

ENGINEERING  
TOMORROW

*Danfoss*

Operator's Manual

# ET6200 Nipple Inserter Machine



## Imprint

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**This Operating Manual of the machine is a translation; the original is in German.**

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## EC Declaration of Conformity

In accordance with EC Machinery Directive 2006/42/EC.

The following machine

ET6200

was developed, designed and manufactured in compliance with EC Directive 2006/42/EC, in the sole responsibility of

**UNIFLEX-Hydraulik GmbH**  
Robert-Bosch-Strasse 50 - 52  
D-61184 Karben

The following standards, codes and specifications have been applied:

- EC Directive 2006/42/EC
- EN ISO 12100: 2010

This declaration are invalid when the machine is modified or if unauthorized and unapproved third-party components are used without our prior approval.

Entity authorised for documentation: Uniflex-Hydraulik GmbH, Technical Documentation Dept.

Karben, 13.10.2022



Managing Director Harald von Waitz

# Contents

<b>1</b>	<b>About this document</b> .....	<b>6</b>
1.1	Target groups .....	6
1.2	Storage .....	8
1.3	Name plate .....	8
<b>2</b>	<b>Safety instructions</b> .....	<b>9</b>
2.1	Presentation of warnings .....	9
2.2	Intended use .....	9
2.3	Product-specific risks .....	10
2.3.1	Risks posed by mechanical equipment .....	10
2.3.2	Risk imposed by pneumatic system .....	11
2.4	Safety .....	12
2.4.1	Working area .....	12
2.4.2	Warning signs on the machine .....	13
<b>3</b>	<b>Machine description</b> .....	<b>14</b>
3.1	Design and function .....	14
3.2	Technical data .....	16
<b>4</b>	<b>Transport and commissioning</b> .....	<b>18</b>
4.1	Transport .....	18
4.2	Intermediate storage of machine/unit .....	19
4.3	Commissioning .....	19
4.3.1	Connection of compressed air .....	20
<b>5</b>	<b>Operation</b> .....	<b>21</b>
5.1	What you have to observe .....	21
5.2	Inserting/extracting nipples .....	22
5.2.1	Prerequisites .....	22
5.2.2	Positioning the inserter cylinder .....	22
5.2.3	Inserting nipples .....	23
5.2.4	Extracting nipples .....	25
5.3	Cleaning .....	27
<b>6</b>	<b>Maintenance</b> .....	<b>28</b>
6.1	What you have to observe .....	28
6.2	Maintenance schedule .....	28

## Contents

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<b>7</b>	<b>Troubleshooting</b> .....	<b>30</b>
<b>8</b>	<b>Decommissioning, disposal</b> .....	<b>31</b>
8.1	Dismantling .....	31
8.2	Recycling .....	31
8.3	Consumables and waste .....	31
<b>9</b>	<b>Annex</b> .....	<b>32</b>
9.1	Accessories (retrofitable) .....	32
9.2	Spare parts list .....	33
9.3	Pneumatic diagram .....	35
9.4	Maintenance log .....	36
9.5	Declaration of qualified staff .....	37

## 1 About this document

### 1.1 Target groups

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## 1 About this document

In this Operation Manual, the “nipple inserterET6200” is consistently referred to as machine.

This Operation Manual includes important notes on how you operate your machine/unit safely, properly and economically.

Use not in compliance with the intended purpose may result in hazard to the operator's health and life and/or in the risk of damage to/the machine/unit. Consequently, please only use the machine/unit

- in good order and condition,
- in accordance with its intended purpose,
- in a safety-conscious manner, with awareness of risks and hazards,
- in compliance with all notes included in this Operation Manual.

The machine/unit may only be operated by staff who

- has read the Operation Manual,
- has understood it,
- has been instructed in the operation of the machine/unit, and
- has signed in the Annex.



Figures may include accessories/options. Customer-specific equipment may vary.

The product images shown are for reference only and may differ from the product delivered.

### 1.1 Target groups

The target groups of this Operation Manual are:

#### **Owner**

An owner is a natural person or entity using the device himself/herself/itself, or on whose behalf the device is used. An owner may appoint a representative to exercise the owner's rights and obligations.

The owner has to make sure that

# 1 About this document

## 1.1 Target groups

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- national provisions, occupational safety regulations and applicable environmental protection regulations are fully complied with;
- persons working on the machine/unit are adequately qualified;
- persons working on the machine/unit are suitable for operating the machine/unit;
- the Operation Manual has been read and understood. One hardcopy of the Operation Manual must always be kept at a designated place where the machine/unit is used.
- persons working on the machine/unit are aware of potential risks;
- the operating staff is familiar with the location as well as with operating the fire alarm and fighting means. Free access to this equipment must be ensured.
- personal protection equipment is worn (safety footwear, protection gloves and safety glasses).

### **Machine/unit fitters**

Machine/unit fitters must be at least 18 years old and have completed training for the task, i.e. they must have attended a specialist vocational training.

#### A fitter

- must observe the instructions in the Operation Manual;
- must inform the owner on failures and damage.

### **Operator**

An operator is a person charged with and instructed in the proper operation of the machine/unit by the owner or the otherwise contractually obliged person.

#### The operator

- must observe the instructions in the Operation Manual;
- must inform the owner on failures and damage.
- must not perform and maintenance or repair work on the machine/unit.

## 1 About this document

### 1.2 Storage

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### 1.2 Storage

The Operation Manual is part of the machine/unit and must be kept near the machine/unit at all times. Upon disposal of the machine/unit, the Operation Manual must also be handed over.

### 1.3 Name plate

The name plate is fixed on the machine back.



## 2 Safety instructions

### 2.1 Presentation of warnings

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## 2 Safety instructions

### 2.1 Presentation of warnings

Warning notes in the Operation Manual warn against risks involved with the handling of the machine/unit. Risk levels are identified as follows:

**HAZARD!**

The signal word HAZARD identifies an imminent hazard resulting in serious injuries or death. This warning is supplemented by a triangular hazard symbol.

