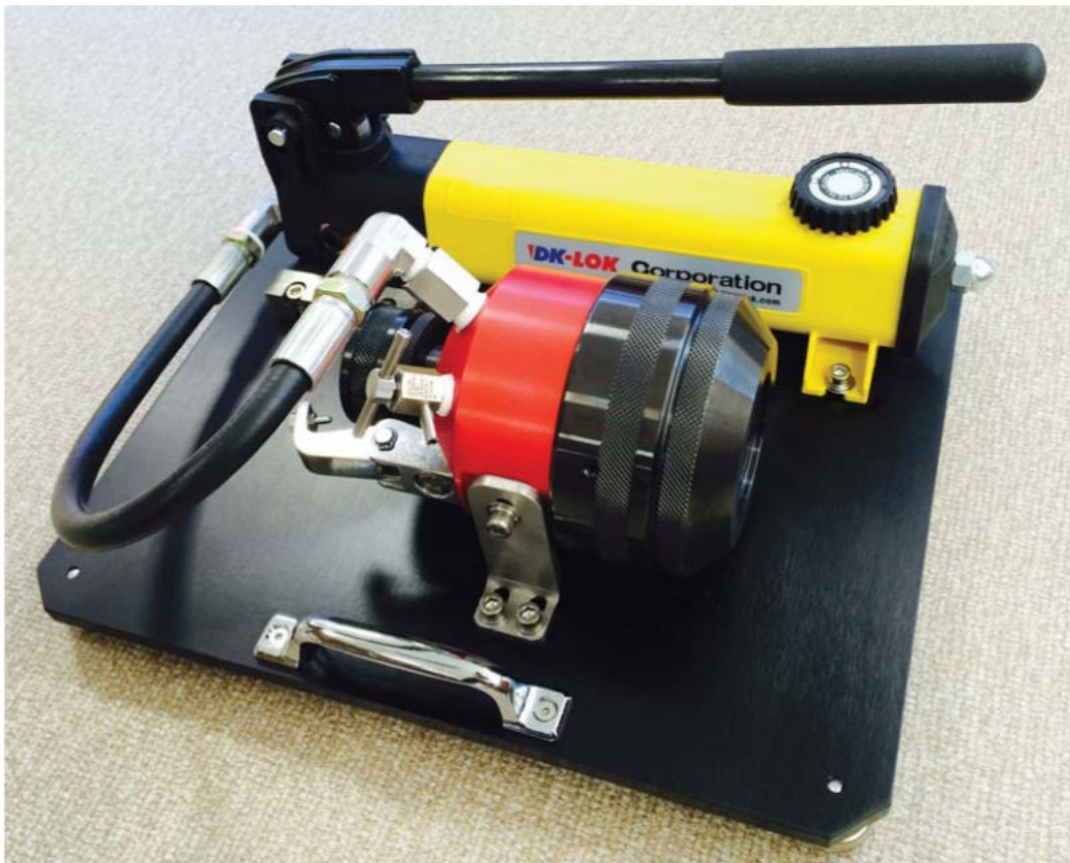




**VALVE AND FLOW CONTROL SPECIALISTS**  
*SERVICE AND RELIABILITY*

# Hydraulic Swaging Unit DHS-2A

Manual # DHS-2A August.2016



AUSTRALIAN DISTRIBUTOR:

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## 1. Safety Issues



Follow all safety precautions to avoid personal injury or property damage during system operation. **DK-Lok** can't be responsible for damage or injury resulting from unsafe use, lack of maintenance or incorrect product and/or system operation. Contact your authorized **DK-Lok** distributor when in doubt as to the safety precaution and operations.



**WARNING!**

Wear proper personal protective gear when operating or working near the swaging unit.

## 2. Features

- Pre-swage **DK-Lok** ferrules onto tubing
- Fractional: 1/2" , 3/4" , 1" , 1-1/4" ,1-1/2" , 2"
- Metric: 12mm , 20mm , 28mm , 32mm , 38mm, 50mm
- Assure consistent makeup with only about 30% of the manual pull-up torque
- Reduce installation time
- Easy to use by one operation
- Different size can be pre-swaged just by replacing Die & Jig
- Portable with wheels on sturdy aluminum carrying case
- **Up to 1in./25mm Swaging Head**  
Part No. : DHS-2HS-A (**Black Arm Gripper**)
- **1in./25mm and over Swaging Head**  
Part No. : DHS-2HS-B (**Red Arm Gripper**)



