

**This manual contains very important safety information  
and must be read!**

# Krimp – *Fast* Plastic Coil Crimper

## **KF-50 / KF-50KB / KF-50e41 Operator's Training Manual**

**Issue "1" 12/06**

The KF-50 Krimp-Fast Coil Crimper will greatly increase productivity by making any operator experienced at crimping coil. An in-depth look at the set up procedures necessary to achieve maximum results follows.

See Figure A: The KF-50 Krimp-Fast Coil Crimper can attach to the right side of the HD-4170 Heavy Duty Coil Inserter Module (1) and the PC-248 Punch and Electric Coiling System (2). The KF-50e41 can attach to the right side of the HD-e4100 (3). The KF-50KB is the Stand-Alone Version that comes pre-mounted to the optional KB-50 Krimping Box (4). This manual discusses all of the necessary steps to use and care for your machine.

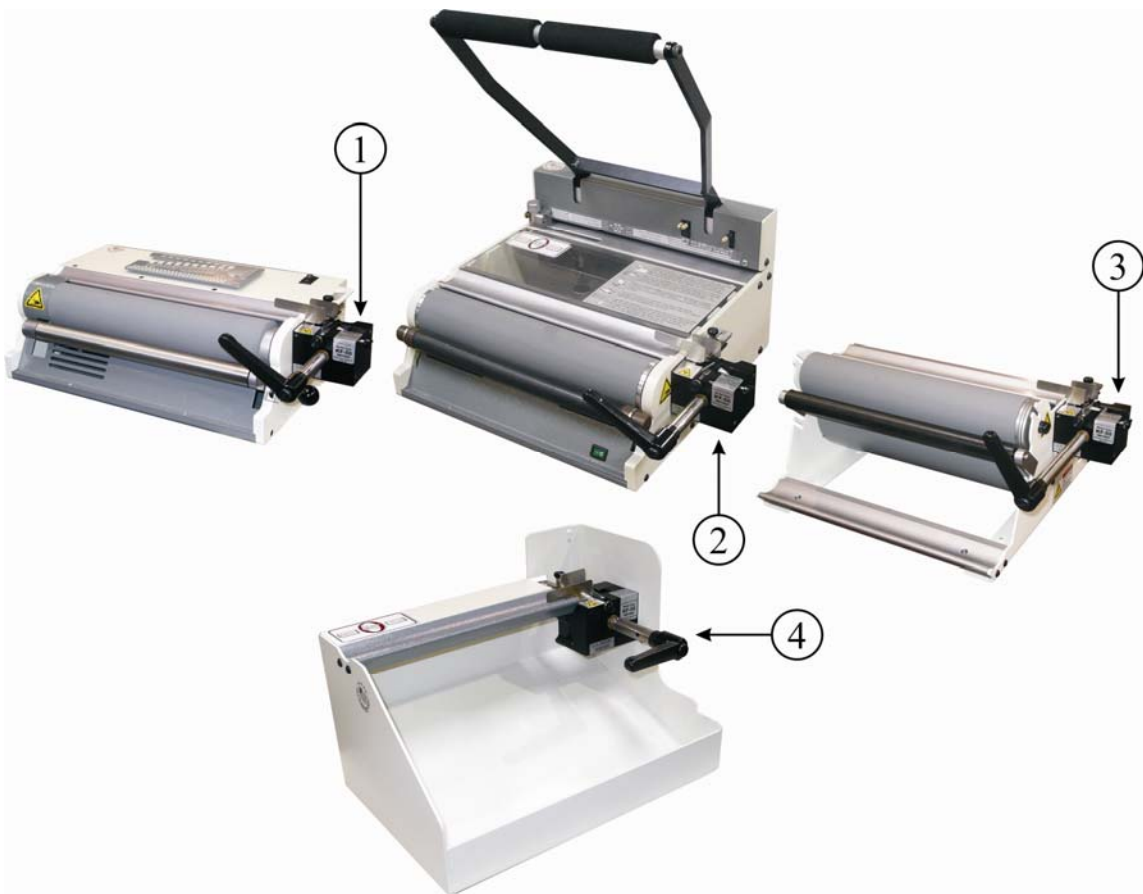


Fig A

There are helpful accessories and other modules to benefit your binding station. These are just a few of our many accessories and modules. Please visit us at [www.RHIN-O-TUFF.com](http://www.RHIN-O-TUFF.com) to see the complete line of punching and binding equipment.

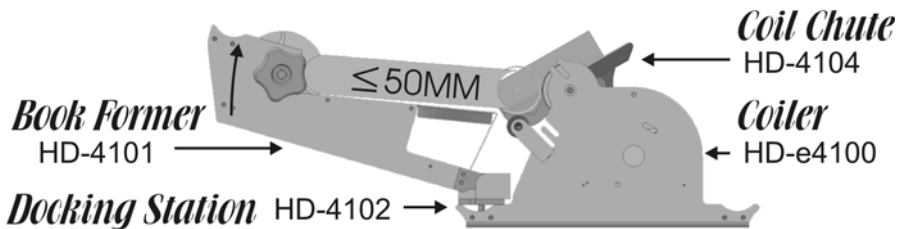
**HD-4170 Coil Inserter**

The HD-4170 "Rhin-O-Roll" Coil Inserter Module has 12" dual powered adjustable rollers for easier more accurate coil insertion. It has gauges for book thickness and coil sizing. The HD 4170 can be used as a stand-alone production coil inserter or it can be attached on any OD or HD Series punch (except the HD-7500 and horizontals). All pitches and diameters can be inserted using it. The HD 4170 comes with a crimper pliers holder and pliers.



