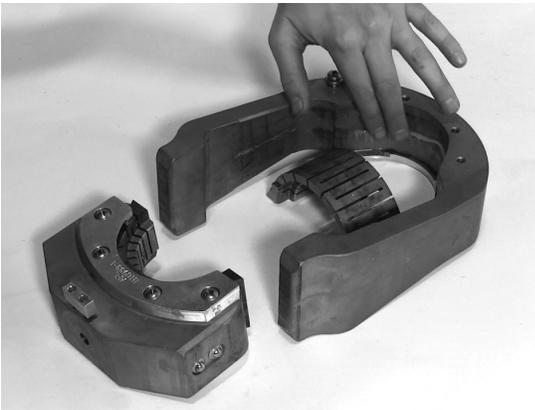
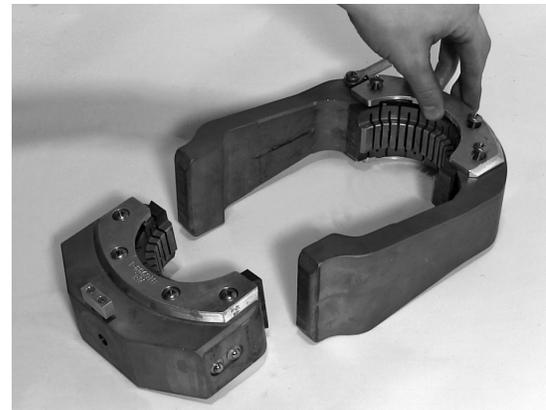


## Swage Tool Assembly and Overview Instructions

1. Apply Swage lube to the head, die block and the outside of each Swage die. Spread evenly with fingers.
2. With the die faceplate off, slide die into grooved area of the head ensuring it sits correctly in the bottom faceplate.



3. Install the top faceplate to lock the die into the head assembly using a Phillips head screw driver. Repeat steps for the die block assembly.



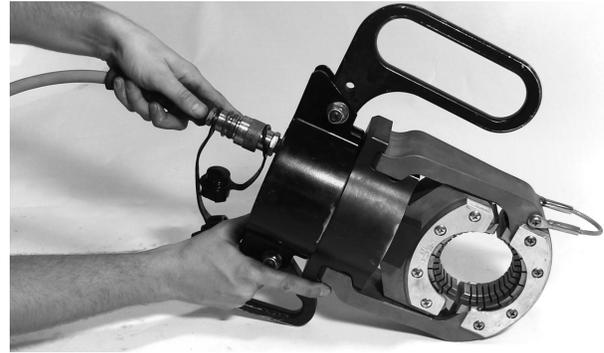
*continued*  
→

## Swage Tool Assembly and Overview Instructions (cont.)

4. Attach the die block to power unit by holding the unlock button on the side of the die block. Slide the pin into bottom and release lock.



6. Remove safety caps from the bottom of power unit and the hose fitting. Insert hose fitting into power unit and tighten to ensure a tight seal.



5. Slide the head assembly on to the power unit and ensure the rollers on the die block roll into place. (**Note:** Incorrect assembly could damage the tool and dies when compressed. Ensure your press head is aligned with the power unit.)



## Swage Tool Maintenance Instructions

1. Disassemble press head from power unit.
2. Disassemble press head: Remove the die face plates and the top die.
3. Use aerosol parts cleaner to spray press head, die and face plates. Wipe off with a clean rag to remove any grease, dirt or debris.
4. Reassemble press head: Re-install one face plate on the press head, apply Swage grease to the press head surface that comes in contact with the die when assembled, apply Swage grease to the outside of the die, then install the die into the press head. Next, install the second face plate.
5. Remove the die block from the power unit.
6. Disassemble the die block by removing both face plates and die.
7. Use aerosol parts cleaner to spray die block, die and face plates. Wipe off with a clean rag to remove any grease, dirt or debris.
8. Reassemble die block: Re-install one face plate on the die block, apply Swage grease to the die block surface that comes in contact with the die when assembled, apply Swage grease to the outside of the die, then install the die into the die block. Next, install the second face plate.
9. Use aerosol parts cleaner to spray the power unit. Wipe off with a clean rag to remove any grease, dirt or debris.
10. Re-install the die block onto the power unit. Then re-install the press head assembly.

**NOTE: THE 45 AND 65 TON PRESS SHOULD BE CLEANED AFTER EACH USE AND/OR WHEN DIES ARE CHANGED.**

### Preventive Maintenance Instructions

#### Before Each Use:

- Ensure the swivel is secured tightly.
- Ensure the quick disconnect is tight and works properly
- Ensure the piston is fully retracted and flush with the top of the power unit surface.
- Ensure the die block lock button is operating properly and that the die block engages into the power unit correctly.
- Ensure the quick disconnect is tight and works properly.
- After the 45 or 65 Ton Press is fully assembled, run to full compression a few times to ensure there are no leaks and/or lack of compression.

#### Other Things to Inspect:

- Check Swage dies for debris between slots and for any cracks. Clean the dies using a wire brush and a rag to remove metal chips, excess grease and dirt between the slots of the dies. Use a rag to “floss” each groove in the die blocks. (See Tool Maintenance Instructions for more information.)
- Perform die penetrate inspection on the cylinder and head at least once per year.