**WARNING!**

The signal word WARNING identifies a potentially hazardous situation, which might result in serious injuries or death. This warning is supplemented by a triangular hazard symbol.

**CAUTION!**

The signal word CAUTION identifies a potentially hazardous situation, which might result in light injuries. This warning is supplemented by a triangular hazard symbol.

**ATTENTION!**

The signal word ATTENTION identifies a potentially hazardous situation, in which the product or property in the environment may be damaged. This warning is supplemented by a hazard symbol or an exclamation mark.

### 2.2 Intended use

This machine is intended for industrial use; it is only suitable for inserting nipples in hoses up to a specific permissible diameter (see "Technical Data", Section 3). Nipples which have not been crimped can also be extracted from the hose by the machine.

Intended purposes include:

- Single user workplace for one person only
- Manual input and retrieval
- Operating temperatures between 10 °C and 35 °C
- Operation in a closed operation room
- The machine must not be operated by persons not capable of operating the machine without any risk. These may include:
  - persons with physical or mental disabilities;
  - children and persons under age;

## 2 Safety instructions

### 2.3 Product-specific risks

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- persons with a restricted capability for the operation of machines (e.g. under the influence of drugs, alcohol or narcotics)

Use of the control in compliance with the intended purpose also includes compliance with the instructions in this Operation Manual.

#### **Use for other than the intended purpose**

Any other use is considered as being not in compliance with the intended purpose, in particular:

- Design modifications of the machine
- Nipples and hoses must match each other
- Use in explosive environments
- misuse of consumables and waste materials.

<b>WARNING!</b>	
	<p><b>Risk for life and health!</b></p> <p>Use not in compliance with the intended purpose imposes risks for life and health. Consequences resulting from use for other than the intended purpose shall be under the sole responsibility of the owner.</p> <ul style="list-style-type: none"><li>• Always use the machine in compliance with its intended purpose.</li></ul>

## 2.3 Product-specific risks

The machine/unit is designed in accordance with the latest state of technology. Nevertheless, the machine/unit may impose risks:

### 2.3.1 Risks posed by mechanical equipment

#### **Risk of shearing**

There is risk of shearing between the protective cover and the chassis when closing the protective cover.

- Close the protective cover by the handle.
- When closing the protective cover, make sure that your extremities are not between the hose feed and the knife protection.

## 2 Safety instructions

### 2.3 Product-specific risks

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#### **Risk of squeezing**

There is risk of getting squeezed between the protection cover and the chassis when closing the protection cover.

- Close the protective cover by the handle.
- When closing the protective cover, make sure that your extremities are not between the hose feed and the knife protection.

There is risk of getting squeezed between the work piece and the clamping dies when closing the clamping device.

- Keep sufficient distance to the clamping device.

#### **Tilting hazard**

The risk of tilting mainly exists while the machine is being transported.

- Observe the machine's centre of gravity during transport.

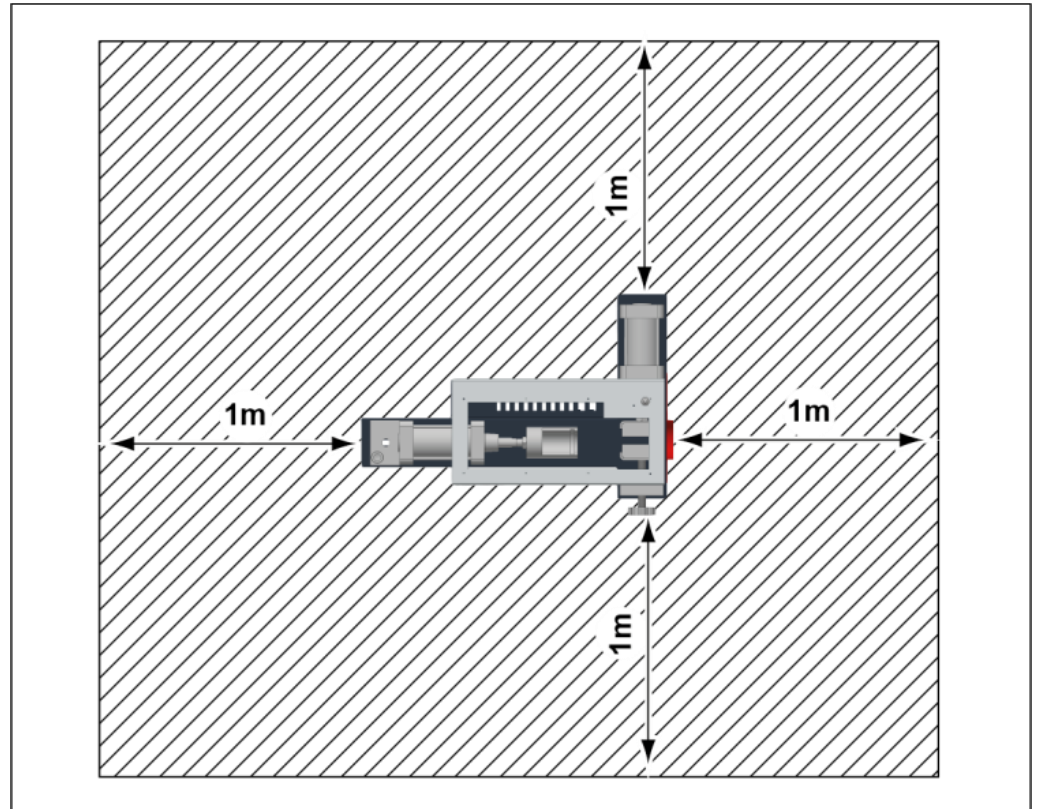
#### **2.3.2 Risk imposed by pneumatic system**

Risks are imposed by all pneumatic lines and connections. Pneumatic systems are subject to special safety provisions.