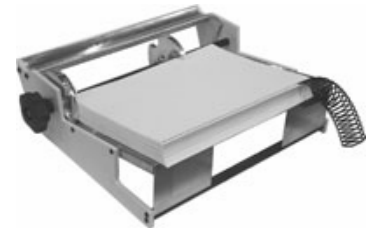
**HD-e4100 Economical Coil Inserter**

The HD-e4100 uses the unique Rhin-O-Roll gripping roller along with an adjustable lower roller for faster and more accurate coil insertion. Shown in the stand-alone configuration, it also can be mounted as a module to any vertical punch.



**HD-4101 EZ Coil Book Former**

The HD 4101 forms the spine of your book for EZ-Coil Insertion of 6MM to 50MM Coil. Up to 14" (356mm) binding edge capacity for any size. Attachable to HD-e4100 Coil Inserter: The HD-4102 Docking Station Links the HD-e4100 Coil Inserter with the HD-4101 Book Former, Providing Controlled EZ-Coil Insertion with larger coil sizes up to 50MM. The HD-4104 Coil Chute Keeps the coil tangle free.



**PC-248 Punch & Electric Coil Insertion System**

The first fully featured Manual Punch and Electric Coil Inserter with Heavy Duty Features at an affordable price. Offers significant productivity gains through operator driven common sense solutions.

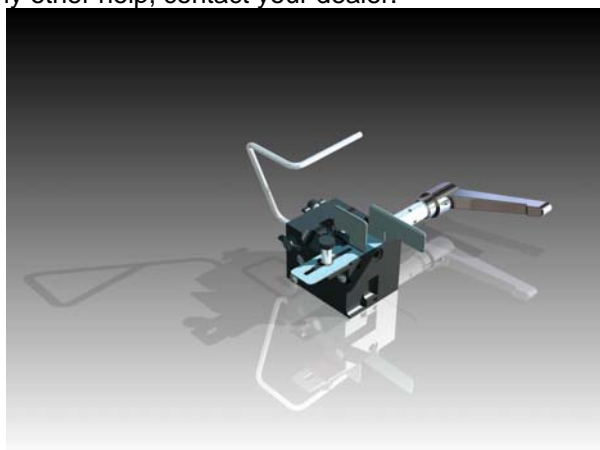


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Read the entire operators manual before setting the machines adjustments for your first book. The *hint* paragraphs are helpful tips if you should run into problems with a certain portion of setup or binding a book

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**Warranty Registration Card Information:** Please fill this out immediately and mail in. **Product registration is important to establish trouble free warranty repair** of any of your Rhin-O-Tuff equipment. Please fill out and mail in the card provided with your machine or register on-line at [www.RHIN-O-TUFF.com](http://www.RHIN-O-TUFF.com) ; then select Support, then Warranty Registration. For a repair, service, supplies, or any other help, contact your dealer.



## Important Safety Notice!



Make sure you read this section very carefully! Learn to recognize this **Safety Alert Symbol**. The KF-50 has been designed to provide a very high level of protection to an operator. Follow the guidelines below while installing, operating and maintaining your machine.



- Keep fingers out of Anvil Clamp and Cut area.



- Watch for the safety Symbol within this manual. Correct machine setup is important for user safety and machine longevity.

### Special Note:

This manual covers the Setup and Operation of the KF-50 and KF-50KB. For operation of the HD-4170, HD-e4100, and PC-248 please see the manual for that machine.

## 1) "Out of the Box" Initial Setup:

### ➤ 1.1) KF-50KB: See Fig. B

The KF-50KB came partially assembled to protect items from damage during shipment. The Front and Rear Coil Guides (2)(3) have been installed up-side-down. Loosen and remove the Coil Guide Clamp Screw (5) and remove the Guides. Locate item (1), the Book End Stop (This is a 3/16" Diameter wire bent in 3 places) supplied in the shipping kit. Continue to the next paragraph.

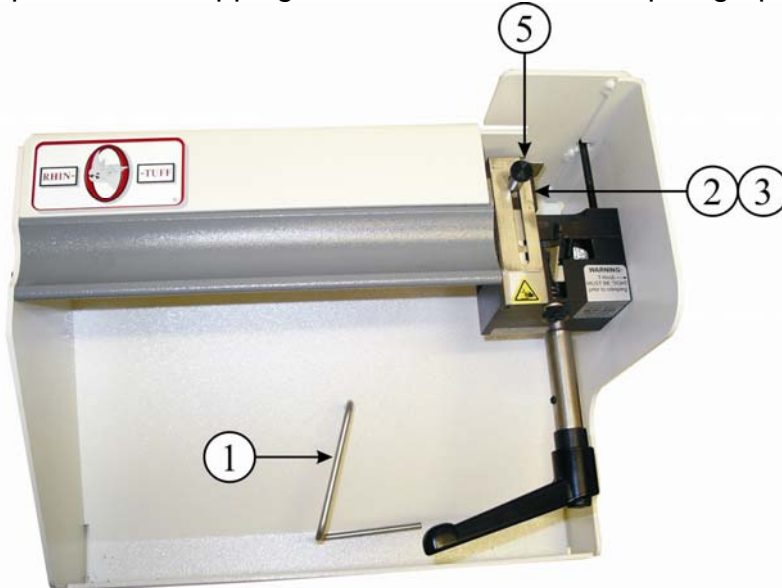


Fig. B

See Fig. C. Place the short leg of the Book End Stop (1) into the hole located on the right side of the crimper box (8). Loosen the rear 2-winged Finger Screw (9) to allow the Book End Stop to pass, and then tighten the Finger Screw onto the Book End Stop. Orient as shown. Fine adjustment will be made later in this manual. Flip over and replace the longer Front Coil Guide (2) first (as shown) then flip over the Rear Coil Guide (3) and place on top of the Front Coil Guide (2) (as shown), Replace the Coil Guide Clamp Screw (5) to secure the guides in place. Fine adjustment will be made later in this manual. Continue to Chapter 3.

