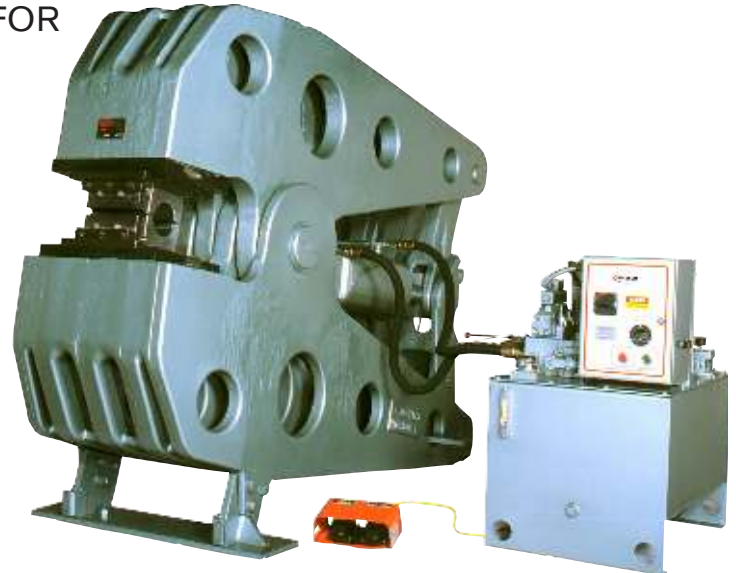


MARK 250 SWAGER

SUPERIOR POWER AND PERFORMANCE FOR SWAGING UP TO 2-1/2IN. WIRE ROPE

- ESCO's open jaw design allows fast, easy, work access for more efficient swaging. Operator can easily observe and completely control the swaging process.
- ESCO's unique mechanical design leverages relatively low 2000 PSI hydraulic force to deliver up to 1200 tons of swaging force. Lower system pressure allows longer component life, less maintenance and lower operating costs.
- The limit switch feature, standard on all ESCO swagers, automatically uses only the force needed to close the dies. Reduces the strain on the swager resulting in increased service life.
- Power units operate at less than 80 db – no hearing protection required.
- Double vane (8/27GPM) pump speeds cycle times to support efficient production.
- Power unit has convenient filter gauge to indicate when the filter needs attention. Top mounted filter cartridge is easy to access. Hour meter aids in scheduling maintenance checks. Sight glass indicates oil level and temperature. Power unit controls can be locked out for safety.
- The MK250 uses 4" x 7" dies. Dies change quickly and easily with ESCO's slide in – slide out die holder design.



- Operating information, parts and service are available for current and older model ESCO swagers.
- ESCO swagers are warranted for one year from purchase against defects in material and workmanship. Castings are warranted for two years against failure due to defects.

Optional Equipment

- Power unit can be wired for non-standard electric service.
- Adapter for 2-1/2" x 5" dies increases the swaging range for 2-1/2" x 5" dies down to 1/8".
- Lubrication grease.



Electrically operated foot controls provide precise control. Controls can be positioned for maximum operator comfort.



Sight glass indicates the hydraulic oil level and temperature.



To simplify maintenance, the power unit features a filter gauge to indicate when the filter should be changed.

Specifications:

MK250 Swager (Part No. 4062217)

Weight	19,500 lb / 8845 kg
Swager height	74" / 1880mm
Swager width	54" / 1372mm
Swager length	96" / 2438mm
Die work height from floor	44 1/4" / 1124mm
Cylinder diameter	10" / 254mm
Recommended floor area (Swager and Power Unit)	12' x 12' / 3.6m x 3.6m
Standard die block size	4" x 7" / 102mm x 178mm
Optional die size	2-1/2" x 5" / 64mm x 127mm

Note: A die adapter is required in order to use 2-1/2" x 5" dies, and system hydraulic pressure needs to be reduced to 1150PSI.

Hydraulic Power Unit

Weight (dry)	610 lb / 277 kg
Power unit length	36" / 915mm
Power unit width	24" / 610mm
Power unit height	48" / 1219mm
Motor	10HP / 7.5kW
Electrical service	230-460V, 3 phase, 60HZ
Rated current	26.8amps @ 230 / 13.4amps @ 460
Reservoir	50 US Gal / 189 liters
Output - double vane pump	27 / 8 GPM - 2100 PSI / 102 / 30 LPM - 145 BAR

Swaging Capabilities Sleeves

SS 1pc	1"
SS 2pc	2-1/2"
SS Sing.	2-1/4"
CS Sing.	2-1/2"

Ferrules

Midget, Dwarf, Bantam, Light, & Junior

Sockets

SS	2"
Forged	2"

Dies for ESCO Mark 250 Swager

Standard Die Size: 4" x 7"

Open Channel Dies for SS Fittings: 1-5/8" - 2-1/2"

Tapering Dies for Carbon Steel Sleeves: 1-3/4" - 2-1/2"*

*Carbon steel sleeves 1" and larger should be pressed in standard open channel dies before being pressed in tapering dies.

Forged Socket Dies: 1-1/4" - 2"

Optional Die Size: 2-1/2" x 5"

Note: A die adapter is required in order to use 2-1/2" x 5" dies, and system hydraulic pressure needs to be reduced to 1150 PSI.

Open Channel Dies for SS Fittings: 1/8" - 1-1/2"

Tapering Dies for Carbon Steel Sleeves: 1/4" - 1-1/2"

Ferrule dies: Midget, Dwarf, Bantam, Light & Junior

Forged Socket Dies: 1/4" - 1-1/8"

Note: Dies are not included with the swager.

Note: See ESCO Swage Instruction Manual for proper die selection and swage techniques.

ESCO 4 Step Swaging

1. Wire Rope

ESCO swage fittings are designed for use on 6 x 19 or 6 x 37 Classification, Right Regular Lay, EIP, IWRC, and F.C. (for some aluminum sleeves) wire ropes manufactured to U.S. specifications. If other wire ropes are used, sample assemblies should first be swaged and properly tested.

2. Fittings

Design the rigging for the job. Always select the correct rope size and the correct fitting type and size to meet the requirements of the specific application.

3. Dies

To ensure desired performance, the fittings must be swaged in the correct die. Check dies periodically for wear using ESCO "GO/NO-GO" gauges.

IMPORTANT: Clean dies and the die area before swaging. Grit and dirt will accelerate wear and can cause die breakage. Use EP No. 1 or No. 2 extreme-pressure grease to lubricate the dies and/or fittings before swaging.

4. Swaging

Follow the procedures in the ESCO Swaging Instructions Manual carefully. To ensure proper gripping strength of the swage fittings, the dies must close fully on the final pressing.

IMPORTANT: Do not allow sharp flashing to form. If excessive flash starts to form, do not close dies fully; work the fitting in subsequent pressings until the dies can be closed fully. Rotate the fittings 45 degrees (one-eighth of a turn) for the second pressing. Do not position the flash in the bottom of the die channel.

⚠ WARNING: When performing the work described in these instructions, use proper personal protection equipment to help avoid injury. Always wear hard hat, gloves, safety shoes, eye protection, hearing protection and fall protection that complies with regional, national and worksite requirements (e.g., OSHA, MSHA) when working with this equipment. To avoid injury to bystanders, keep them a safe distance from the work area

⚠ WARNING: Do not use any ESCO Swager in any manner other than that specified in the appropriate ESCO Swaging Operator's Manual and the ESCO Swaging Instructions Manual. Improper use may cause damage to the swager, swaging dies, or personal injury.

The main power switch of this swager may be locked in the OFF position to prevent unwanted starts.