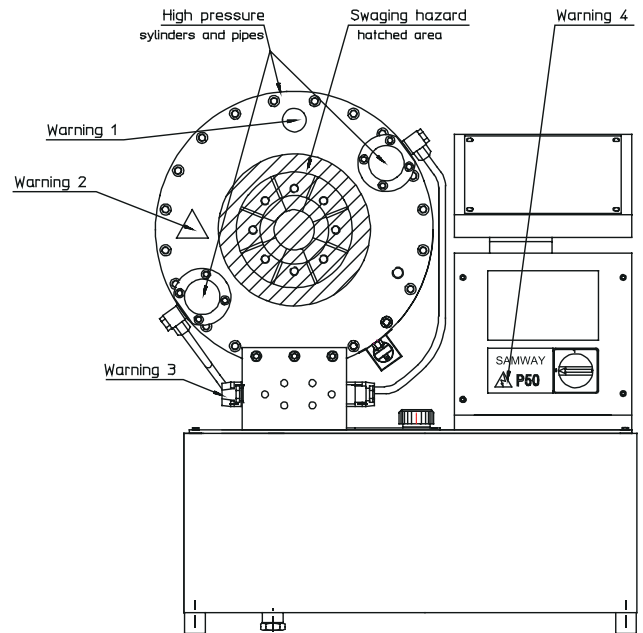
Do not remove this housing!

keeptool.eps



### WARNING 6

When changing dies with the quick change tool, hold the handle as shown in the above figures. Make sure your hand will not get between the dies!



P50var.hgl

## COMMISSIONING

### Oil fill

Fill the oil tank to centre line of the indicators in the dipstick with hydraulic oil like Shell Tellus T46 or equivalent. Volume of the tank is 32 litres (P51 –model: 50 litres).

It is recommended to pump the oil into the tank through a 20 µ filter, because new oil in drums is not pure.

### Electrical connection

**CAUTION!** Check that the machine voltage (see type plate) is equal to your supply voltage. For proper installation to local code, consult a licensed contractor.

Bring the supply cable in through the hole in the side panel of the electric box. Secure the cable with a stress relief plug.

**3-phase:** Connect the phase conductors to the respective L1, L2 and L3 terminals in the supply disconnecting device. Connect the earth connection to the ground terminal on the fixing plate. Check the connection against the wiring diagram enclosed in the spare parts list.

Check that the motor rotation is parallel with the arrow on the tank close to the motor. In case the motor rotates in wrong direction, two phase conductors in the supply disconnecting device must be interchanged.

**1-phase:** Connect the phase and the neutral to the respective terminals in the supply disconnecting device. Connect the earth connection to the ground terminal on the fixing plate. Check the connection against the wiring diagram enclosed in the spare parts list.

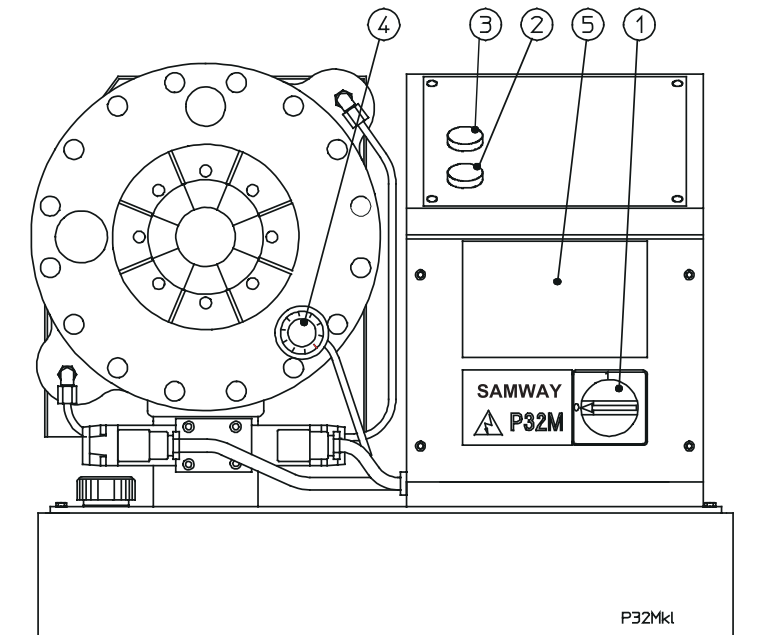
### Quick Fix-package

Included with the machine, there is a Quick Fix-package which has some basic parts for that machine model.

# OPERATION

## Control identification MS -control

1. **Supply disconnecting device** for starting and stopping the motor. The device is used to separate the machine from power supply. However, the undervoltage trip can be made dead only by disconnecting the plug or supply cable from the mains.
2. As long as the **crimping push-button** is depressed, the dies will close until the button is released or the preset crimping diameter is reached.
3. **Retraction button**. When depressed and held down, the dies will open until the button is released or the maximum retraction is reached.
4. **Crimping diameter dial**.
5. **Die chart** with crimping diameter range for each die set and corresponding dial adjustment values.



P32Mkl.hgl

The main operating area of the machine is in front of the controls.

## Covers P32

The rear of the crimping head is covered by a housing protecting the operator from the crimping hazard between rear flange and cylinder.

KEEP THIS COVER HOUSING IN ITS PLACE DURING CRIMPING!

## Test run MS controls

- Start the motor.
- Set the crimping diameter dial to 0.0.
- During the first crimping cycles air in the cylinders may make the piston/dies move irregularly and at high speed. Cycle the press a few times till the motion becomes even.
- To avoid accidents, make sure that there are no foreign objects between the dies.
- In case the dies do not move in either direction, the motor rotates in wrong direction. Correct by interchanging two phase conductors in the supply disconnecting device.

## Selecting the die set P32

Use only original SAMWAY die sets in SAMWAY crimping machines.

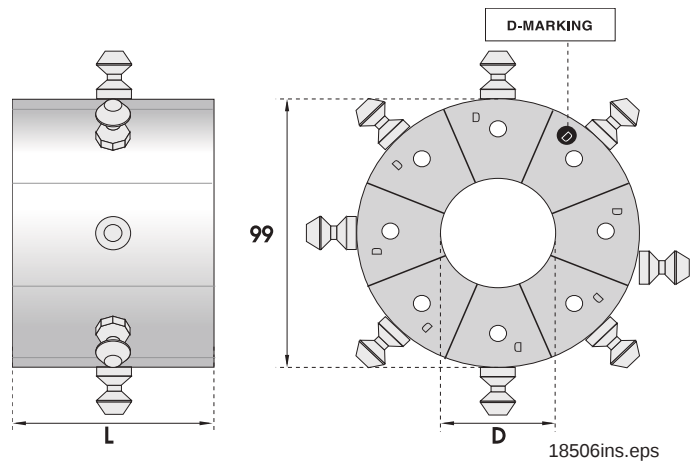
Refer to the fitting manufacturer's specifications for proper crimping diameter for the fitting.

Each die set has its own crimping range. Follow it to assure the roundest possible crimping result.

The minimum crimping diameter **D** is marked on each die set.

Example: with die set No 18506/10 the minimum crimping diameter is 10 mm.

| D  | L   | Die set No | Crimping range |
|----|-----|------------|----------------|
| 10 | 55  | 18506/10   | 10 ... 12 mm   |
| 12 | 55  | 18506/12   | 12 ... 14 mm   |
| 14 | 55  | 18506/14   | 14 ... 16 mm   |
| 16 | 55  | 18506/16   | 16 ... 19 mm   |
| 19 | 55  | 18506/19   | 19 ... 22 mm   |
| 22 | 70  | 18506/22   | 22 ... 26 mm   |
| 26 | 70  | 18506/26   | 26 ... 30 mm   |
| 30 | 70  | 18506/30   | 30 ... 34 mm   |
| 34 | 75  | 18506/34   | 34 ... 39 mm   |
| 39 | 75  | 18506/39   | 39 ... 45 mm   |
| 45 | 90  | 18506/45   | 45 ... 51 mm   |
| 51 | 90  | 18506/51   | 51 ... 57 mm   |
| 57 | 100 | 18506/57   | 57 ... 63 mm   |
| 63 | 110 | 18506/63   | 63 ... 69 mm   |
| 69 | 110 | 18506/69   | 69 ... 75 mm   |
| 74 | 110 | 18506/74   | 74 ... 80 mm   |
| 78 | 110 | 18506/78   | 78 ... 87 mm   |



In addition to the standard dies, a wide range of special dies is available on request.

## Installing the die set

### QUICK CHANGE MS (OPTION)

An optional Quick Change Tool Base enables storing die sets under the machine. Die sets can be installed into the master dies with a quick change tool one set at a time.