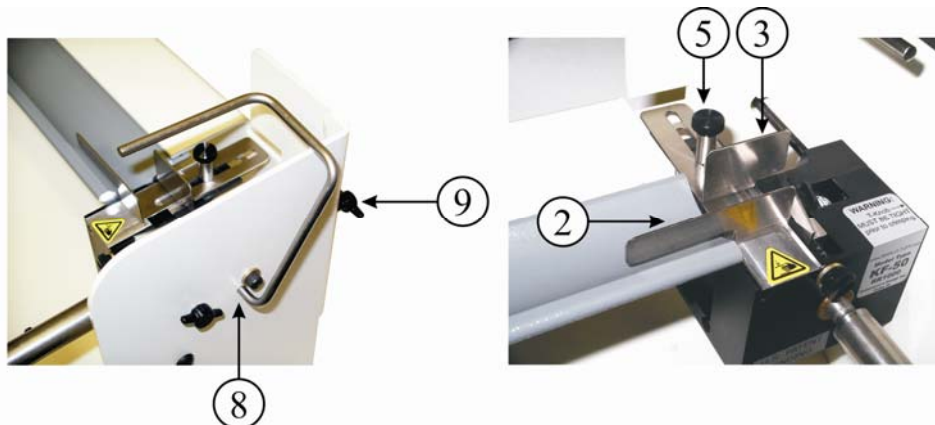


Fig. C

## Chapter 1 “Out of the Box” initial Setup Continued...

➤ **1.2) KF-50 and KF-50e41:** See Figure D.

The KF-50 and KF-50e41 came partially assembled to protect items from damage during shipment. Locate the following items supplied in the shipping kit.

- (1) Book End Stop
- (2) Front Coil Guide
- (3) Rear Coil Guide
- (4) Coil Guide Support
- (5) Coil Guide Clamp Screw
- (6) Supplied Allen Wrench that fits screw (7).

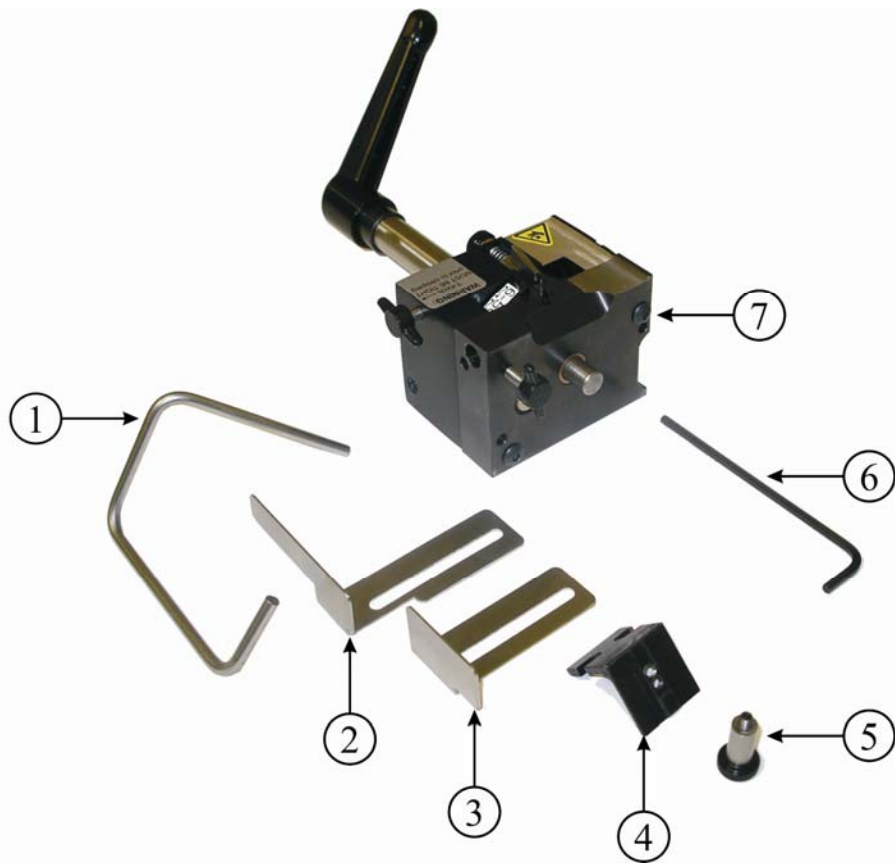


Fig. D

## Chapter 1 “Out of the Box” initial Setup Continued...

See Figure E. Place the short leg of the Book End Stop (1) (arrow points to long leg) into the ‘same size hole as the stop’ shown at (8) on the crimper. Loosen the 2-winged Finger Screw (9) to allow the Book End Stop to pass, and then tighten the Finger Screw onto the Book End Stop. Orient as shown. Fine adjustment will be made later in this manual. Loosen screw (7) several turns or 1/8” as shown. Hold and align the Front Coil Guide (2) to the Coil Guide Support (4) as shown. Hold and align the Rear Coil Guide (3) to the top of the Front Coil Guide (2) as shown. Fasten these three items together with the Coil Guide Clamp Screw (5) creating the Coil Guide Assembly. (This step may have already assembled by the factory)

