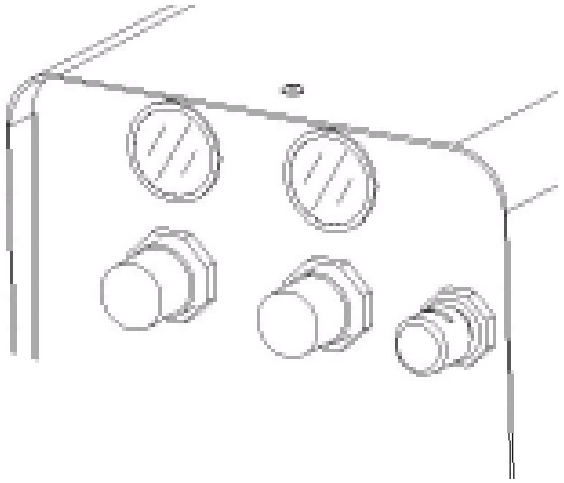
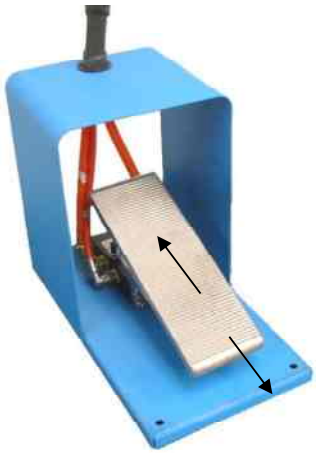


Air pressure setting can be made using the regulators and gauges on face of the tool.



Dual function foot control valve. Pressing forward activates clamp installation. Heel action activates tail return and prepares for next clamp.

Rule: Always approach the pull-up pressure setting from below and the holding pressure setting from above the recommended value.

Rule: Gauge readings are to be used as a guide. It may be necessary to adjust the Pull-Up and Holding Pressure settings to match the requirements of the particular hose assembly construction or application.

1. Speed Control adjusts the speed of piston travel during tensioning of the band clamp. A slower setting will allow more time while a faster setting may cause increased friction between the band and the buckle as the clamp tail is pulled through the buckle during tensioning. Increased friction may cause the clamp to tension improperly.

2. Setting the Speed Control: The speed of the cycle should be set according to the width of Junior Clamp being tensioned. Each width clamp has a color code setting on the speed control regulator. See this manual page # 8 or the decal on the side of the tool. Use the attached lock ring to secure the desired setting and prevent accidental changes.

3. Pull-up Pressure reflects the tension applied to the clamp and is measured by force applied to the clamp tail being pulled through the buckle. A pull-up pressure setting too low may allow the fitting to be forced out of the hose assembly. A setting too high may cause damage to the assembly or cause the clamp tail to tear. For most hose applications, the ideal setting is as high as can be achieved without sacrificing the strength of the lock, damaging the hose and fitting or breaking the clamp tail.

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4. Setting Pull-up Pressure: Pull the identified regulator knob and turn clockwise to reach pull-up pressure. Approach pressure setting from below by increasing pressure. Many factors should be considered when choosing the correct operating setting for the tool. The fitting design as well as the type, thickness and durometer of the hose material must be considered when setting the correct pressures for your assembly.
5. Holding Pressure reflects a lower pressure designed to allow the hose assembly to be rolled up in preparation for setting the lock with the shearing or cutting action on the clamp tail. A setting too low will cause difficulty in shearing the clamp tail and leaving an excessive burr on the buckle at the point of lock. A setting too high may cause the clamp tail to "pop" free of the band gripper, cause the lock to slip back under the buckle or cause a sudden jolt to the S75099 tool.
6. Setting Holding Pressure: Cycle the tool, holding the foot pedal in the toe forward position. The tool will reach pull-up tension and kick down to a holding pressure. Read the gauge and repeat the cycle turning the holding regulator clockwise to raise pressure or counter clockwise to lower pressure. Allow the tool to settle after each cycle before reading the value on the gauge.
7. Check pressure setting by cycling tool until hold pressure gauge stops.
8. Reset tool by depressing heel end of foot pedal. Remove foot.
9. Repeat steps 2, 4, 6, and 7. At pressure kick down, verify all settings and adjust if necessary. Lock settings in place.

Rule: Allow air to completely exhaust between each stage of the tools cycle. Failure to let air completely exhaust may result in clamps not pulling up tight.

	Guide for Operating Pressures for the S75099 Air tool								
Clamp Width	201 Stainless Steel			316 Stainless Steel			Galvanized Carbon Steel		
Inch	Pull Up Pressure (PSI)	Holding Pressure (PSI)	Speed Control Setting	Pull Up Pressure (PSI)	Holding Pressure (PSI)	Speed Control Setting	Pull Up Pressure (PSI)	Holding Pressure (PSI)	Speed Control Setting
1/4" (6.4mm)	15	4	Blue	15	4	Blue	NA	NA	NA
3/8" (7.5mm)	25	5	White	20	5	White	25	6	Blue
1/2" (12.7mm)	40	6	White	35	6	White	40	7	White
5/8" (15.9mm)	50	7	Red	40	7	Red	50	8	White
3/4" (19.1mm)	60	8	Red	50	8	Red	60	9	Red

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