- Before installing dies, make sure that the master dies are clean.
- **STOP THE MOTOR PRIOR TO CLEANING DIES.**
- Insert the pins of the tool into the die set in the die table, turn the tool clockwise and pull the whole set out (Fig. 1, next page).
- Hold the handle of the quick change tool as shown in figures 1 and 2, and make sure your hand will not get between the dies.
- Mount the die set between master dies (Fig. 2) and start closing the dies.
- **TO AVOID DAMAGING MASTER DIES, MAKE SURE THAT ALL DIE SET PINS HIT IN THEIR HOLES.**
- Close the master dies completely until the pins are locked in their places (Fig. 3). Remove the tool. The dies are now ready for use (Fig. 4).
- Die set is removed from the master dies in reverse order: close the dies, insert the tool into the die set, open the master dies and place the set back in the die table.

Fig. 1

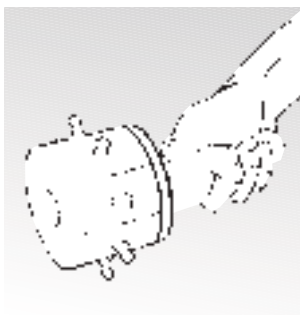


Fig. 2

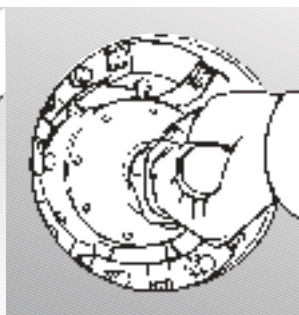


Fig. 3

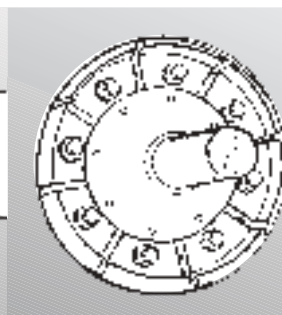
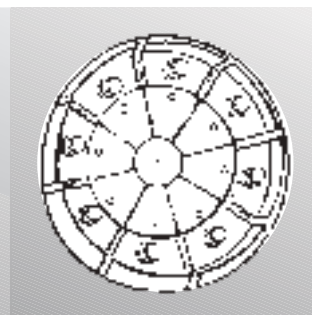


Fig. 4



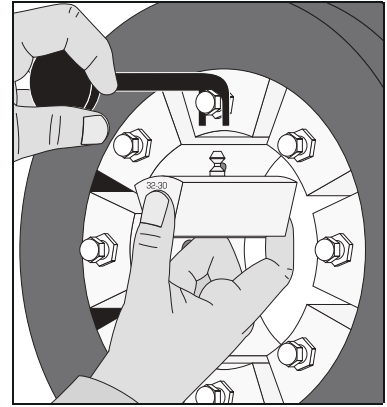
QC-homma.eps

## CHANGE OF A SINGLE DIE P20, P21, P32, CC22

- Start the motor and depress the retraction button until maximum retraction is reached. Stop the motor.

**CAUTION ! THE MOTOR SHALL ALWAYS BE STOPPED DURING INSTALLATION OF DIES.**

- Prior to installing dies, clean the contact surfaces of both the die set and master dies properly to avoid damaging the surfaces.
- Pull the pull pin in the master die with the tool delivered together with the machine (see figure).
- Insert the die with the retaining pin into the master die, die number always towards you. Release the pull pin.
- After installing all the dies, make sure they are straight and properly seated in the master dies.



Fork20.eps

## Setting the crimping diameter MS

| DIE SET N° | 1 0 9<br>0 min | 2 1 0<br>+1 mm | 3 2 1<br>+2 mm | 4 3 2<br>+3 mm | 5 4 3<br>+4 mm | 6 5 4<br>+5 mm | 7 6 5<br>+6 mm | 8 7 6<br>+7 mm | 9 8 7<br>+8 mm | 10 9 8<br>+9 mm |
|------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|-----------------|
| 32-10      | 10             | 11             | 12             | 13             |                |                |                |                |                |                 |
| 32-12      | 12             | 13             | 14             | 15             |                |                |                |                |                |                 |
| 32-14      | 14             | 15             | 16             | 17             |                |                |                |                |                |                 |
| 32-16      | 16             | 17             | 18             | 19             | 20             |                |                |                |                |                 |
| 32-19      | 19             | 20             | 21             | 22             | 23             |                |                |                |                |                 |
| 32-22      | 22             | 23             | 24             | 25             | 26             | 27             |                |                |                |                 |
| 32-26      | 26             | 27             | 28             | 29             | 30             | 31             |                |                |                |                 |
| 32-30      | 30             | 31             | 32             | 33             | 34             | 35             |                |                |                |                 |
| 32-34      | 34             | 35             | 36             | 37             | 38             | 39             | 40             |                |                |                 |
| 32-39      | 39             | 40             | 41             | 42             | 43             | 44             | 45             | 46             |                |                 |
| 32-45      | 45             | 46             | 47             | 48             | 49             | 50             | 51             | 52             |                |                 |
| 32-51      | 51             | 52             | 53             | 54             | 55             | 56             | 57             | 58             |                |                 |
| 32-57      | 57             | 58             | 59             | 60             | 61             | 62             | 63             | 64             |                |                 |
| 32-63      | 63             | 64             | 65             | 66             | 67             | 68             | 69             | 70             |                |                 |
| 32-69      | 69             | 70             | 71             | 72             | 73             | 74             | 75             | 76             |                |                 |
| 32-74      | 74             | 75             | 76             | 77             | 78             | 79             | 80             | 81             |                |                 |
| 32-78      | 78             | 79             | 80             | 81             | 82             | 83             | 84             | 85             | 86             | 87              |

The crimping diameter chart P32 MS

### EXAMPLE:

Manufacturer has specified a crimping diameter of 20.6 mm for the fitting. Select die set No 20-19 (min crimping diameter 19 mm) according to the die chart. Turn the dial to position 1.60 (upper scale 1, lower 60). This setting will give the crimping diameter 20.6 mm (19 + 1.6 mm).

The machine has been calibrated at the factory with 40 bar pressure. This means that when you are crimping a fitting requiring 40 bar pressure, the measuring scale of the crimping diameter dial provides an accuracy of +/- 0.1

mm (possible elastic recovery of the fitting not regarded).

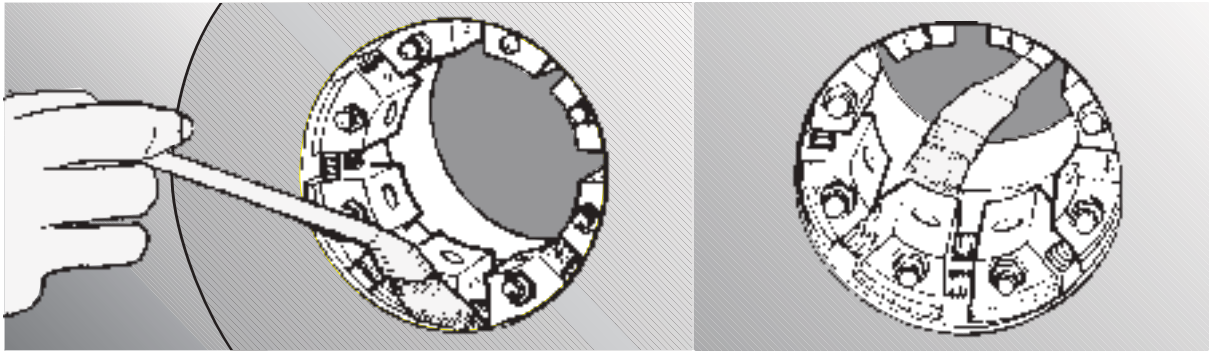
When fittings requiring higher pressure are crimped, the crimping diameter may become larger than the value on the scale due to machine deflections. Then the crimping diameter has to be corrected by changing the scale value.

## PREVENTIVE MAINTENANCE

- The following maintenance operations can be performed by the operator according to the instructions below. However, electrical works and repairs like changing seals or the pump must only be carried out by a qualified specialist.
- PRIOR TO ANY SERVICING OPERATION, TURN THE SUPPLY DISCONNECTING DEVICE TO POSITION '0'.**
- BEFORE CHANGING THE MOTOR CIRCUIT BREAKER OR UNDERVOLTAGE TRIP, DISCONNECT THE PLUG OR SUPPLY CABLE FROM THE MAINS !**
- Open the dies to maximum retraction before servicing.

## Greasing P20, P21, P32

Greas\_32.eps

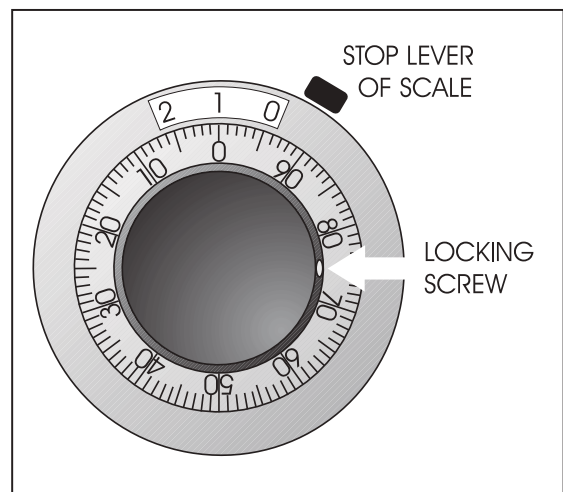


- Lubricate the inner surface of the conical flanges daily with pressure-proof grease like Molub Alloy OG-H or equivalent.
- Apply the grease to the conical surfaces at the front and back of the die with a small brush.
- Lubricate often with a small amount of grease rather than seldom with much grease.
- Do not grease the piston rod.