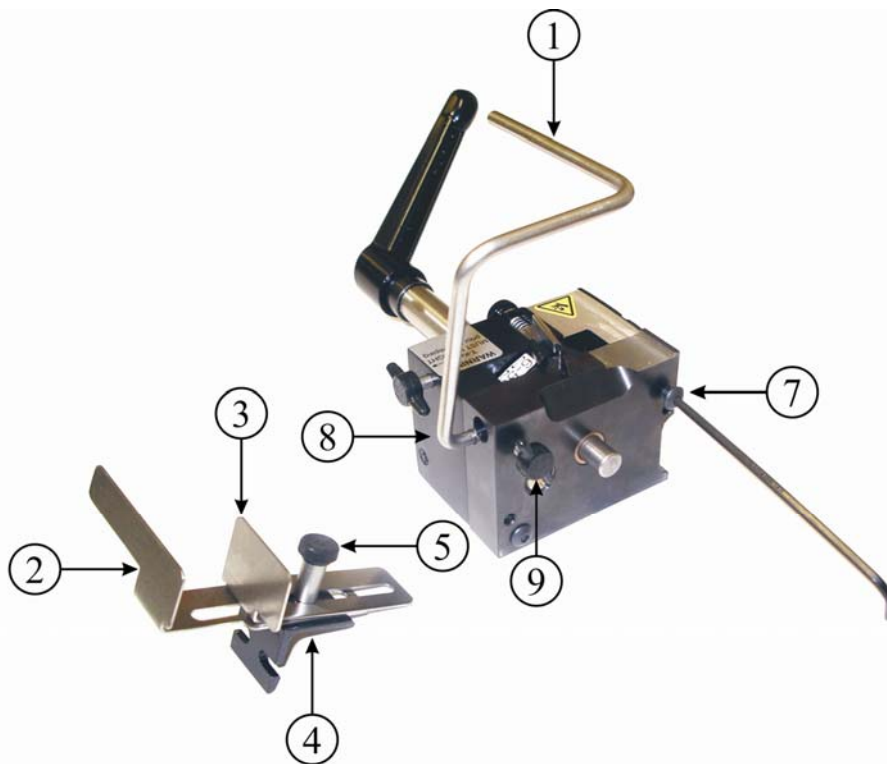


Fig. E

## Chapter 1 “Out of the Box” initial Setup Continued...

See Figure F. Place the Coil Guide Assembly’s Coil Guide Support onto the loosened screw as shown. Center the Coil Guide Assembly Coil Guides into the slot in the main body of the KF-50 Crimper and tighten screw. The KF-50 will look like the various views below.

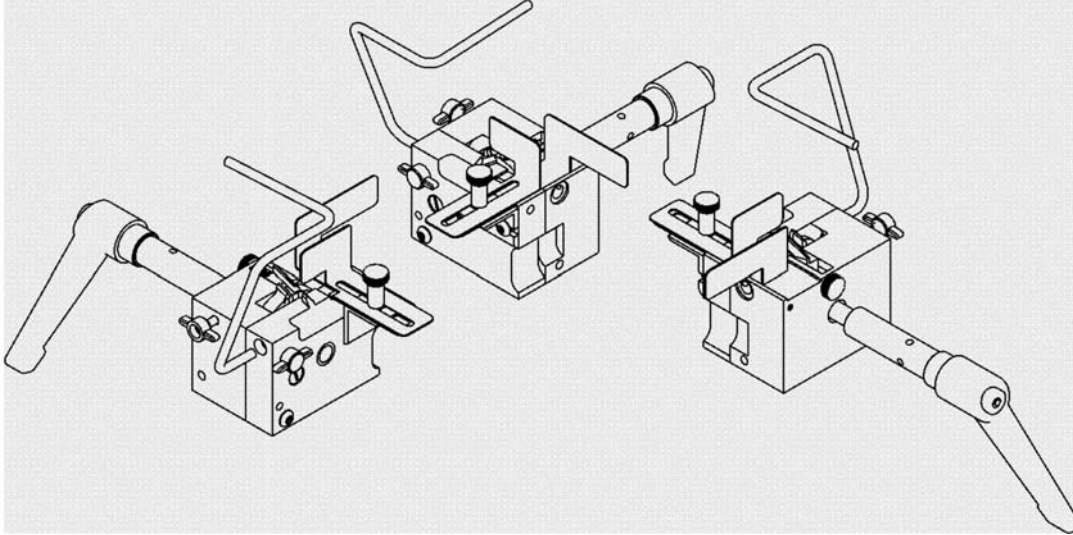


Fig. F

### 2) Installation:

#### ➤ 2.1) KF-50KB:

The KF-50KB is pre-installed, Please go to Chapter 3.

#### ➤ 2.2) KF-50 Mounted to a HD-4170 or PC-248: See Fig. G

The KF-50 Mounting procedure is identical for both HD-4170 and PC-248. The KB-50 is mounted to the front-right of both machines and mounting screw placement is the same.



Fig. G

**Chapter 2 installation Continued... See Fig. H**

**2.2.1)** Locate the Supplied Allen Wrench (1) that fits the screws shown (2). Remove and store these two screws. Locate the #10 X 3/4" Black Screw and #8 Silver Washer (3). Using the Allen Wrench, install both the screw and washer into the forward hole (4).



