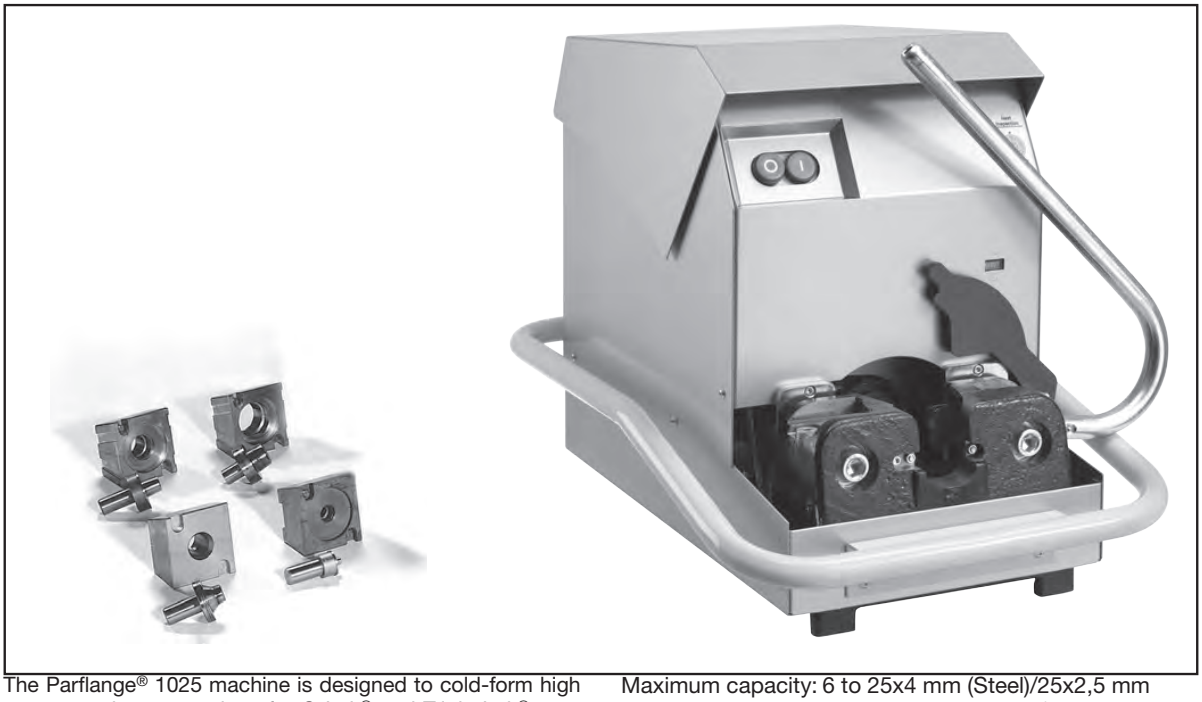
Parflange® 1025 workshop machine for O-Lok® and Triple-Lok®



The Parflange® 1025 machine is designed to cold-form high pressure tube connections for O-Lok® and Triple-Lok® connection. It uses the Parflange® orbital flaring process. The Parflange® 1025 machine smoothly compresses the tube material and achieves a high strength joint with a polished surface of the tube end. O-Lok® and SAE flange sleeves are firmly fixed onto the tube end, resulting in a very rigid high-pressure tube connection.

The 1025 is the smallest machine of the Parflange® machine programme. It is recommended for low-volume assembly jobs of small to medium tube dimensions. Maximum tube capacity is 25 × 4 mm/1″ (steel tube) and 25 × 2.5 mm/1″ Parker tube 1.4571 (tube made from other material has to be checked). Its advantage is the quick and easy change of tooling and the simple operation without manual adjustments or programming. The machine is transportable so that it can be moved to any assembly site with electrical power supply.

The Parflange® 1025 comes ready to be used. Parflange® tools are purchased separately. For each tube dimension, special clamping dies and Parflange® pins are required.

