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Find the *Wheaton Crimpmaster* at our website: ***Click HERE***

WHEATON SCIENCE PRODUCTS

CRIMPMASTER® CRIMPING STATION
CATALOG NUMBER 224550

INSTRUCTION MANUAL

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Warranty

Wheaton Science Products 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 or abuse, you may return the unit freight prepaid, provided that return authorization has been obtained. Wheaton Science Products will correct the defect or adjust the unit at no charge.

Items returned for repair or adjustment should be packed very carefully to prevent damage in transit and also should be insured for your protection. Should damage occur in transit, all claims should be made against the carrier. The shipping carton should not be discarded but retained until inspection by a representative of the carrier is made.

Wheaton Science Products will repair or adjust out-of-warranty products at a nominal charge.

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INTRODUCTION

The Wheaton Crimpmaster® Crimping Station is designed to offer maximum flexibility in packaging applications where various sizes and styles of aluminum seals for serum finish bottles and vials are required. The Crimpmaster® enables low cost hand operated crimpers to function as air powered crimpers, without the high cost normally associated with dedicated air powered crimpers. The design of the unit enables the Crimpmaster to accept most of the standard makes and models of hand crimpers and decappers available today, which can be interchanged in a matter of seconds. A footswitch is provided to facilitate semi-automatic hands free operation. The Crimpmaster® requires 25-40 p.s.i. which may be obtained from a standard in-house air supply or a compressed air cylinder.

SAFETY SYMBOLS USED IN THIS MANUAL



A **Warning** symbol indicates an operation which can cause operator injury, improper function of, or damage to the equipment and possible problems with the process.



A **Danger** symbol indicates an operation which could cause electrocution, severe injury, or death!

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GENERAL SAFETY INSTRUCTIONS

NOTE: EVEN THE SAFEST EQUIPMENT CAN CAUSE INJURY IF THE USER IS CARELESS

1. KNOW YOUR INSTRUMENT - Read the operating manual carefully. Learn the equipment's application and limitations as well as the specific potential hazards peculiar to this instrument.

2. GROUND ALL EQUIPMENT - If electrical, this instrument is equipped with an approved 3-conductor cord and a 3-prong grounding type plug to fit the proper grounding type receptacle. The green conductor in the cord is the grounding wire, and should never be connected to a live terminal.

3. AVOID DANGEROUS ENVIRONMENT - Electrical instruments designed to process liquids must be operated with extreme caution. If liquid comes in contact with internal components or wires, fire or electric shock may occur. Adequate surrounding work space should be provided during use. Do not operate electrical instrumentation in a combustible atmosphere.

4. WORK SURFACE - Keep area well lighted. Be certain the work surface is clean, level, and sturdy enough to support the weight of the unit, particularly if it is to be filled with liquid.

5. WEAR PROPER APPAREL - Do not wear loose clothing, neckties, or jewelry that might get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

6. WEAR SAFETY GOGGLES - Wear safety goggles at all times. Everyday eyeglasses only have impact resistant lenses; they are NOT safety glasses.

7. DON'T OVERREACH - Keep proper footing and balance at all times. Do not place instrument in an area or position that would hinder access to or proper operation of the instrument.

8. MAINTAIN INSTRUMENT WITH CARE - Keep screws tight and unit clean. Check periodically for worn or damaged parts. Inspect the plug and cord before each use. Do not operate this instrument if there are signs of damage.

9. AVOID ACCIDENTAL STARTUP - If electrical, always make sure switch is in the "OFF" position before plugging the instrument into outlet.

10. DISCONNECT INSTRUMENT - Always disconnect the instrument from the power source before servicing.

11. DO NOT BLOCK COOLING VENTS IF PROVIDED.

12. DO NOT OPERATE THIS EQUIPMENT IN ANY MANNER NOT SPECIFIED IN THIS MANUAL.

13. KEEP THE OPERATING MANUAL - Keep the operating manual for this instrument in a safe place near the instrument for quick and easy reference.