## Re-calibration of crimping diameter dial MS-control

NOTE: The crimping diameter dial has been calibrated at the factory during test run.

1. Re-calibrate the crimping diameter with ferrule (seamless steel tube), Ø 25 mm; wall 2 mm, by using the die set No 20-19 (P20, P21, CC22) or the die set 32-19 (P32, P51).
2. Set the dial at 1.0, so that the crimping diameter will be 20 mm (see the adjacent picture) and lock the dial. Crimp the ferrule and measure the real diameter.
3. Remove the control dial (avoid to turn the dial shaft at the same time).
4. Open the dial lock and set the real diameter into it (diameter of ferrule) rellock it and install back.
5. Turn the dial to right diameter and crimp another ferrule. Now the machine has been calibrated and the real diameter should be the same than the diameter which state on the dial. If not, repeat from point 2 and be more careful when handling the dial.
6. After the adjustment, the crimping result should be the minimum nominal crimping diameter of each die set with the dial at 0.0.



10-turn uusi.eps

# TROUBLESHOOTING

Troubleshooting is to be carried out by a serviceman.

| TROUBLE                            | POSSIBLE CAUSE                                                                                                                                                                                 | ACTION                                                                                                                                                                             |
|------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Machine will not start.            | 1. No electric supply<br>2. Motor protection tripped<br><br>3. Switch broken<br>4. Low supply voltage                                                                                          | Check fuses and supply cable connections.<br>Reset. If tripped again, check motor and pump condition.<br>Check the voltage up to the motor.<br>Check the voltage.                  |
| Motor runs but no piston movement. | 1. Wrong rotation direction<br><br>2. Low oil level<br>3. Fuses/rectifier/transformer out of order<br>4. Dial broken (MS)<br>5. Valve out of order<br><br>6. Pump or coupling broken           | Interchange two phases in the supply disconnecting device.<br>Check, refill.<br><br>Check, replace.<br>Check movability of valve steam.<br>Check the solenoids.<br>Check, replace. |
| Insufficient crimping force.       | 1. Insufficient lubrication<br>2. Low oil level<br>3. Pressure relief valve stuck<br>Pilot check valve leaking<br>4. Leaking pump/pressure pipe<br>5. Coupling between motor and pump slipping | Lubricate the dies.<br>Check, refill.<br>Check, clean.<br>Replace if broken.<br>Check, tighten, replace.<br><br>Check, replace.                                                    |
| Crimping diameter varies.          | 1. Insufficient lubrication<br>2. Set value changed<br>3. Dial knob loose (MS)<br>4. Dial loose or broken (MS)<br>5. Sliding potentiometer<br>6. Valve sticking                                | Lubricate the dies.<br>Check.<br>Check, calibrate, tighten<br>Check, tighten, replace<br><br>Check, clean.                                                                         |

## GUARANTEE

The machines produced by SAMWAY are guaranteed against defects in material and manufacture. Within the limits of the guarantee, the defective part will be replaced with a new one, or when possible, repaired free of charge.

The guarantee is valid for 12 months after commissioning, yet for a period not exceeding 18 months after delivery ex works SAMWAY, China.

The guarantee does not compensate for damage due to improper use, overload, neglect, or normal wear. Working and travelling costs as well as freight charges caused by guarantee repairs are not covered by the guarantee.

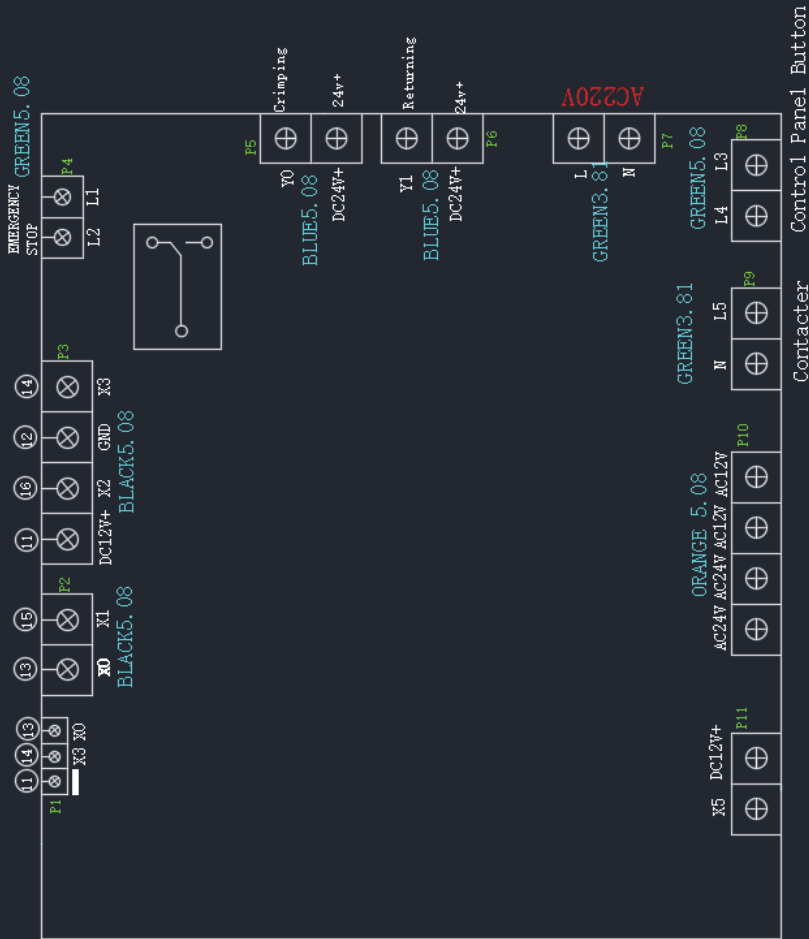
Guarantee repairs shall be carried out at SAMWAY, SAMWAY, China, or by an authorized SAMWAY service. In case guarantee repair is demanded, the customer has to prove that the machine is under guarantee.

SAMWAY DO NOT WARRANT FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES, OR FOR ANY OTHER LOSS, DAMAGE OR EXPENSE OF ANY KIND, INCLUDING LOSS OF PROFITS.

Electrical Wiring Diagram

|     |    |        |                         |
|-----|----|--------|-------------------------|
|     | 1  | DC12V+ | Limit Switch Power      |
| P1  | 2  | X3     | Limit Switch Singa Out  |
|     | 3  | X0     | Limit Switch Stop       |
| P2  | 4  | X0     | Limit Switch Stop       |
|     | 5  | X1     | Crimping Button         |
|     | 6  | DC12V+ | Button Power            |
| P3  | 7  | X2     | Returning Button        |
|     | 8  | GND    | DC12V-                  |
|     | 9  | X3     | Limit Switch Signal     |
| P7  | 10 | L      | AC220V output           |
|     | 11 | N      | AC220V output           |
| P4  | 12 | L1     | Emergency Stop Out      |
|     | 13 | L2     | Emergency Stop In       |
| P8  | 14 | L3     | Control Panel Output    |
|     | 15 | L4     | Control Panel Input     |
| P5  | 16 | L5     | Contactor Input         |
|     | 17 | N      | Contactor Output        |
|     | 18 | AC12V  | AC                      |
| P10 | 19 | AC12V  | AC                      |
|     | 20 | AC24V  | AC                      |
|     | 21 | AC24V  | AC                      |
| P11 | 22 | DC12V+ | Foot pedal Power        |
|     | 23 | X5     | Foot pedal Signal       |
| P5  | 24 | Y0     | Crimping Signal         |
|     | 25 | DC24V+ | Directional Valve Power |
| P6  | 26 | Y1     | Returning Signal        |
|     | 27 | DC24V+ | Directional Valve Power |

