

Mechanical Crimper and Decapper for Crimp Caps - Description and Installation

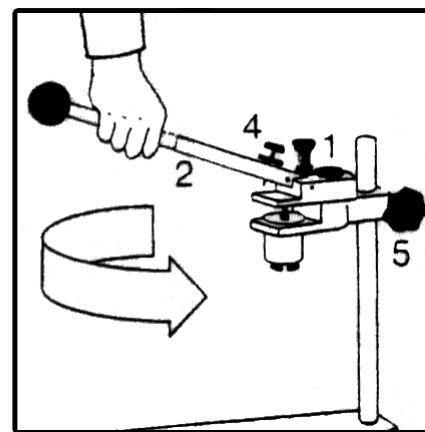
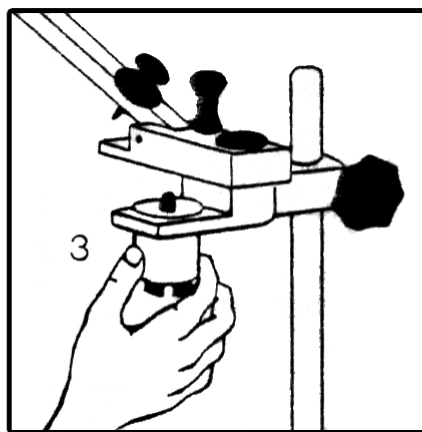
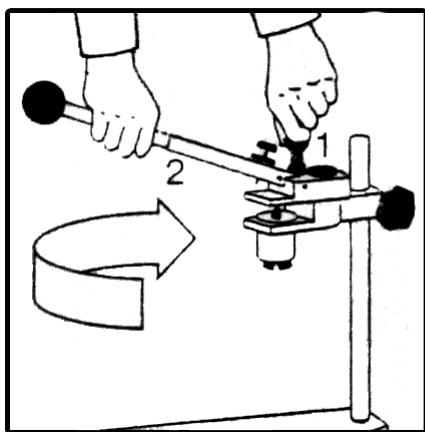
1. Installation:

Connect the stand rod to the stand plate using the hexagon socket screw. Then connect the crimper holder assembly to the stand rod using the fastening screw. The lever must show into the same direction as the stand plate. The working height has to be adjusted and fixed using the fastening screw. The installation of the crimp and decapper head is described below.

If usage of the vial guide is requested it has to be fastened onto the crimping respectively decapping chuck using the hexagon socket screw at the upper side of the vial guide.

2. Installation and change of the crimp or decapper head

Lift and move ($\frac{1}{4}$ rotation to the left) the lock bolt (1) on the left side behind the lever. The present insert can now be removed and the new can be inserted (eventually the vial guide has to be removed before and installed again afterwards). Turn back the lever and the lock bolt so that it is caught again.

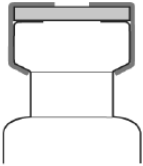
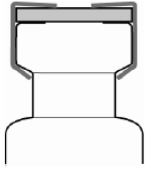
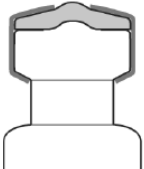
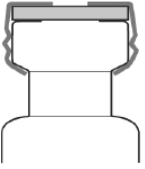
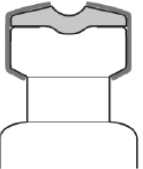
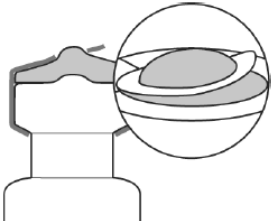


3. Crimping Problems

The crimping of crimp top vials with crimpers may possibly lead to problems due to differences in the height of the crimp top and the crimp cap or 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 8, R 11, R 13 and R 20 as adjustable type for many years now already, incl. $\frac{1}{8}$ " hexagon key to adjust the crimper.

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 over-stretched 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)

4. 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.