14. FIRE EXTINGUISHER - It is recommended that a fire extinguisher always be located in areas where electrical instruments are being used.

WSP-305

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INSTRUMENT SET-UP (refer to fig. A)

1. Carefully unpack unit, being sure to save the box and packing materials to facilitate returning the unit in the event it should require servicing.

2. Loosen the compression nut on the nylon tube fitting (6) located on the rear of the Crimpmaster.

3. Insert one end of the connecting hose (1) into the nylon tube fitting, being certain the tubing is fully inserted. Hand tighten the nylon compression nut.

4. Loosen the compression nut on the nylon tube fitting (14) located on the air valve (13).

5. Insert the other end of the connecting hose into the nylon tube fitting, being certain the tubing is fully inserted. Hand tighten the nylon compression nut.

6. Using ¼" I.D. high pressure air hose (not supplied), connect the air supply to the brass hose fitting (15) on the air valve. Recommended air pressure for operation is 25-40 P.S.I. Bottled air or nitrogen may be used with the Crimpmaster.



DANGER! NEVER ATTEMPT TO POWER THE UNIT WITH FLAMMABLE GASES OR OXYGEN.

HAND CRIMPER INSTALLATION (refer to figs. A and B)

1. Prior to operation, a standard hand operated crimper must be installed in the Crimpmaster. Virtually any size crimper may be installed to accommodate a wide range of aluminum closures. Hand crimpers are not included with the Crimpmaster, and must be purchased separately. Please contact Wheaton for all your crimping needs.

2. Remove the handle retaining clip and adjustment screw, if present, from the hand crimper prior to installation in the Crimpmaster. Depending on the crimper model, the retaining clip may be located at the end of the handle or near the base of the crimping head.

3. If installing a Wheaton hand crimper with plastic coated handles, the plastic coating must be removed to allow insertion into the crimpmaster. This is best accomplished by pushing each plastic grip off the handles from the open (top) end. Avoid squeezing the grips. as this will make removal extremely difficult.



NOTE! SOME OLDER CRIMPER MODELS MAY REQUIRE THE PLASTIC HANDLE GRIPS BE CUT FROM THE HANDLES WITH A SHARP KNIFE. IF THIS IS NECESSARY, CARE SHOULD BE TAKEN TO AVOID PERSONAL INJURY DURING CUTTING.

4. Keep hands and fingers clear from crimper jaws, squeeze crimper handles together and insert bottom handle into black channel (16) on front of Crimpmaster and push crimper into place.

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ADJUSTMENT (refer to fig. A)

WARNING! PERSONAL INJURY MAY RESULT IF THE CRIMPMASTER IS USED CARELESSLY. KEEP HANDS AND FINGERS AWAY FROM THE CRIMPER JAWS WHEN OPERATING THE CRIMPER.

NOTE! AIR PRESSURE MAY REQUIRE ADJUSTMENT TO ACHIEVE THE OPTIMUM DEGREE OF SEAL TIGHTNESS. THIS IS DUE TO THE DIFFERENCES BETWEEN VARIOUS COMBINATIONS OF SEALS AND SEPTUM.

1. Turn on air supply and adjust air pressure to 25 PSI. Keeping hands and fingers clear of crimping jaws, depress the footswitch a few times making certain crimper is functioning properly.

WARNING! PERSONAL INJURY MAY RESULT IF THE CRIMPMASTER IS USED CARELESSLY. KEEP HANDS AND FINGERS AWAY FROM THE CRIMPER JAWS WHEN OPERATING THE CRIMPER. NEVER ATTEMPT TO OPERATE THE CRIMPING STATION WITHOUT THE SAFETY COVER IN PLACE: REMOVAL OF SAFETY COVER COULD LEAD TO SERIOUS INJURY.

