

Pre-assembly tools reworked

SERTO has been selling not just unions for many years, but also the compatible pre-assembly tools. For smaller diameters up to 10 mm the pneumatic device SERTOtool is recommended; for larger diameters (up to 35 mm!) the electro-hydraulic device SERTOmatic. The pressing operation of both devices has now been technically revised and we have created an easy-to-follow film documentation.

Due to diverse modifications in our product range, we have had to make adaptations to our reliable pre-assembly tools SERTOtool and SERTOmatic. The handling features were also looked at in greater detail, which led to a few improvements.

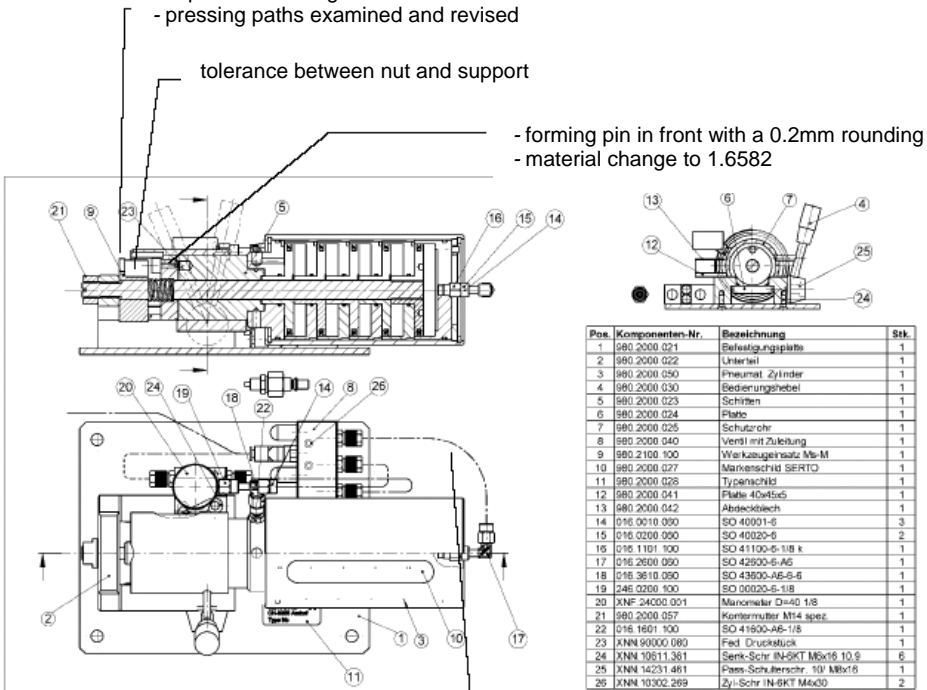
SERTOtool

The **SERTOtool** device is operated with compressed air and can be set up practically anywhere thanks to its small size and low weight. Each device has a rotatable tool insert, adapted to the respective material (brass M, Inox, Inox SOL, etc.) and mix-ups are not permitted. A detailed overview is enclosed.

- improved cladding of tool insert
- pressing paths examined and revised

tolerance between nut and support

- forming pin in front with a 0.2mm rounding instead of bevel
- material change to 1.6582




Pos.	Komponenten-Nr.	Bezeichnung	Stk.
1	980 2000 021	Befestigungsplatte	1
2	980 2000 022	Unterteil	1
3	980 2000 050	Pneumat. Zylinder	1
4	980 2000 030	Bedienungshebel	1
5	980 2000 023	Schirmen	1
6	980 2000 024	Platte	1
7	980 2000 025	Schutzrohr	1
8	980 2000 040	Ventil mit Zuleitung	1
9	980 2100 100	Werkzeugeinsatz Mx-M	1
10	980 2000 027	Markierschub SERTO	1
11	980 2000 028	Typenschild	1
12	980 2000 041	Platte 40x45x5	1
13	980 2000 042	Abdeckblech	1
14	016.0010.090	SO 40001-S	3
15	016.0200.090	SO 40020-S	2
16	016.1101.100	SO 41100-S-1/8 k	1
17	016.2800.090	SO 42900-S-AG	1
18	016.3610.090	SO 43600-S-AG-S-6	1
19	046.0200.100	SO 00020-S-1/8	1
20	XNF 24000 001	Manometer D=40 1/8	1
21	980 2000 057	Kantennut M14 spez.	1
22	016.1601.100	SO 41900-AG-1/8	1
23	XNN 90000 080	Fed. Druckstück	1
24	XNN 10811.381	Senk-Schr. IN-SKT M16x16 10.9	6
25	XNN 14231.461	Pass-Schulterrohr 10/ M16x16	1
26	XNN 10300.269	Zyl.-Schr. IN-6KT M4x30	2