- After the machine is deactivated, the given and potentially hazardous residual energy has to be considered.
- Use correct hoses and hose clamps.
- Only work in the permissible pressure range.

## 2.4 Safety

### 2.4.1 Working area



The working area is defined as the area 1 metre all around the machine (shaded).

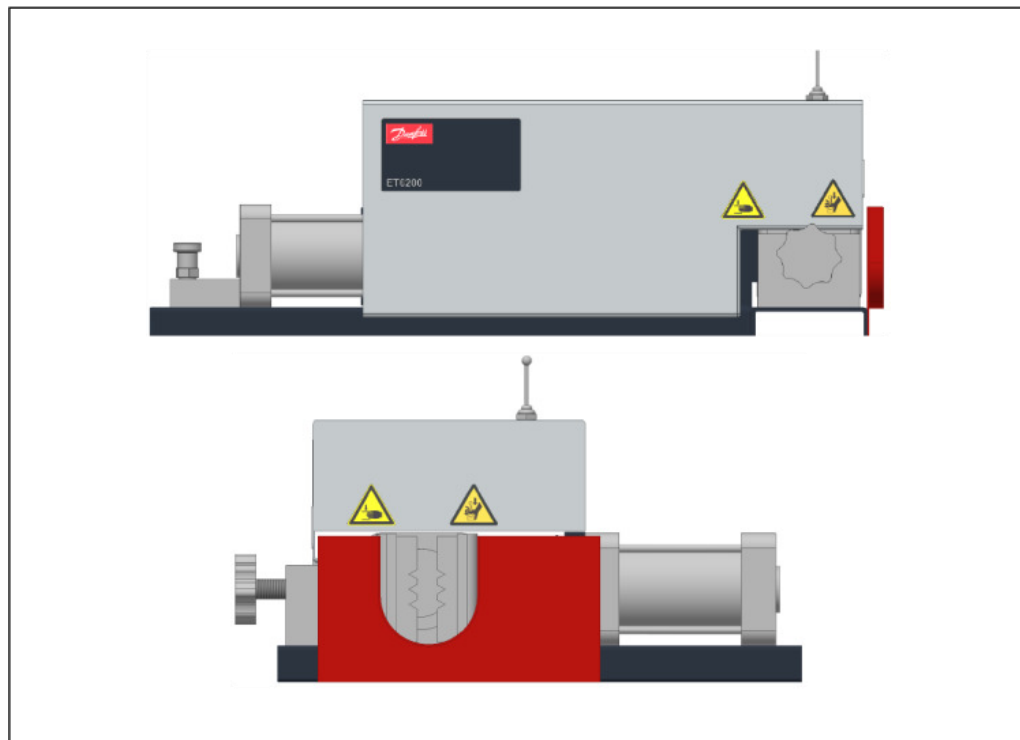
- Keep the working area free from trip hazards.
- Use ducts for lines and cables.
- Provide good illumination.

## 2 Safety instructions

### 2.4 Safety

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#### 2.4.2 Warning signs on the machine