Fig. H

**2.2.2)** See Fig. J. Locate the #10 X 3-3/4" long screw and lock washer (1) supplied in the shipping kit. Feed it completely through the large hole on the right side of the KF-50 as it's oriented and shown in Fig. J (2). Set the KF-50 along side the coiler so that the 3-3/4" screw, now protruding out of the left side of the KF-50, inserts into the available hole left over from the previous step in Fig. H. Keep the KF-50 level to the top of the coiler. You will notice that the KF-50 will position itself over the single 'screw head' in the coiler from previous step in Fig. H balloon 4. Tighten the 3-3/4" screw (4) with the Allen Wrench provided. Note the arrow position for balloon 5. From the shipping kit locate the small Allen Wrench. At the position of arrow 5 there is a small hole in the front side of the KF-50. Pre-installed in this hole is a set-screw that when tightened, further secures the KF-50 to the coiler. Tightening this set-screw drives the set-screw into the head of the single screw installed in Fig H.

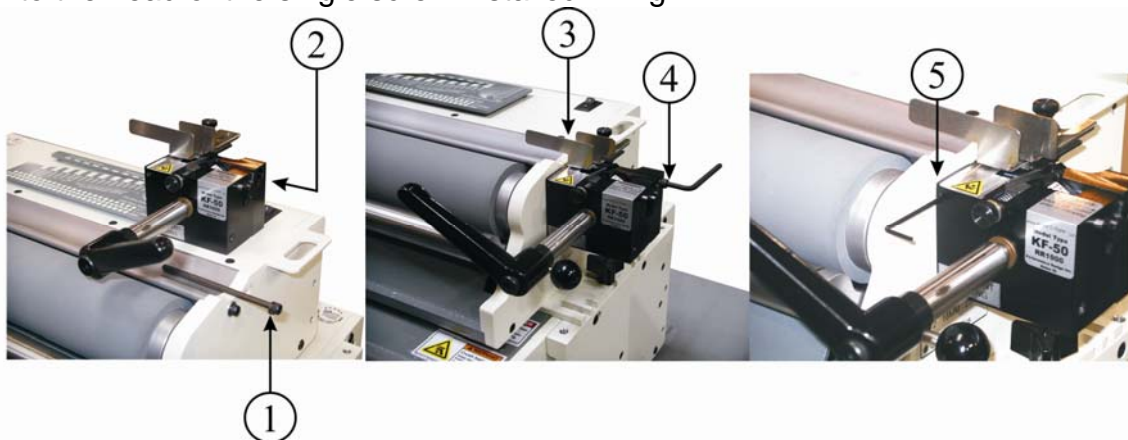


Fig. J

➤ **2.3) KF-50e41 Mounted to a HD-e4100:** See Fig. K.

Turn the HD-e4100 around so you see the rear of the machine as shown. With the supplied Allen Wrench remove 6 screws (1) holding the Separator Rod (2) and the Book Former (3). Remove the Separator Rod (2) and Book Former (3). Move and Separator Rod down (4) to where the Book Former was mounted (3), replace screws and tighten. Take the Book Former (3) and turn 180 degrees (5) from end-to-end and locate where the Separator Rod was located (2). See Fig. K balloon 6 for the correct final orientation of the Book Former. Center the Book Former over the two available holes (7) \*\*\*, replace only the right end screws and tighten. Continue past Fig. K to the next step for the left end screw.

\*\*\* Prior to Serial Number 1E01040 the second mount hole was not added. Call Technical Support at 1-800-390-5782 for the HD-e4100/KF-50 Hole Kit. You will need an electric drill and small clamp or small Vice-Grip® when you receive the Kit.

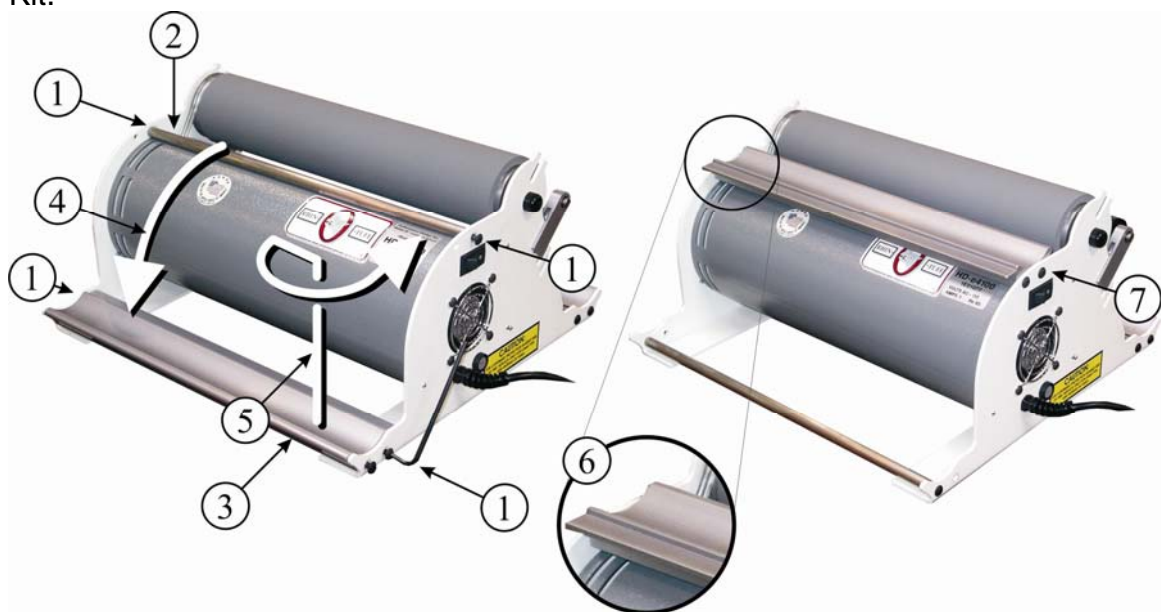


Fig. K

See Fig. L. See the left end of the machine (1). Locate the #10 X 3/4" Black Screw and #8 Silver Washer (2). Using the Allen Wrench, install both the screw and washer into the hole shown (2).

