

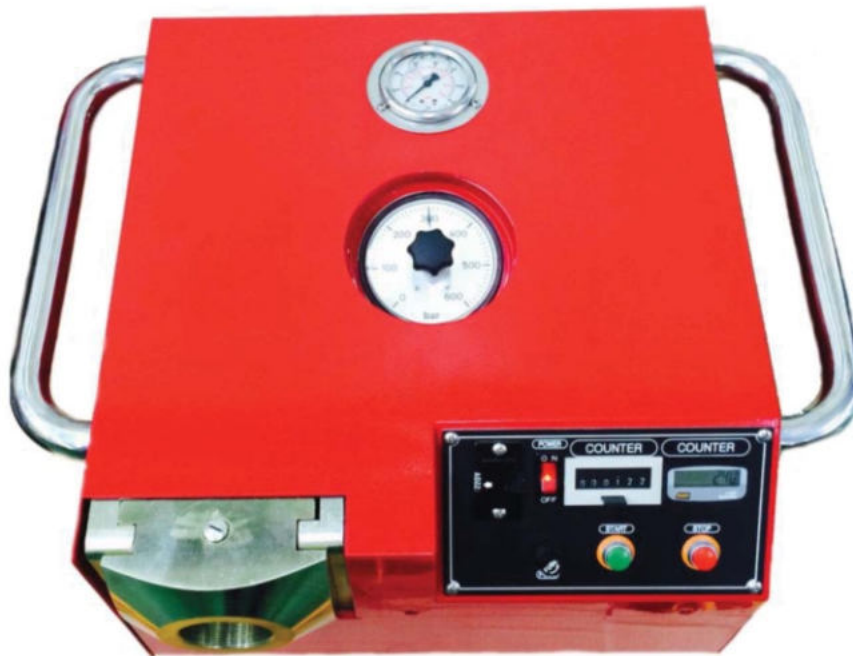


**VALVE AND FLOW CONTROL SPECIALISTS**  
*SERVICE AND RELIABILITY*

# Electric Swaging Unit

## **DES-1A**

**Rev.04 May. 2015**



### **DK-Lok Auto Pre-swaging**

**DK-LOK**  
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## 2. General Information

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DES-1A , DK-Lok'S Auto Hydraulic Pre-swaging Machine, design for use for all DK-Lok tube fitting range 1/2" – 2"(12mm-38mm), The unit may therefore be used for a variety of different applications.

The standard version is for 220V supply, a 110V version is also available on request.

Ferrules, nut and tube being properly pre-assembled, tube end shall rest on die shoulder, tapered face of front ferrule shall contact swaging cone, and nut shall be fixed to swaging jig.

Press the "start" switch, initiating the swaging process. The piston with the swaging cone advances.

Once the set pressure has been reached the swaging process is concluded. The piston with the swaging cone automatically returns to its initial position and the hydraulic pump unit switches off.

Now, pre-swaging is completed.

## 3. Features

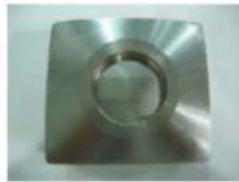
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- re-swage **DK-Lok** ferrules onto tubing
- Fractional: 1/2" , 3/4" , 1" , 1-1/4" ,1-1/2" , 2"
- Metric: 12mm , 20mm , 28mm , 32mm , 38mm
- Standard 220V & Optional 110V
- Assure consistent makeup free from the manual pull-up torque
- Reduce installation time
- Easy to use by one operation
- Different size can be pre-swaged just by replacing Die & Jig
- Portable in sturdy plastic case