WARNING! NEVER ATTEMPT TO UTILIZE A CRIMPER AS A DECAPPING TOOL. PLACING EXCESSIVE PRESSURE ON A GLASS VIAL MAY CAUSE IT TO SHATTER, LEADING TO SERIOUS INJURY. NEVER TWIST OR TURN A GLASS VIAL WHEN CRIMPING.

NOTE! AIR PRESSURE MAY REQUIRE ADJUSTMENT TO ACHIEVE THE OPTIMUM DEGREE OF SEAL TIGHTNESS. THIS IS DUE TO THE DIFFERENCES BETWEEN VARIOUS COMBINATIONS OF SEALS AND SEPTUM.

2. Place an aluminum seal with appropriate septum or stopper (if using unlined seals) over the neck of the vial. If using a stopper under the seal, be certain it is fully inserted into the vial opening. If using lined aluminum seals, an additional septum or stopper is unnecessary.

3. Holding the vial 90 degrees to the crimper, fully insert the vial into the open crimper jaws.

4. Being absolutely certain fingers are kept clear of the crimping jaws, depress the foot valve (M) and hold until bottle is sealed. Check seal for tightness and appearance.

5. If the seal appears to be loose and can be turned easily by hand, it will be necessary to increase the air pressure for a tighter seal.

6. If the sides of the seal are dented or wrinkled, it will be necessary to decrease the air pressure for a looser seal.

7. Always be certain the seal is properly positioned on the vial and the vial is squarely positioned inside the crimper.

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NOTE! A PROPERLY CRIMPED SEAL CAN NORMALLY BE TURNED SLIGHTLY IF TWISTED BY HAND.



IMPORTANT! ADJUSTING THE CRIMPER FOR TOO TIGHT A SEAL WILL CAUSE EXCESSIVE WEAR ON INTERNAL COMPONENTS.

IMPORTANT! THE CRIMPER JAWS SHOULD BE CLEANED AND LUBRICATED APPROX. EVERY 5,000 CRIMPING OPERATIONS OR SOONER IF THE CRIMPER IS UNDER CONSTANT HEAVY USE OR WHEN USED IN CORROSIVE ATMOSPHERES. ANY INDUSTRIAL SPRAY LUBRICANT OR SIMILAR SPRAY LUBRICANT MAY BE USED.

SPECIFICATIONS

REQUIRED AIR PRESSURE:	25 - 40 PSI
AIR SUPPLY TYPE:	COMPRESSOR OR BOTTLED AIR
INCLUDED COMPONENTS:	1 EACH CRIMPING STATION 1 EACH 10 FOOT AIR HOSE 1 EACH FOOT PLATE ASSEMBLY
CABINET:	ALUMINUM W / CORROSION RESISTANT ENAMEL
WEIGHT:	13 LBS. (5.90 KG.)
DIMENSIONS:	19 ¾” H x 6” D x 8 5/8” W (50.2 x 15.2 x 22 CM)

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PARTS LIST (FIG. A) WHEATON CRIMPMASTER CAT. #224550

ITEM	DESCRIPTION	USE QTY.	WHEATON NO.
1	¼" O.D. TUBING	11 ft	051395
2	90 DEGREE TAB	1	50029479
3	RUBBER FOOT	4	50029504
4	AIR CYLINDER	1	054705
5	TUBE FITTING, ¼" O.D. TUBE TO ¼" PIPE THD	1	50029513
6	BULKHEAD UNION, ¼" O.D. TUBE	1	50029314
7	½" DIA. ADHESIVE BACKED VINYL BUMPER	1	50029534
8	EXTENSION SPRING	1	50029535
9	STEEL WASHER	4	50029536
10	7/16"-20 HEX NUT	1	50029856
11	3/16" DIA. x 1 ¼" CLEVIS PIN	2	50030021
12	3/32" DIA. x ½" LG. COTTER PIN	2	50030022
13	AIR VALVE	1	054496
14	ST. NYLON TUBE FITTING WITH 1/8" PIPE THD.	1	054492
15	BRASS HOSE FITTING WITH 1/8" PIPE THD.	1	054494
16	RETAINING CHANNEL	1	054706
17	CONNECTING LINK	2	50028047
18	COUPLING	1	50028044
19	ROLLER	1	054704
20	AIR FLOW RESTRICTER	1	054708
21	SAFETY COVER	1	50028038

