

## Order Codes

Type	Order code
EOMAT UNI basic machine 220 V, Single Phase	EOMATUNI230V
Fixture for PSR/DPR/EO-2 preassembly	EOMATSCHEIDRX
Fixture for 37° tube flaring	EOMATBOERDELBX
Tool mounting rack for MOK/GHP	EOMATWERKZGAUFN.X

Size		Order code				
Series	Tube OD	Assembly cone for EO PSR/DPR	Assembly cone for EO2/MOK/EO-2	Tube locating plate GHP	Distance Gauge for Assembly AKL	Cone gauges KONU
<b>L</b>	6	MOK06LX	same as MOK for PSR/DPR	GHP06X <sup>1</sup>	AKL06LS	KONU06+08L/SX <sup>1</sup>
	8	MOK08LX		GHP08X <sup>1</sup>	AKL08LS	KONU10+12LSX <sup>1</sup>
	10	MOK10LX		GHP10X <sup>1</sup>	AKL10L	
	12	MOK12LX		GHP12X <sup>1</sup>	AKL12L	
	15	MOK15LX		GHP15X	AKL15L	KONU15+18LX
	18	MOK18LX	GHP18X	AKL18L	KONU22+28LX	
	22	MOK22LX	MOKEO222LX	GHP22X		AKL22L
	28	MOK28LX	MOKEO228LX	GHP28X		AKL28L
	35	MOK35LX	MOKEO235LX	GHP35X <sup>2</sup>		AKL35L
	42	MOK42LX	MOKEO242LX	GHP42X <sup>2</sup>	AKL42L	
<b>S</b>	6	MOK06SX	same as MOK for PSR/DPR	GHP06X <sup>1</sup>	AKL06LS	KONU06+08L/SX <sup>1</sup>
	8	MOK08SX		GHP08X <sup>1</sup>	AKL08LS	KONU10+12L/SX <sup>1</sup>
	10	MOK10SX		GHP10X <sup>1</sup>	AKL10S	
	12	MOK12SX		GHP12X <sup>1</sup>	AKL12S	KONU14+16SX
	14	MOK14SX		GHP14X	AKL14S	
	16	MOK16SX	GHP16X	AKL16S	KONU20+25SX	
	20	MOK20SX	MOKEO220SX	GHP20X		AKL20S
	25	MOK25SX	MOKEO225SX	GHP25X		AKL25S
	30	MOK30SX	MOKEO230SX	GHP30X		AKL30S
	38	MOK38SX	MOKEO238SX	GHP38X	AKL38S	

1) The tube locating plates, cone gauges and flaring sets are the same for series L and S tube with OD 6-12 mm. Tools and specifications subject to change without notice.

2) Tube locating plates 35L and 42L for Tube O.D. 35 and 42 as two parts.

Design details and specifications subject to change without notice.



Bulletin 4042-4/UK



**EO** Ermeto Original  
**EOMAT UNI**  
Universal assembly machine  
for hydraulic tube fittings

Bulletin 4042-4/UK

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Universal assembly machine for hydraulic tube fittings

General

The EOMAT UNI is an electro-hydraulic machine for the assembly of:

**EO-2 Progressive Ring PSR/DPR and Triple-Lok® 37° flared tube fittings.**

Compared to manual assembly it greatly reduces assembly time, effort and cost and also guarantees leakfree performance of constant high-quality fitting assemblies.

Common tube materials such as steel (ST 37.4 NBK, ST 52.4 NBK), stainless steel (1.4571/1.4541/316Ti or similar) and copper can be preassembled.

The tool range covers all metric tube sizes from 6 to 42 mm outer diameter. The required operating pressure is variable and set at the LED Display. The unit may therefore be used for a variety of different applications. The tooling for either EO-2/PSR/DPR preassembly or tube flaring may be manually replaced, without the use of tools.

Technical Data

Oil: Esso Nuto H 32 or equal, 3.5L  
 Operating pressure: Variable from 15 to 200 bar  
 Dimensions: Width 535 mm, height 285 mm, depth 515 mm