### 3. Standard Components

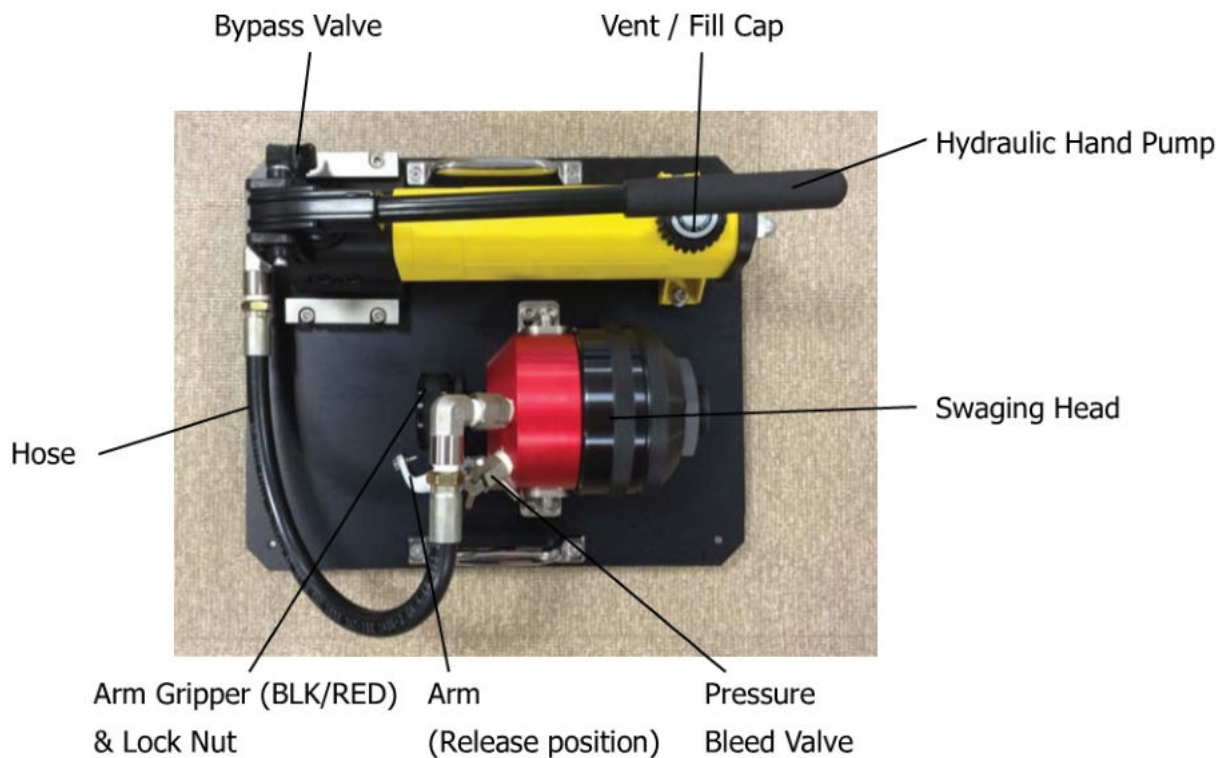


① Hydraulic Swaging Unit  
(Swaging Head + Hydraulic Hand Pump)



② DJS consisting of DIE and JIG  
③ Ratchet Wrench  
④ Allen Key  
⑤ DIE Fixing Bolt  
⑥ DKLUB-0311 (Lubricant)

### 4. Hydraulic Swaging Unit Lay Out





## 10. Recommended Tubing Wall Thickness for use with DHS-2A unit and DJS Ordering Number

※ CAUTION

Use of tubing below the recommended minimum wall thickness may result in the tube sticking in the die head.

For DK-Lok OD (in.)	Stainless Steel Seamless Tubing Wall Thickness		DJS Ordering Number
	Min. (in.)	Max (in.)	
1/2	0.065	0.083	DJS-8
5/8		0.095	DJS-10
3/4		0.109	DJS-12
1	0.083	0.120	DJS-16
1-1/4	0.095	0.156	DJS-20
1-1/2		0.188	DJS-24
2	0.109		DJS-32

For DK-Lok OD (mm)	Stainless Steel Seamless Tubing Wall Thickness		DJS Ordering Number
	Min. (mm)	Max (mm)	
12	1.5	2.0	DJS-12M
14		2.2	DJS-14M
15			DJS-15M
16	1.8	2.5	DJS-16M
18			DJS-18M
20	2.0	2.8	DJS-20M
22			DJS-22M
25		3.0	DJS-25M
28	2.2	3.5	DJS-28M
30			DJS-30M
32		4.0	DJS-32M
38	2.5	4.5	DJS-38M
50		5.0	DJS-50M

<b>Safe Product Selection</b>
When selecting a product, the total system design must be considered to ensure safe performance. Product function, material compatibility, adequate ratings, proper installation, operation, and maintenance are the sole responsibility of the system designer and user.
<b>Product Warranty</b>
DK-Lok hereby warrants to the purchaser of this product that the components of the product shall be free from defects in material and workmanship for twelve months from the date of purchase. Manufacturer shall be liable only if the product is used as specified in the current catalog and written instructions.  The purchaser's remedies shall be limited to replacement and installation of ant parts that fail through a defect in material or workmanship.  MANUFACTURER SPECIFICALLY DISAVOWS ANY OTHER REPRESENTATION, EXPRESS OR IMPLIED, WARRANTY, OR LIABILITY RELATING TO THE CONDITION PURCHASE, OR ANY THIRD PARTY, FOR ANY DIRECT OR INDIRECT CONSEQUENTIAL OR INCIDENTAL DAMAGES.