

Setup Instructions for manual Crimp Cap Crimpers

The crimping of crimp top vials with a manual crimper may possibly lead to problems due to differences in:

- the height of the crimp top
- the height of the crimp cap
- the thickness of the sealing disc

Wrong crimper setup leads either to an incorrect sealing due to loose-fitting crimp caps or to a deformation of the crimp caps due to wrongly adjusted (too short) crimping height.

Therefore we only provide our crimpers R 11, R 13, R 20 and R 32 as adjustable type for many years now already, incl. 1/8" hexagon key to adjust the crimper.

Due to technical reasons an adjustable type of the crimper R 8 is not available.

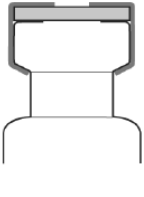
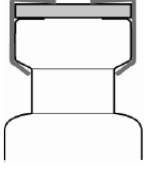
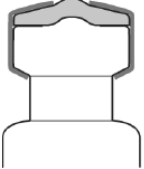
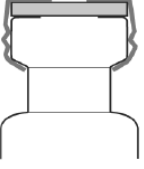
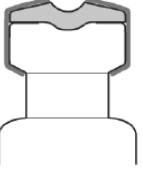
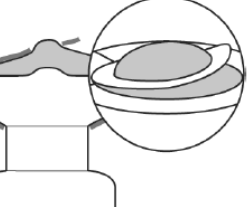
Basing on our current experience it is not necessary to provide decappers with an option for adjustment.

Tutorial for crimper adjustment:

The enclosed 1/8" hexagon key has to be put into the hexagon socket within the crimper. By clockwise rotation (to the right) the crimping height is being enlarged as the stroke of the center plunger is being reduced, i.e. the crimp gets looser. By counterclockwise rotation (to the left) the crimping height is being reduced as the stroke of the center plunger is being increased, i.e. the crimp gets tighter.



An inappropriate crimp may be recognized by comparison to the correct crimp shown below:

<p>Correct Crimp</p> <p>Flat cap surface</p> <p>Flat septa surface</p>  <p>Tight fitting of the Aluminium edge</p> <p>Plain + undeformed cap sides</p>					
	Loose Aluminium edge	Upward bulge of liner and crimp cap	Deformation of the crimp cap side	Convex indentation of liner	Rounded edges / Upward bulge of the Cap/Liner
	Adjust crimping pressure with the screw in the handle +Adjust crimping height with the hexagon key (s. below)	Adjust crimping pressure with the screw in the handle +Adjust crimping height with the hexagon key (s. below)	Adjust crimping height with the hexagon key (s. below)	Adjust crimping pressure with the screw in the handle	With Headspace Caps it is important not to overcrimp them. If the aluminium is overstretched the scorelines suffer extra stress and will either break open at too low pressure (below 3 bars) or can tear apart after crimping making the seal unusable.
	(undercrimped)	(overcrimped)	(overcrimped)	(overcrimped)	(overcrimped)