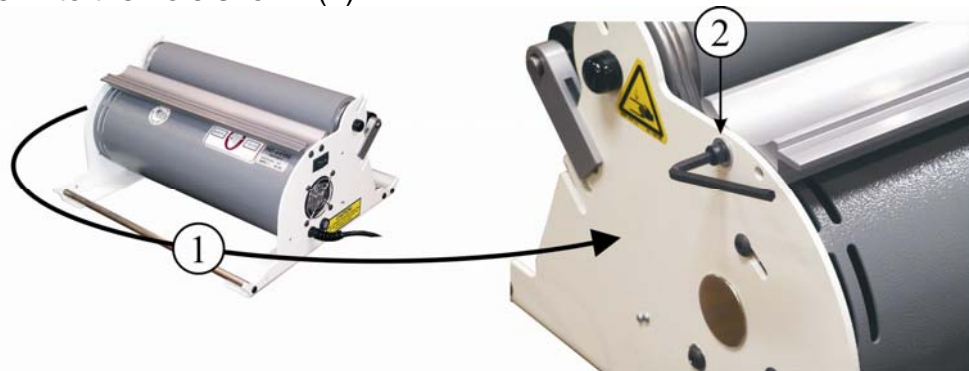


Fig. L

## Chapter 2 installation Continued...

**2.3.1)** See Fig. M. Locate the #10 X 3-3/4" long screw and lock washer (1) supplied in the shipping kit. Feed it completely through the large hole on the right side of the KF-50 as it's oriented and shown in Fig. M (2). Set the KF-50 along side the coiler so that the 3-3/4" screw, now protruding out of the left side of the KF-50, inserts into the available hole left over from the previous step in Fig. L. Keep the KF-50 level to the top of the coiler. You will notice that the KF-50 will position itself over the single 'screw head' in the coiler from previous step in Fig. L balloon 2. (3). Tighten the 3-3/4" screw (4) with the Allen Wrench provided. Note the arrow position for balloon 5. From the shipping kit locate the small Allen Wrench. At the position of arrow 5 there is a small hole in the front side of the KF-50. Pre-installed in this hole is a set-screw that when tightened, further secures the KF-50 to the coiler. Tightening this set-screw drives the set-screw into the head of the single screw installed in Fig. L.

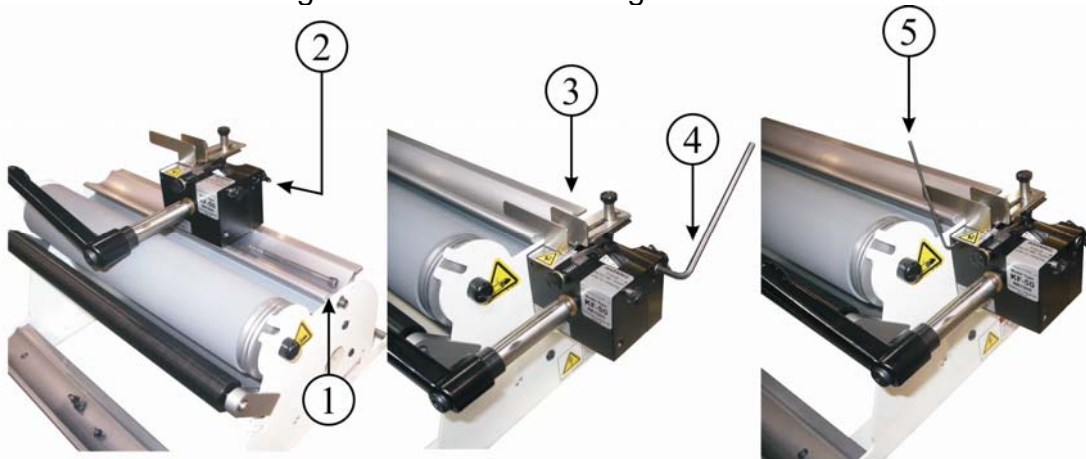


Fig. M

### 3) Operation:

#### ➤ 3.1) Key Items Over View:

In Fig. M are the names of the key items used in the Operation portion of this manual. Refer back to this figure as needed.

