



PIPE TOOLS & VISES  
SINCE 1896

## Bear Hug™ Squeeze Tool System

### Air-over-Hydraulic Pump PESAPA #04330 Instructions



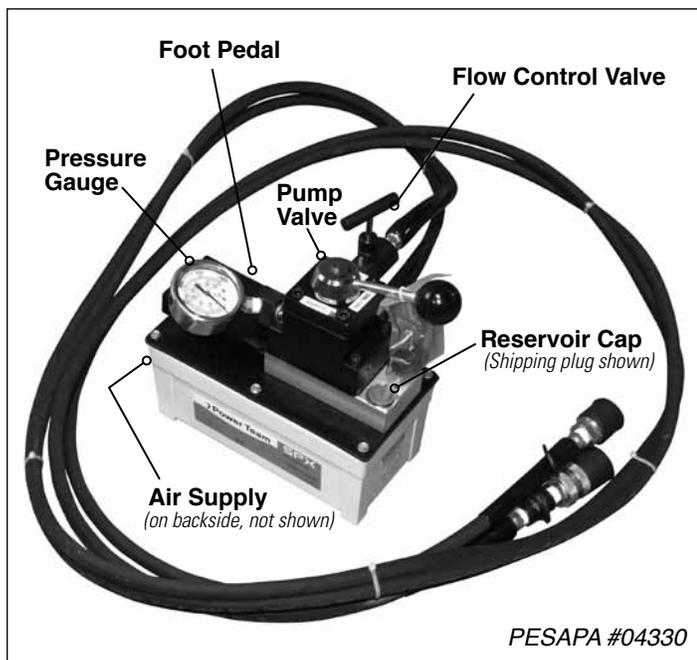
**Air-over-Hydraulic Pump PESAPA is used in conjunction with PES8BT Base Tool. Read and follow #54343 instructions for the PES8BT also.**

#### OPENING THE BOX

- Remove the red shipping plug from the pump and install the filler/vent cap.
- Remove the thread protector from the air inlet of the pump. Air fittings and hoses are not included. The air inlet is a 1/4" NPT thread.

#### PUMP INFORMATION

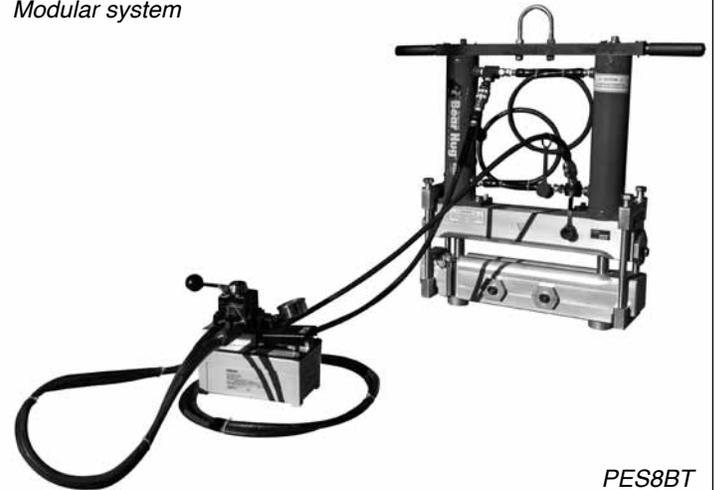
- The air-over-hydraulic pump PESAPA delivers hydraulic fluid through the use of compressed air as a power source. Regulate the air supply between 100-120 psi at the pump to obtain the rated 10,000 psi hydraulic pressure. Required air flow is 20 CFM.



PESAPA #04330

- PESAPA has a 3-position pump valve. The positions are release, neutral, and squeeze. The neutral position releases hydraulic pressure.
- PESAPA includes an internal pressure relief valve that will exhaust oil back into the reservoir beyond 10,000 psi, and a filler/vent cap used to refill and bleed the system. The pressure gauge on the pump reads outlet hydraulic pressure and not the air inlet pressure.
- PESAPA comes standard with a flow control valve (FCV) for slow metered return of hydraulic oil.
- Pressing the foot pedal on the PESAPA sends hydraulic oil through the control valve and into the system.

#### Modular system



PES8BT  
shown with PESAPA

- REED recommends the use of the PESFRLA #04331 with the PESAPA. An FRL (filter-regulator-lubricator) is key to preparing clean air for use in pneumatic system tools. Use of prepared air allows tools and equipment to operate with maximum effectiveness and efficiency.
- If an automatic in line oiler /FRL is not used, manually feed a few drops of a synthetic air line oil into the air inlet before each use of the tool.
- Maintain the PESAPA with a medium grade (AW46) hydraulic fluid\* as needed. Oil level in the reservoir should be approximately 1/2" from the filler/vent cap when the tool is in the fully closed position.

#### SQUEEZE PROCEDURE: WARNING:

- Avoid binding the tool. Keep the squeeze bars parallel to each other to avoid tool damage.
- Do not build pressure in the release mode. If pressure or pumping effort builds, stop pumping immediately and relieve excess pressure.

#### PART 1: SQUEEZING PE PIPE

1. Connect air supply to the pump and ensure proper inlet air pressure (100-120 psi). Required air flow is 20 CFM.
2. Connect pump couplers to the tool. Hand thread until the gap between mating couplers is closed.
3. Adjust pump lever to the release position.
4. Ensure the Flow Control Valve (FCV) is open fully.



*NOTE: FCV closes when turned clockwise and opens when turned counterclockwise. (approx. 7 full revolutions opens/closes FCV)*