## 4. Standard Components & Accessories



Swaging unit



Fixture



Jig



Die



Die fixing bolt



Allen key

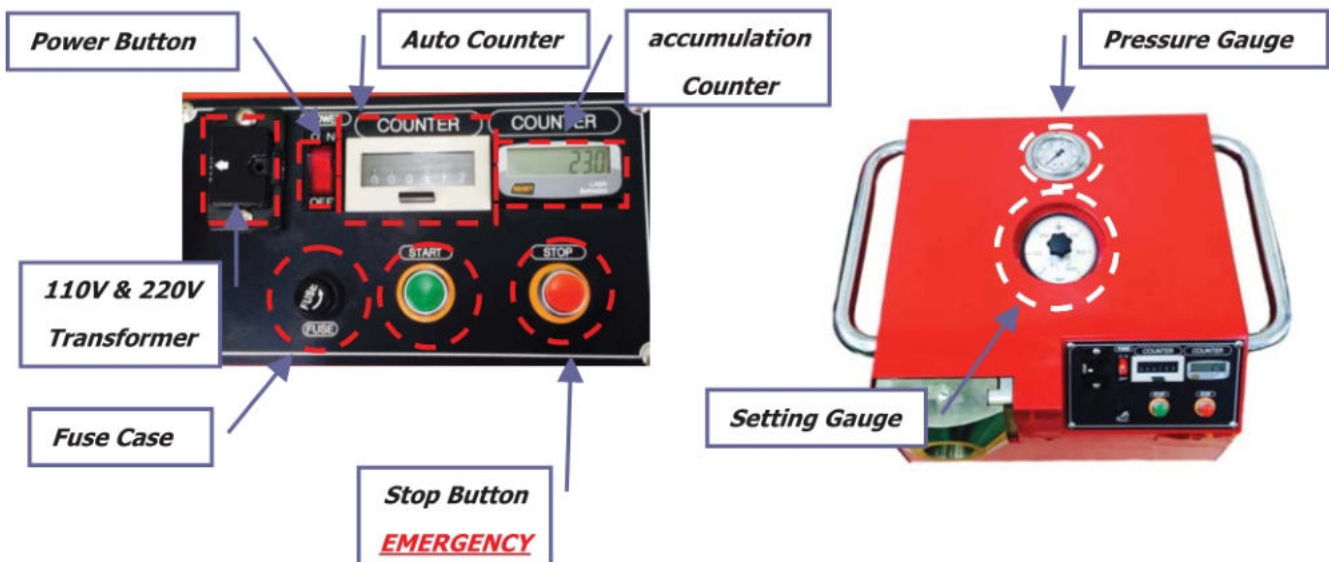


Wrench



DKLUB-0311

## 5. Box Lay Out



## 6. Technical data

The standard version is for 220V supply and a 110V version is also available on request.

Hydraulic pump	0.35 – 2.01 kW /min
Operation pressure	0 ~ 600 bar
Connection	220V/110V/1phase 50-60 Hz/2.5A
Dimension	400 * 400 * 230mm
Weight	48kg
Fuse	



## Table 1 - Electric Swaging Unit –Set Pressure

**Note)** The pressure used in accordance with the tube can be changed.

It is recommended to use a higher pressure than the pressure when using heavy-wall tubing **Table 1**.

*All Set Pressure For DK-Lok Tube Fitting*

Fitting size		Tube Tickness	Swaging Pressure (bar)	Turn From Pre-Swaging
Fraction	Metric		Stainless Steel	
1/4"	6mm	1.0mm	35	1/2
		1.5mm		
5/16"	8mm	1.0mm	40	
		1.5mm		
3/8"	10mm	1.0mm	65	
		1.5mm		
1/2"	12mm	1.0mm	65	
		1.5mm	80	
		2.0mm		
5/8"	15mm	1.5mm	75	
		2.0mm	80	
3/4"	18mm	1.5mm	90	
		2.0mm	100	
	20mm	2.0mm	120	
		2.5mm		
7/8"	22mm	1.5mm	130	
		2.0mm	150	
		2.5mm		
1"	25mm	2.0mm	150	
		2.5mm	170	
		3.0mm		
1-1/8"	28mm	1.5mm	145	5/8
		2.0mm	150	
		3.0mm	160	
1-1/4"	32mm	3.0mm	140	
		4.0mm	170	
1-5/16"	35mm	2.0mm	165	
		3.0mm	180	
1-1/2"	38mm	3.0mm	200	
		4.0mm	240	
1-5/8"	42mm	3.0mm	220	
		4.0mm	240	
2"	50mm	3.0mm	220	
		4.0mm	240	
		5.0mm	260	