**Squeezing risk**  
on the protective cover and the clamping device.

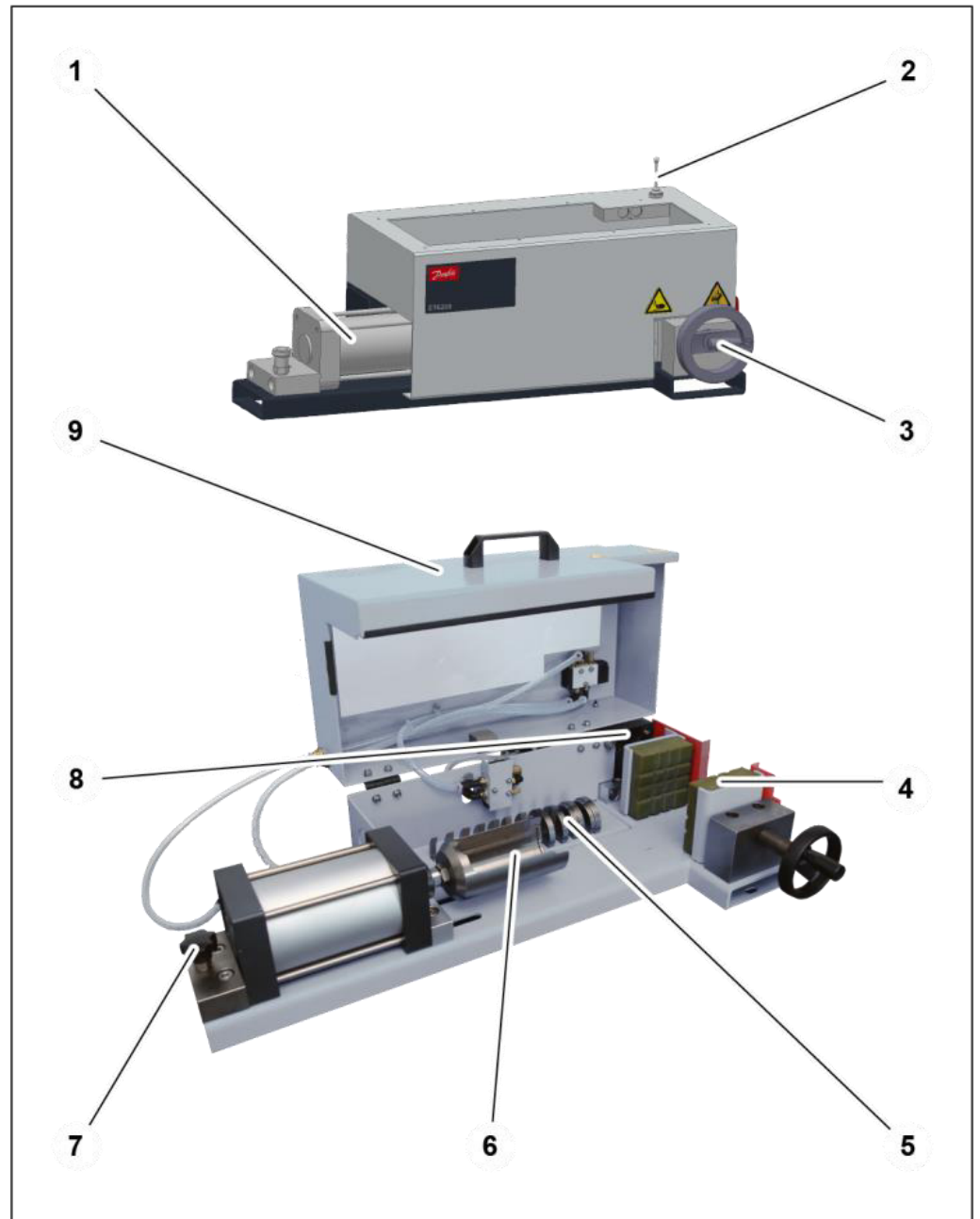


**Hand injury**  
on the cover

Illegible or missing warning signs must immediately be replaced by the operator.

## 3 Machine description

### 3.1 Design and function



- (1) Inserter cylinder
- (2) Hand lever
- (3) Hand wheel
- (4) Clamping dies

## 3 Machine description

### 3.1 Design and function

---

- (5) Holding rings
- (6) Seat
- (7) Catch bolt
- (8) Clamping cylinder
- (9) Protection cover

The machine is ready for operation as soon as it is connected to the compressed air system.

In order to insert nipples into hoses or extract nipples from hoses, the work piece is mounted in the seat (6) using a holding ring (5). In addition, the work piece is centred by the clamping dies (4). The clamping dies (4) are adjusted using the hand wheel (3). The position of the inserter cylinder (1) can be adapted to the work piece. Once the position of the inserter cylinder (1) has been set, the position is secured by means of the catch bolt (7).

The protective cover (9) is closed manually before beginning with the insertion or extraction process. When the protective cover (9) is closed, the clamping cylinder (8) extends automatically and clamps the work piece. The insertion/extraction is controlled by means of the hand lever (2). For this purpose, the hand lever (2) has the positions BACK, STOP and PUSH. The protective cover (9) is opened manually after the insertion or extraction process. When the protective cover (9) is opened, the clamping cylinder (8) retracts automatically and releases the work piece so that it can be removed.

#### **Accessories**

The machine can be fitted with accessories. A list of the available accessories is included in the Annex, Section "Accessories".

## 3 Machine description

### 3.2 Technical data

---

#### 3.2 Technical data

##### Machine

Dimensions L x W x H	625 x 795 x 325 mm
Weight	approx. 35 kg
Noise level	< 70 dB(A)*

##### Function

Insertion force	5.1 kN (6 bar)
Hose feed	Manual

##### Work piece capacity

Working area	2"
Max. outside	Ø up to 54 mm

##### Pneumatic connection

Power rating	7 bar
Connection hose	Ø 8 mm
Air consumption	Approx. 40l/min

##### Workbench

Solid, plane workbench with a carrying capacity of approx. 500 kg

##### We recommend industrial flooring which meets the following structural requirements

Permanent floor loading	Approx. 0.07 kg/mm <sup>2</sup>
Floor carrying capacity	Min. 2,500 kg/m <sup>2</sup>
Floor quality	B25
Evenness	Max. unevenness 5 mm/m



## 3 Machine description

### 3.2 Technical data

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Inclination	max. 5 mm/m
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#### **Ambient conditions**

Ambient temperature	10 °C – 40 °C
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Air humidity	45 % – 65 %
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The \* data are theoretical/computed values, or values measured on a prototype. Actual values may vary slightly, depending on the machine.

## 4 Transport and commissioning

### 4.1 Transport

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## 4 Transport and commissioning

### 4.1 Transport

The goods should be transported in the original packaging. During transport, the goods must be secured safely within the packaging. All applicable laws and regulations relating to securing loads shall be observed during transport.

The machine can only be transported manually. For machine weight, please refer to "Technical data" in Section 3.

#### WARNING!



#### Danger from falling loads!

Risk of injury from falling loads.

- Do not stand under suspended loads.

#### WARNING!



#### Danger from moving parts

Risk of injury from moving protective cover.

- Do not lift the machine by the protective cover.

#### WARNING!



#### Danger from increased load weights!

The weight of the machine is approx. 30 kg.

- Transport the machine with two persons.
- Use transport aids.

1. Lift the machine manually and transfer it to the installation site.

## 4 Transport and commissioning

### 4.2 Intermediate storage of machine/unit

---

### 4.2 Intermediate storage of machine/unit

If the machine/unit cannot be mounted immediately upon delivery, it must be protected against:

- Contamination,
- Weather influences,
- Mechanical damage.

The machine/unit components may only be stored in closed rooms and under the following conditions:

- temperature between 10°C and 35°C,
- maximum air humidity 80% (non-condensating).

### 4.3 Commissioning

The machine is commissioned by the customer's fitter.

1. Place the machine onto the optionally supplied table.
2. Bolt the machine on the bench.



Place the machine in a way so that it is easily accessible for maintenance work from all sides.

3. Check the machine for damage.
4. Check the compressed-air hoses for damage.
5. Train the operating staff and record training sessions in "Declaration of trained staff", Section 9.

#### **WARNING!**



#### **Risk of injuries!**

Machine components might loosen during transport. Such components might be flung out during the nipple insertion process. There is a risk of being injured.