Wiring  
Definition

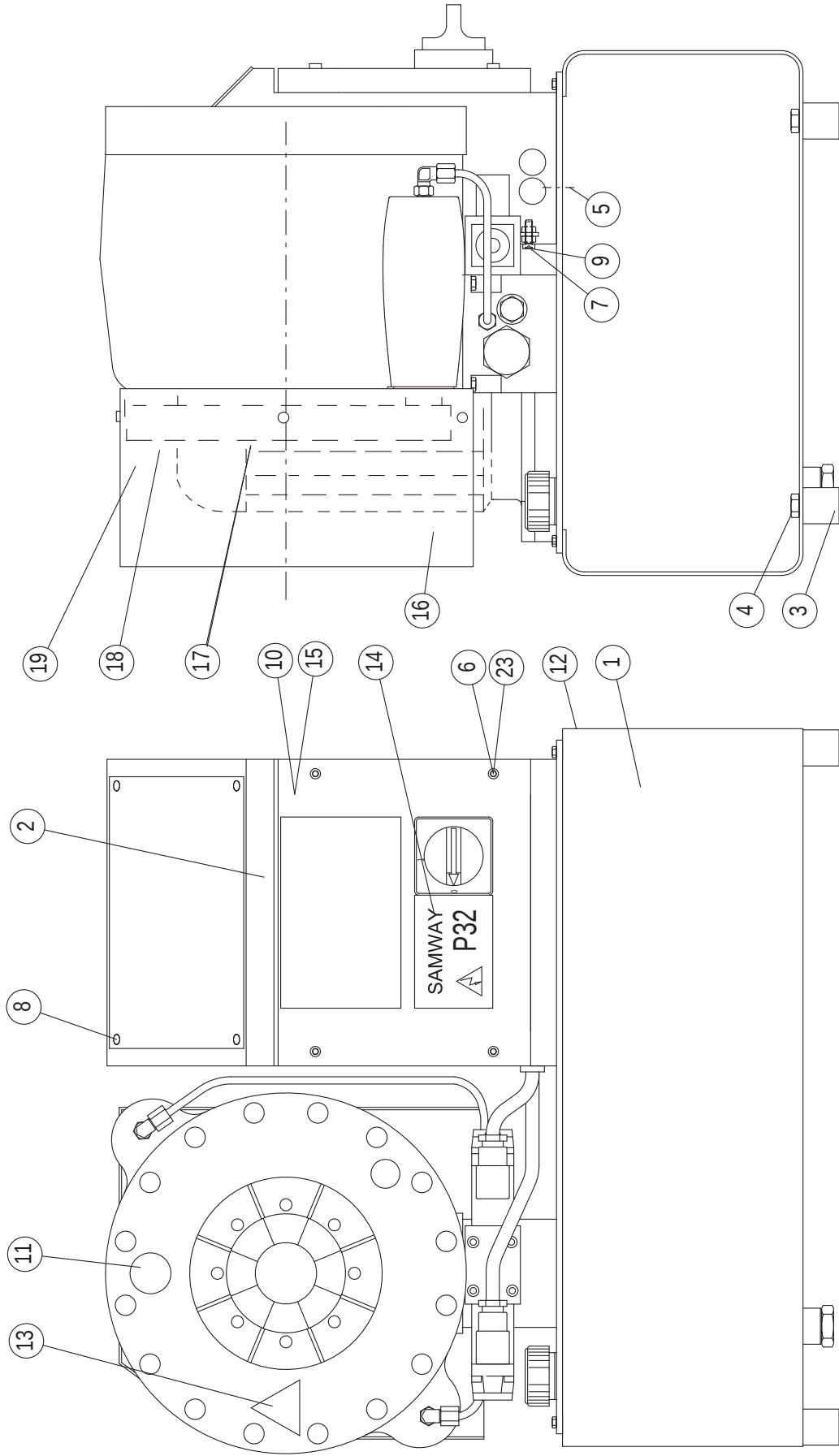


|        |  |  |            |
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## SPARE PART LIST





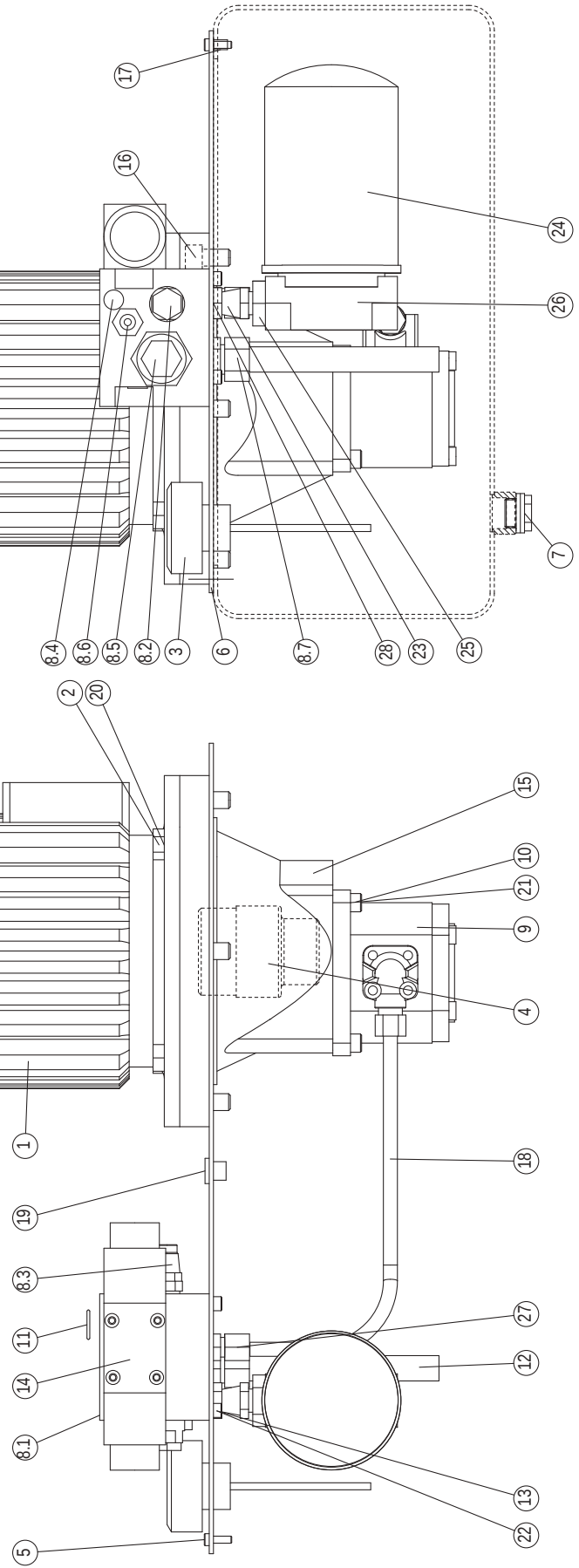
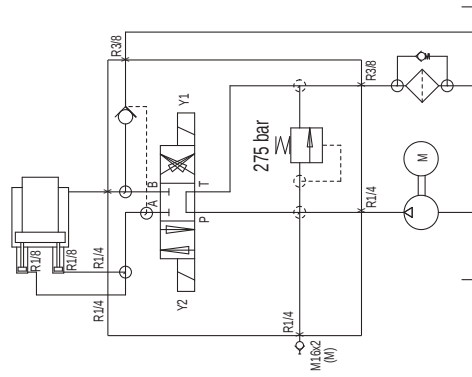
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EQUIPMENT

VARUSTELU

SAMWAY

| NO | CODE   | REV | QTY | NAME                      | DESCRIPTION | NIMITYS                |
|----|--------|-----|-----|---------------------------|-------------|------------------------|
| 1  | 51608  | A   | 1   | TANK                      |             | SÄILIÖ                 |
| 2  | 51669  | A   | 1   | ELECTRIC BOX              |             | SÄHKÖKOTELO            |
| 3  | 111484 | A   | 4   | FOOT                      |             | JALKA                  |
| 4  | 030157 |     | 4   | SCREW                     |             | RUUVI                  |
| 5  | 031310 |     | 4   | SCREW                     |             | KUUSIOKOLORUUVI        |
| 6  | 031315 |     | 4   | SCREW                     |             | RUUVI                  |
| 7  | 031323 |     | 4   | SCREW                     |             | RUUVI                  |
| 8  | 031301 |     | 4   | SCREW                     |             | RUUVI                  |
| 9  | 033004 |     | 8   | NUT                       |             | KUUSIOMUTTERI          |
| 10 | 164901 | E   | 1   | DOOR                      |             | SÄHKÖKOTELON OVI       |
| 11 | 003199 |     | 1   | STICKER "MIND YOUR HANDS" |             | TARRA "VARO KÄSIÄSI"   |
| 12 | 003001 |     | 1   | STICKER "ARROW"           |             | TARRA "NUOLI"          |
| 13 | 003306 |     | 1   | STICKER "MIND YOUR HANDS" |             | TARRA "VARO KÄSIÄSI"   |
| 14 | 003312 |     | 1   | TYPE STICKER AND "FLASH"  |             | TYYPPIARRA JA "SALAMA" |
| 15 | 048515 |     | 1   | SEALING TAPE              |             | TIIVISTENAUHA          |
| 16 | 161284 | D   | 1   | HOUSING                   |             | SUOJUS                 |
| 17 | 151163 | D   | 1   | FLANGE                    |             | LAIPPA                 |
| 18 | 033222 |     | 5   | RIVET NUT                 |             | NIITTIMUTTERI          |
| 19 | 031311 |     | 5   | SCREW                     |             | RUUVI                  |
| 20 | 69154  |     | 1   | DIE CHANGE TOOL           |             | VETOTYÖKALU            |
| 21 | 019302 |     | 1   | DIE GREASE                |             | LEUKARASVA             |
| 23 | 033217 |     | 4   | NUT                       |             | PELTIMUTTERI           |