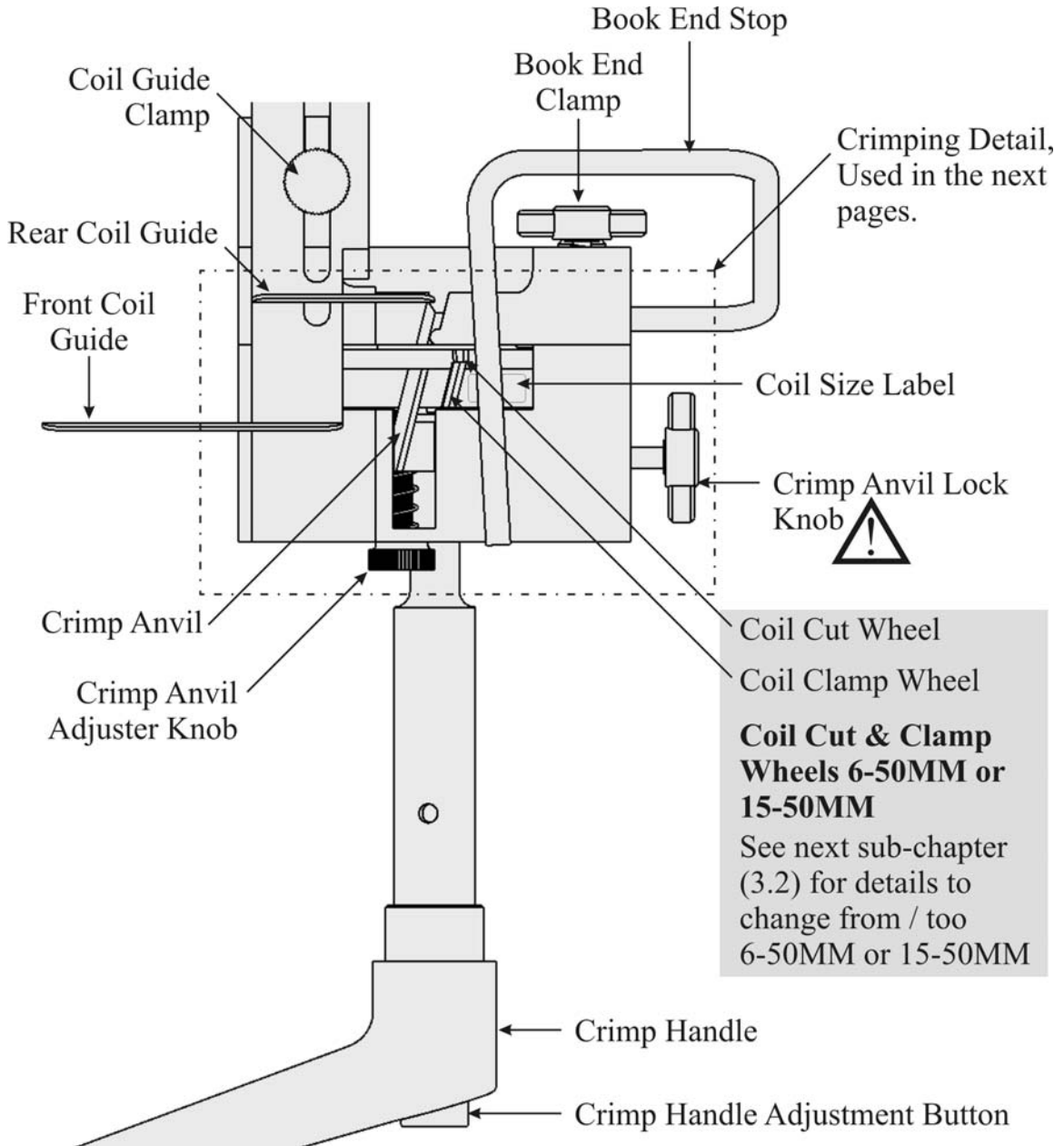


Fig. M



**Important Notice: ALWAYS keep the Crimp Anvil Lock TIGHTENED while crimping.** Failure to do so will cause premature wear to these mechanisms.

## Chapter 3 Operation Continued...

### ➤ 3.2) Set Crimper to Coil Size: See Fig. N.

**3.2.1)** The first step to setting your crimper is by determining how long of tail (1) you need. There are two settings for the KF-50, 6-50MM and 15-50MM indicated by the label (2), the difference is a short tail or long tail. The 6-50MM setting creates a short tail for all sizes of coil. The 15-50MM setting creates long tail, but for only 15-50MM coil.

**3.2.2)** See Fig. N. To switch between settings, loosen the Crimp Anvil Clamp Knob (3) about a ¼ turn. Turn the Crimp Anvil Adjuster Knob (4) clock-wise several times until the Crimp Anvil far tip (5) pulls back to clear the Coil Clamp Wheel (6) as shown. Rotate the Crimp Knob (7) either direction 180 degrees, this will carry the Coil Cut & Clamp Wheels (8) until they drop back into the detent position 180 degrees from the start of your turn.

Tip: To change sizes quickly, PULL the Anvil Clamp Adjuster Knob OUT FULLY (4) then quickly rotate the Crimp Handle to the next detent, release Anvil Clamp Adjuster Knob.

Go to the next step.

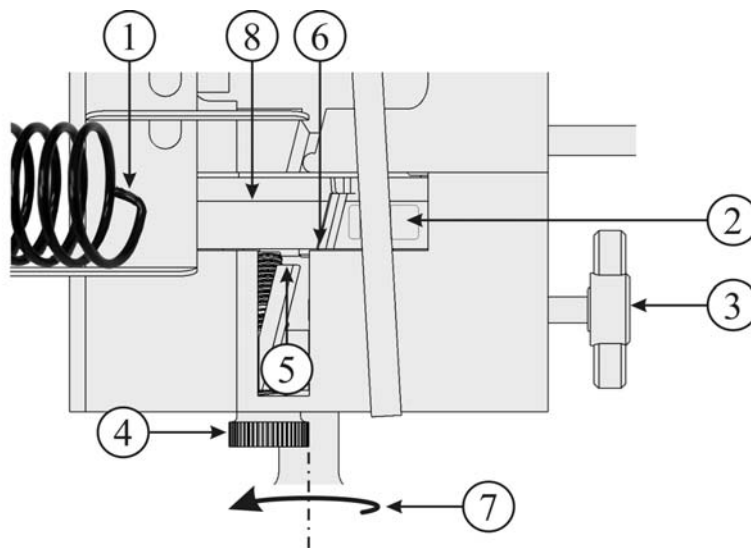


Fig. N

**3.2.3)** See Fig. P next page. First note the Center Line of coil cutting (1); This Center Line is at the bottom of the Coil Cut Wheel 'Cutter' (2) as shown. Turn the Crimp Anvil Adjuster Knob (3) counter-clockwise until the space (4) between the tip of the Crimp Anvil and the bottom of the Coil Cut Wheel 'Cutter' is slightly smaller than the diameter of the coil filament to be crimped. TIGHTEN THE CRIMP ANVIL LOCK KNOB TIGHTLY (5). Adjust the Front and Rear Coil Guides (6) so that your coil is centered above the Cutting Center Line (1).