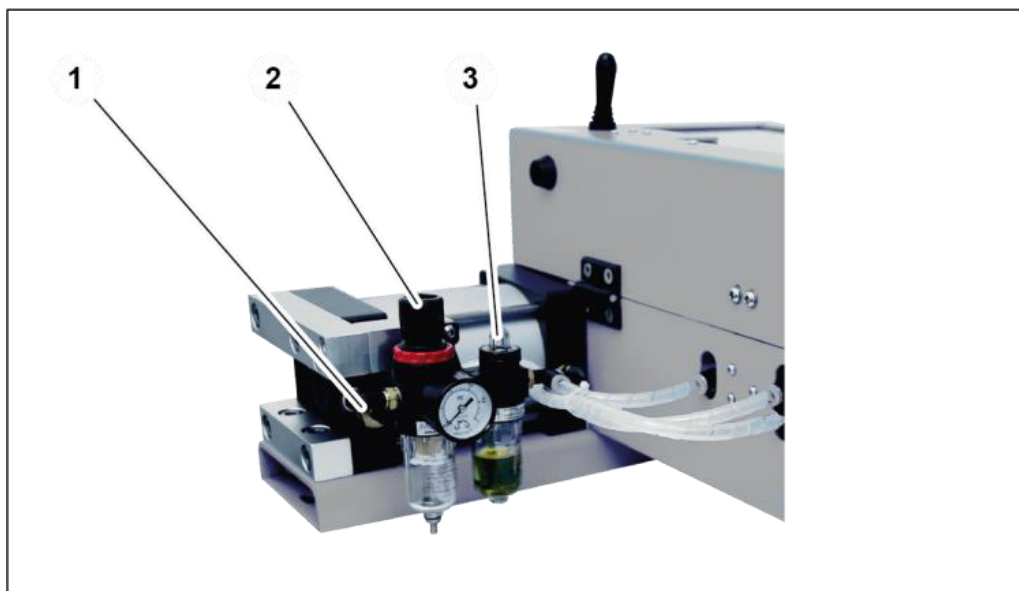
- Simulate the nipple insertion process several times without a work piece.
- Check the machine for atypical noise.

## 4 Transport and commissioning

### 4.3 Commissioning

#### 4.3.1 Connection of compressed air

The compressed air connection must supply 6 bar.



1. Establish the compressed air connection (1) between the grid and the compressed-air maintenance unit.
2. Check the pressure at the compressed-air maintenance unit (2) and adjust to 6 bar.
3. Check that the scale (3) of the compressed-air maintenance unit is at the value 1.



The compressed air can be enriched with standard pneumatic oil through the oiler of the maintenance unit.

#### ATTENTION!



##### Damage to the machine

Contaminated compressed air may cause damage to the machine.

- Only use clean, and water-free compressed air.

## 5 Operation

### 5.1 What you have to observe

---

## 5 Operation

### 5.1 What you have to observe

The operator has received the Operation Manual from the owner, has read and understood it and will observe it.

#### **Prior to starting work**

- Ensure sufficient illumination of the working area of the machine.

#### **During operation**

- Observe the safety instructions on the machine.
- Make sure that no other persons stay in the working area.
- Each movement of the hand must be observed.
- Eating, drinking and smoking at the workplace is prohibited.
- Wear close-fitting clothes.
- Do not wear watches or jewellery.

#### **After operation**

- Disconnect the machine from the compressed-air supply.

## 5 Operation

### 5.2 Inserting/extracting nipples

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## 5.2 Inserting/extracting nipples

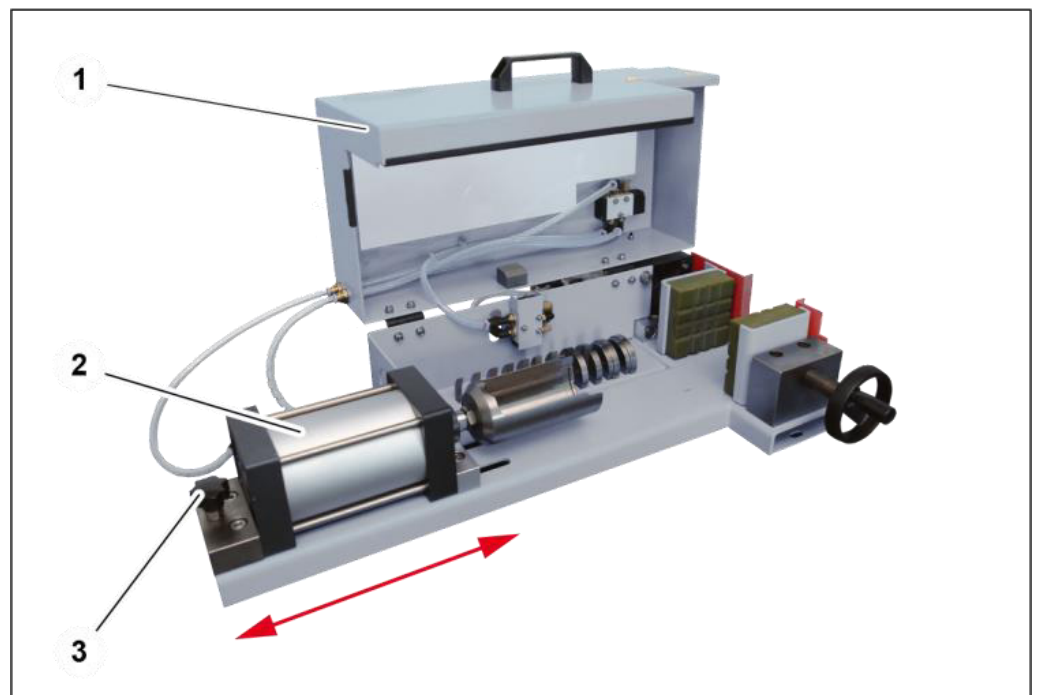
### 5.2.1 Prerequisites

Prerequisites for correct insertion/extraction:

- The machine must be connected to the compressed-air system.
- Only work pieces of permissible diameters may be used (see Technical Data).
- Skiving of the hose may be necessary before the nipple can be inserted.