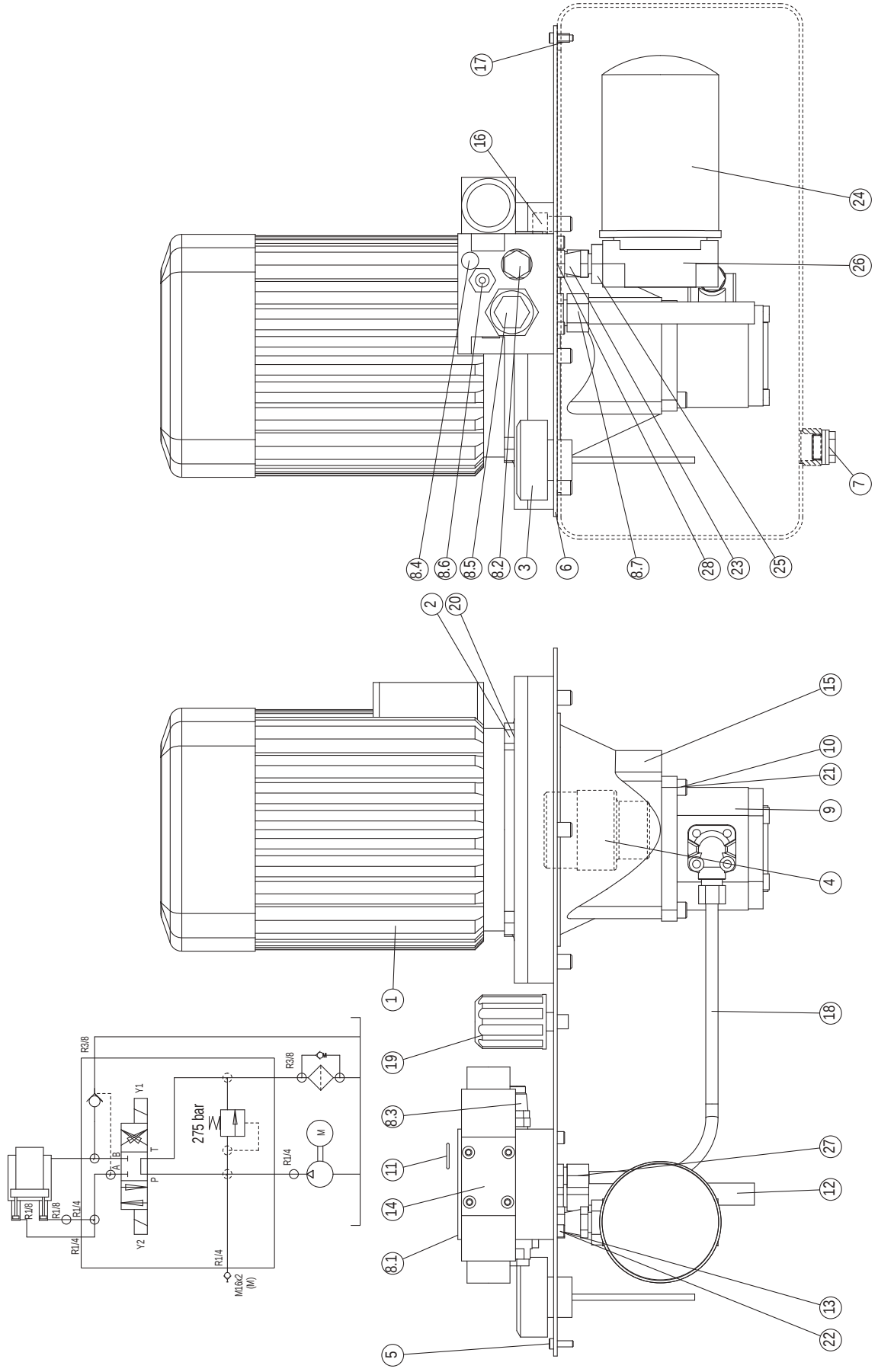
701148

HYDRAULIC UNIT 1-V

KONEIKKO 1-V

SAMWAY

| NO | CODE    | REV | QTY | NAME                  | DESCRIPTION | NIMITYS             |
|----|---------|-----|-----|-----------------------|-------------|---------------------|
| 1  | 058016  |     | 1   | ELECTRIC MOTOR        |             | SÄHKÖMOOTTORI       |
| 2  | 030175  |     | 4   | SCREW                 |             | KUUSIORUUVI         |
| 3  | 043141  |     | 1   | AIR BREATHER          |             | HUOHOTIN            |
| 4  | 052405  |     | 1   | COUPLING              |             | KYTKY               |
| 5  | 031312  |     | 20  | SCREW                 |             | KUUSIOKOLORUUVI     |
| 6  | 153702  | G   | 1   | COVER                 |             | KANSI               |
| 7  | 043201  |     | 1   | MAGNET PLUG           |             | MAGNEETTITULPPA     |
| 8  | 701149  |     | 1   | VALVE BLOCK           |             | VENTTILOHKO         |
| 9  | 040011  |     | 1   | PUMP                  |             | PUMPPU              |
| 10 | 031240  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 11 | 048043  |     | 1   | O-RING                |             | O-RENGAS            |
| 12 | 014105  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI       |
| 13 | 031228  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 14 | 041001  |     | 1   | DIRECTIONAL VALVE 4/3 |             | SUUNTAVENTTIILI 4/3 |
| 15 | 058614  |     | 1   | FLANGE                |             | LAIPPA              |
| 16 | 031269  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 17 | 033222  |     | 20  | RIVET NUT             |             | NIITTIMUTTERI       |
| 18 | 014102  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI       |
| 19 | 043302  |     | 1   | PLUG                  |             | TULPPA              |
| 20 | 033406  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 21 | 033404  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 22 | 033403  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 23 | 0424198 |     | 1   | NIPPLE                |             | NIPPA               |
| 24 | 043167  |     | 1   | FILTER INSERT         |             | SUODATINPANOS       |
| 25 | 042017  |     | 1   | REDUCTION NIPPLE      |             | SUPISTUSNIPPA       |
| 26 | 043163  |     | 1   | RETURN FILTER         |             | PALUUSUODATIN       |
| 27 | 042203  |     | 1   | MALE STUD COUPLING    |             | PERUSLIITIN         |
| 28 | 048404  |     | 1   | USIT-RING             |             | USIT-RENGAS         |



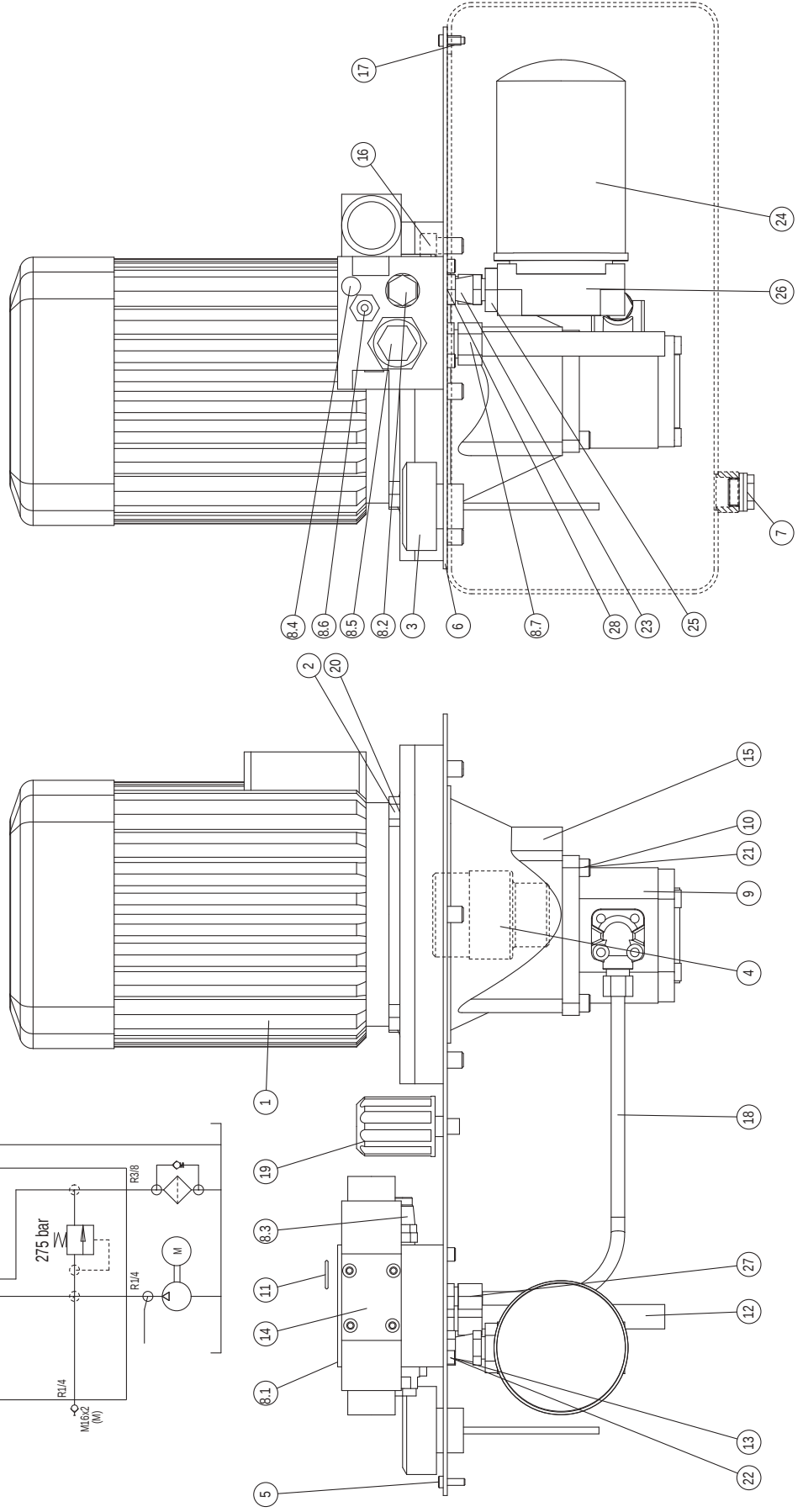
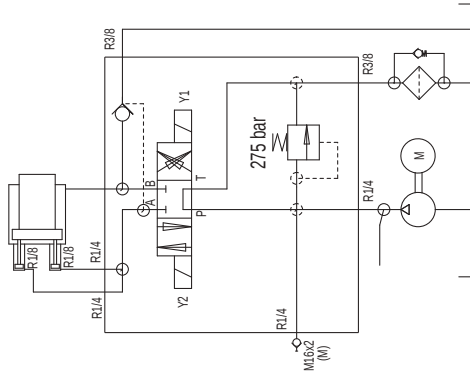
701152