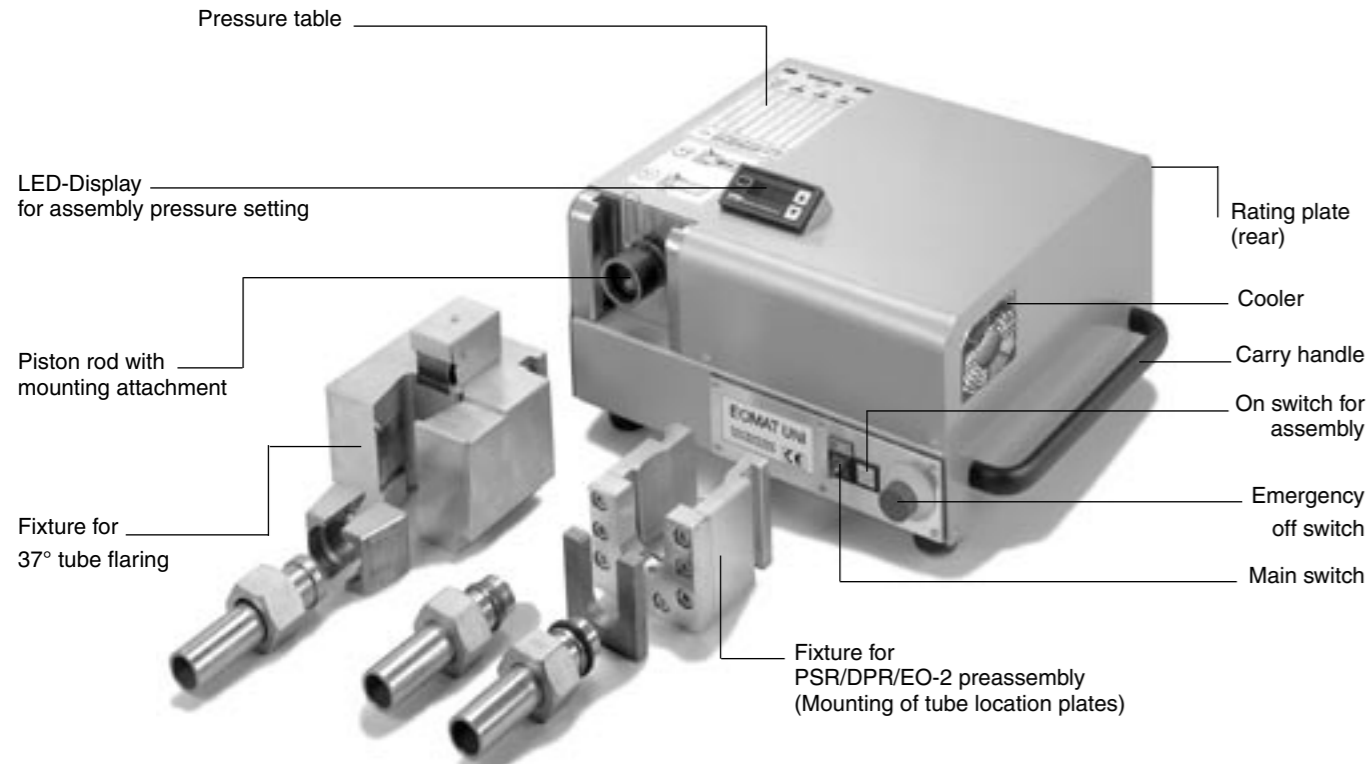
Hydraulic pump: 1.2 kW - 3.7 l/min  
 Feedrate: 6.9 mm/sec.  
 Electrical connection: 220-240 V/ 1~ / 50 Hz / 9 A  
 Connection cable: 5 m - Earth plug  
 Weight: 66 kg

We reserve the right to make modifications in the course of further technical development.

Features, Advantages and Benefits:

- **Universal** - Assembly of EO-2, EO-Progressive Ring and 37° flaring for Triple-Lok® can be done with just 1 machine.
- **Efficient** - With a cycle time of some 10 seconds the EOMAT UNI greatly saves assembly time and effort. The investment pays back soon.

- **Safe** - Proper Pre-assembly greatly reduces the danger of leaking fittings or even hazardous tube blow out.
- **Strong** - Even 37° flaring of large size stainless steel tube is done within few seconds.
- **Flexible** - All tube dimensions from 4 to 42 mm can be preassembled. All common tube materials are covered.
- **Workshop tool** - With a 66 kg, the EOMAT UNI can be brought to an assembly site.
- **Marking notch** - The pre-assembly tools feature a special notch in the bottom surface which is designed to engrave a circular groove into the tube-end at assembly. A missing of this mark indicates that the tube-end has not been properly bottomed at assembly.
- **Reliable** - Since more than 20 years, hundreds of machines are operated under heavy duty workshop conditions.
- 230V version with identical performance as EOMAT II 400 V.
- Noise level lower than EOMAT II.