## Chapter 3 Operation Continued...

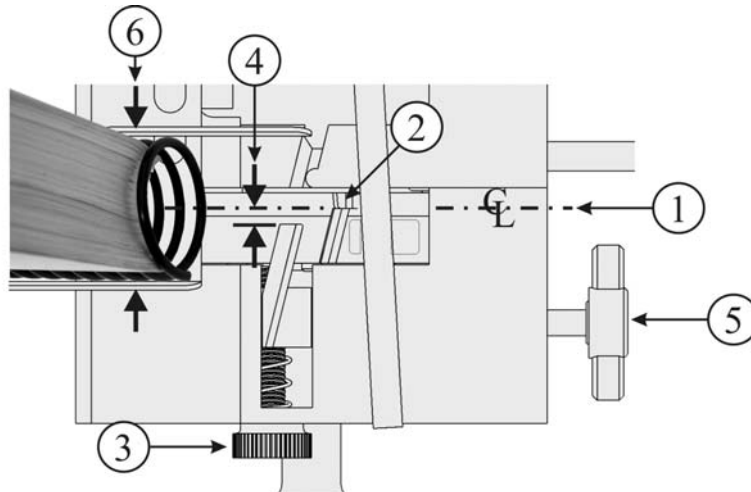


Fig. P

**3.2.4)** See Fig. R. Be sure to tighten the Coil Guide Clamp (1). Place your book into the crimper so that the first coil that exits the book rests between the Crimp Anvil and Coil Clamp Wheel (2) as shown. Loosen the Book End Clamp (3)  $\frac{1}{4}$  turn and adjust the Book End Stop against the book (4). Tighten Book End Clamp (3).

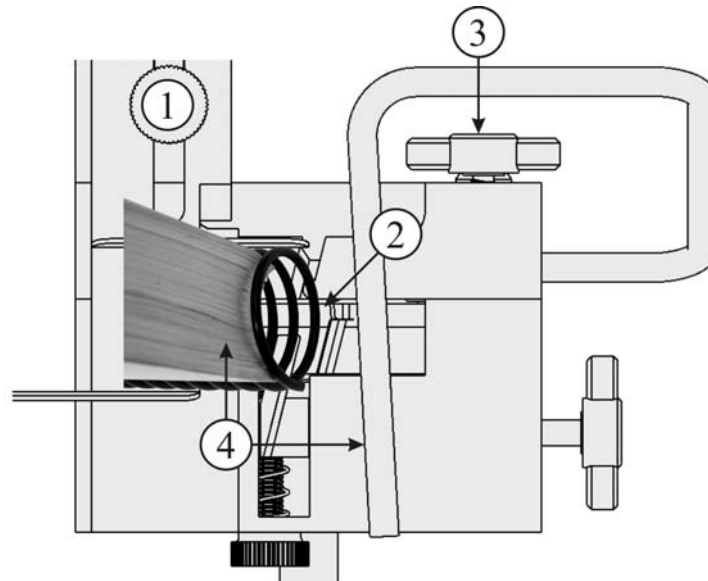


Fig. R

## Chapter 3 Operation Continued...

### ➤ 3.3) Crimp Knob final adjustment and Crimping.

**3.3.1)** See Fig. S. During this Adjustment Crimping Handle Shaft (1) should not turn. It will stay in its current detent position. Adjust the Crimping Handle, press your thumb against the Crimping Handle Adjustment Button (2) then pull and rotate the Crimping Handle (3) until it is orientated as shown. Release the Handle. Crimping requires rotating the Knob counter-clockwise. The orientation of the Handle may be changed to the operator's preference.

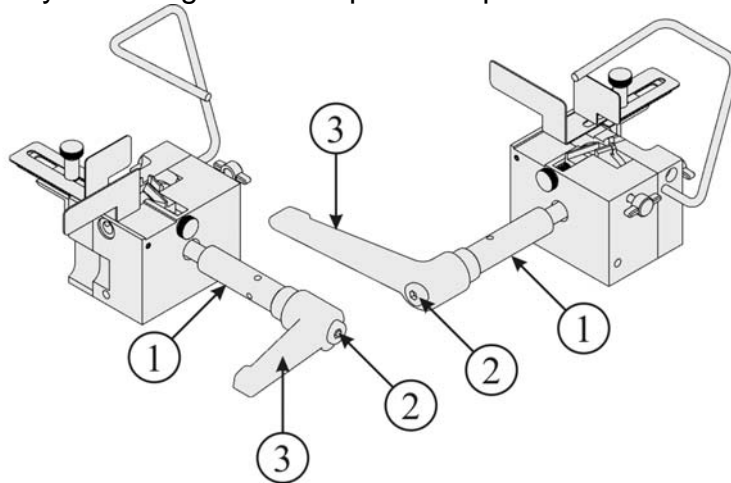


Fig. S

**3.3.2)** See Fig. T. Now that setup is complete production crimping may begin. Simply load your book and crimp by pressing down (counter-clockwise) on the Crimping Handle. Rotate your book around to crimp the opposite end. Refer back to Fig. P as minor adjustments to the setup may be necessary if the crimp isn't just right. A perfect crimp will squeeze and stretch the filament (coil) into a new filament memory for a permanent crimp (1). If the Crimping Anvil is adjusted too closely to the Coil Cut Wheel it will tear-up and noticeably damage the coil (2). If the Crimping Anvil is too far away from the Coil Cut Wheel, the crimp will un-do and become un-crimped within a day (3).



Fig. T

End