HYDRAULIC UNIT 200VAC

KONEIKKO 200VAC

SAWWAY

| NO | CODE    | REV | QTY | NAME                  | DESCRIPTION | NIMITYS             |
|----|---------|-----|-----|-----------------------|-------------|---------------------|
| 1  | 058071  |     | 1   | ELECTRIC MOTOR        |             | SÄHKÖMOOTTORI       |
| 2  | 030175  |     | 4   | SCREW                 |             | KUUSIORUUVI         |
| 3  | 043141  |     | 1   | AIR BREATHER          |             | HUOHOTIN            |
| 4  | 052401  |     | 1   | COUPLING              |             | KYTKY               |
| 5  | 031312  |     | 20  | SCREW                 |             | KUUSIOKOLORUUVI     |
| 6  | 153702  | G   | 1   | COVER                 |             | KANSI               |
| 7  | 043201  |     | 1   | MAGNET PLUG           |             | MAGNEETTITULPPA     |
| 8  | 701149  |     | 1   | VALVE BLOCK           |             | VENTTILOHKO         |
| 9  | 040047  |     | 1   | PUMP                  |             | PUMPPU              |
| 10 | 031240  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 11 | 048043  |     | 1   | O-RING                |             | O-RENGAS            |
| 12 | 014105  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI       |
| 13 | 031228  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 14 | 041001  |     | 1   | DIRECTIONAL VALVE 4/3 |             | SUUNTAVENTTIILI 4/3 |
| 15 | 058613  |     | 1   | FLANGE                |             | LAIPPA              |
| 16 | 031269  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 17 | 033222  |     | 20  | RIVET NUT             |             | NIITTIMUTTERI       |
| 18 | 014103  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI       |
| 19 | 043111  |     | 1   | AIR BREATHER          |             | HUOHOTINKORKKI      |
| 20 | 033406  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 21 | 033404  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 22 | 033403  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 23 | 0424198 |     | 1   | NIPPLE                |             | NIPPA               |
| 24 | 043167  |     | 1   | FILTER INSERT         |             | SUODATINPANOS       |
| 25 | 042017  |     | 1   | REDUCTION NIPPLE      |             | SUPISTUSNIPPA       |
| 26 | 043163  |     | 1   | RETURN FILTER         |             | PALUUSUODATIN       |
| 27 | 0422101 |     | 1   | MALE STUD COUPLING    |             | PERUSLIITIN         |
| 28 | 048404  |     | 1   | USIT-RING             |             | USIT-RENGAS         |



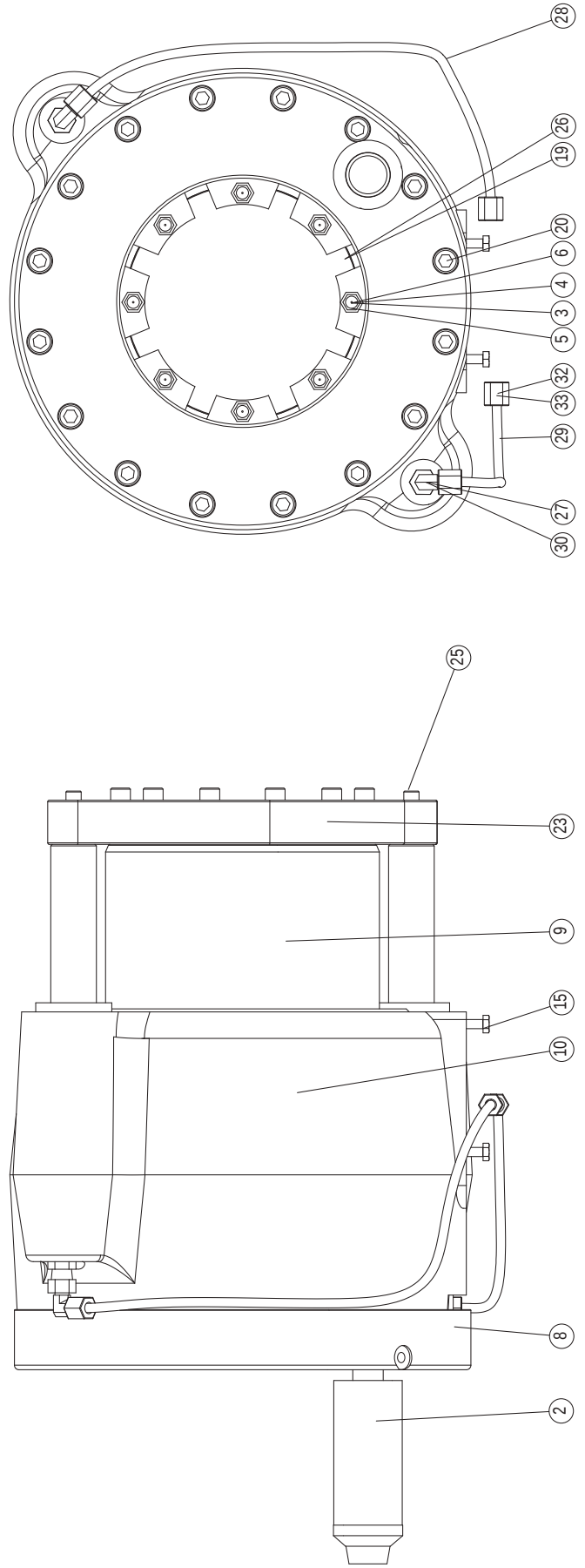
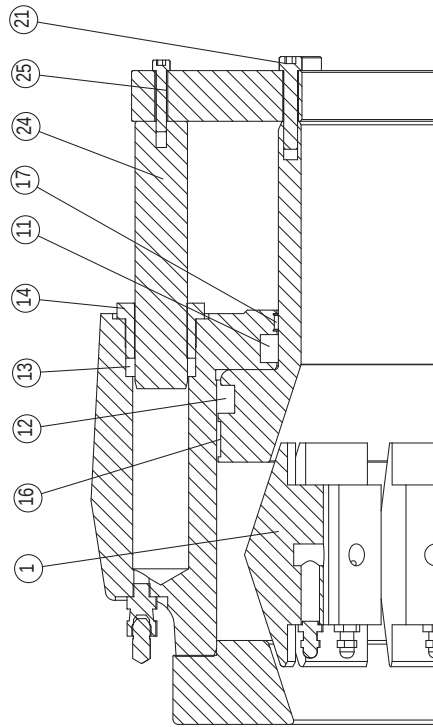
701150