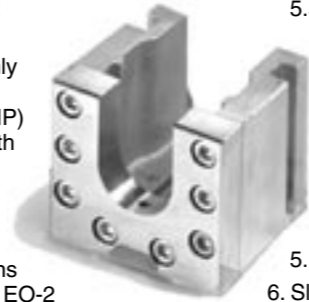


Assembly

Assembly of EO-2 Functional Nuts

See EO-2 instructions for fitting assembly

1. Adjust EO-2 pressure according to chart (A)
2. Insert the preassembly fixture in the tool mounting (weight approx. 5.5 kg).
3. Select the assembly cone (MOK) and backing plate (GHP) in accordance with the tube size and type. Check assembly cone MOK for correct dimensions and suitability for EO-2 assembly.
4. Place and lock the assembly cone in the tool holder. Place the backing plate in the slot in the fixture.
5. Slide the EO-2 functional nut onto the tube, which has been cut off square and deburred.
6. Place the tube with the EO-2 functional nut in the preassembly fixture between backing plate and assembly cone.
7. Press the tube against the stop in the assembly cone. Hold the tube in this position. Press and hold the start button until the preassembly process is complete.
8. Take the assembled tube connection out of the location plate. Loosen nut and check that the gap between the sealing ring and retaining ring is closed.



Preassembly of Progressive Rings

See PSR/DPR instructions for fitting assembly

1. Adjust PSR/DPR-pressure according to chart (A)
2. Insert the preassembly fixture in the tool mounting (weight approx. 5.5 kg).
3. Select the assembly cone (MOK) and backing plate (GHP) in accordance with the tube size and type. Check the assembly cone using a cone gauge.
4. Place the assembly cone in the tool holder. Place the backing plate in the slot in the fixture.
5. Oil the ring, nut and assembly cone.
6. Slide the nut and ring onto the tube, which has been cut off square and deburred.
7. Place the tube with nut and ring in the preassembly fixture between backing plate and assembly cone.
8. Press the tube against the stop in the assembly cone. Hold the tube in this position. Press and hold the start button until the preassembly process is completed.
9. Take the preassembled tube out of the backing plate. The ring has cut into the tube leaving a visible raised collar (check!).



Flaring Tubes




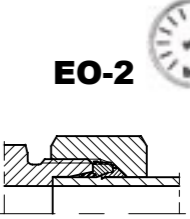
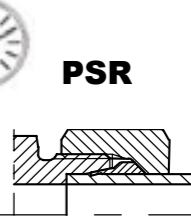





See Triple-Lok® instructions for fitting assembly

1. Adjust Triple-Lok® pressure according to chart (A)
2. Insert the tube flaring fixture in the tool mounting (weight approx. 19.5 kg).
3. Oil the flaring pin.
4. Insert the flaring die set corresponding to the tube size.
5. Push the nut and support sleeve onto the tube.
6. Push the tube through the flaring die hole to the stop plate. To prevent misalignment, longer tubes are to be supported during the flaring process.
7. Press the start button and hold until the flaring procedure is completed.
8. Lift the tube with the flaring die upwards out of the fixture.
9. To release the tube, place the flaring die set in the opening provided in the fixture and tilt the tube to one side.
10. Check surface and dimensions of flaring.

**Important!**  
 Do not drive the flaring pin into the flaring die without a tube in position. The roughened surface of the flaring die must be absolutely free of oil and grease to prevent the tube from slipping.  
**Caution: do not reach into the working area of the flaring fixture while it is operating!**

**Important!**  
 Only proceed with preassembly when a tube with nut and cutting ring has been placed in the fixture (failure to observe this can result in damage to the tools). Longer tubes are to be suitably supported during preassembly. The assembly cones are to be regularly checked for correct dimensions using the cone gauge and should be replaced when necessary.  
**Caution: do not reach into the working area of the preassembly fixture while it is operating!**

Set Pressures

	<b>EOMAT UNI</b>		
			
Ø (mm)	P (bar)	P (bar)	P (bar)
6	30	25	20
8	35	30	25
10	45	35	35
12	50	40	35
14	60	50	45
15	60	50	60
16	70	55	60
18	70	55	70
20	100	80	95
22	80	75	95
25	130	100	105
28	100	90	125
30	180	125	135
35	150	110	155
38	200	170	165
42	180	140	185
			
Installation	min. 60° - max. 90°	~30°	min. 60° - max. 90°

The given values are a guide. The results of pre-assembly and/or tube flaring are therefore always to be checked. For detailed instructions on tube preparation, tool selection, assembly check and final installation see chapter E.