Specifications

Purpose:	180° flanging for O-Lok® and 37° flaring for Triple-Lok®
Process:	Orbital flaring and flanging according to Parflange® process
Design:	Desktop machine for workshop use
Tube material:	steel and stainless steel tube
Tube diameter:	metric: 6 to 25 mm Inch: ¼ to 1″
Maximum capacity:	6 to 25x4 mm (Steel)/25x2,5 mm Stainless Steel O-Lok®[1]) 1/4″ to 1″x0.120 (Steel)/1″x0.095 Stainless Steel O-Lok®[1]) 6 mm to 42 mm / 1/4” to 2” Triple-Lok®
Min. U-bend:	140 mm
Tube specification:	fully annealed seamless cold drawn or welded precision tube
Performance:	
Overall cycle time	1.5 kW: 50 sec; 1.1 kW: 60 sec
Economic production quantity	1.5 kW: max. 100; 1.1 kW: max. 50
Operation:	Manual clamping, automatic flanging/flaring
Continuous operating:	80 %
Cycle time:	approx. 15 to 20 secs.
Tools:	Flaring pin B30 or B40 … and clamping dies M40 …
Tool clamping:	Manual, by eccentric lever
Tool lubrication:	Automatic lubrication device
Lubricant:	EO-NIROMONT LUBSS (filled when delivered)
Hydraulic oil:	HLP 23 0.5L (filled when delivered)
Installation:	rigid workbench and electrical power supply required
Dimensions:	670×390×460 mm
Weight:	85 kg

[1]) Other sizes on request.

Features, advantages and benefits

1. **Superior sealing performance –** The Parflange® process achieves a sealing surface of unique surface quality and mechanical strength.
2. **Superior vibration resistance –** Unlike conventional flaring, the Parflange® process results in a rigid connection of the O-Lok® sleeve on the tube-end. Parflange®/ O-Lok® connections perform much better under reversed bending stress conditions.
3. **Easy to use** – No programming or adjustments necessary. High quality results are consistently achieved without manual adjustments.
4. **Quality –** Machine setting, tool control and even lubrication are fully automated so that high and consistent quality results are achieved without manual adjustments.
5. **Small bending radii** – The compact clamping device and special dies are suitable for flanging short tube ends.
6. **Cost saving** – Compared to brazing or welding, orbital flanging is much less time consuming. Special tube preparation and finishing are not necessary. Flanging uses only a fraction of the energy needed for brazing or welding.
7. **Clean** – The Parflange® process is environmental clean and safe. As no heat or chemicals are used, hazards from fumes or heat do not occur.
8. **Zinc plated tubing** – The Parflange® process allows the use of zinc-plated tubing. The cost for cleaning or painting can be saved.
9. **High tool lifetime** – The Parflange® 1025 machine is equipped with an automatic lubrication device. The tools will not wear rapidely if the operator does not lubricate regularly.
10. **Process/Product concept** – Parflange® machines are especially designed to match Parker O-Lok® and Triple-Lok® standards. Machine, tools and products are fine-tuned for reliable performance.
11. **Proven technology** – Since more than 10 years, hundreds of Parflange® machines have operated worldwide under heavy duty workshop conditions.

Applications

Workshop use, project work, plant maintenance, on-site assembly.
Not for efficient mass production

Ordering

Type	Order code
Parflange® 1025 Basic machine Ready to use, Including operating manual, Filled with hydraulic oil and lubricant Without Parflange® tools Basic machine 400 V, 3 Phase, 50 Hz Basic machine 230 V, 1 Phase, 50 Hz Rental (monthly usage)	 1025-380VTRI50 1025-220VMONO50 1025RENTFEE
1025 promotion leaflet UK	4390/UK
1025 promotion leaflet DE	4390/DE
1025 operating manual UK/DE/FR/IT	4390-B5
Standard preventive maintenance	1025/INSPECTION

Parflange® machines are shipped in a special container which should be kept for all transports to avoid damage.

Spare parts

Type	Order code
Tool lubricant qty: 1L EO-NIROMONT	LUBSS
Drive belt	1025/028Polyv
Came guide and with screw	1025/0281031
Hydraulic tank seal kit	1025/0281042
Lubrication kit	1025/0281200
Retrofit Kit: Oilsump for the Parflange 1025 to catch rest lubricant	1025/OILSUMP

Tel: +45 63 12 83 00 | Email: ps@hymatik.com | www.hymatik.com | Hvidkaervej 27a, DK-5250 Odense SV, Denmark