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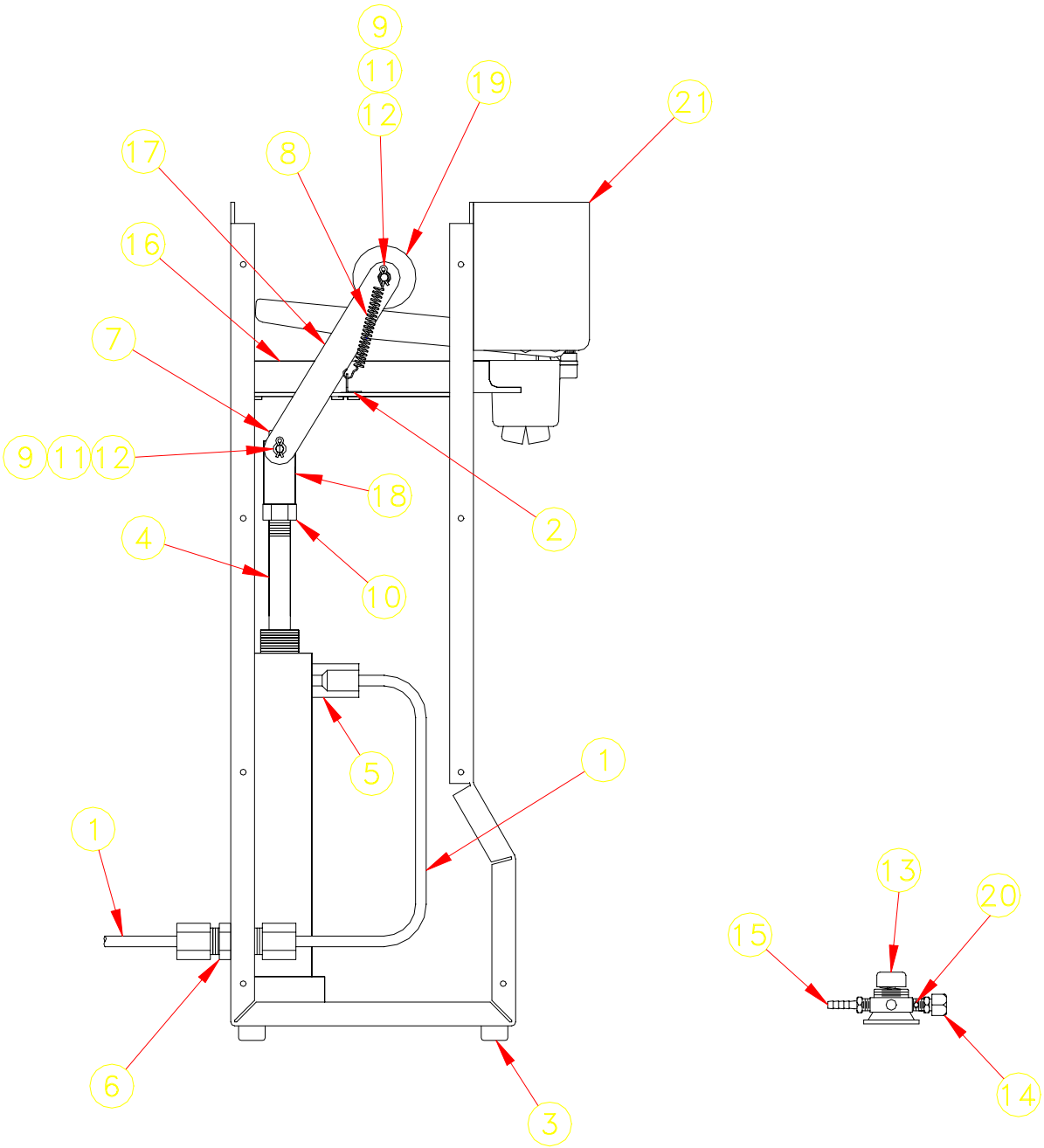