### 5.2.2 Positioning the inserter cylinder

The position of the inserter cylinder can be changed and adapted to the hose length.



1. Open protective cover (1).
2. Pull and hold the catch bolt (3).
3. Move the inserter cylinder (2) to the required position.

## 5 Operation

### 5.2 Inserting/extracting nipples

#### ATTENTION!



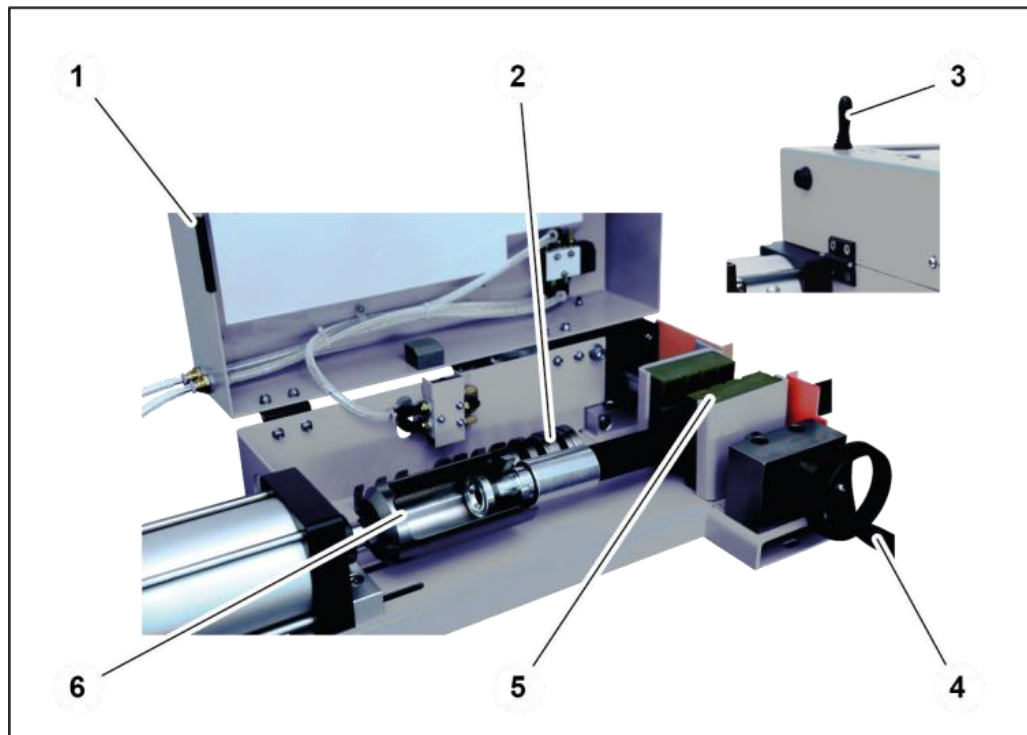
#### Risk of damage to machinery

If the catch bolt is not engaged, this may result in damage to the machine and/or work piece when the machine is operated.

- Before inserting/extracting, make sure that the catch bolt is engaged properly.

4. Release the catch bolt (3) and allow it to engage.

#### 5.2.3 Inserting nipples



1. Move the hand lever (3) to the BACK position.
2. Open the protective cover (1).
3. Select the suitable holding ring (2) and insert it into the seat (6).
4. Place the nipple on the hose so that it is hand-tight and straight.
5. Place the work piece in the seat (6).
6. Use the hand wheel (4) to adjust the clamping dies in order to centre the hose.

## 5 Operation

### 5.2 Inserting/extracting nipples

---

#### CAUTION!



##### **Risk of squeezing**

There is a risk of injury from the clamping device when closing the protective cover.

- Make sure that no extremities are in the working area behind the protective cover.

7. Close protective cover (1).
8. Move the hand lever (3) to the PUSH position.
9. Open protective cover (1).
10. Remove the workpiece.
11. Close protective cover (1).
12. Move the hand lever (3) to the STOP position.



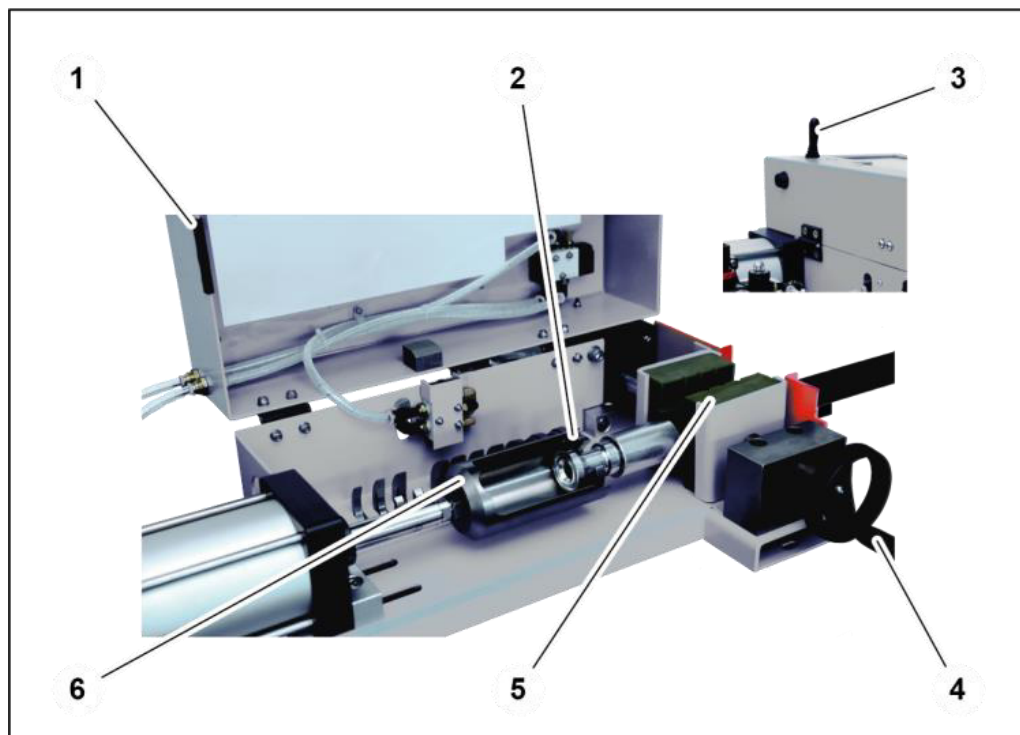
The movement of the inserter cylinder can be stopped at any time. To do this, move the hand lever to the STOP position.



