HVM-B Pre-assembly tool

This pre-installation tool is a simple tool for a quick and safe pre-assembly of EO-Progressive Stop Ring/Progressive ring. The tool is very handy and can be used at any site provided a vice is available. Suitable for LL, L and S series and tube sizes from 4 to 15 mm O.D.

Attention:

⚠ **Not suitable for EO-2 assembly.**
⚠ **Not suitable for stainless steel progressive ring assembly.**
⚠ **Final assembly of ½ turn in fitting body required.**
⚠ **Not suitable for tube OD larger 15 mm**

Specifications:

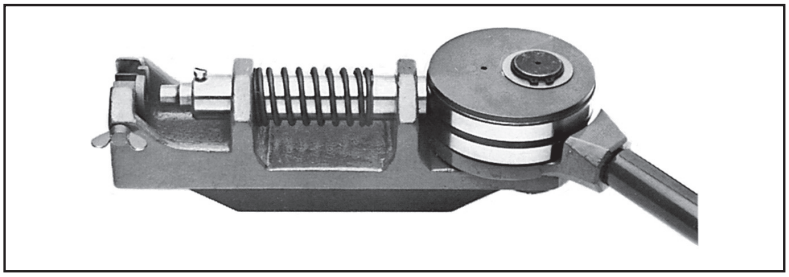
For pre-assembly of: EO Progressive Stop Ring (PSR)/Progressive Ring (DPR)
Pre-assembly equals: 1 turn of nut

For assembly check and fitting installation see assembly instructions chapter E.

Tube O.D.: 4 to 15 mm
Min. U-bend: 25 mm
Series: LL, L and S
Tube and fitting material: Steel
Weight: approx. 7.0 kg (without tools)
Economic production quantity: max. 20 ass./day

Features, advantages and benefits of pre-assembly tool:

1. **Special** – HVM-B is designed and manufactured to match EO-DPR standards.
2. **Vice mounted** – For easy workshop use, the HVM-B can be clamped into any vice.
3. **Flexible** – A HVM-B can be used anywhere to assure safe fitting assembly – even at assembly sites where EOMAT technology is not available.
4. **Efficient** – There is no doubt that HVM-B-presetting contributes to save time and effort in bite-type assembly. The small investment pays back immediately.



Type	Order code
HVM-B pre-assembly tool device for mount in vice, without tools	HVMBKPLX

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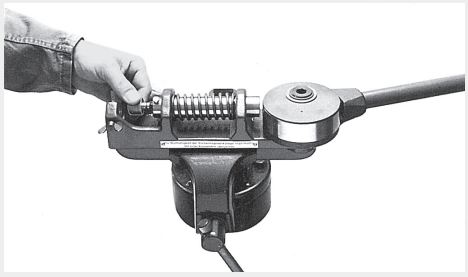
Series	Tube O.D. mm	Tube location plate Order code	Assembly cone Order code	Cone-template Order code
LL	4	HL04X	MOSI04LLX	KONU04LL
	6	HL06X	MOSI06LLX	KONU06LL
	8	HL08X	MOSI08LLX	KONU08LL
	10	HL10X	MOSI10LLX	KONU10LL
	12	HL12X	MOSI12LLX	KONU12LL
L	6	HL06X	MOSI06LX	KONU06L[1])
	8	HL08X	MOSI08LX	KONU08L[1])
	10	HL10X	MOSI10LX	KONU10L[1])
	12	HL12X	MOSI12LX	KONU12L[1])
	15	HL15X	MOSI15LX	KONU15L
S	6	HL06X	MOSI06SX	KONU06L[1])
	8	HL08X	MOSI08SX	KONU08L[1])
	10	HL10X	MOSI10SX	KONU10L[1])
	12	HL12X	MOSI12SX	KONU12L[1])
	14	HL14X	MOSI14SX	KONU14S

1) Cone-templates for tube o.d. 6 to 12 are identical in series L and S.

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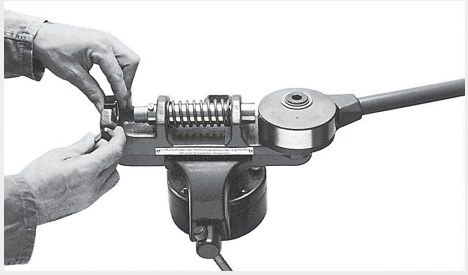
1



How to use

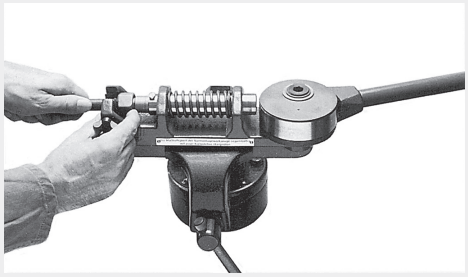
- Clamp HVM-B into vice.
- Select required assembly cone (MOSI) and insert.
- The assembly cones are marked with tube O.D. and series (e.g. 10-L).

2



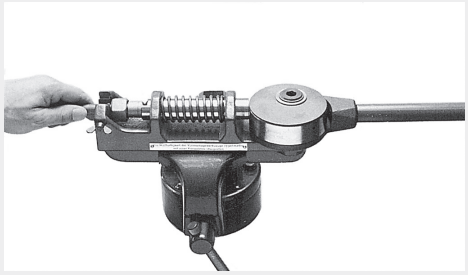
- Insert the tube location plate – HL – of corresponding size and fasten with screw.
- The tube location plates are marked with tube O.D. (e.g. “10”).

3



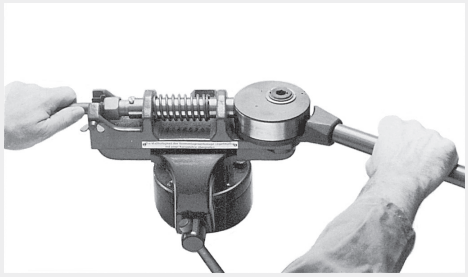
- Slip nut “M” and Progressive Stop Ring PSR/Progressive ring “DPR” (or cutting ring “D”) over tube end and insert into pre-assembly tool.
- Nut position must be in front of tube location plate – HL – !

4



- Hold tube against stop in the assembly cone.

5



- Pull lever to turn the eccentric cam (Pre-assembly).

Attention

⚠ **For assembly check and final assembly see PSR/DPR instructions.**

Attention:

⚠ **At final assembly nut must be tightened by ½ turn.**

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