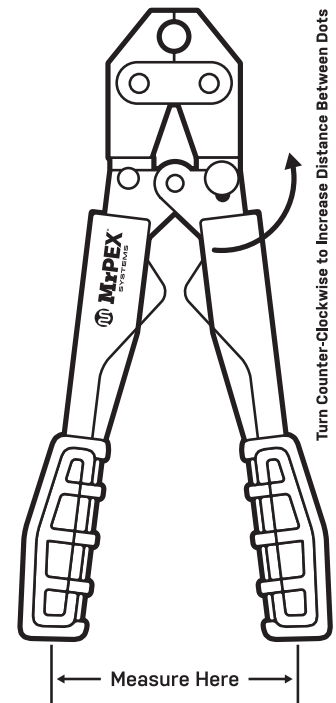


# PRESS TOOL CALIBRATION

Please follow procedure below:

1. Close the handles until the jaws meet, stop closing at the point that further pressure is required.
2. Measure the distance between the dots on the end of the handles.
3. If the tool has only one size press  $\frac{3}{4}$ " or less and does not have interchangeable press sizes then the length between the dots should be  $7\frac{3}{4}$ "  $\pm$   $\frac{1}{4}$ ". If the tool has a 1" press size, a combination of two sizes, or has interchangeable press sizes then the measurement between the dot will be  $8\frac{1}{2}$ "  $\pm$   $\frac{1}{4}$ ".
4. To adjust the distance between the dots, remove the 116-32 eccentric lock screw and push up eccentric from opposite side to disengage from handle half punch. Rotate counter-clockwise to increase the distance and clockwise to decrease the distance between dots.
5. Measure new distance and replace lock screw when you have a satisfactory measurement.
6. Complete three (3) fitting connections and recheck the measurement between dots.
7. Check the new pressed fittings with "Go/No Go" gauge provided with the tool. If results are unsatisfactory, further adjust the tool, if still unsatisfactory, replace the tool.



Always remember to check tool daily for proper adjustment, we recommend to check, at a minimum, the first and last pressed fitting of the day.

Never exceed the specified handle distance when adjusting your tool. Premature wear will result.

Lubricate linkages on a regular basis to maximize tool life.

CATALOG NUMBER	DESCRIPTION	MEASUREMENT
8400500	1/2"	$7\frac{3}{4}$ " $\pm$ $\frac{1}{4}$ "
8400750	3/4"	$7\frac{3}{4}$ " $\pm$ $\frac{1}{4}$ "
8405075	1/2" & 3/4"	$8\frac{1}{2}$ " $\pm$ $\frac{1}{4}$ "
8401000	1"	$8\frac{1}{4}$ " $\pm$ $\frac{1}{4}$ "