HYDRAULIC UNIT 400VAC

KONEIKKO 400VAC

SAIMWAY

| NO | CODE    | REV | QTY | NAME                  | DESCRIPTION | NIMITYS             |
|----|---------|-----|-----|-----------------------|-------------|---------------------|
| 1  | 058007  |     | 1   | ELECTRIC MOTOR        |             | SÄHKÖMOOTTORI       |
| 2  | 030175  |     | 4   | SCREW                 |             | KUUSIORUUVI         |
| 3  | 043141  |     | 1   | AIR BREATHER          |             | HUOHOTIN            |
| 4  | 052401  |     | 1   | COUPLING              |             | KYTKY               |
| 5  | 031312  |     | 20  | SCREW                 |             | KUUSIOKOLORUUVI     |
| 6  | 153702  | G   | 1   | COVER                 |             | KANSI               |
| 7  | 043201  |     | 1   | MAGNET PLUG           |             | MAGNEETTITULPPA     |
| 8  | 701149  |     | 1   | VALVE BLOCK           |             | VENTTILOHKO         |
| 9  | 040047  |     | 1   | PUMP                  |             | PUMPPU              |
| 10 | 031240  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 11 | 048043  |     | 1   | O-RING                |             | O-RENGAS            |
| 12 | 014105  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI       |
| 13 | 031228  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 14 | 041001  |     | 1   | DIRECTIONAL VALVE 4/3 |             | SUUNTAVENTTIILI 4/3 |
| 15 | 058613  |     | 1   | FLANGE                |             | LAIPPA              |
| 16 | 031269  |     | 4   | SCREW                 |             | KUUSIOKOLORUUVI     |
| 17 | 033222  |     | 20  | RIVET NUT             |             | NIITTIMUTTERI       |
| 18 | 014103  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI       |
| 19 | 043111  |     | 1   | AIR BREATHER          |             | HUOHOTINKORKKI      |
| 20 | 033406  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 21 | 033404  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 22 | 033403  |     | 4   | SPRING WASHER         |             | JOUSIALUSLAATTA     |
| 23 | 0424198 |     | 1   | NIPPLE                |             | NIPPA               |
| 24 | 043167  |     | 1   | FILTER INSERT         |             | SUODATINPANOS       |
| 25 | 042017  |     | 1   | REDUCTION NIPPLE      |             | SUPISTUSNIPPA       |
| 26 | 043163  |     | 1   | RETURN FILTER         |             | PALUUSUODATIN       |
| 27 | 0422101 |     | 1   | MALE STUD COUPLING    |             | PERUSLIITIN         |
| 28 | 048404  |     | 1   | USIT-RING             |             | USIT-RENGAS         |



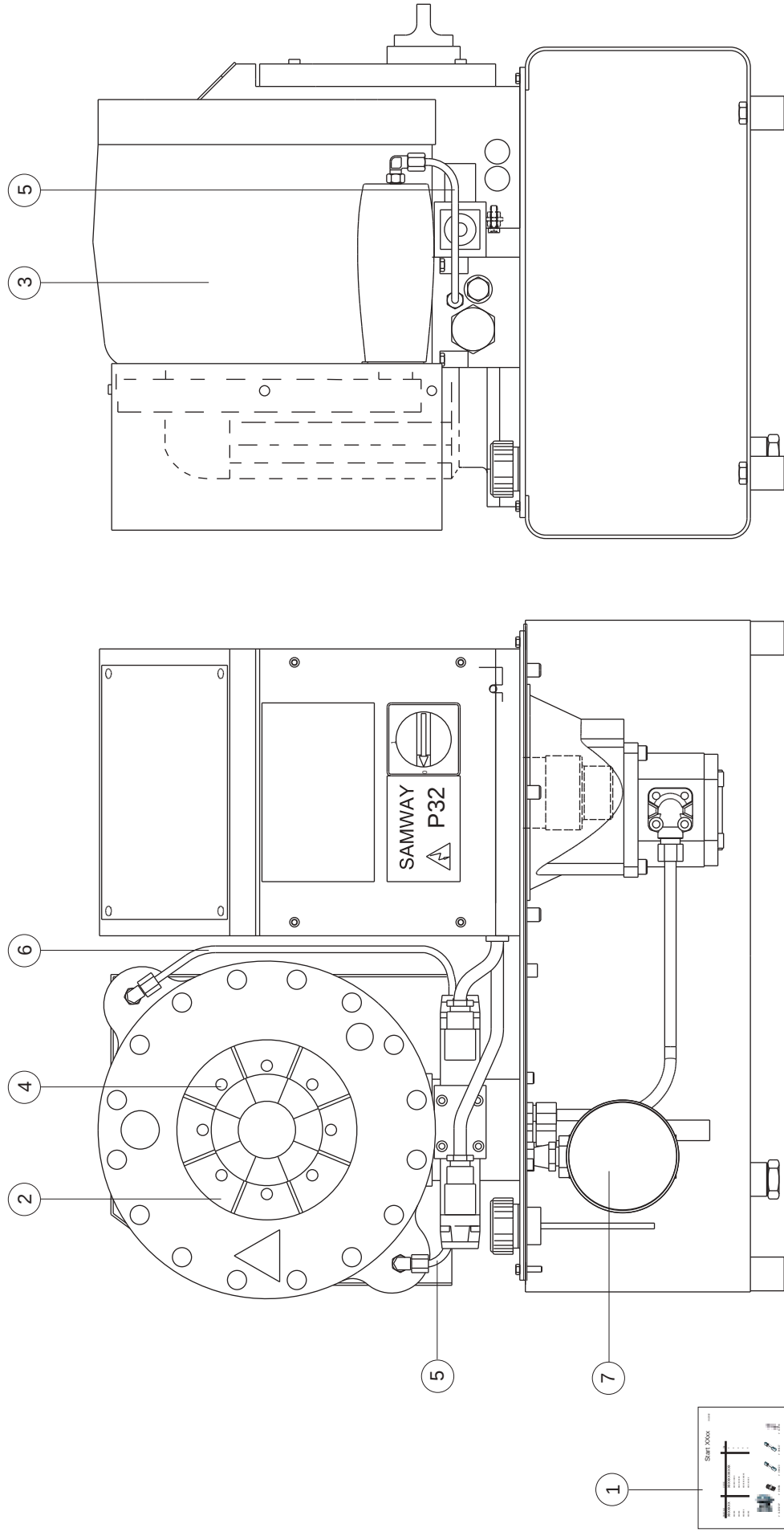
701200

CRIMPING UNIT

PURISTUSYKSIKKÖ

SAMWAY

| NO | CODE    | REV | QTY | NAME                  | DESCRIPTION | NIMITYS           |
|----|---------|-----|-----|-----------------------|-------------|-------------------|
| 1  | 13011   | G   | 1   | MASTER DIE SET        |             | PERUSLEUKASARJA   |
| 2  | 60426   |     | 1   | CONTROL DEVICE P32 MS |             | MITTALAITE P32 MS |
| 3  | 033201  |     | 8   | CAPPED NUT            |             | HATTUMUTTERI      |
| 4  | 11379   | B   | 8   | SCREW                 |             | RUUVI             |
| 5  | 053023  |     | 8   | SPRING                |             | JOUSI             |
| 6  | 11380   | B   | 8   | RETAINING PIN         |             | LUKITUSTAPPI      |
| 8  | 14201   | E   | 1   | CONIC FLANGE          |             | KARTIOLAIPPA      |
| 9  | 12058   | E   | 1   | PISTON                |             | MÄNTÄ             |
| 10 | 13413   | E   | 1   | CYLINDER              |             | SYLINTERI         |
| 11 | 048202  |     | 1   | GROOVED RING          |             | URARENGAS         |
| 12 | 048103  |     | 1   | PISTON SEAL           |             | MÄNNÄNTIIVISTE    |
| 13 | 048227  |     | 2   | GROOVED RING          |             | URARENGAS         |
| 14 | 13411   | C   | 2   | SLEEVE                |             | HOLKKI            |
| 15 | 030130  |     | 4   | SCREW                 |             | RUUVI             |
| 16 | 048302  |     | 1   | GUIDE RING            |             | OHJAINRENGAS      |
| 17 | 048301  |     | 1   | GUIDE RING            |             | OHJAINRENGAS      |
| 18 | 031260  |     | 14  | SCREW                 |             | RUUVI             |
| 19 | 053003  |     | 16  | SPRING                |             | JOUSI             |
| 20 | 031262  |     | 2   | SCREW                 |             | KUUSIOKOLORUUVI   |
| 21 | 031244  |     | 6   | SCREW                 |             | RUUVI             |
| 23 | 14206   | C   | 1   | REAR FLANGE           |             | TAKALAIPPA        |
| 24 | 11799   | A   | 2   | RETURN PISTON         |             | PALUUMÄNTÄ        |
| 25 | 031232  |     | 2   | SCREW                 |             | RUUVI             |
| 26 | 034001  |     | 8   | COTTER PIN            |             | SOKKA             |
| 27 | 0424208 |     | 2   | ELBOW CONNECTOR       |             | KULMALIITIN       |
| 28 | 014101  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI     |
| 29 | 014101  |     | 1   | HYDRAULIC PIPE        |             | HYDRAULIPUTKI     |
| 30 | 0424209 |     | 2   | THREADED COUPLING     |             | KIERRELIITIN      |
| 32 | 0424206 |     | 4   | SHELL NUT             |             | VAIPPAMUTTERI     |
| 33 | 0424207 |     | 4   | ADAPTER SLEEVE        |             | KIRISTYSHOLKKI    |