## 5 Operation

### 5.2 Inserting/extracting nipples

#### 5.2.4 Extracting nipples



1. Move the hand lever (3) to the PUSH position.
2. Open protective cover (1).
3. Select the suitable holding ring (2) and insert it into the seat (6).
4. Place the work piece in the seat (6).
5. Use the hand wheel (4) to adjust the clamping die (5) in order to centre the hose.

#### CAUTION!



##### Risk of squeezing

There is a risk of injury from the clamping device when closing the protective cover.

- Make sure that no extremities are in the working area behind the protective cover.

6. Close protective cover (1).
7. Move the hand lever (3) to the BACK position.
8. Open protective cover (1).
9. Remove the workpiece.

## 5 Operation

### 5.2 Inserting/extracting nipples

---

10. Close protective cover (1).
11. Move the hand lever (3) to the STOP position.



The movement of the inserter cylinder can be stopped at any time. To do this, move the hand lever to the STOP position.

## 5.3 Cleaning

### ATTENTION!



#### **Risk of damage to machinery!**

If the machine is cleaned with a steam jet or compressed air, dirt and water may ingress in the machine and cause serious damage.

- Do not use a steam jet to clean the machine.
- Do not use compressed air to clean the machine.

1. Use a soft cloth to clean the machine.

## 6 Maintenance

### 6.1 What you have to observe

---

## 6 Maintenance

Regular maintenance will ensure the continuous operation reliability of the machine.

### 6.1 What you have to observe

This Section describes action to be taken by you as the fitter regularly to ensure the troublefree use of the machine.

- Maintenance work may only be performed by qualified maintenance staff (fitter).
- Repair work on the machine or components may only be performed by appropriately qualified expert staff or UNIFLEX experts!
- During all maintenance work, the machine must be disconnected from the compressed air supply.

Machine out of service for maintenance work!  
Do not switch on!

- Welding, flame-cutting and grinding work on and in the machine and its environment must be approved in advance. There is a risk of fire. The machine must be cleaned from dust and inflammable substances. Adequate ventilation must be ensured.

### 6.2 Maintenance schedule

If not specified otherwise, inspections listed in the maintenance schedule are visual inspection. Replace defective parts.

If you work in 2 shifts, the check frequency has to be doubled. If you work in 3 shifts, you proceed as with 2-shift operation.

Record maintenance work performed in the maintenance log.

## 6 Maintenance

### 6.2 Maintenance schedule

Maintenance item	Weekly	Monthly	Number of years
<b>Machine</b>			
Clean the machine.	X		
Check machine for damage and wear.	X		
Check the clamping dies for secure fitting.	X		
Check the clamping dies for damage.	X		
Grease the threaded spindle of the clamping dies.		X	
<b>Inserter unit</b>			
Check seat for damage and wear.	X		
Check the seat for secure fitting.	X		
Check the holding rings for damage and wear.	X		
<b>Compressed-air system</b>			
Check the compressed-air maintenance unit.	X		
Check the compressed-air hoses for damage and leaks.	X		
<b>Safety equipment</b>			
Clean the protective screen using a household window cleaner.	X		
Replace the protective screen no later than five years after manufacture (see year of construction).			5
Check the legibility of the warning signs on the machine.		X	



The replacement of wear parts must be recorded in the maintenance log!

## 7 Troubleshooting

Error	Cause	Remedy
Machine is not working	Compressed air supply disconnected	Connect compressed air
	Air pressure too low	Check air pressure

## 8 Decommissioning, disposal

### CAUTION!



#### **Risk of injuries!**

Parts of the machine/unit may be under pressure and/or tension. Loosening components may impose a risk of injuries!

- De-pressurize the machine/unit before performing any work and check for potential sources of hazard.

### 8.1 Dismantling

This section describes activities to be performed by you as the operator to ensure the safe dismantling of the machine/unit.

- The device may only be dismantled by entrusted and qualified staff.
- Disconnect the machine/unit from the pressure supply before dismantling and depressurise it.
- Check the device for mechanical tension and consider it during dismantling.

### 8.2 Recycling

The machine/unit contains metal, hydraulic hoses, electric cables and electronic components, depending on the type.

As regards disposal, the applicable national environmental protection and waste disposal regulations have to be complied with.

### 8.3 Consumables and waste

Observe applicable national environmental protection and waste disposal regulations.

Return consumables, e.g. oils, greases, test media, to supplier - they are hazardous waste. Also observe the information given on the safety data sheet.

## 9 Annex



Individual machine/unit components may deviate in their features. Please indicate the serial number of the machine for spare part orders.

