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 |
| | | | | | | | | | |
| | | | Red | 40 | 7 | Red | 50 | 8 | White |
| | | | | | | | | | |
| | | | | | | | 60 | 9 | Red |

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