© SERTO AG 02/09/2006

Druckdatum: 12.12.2006

Artnr.: **980.2100.000** SO-Bez.: **SERTOtool Ms-M** Messstab 1:2
 Änd.-Nr.: X08-AM450-109 Programm: **SERTO tool** kg
 Ersatz für: S2_980_210_000 C Werkstoff
 gezeichnet: 22.03.2005 HB Dimension / Modult
 freigegeben: 05.10.2005 PW SERTOtool Messing M
 Bemerkung:

SERTO  **SZ_980_2100_000 A A3**

- pressing safeguard built in via pneumatic time interval

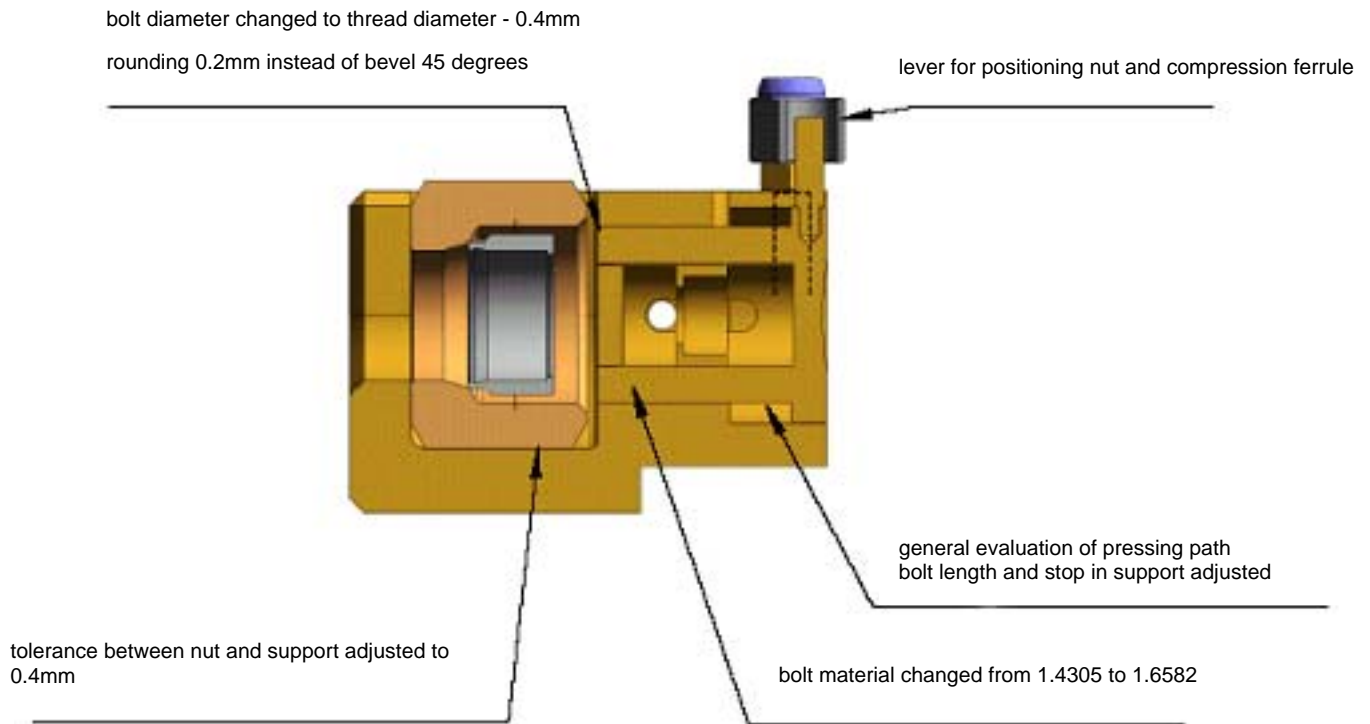
The most obvious improvement is the built-in pneumatic time interval. This prevents the operator from pulling back the control lever too soon during the pressing process, which has led to incorrect pressing in the past. From now on, the lever is blocked in the front position for a short duration, thus ensuring optimal pre-assembly.

Other minor modifications were made to the tool inserts and the forming pins (see diagram above).

8355 Aadorf	SERTO 	Seite 2/2
Aktennotiz		Beilagen:

SERTOmatic

For larger diameters, we offer the SERTOmatic pre-assembly tool. It is equipped with an electro-hydraulic pump and can take pressures up to 700 bar and deformation forces of up to 10 tons. This renders the device ideal for unions up to size 35 mm. Transportation of the SERTOmatic is limited, but it can be used wherever there is a power connection.



Diverse tool inserts, which are compatible with our product lines, are available for the base unit. Because of the different geometries, every material and every tube diameter requires its own tool insert (see overview in the enclosed).

The most important modification is the centering lever at the end of the carrier; this is used to position the nut and compression ferrule correctly after inserting the tube union. This prevents the pressing bolt from entering at a slant and prevents the individual parts from becoming damaged or jammed.