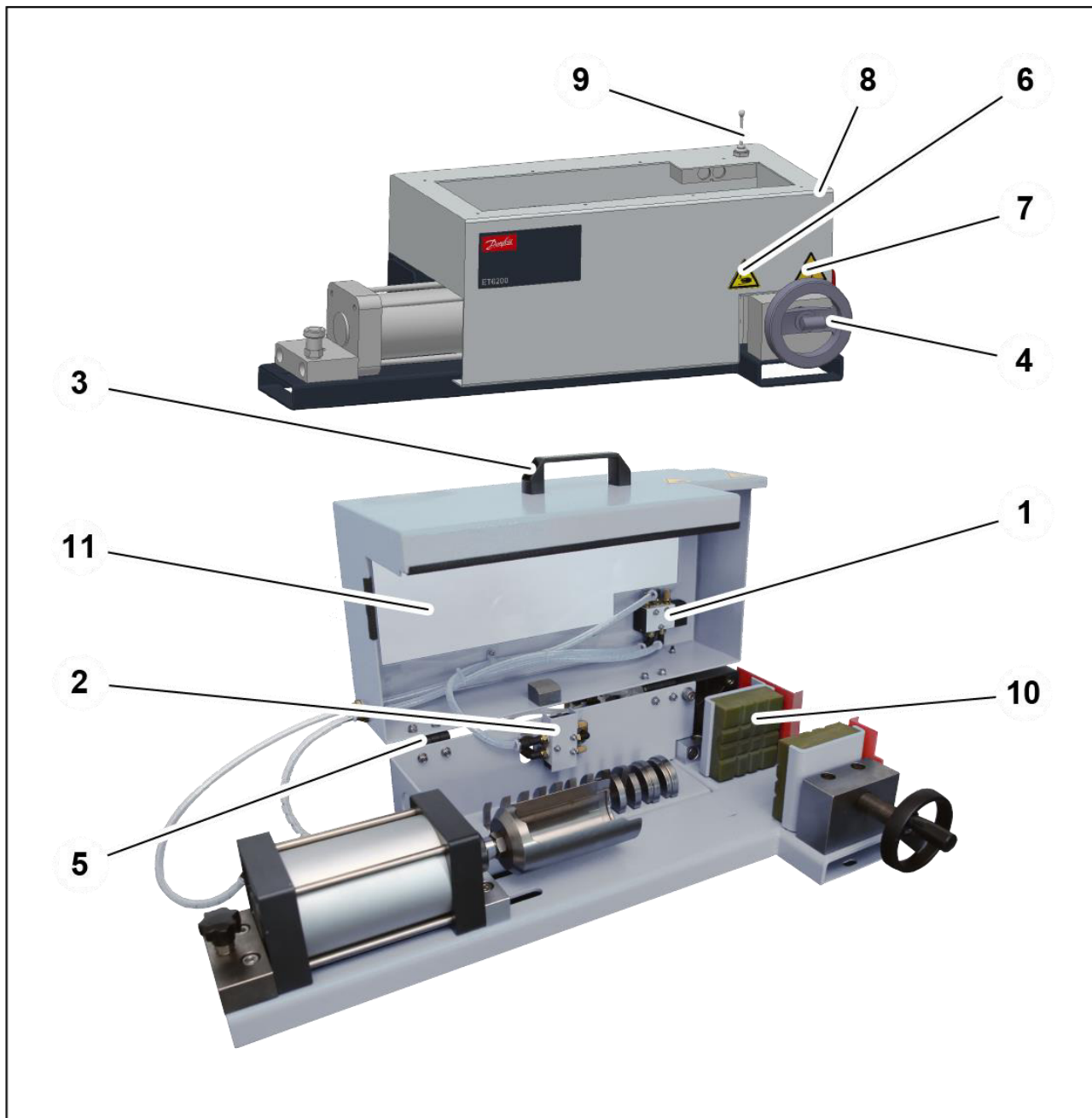
### 9.1 Accessories (retrofittable)

Accessories	Part code
Workbench	TU
Hard rubber wheels (set = 4 wheels, 2 with fixing brake)	778.2

Please contact our Sales department for ordering optional accessories.



## 9.2 Spare parts list



Item	Quantity	Part code	Designation
1	1	102.010	5/3-way pneumatic manual valve
2	1	PJ_PLS350	Stem-actuated valve
No picture	1	PJ_PLS100	Inserter cylinder
No picture	1	PJ_PFRL2000	Compressed-air maintenance unit

## 9 Annex

### 9.2 Spare parts list

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Item	Quantity	Part code	Designation
No picture	1	PJ_PSL75	Clamping cylinder
3	1	PJ_AMHD	Handle
4	1	PJ_MHW350	Hand wheel
5	2	PJ_AHC250	Hinge
6	1	715.4	Squeezing risk warning sign
7	1	716.4	Warning of hand injuries sign
8	1	102.011	Sticker UNE 10
9	1	102.012	Sticker Back/Stop/Push
10	1	PJ_MCB350	Clamping dies
11	2	PJ_AGL350	Protective screen



# 9 Annex

## 9.4 Maintenance log

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### 9.4 Maintenance log

Machine	Inserter unit	Compressed-air system	Safety equipment	Protective screen	Remark	Date	Signature
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			
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## 9 Annex

### 9.5 Declaration of qualified staff

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#### 9.5 Declaration of qualified staff

I herewith declare that I have attended an internal training for the operation of the UNIFLEX machine and have been informed on all safety-related details. In addition I declare that I have read and understood this Operation Manual completely.

City	Date	Name	Signature
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## 9 Annex

### 9.5 Declaration of qualified staff

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## About Danfoss Power Solutions FC

We sincerely appreciate your choice in selecting this product as part of the range of tooling products distributed by Danfoss.

Danfoss hoses, fittings, and tooling provide the ultimate fluid conveyance solutions for a variety of equipment and applications around the world. We proudly engineer to support a sustainable future for tomorrow.

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Thank you for participating in the Danfoss tooling program. We are pleased to offer you high-quality tooling machines manufactured by our trusted partner, Uniflex. These machines are designed to meet the rigorous standards of our industry, ensuring reliability, precision, and efficiency in your operations. We are committed to providing you with the best tools to support your success.