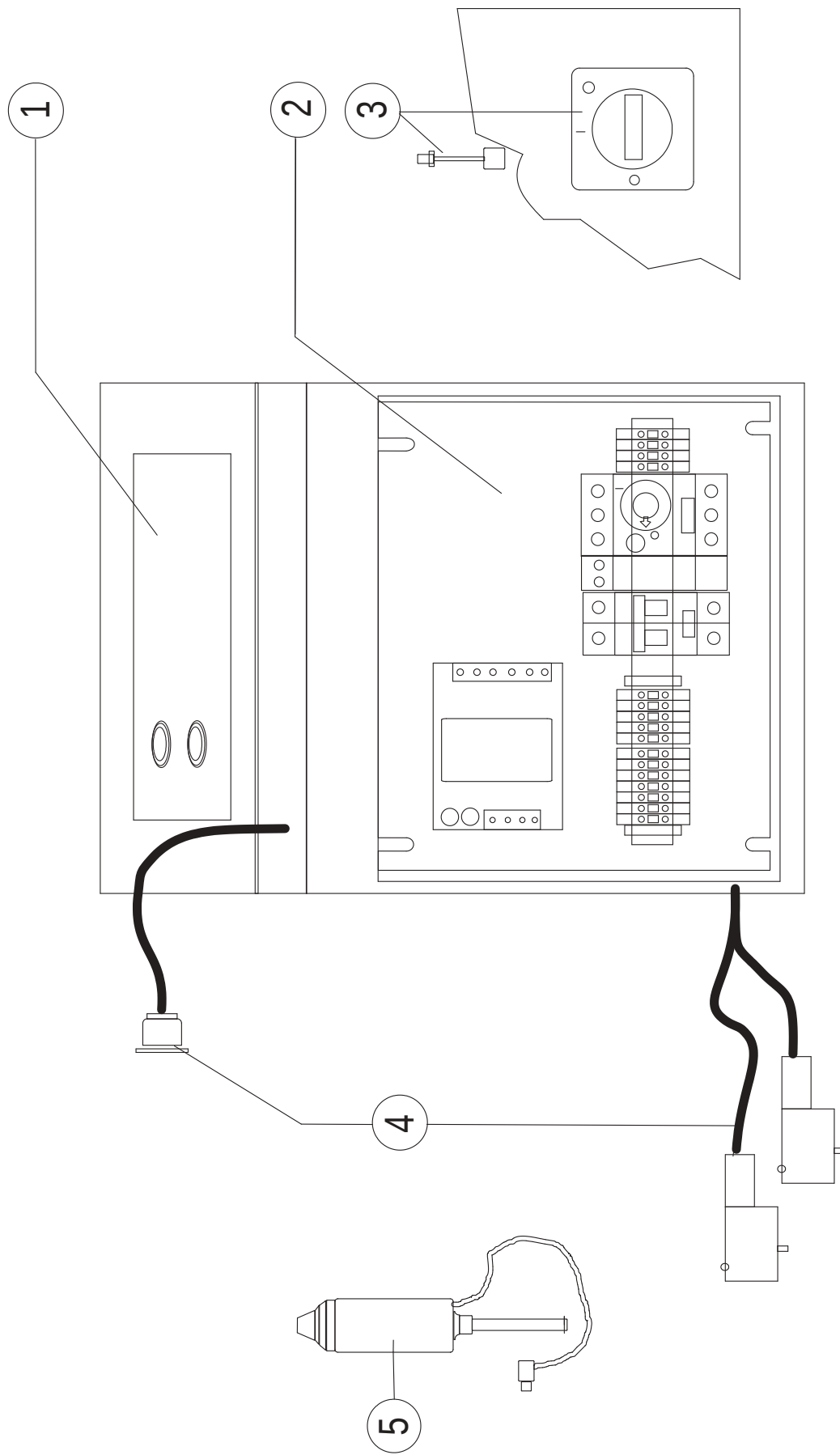
701516

SPARE PART KITS

VARAOSAPAKETIT

SAMWAY

| NO | CODE         | REV | QTY | NAME                   | DESCRIPTION | NIMITYS           |
|----|--------------|-----|-----|------------------------|-------------|-------------------|
| 1  | START<br>P32 |     | 1   | QUICK FIX-PACKAGE      |             | QUICK FIX-PAKKAUS |
| 2  | MD-P32A0     |     | 1   | MASTER DIE KIT         |             | PERUSLEUAT        |
| 3  | SK-P32       |     | 1   | SEAL KIT               |             | TIIVISTESARJA     |
| 4  | LP-11380     |     | 1   | LOCKING PIN            |             | LUKITUSTAPPI      |
| 5  | RPL-P32      |     | 1   | RETURN PIPE KIT, LEFT  |             | PALUUPUTKI, VASEN |
| 6  | RPR-P32      |     | 1   | RETURN PIPE KIT, RIGHT |             | PALUUPUTKI, OIKEA |
| 7  | 043167       |     | 1   | FILTER INSERT          |             | SUODATINPANOS     |



676752

## ELECTRICAL COMPONENTS SÄHKÖVARUSTEET

SAMWAY

| NO | CODE   | REV | QTY | NAME                            | DESCRIPTION | NIMITYS                              |
|----|--------|-----|-----|---------------------------------|-------------|--------------------------------------|
| 1  | 595001 |     | 1   | CONTROL UNIT MS                 |             | MS-OHJAUS                            |
| 2  | 590024 |     | 1   | ASSEMBLY UNIT 480V, 1-PHASE     |             | ASENNUSYKSIKKÖ 480V, 1-VAIH.         |
| 2  | 59058  |     | 1   | ASSEMBLY UNIT 480V, 3-PHASE     |             | ASENNUSYKSIKKÖ 480V, 3-VAIH.         |
| 2  | 59057  |     | 1   | ASSEMBLY UNIT 400V              |             | ASENNUSYKSIKKÖ 400V                  |
| 2  | 59056  |     | 1   | ASSEMBLY UNIT 200/230V/ 1-PHASE |             | ASENNUSYKSIKKÖ 200/230V/ 1-VAIHEINEN |
| 3  | 093450 |     | 1   | DOOR HANDLE                     |             | OVIKAHVA                             |
| 4  | 42095  |     | 1   | CABEL SET                       |             | KAAPELISARJA                         |
| 5  | 60495  |     | 1   | CONTROL DEVICE CC22             |             | MITTALAITE CC22                      |
| 5  | 60426  |     | 1   | CONTROL DEVICE P32 MS           |             | MITTALAITE P32 MS                    |
| 5  | 60425  |     | 1   | CONTROL DEVICE P21 MS           |             | MITTALAITE P21 MS                    |
| 5  | 60424  |     | 1   | CONTROL DEVICE P20 MS           |             | MITTALAITE P20 MS                    |

# SAMWAY P32Q DETAILS



## Benefit:

- Full Automatic Control with Foot pedal
- Quick Change Tool and Die rack
- Energy Saving and Safety Operation
- Automatic PLC Control Modul Built in

## SAMWAY P32Q

Main Specification ..... SAMWAY P32Q  
 Max Hydraulic Hose ..... 2" 4SP  
 Crimping Range ..... 4-87 mm  
 Die Type ..... P32  
 Master Die Length ..... 80 mm  
 Max Opening ..... +32 mm  
 Motor ..... 4 KW  
 Crimping Force ..... 2200 KN  
 Crimpings Per Hour ..... 1200  
 Control .....  
 ..Control with advanced programmable chip  
 Foot pedal ..... Included  
 Die Rack ..... Included  
 Quick Change Tool ..... Included  
 Backstop Device ..... Optional

## SAMWAY P32Q

Control by Pressure ..... Optional  
 Noise Level ..... 65 dBA  
 Protection Class ..... IP56  
 L\*W\*H ..... 680\*600\*1400 mm  
 Weight ..... 300 KG

## Available Voltage:

220V, 400V, 415V, 440V, 480V 3 phase  
 110V 60hz single phase  
 220V 50/60hz single phase

## Standard Die Sets Included:

| Die No. | 10* | 12* | 14 | 16 | 19 | 22 | 26 | 30 | 34 | 39 | 45 | 51 | 57 | 63  | 69  | 74* | 78* |
|---------|-----|-----|----|----|----|----|----|----|----|----|----|----|----|-----|-----|-----|-----|
| Length  | 55  | 55  | 55 | 55 | 55 | 55 | 75 | 75 | 90 | 90 | 90 | 90 | 90 | 100 | 100 | 100 | 100 |

\* Optional Die Sets Upon Request

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 samwaysales@gmail.com ; www.samway.com

# SAMWAY