FIG. A

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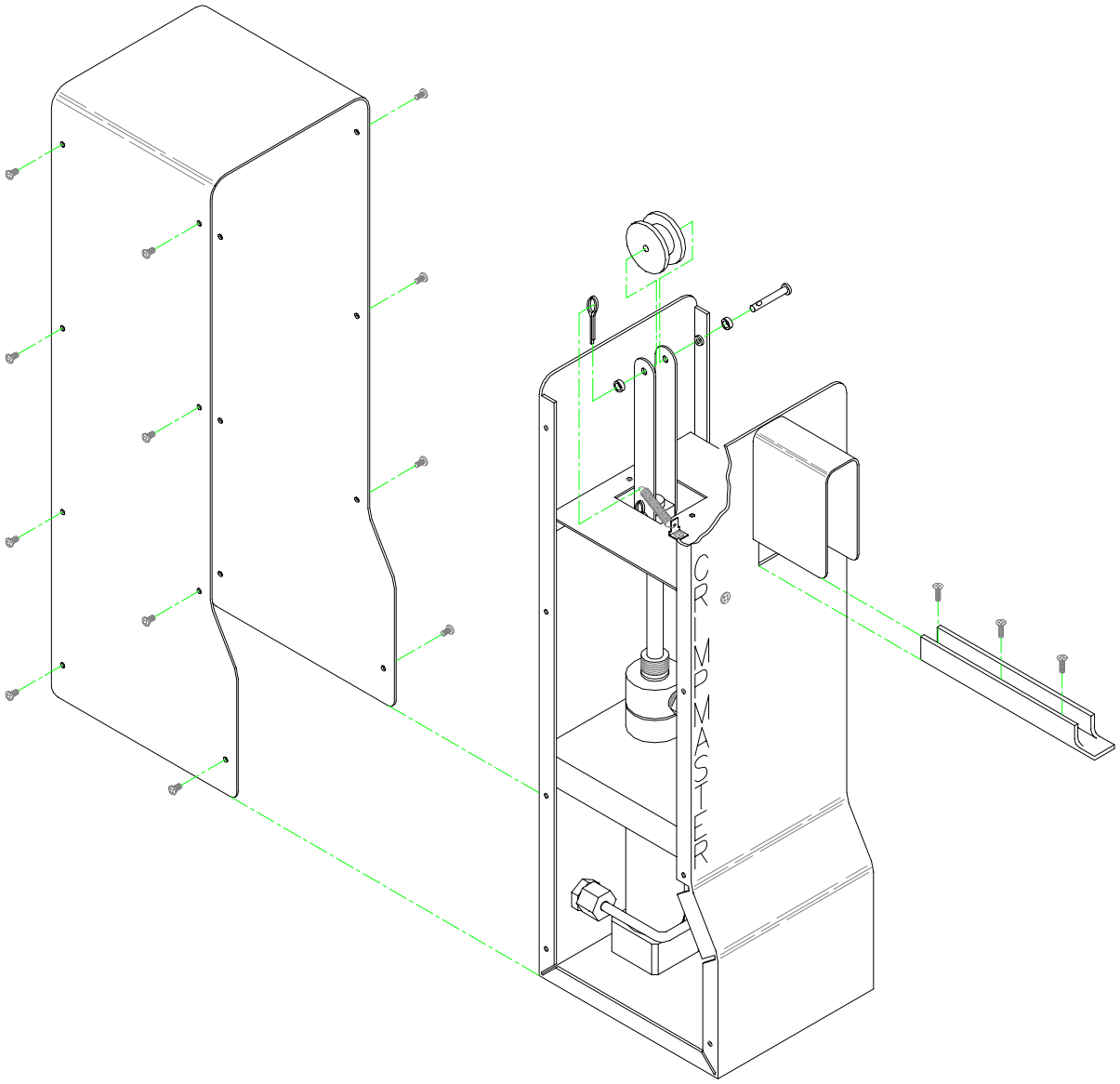
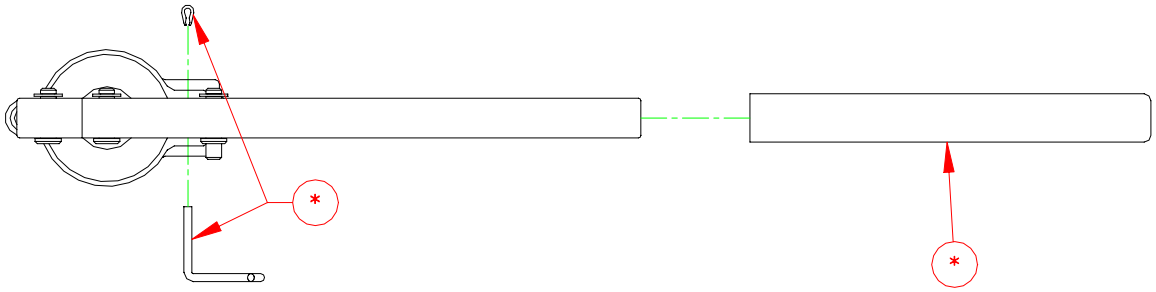
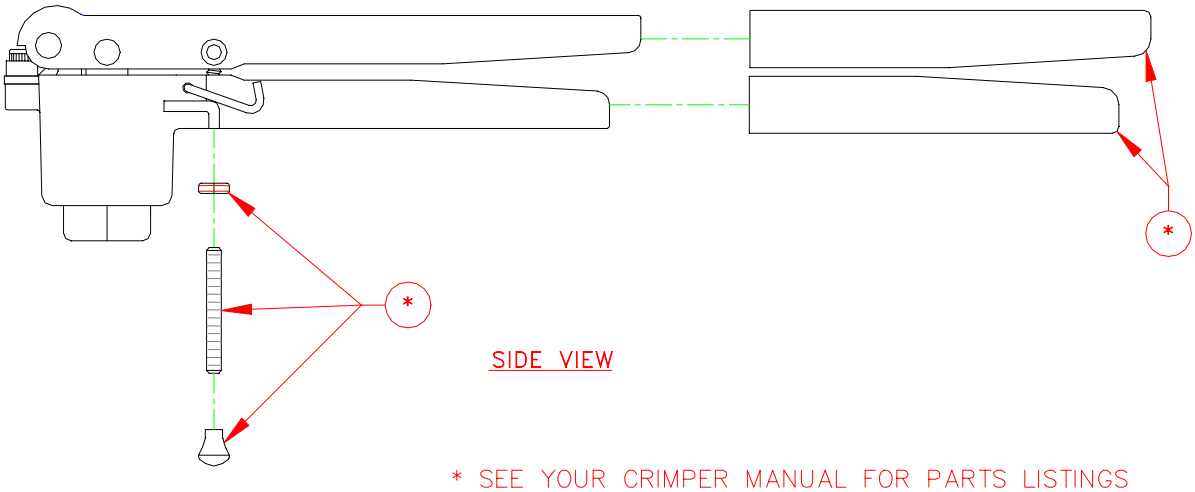


FIG. B

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TOP VIEW



SIDE VIEW

* SEE YOUR CRIMPER MANUAL FOR PARTS LISTINGS

FIG. C

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