

Equipment

T-465-1 Crimping Procedure

WARNING

You must hold the hose assembly in place from below throughout the crimping operation. Do not place fingers or hands at the crimping point during operation. Failure to follow this procedure could result in serious injury to your hand or finger.



1. Clamp the crimper into a vise or mount to a work bench using the mounting bracket.
2. Remove pusher and insert proper size collet halves.



3. Select proper Coll-O-Crimp hose and end fitting. Insert hose into end fitting.

IMPORTANT: Make sure hose is bottomed on end fitting.



4. Insert hose assembly from below between the collet halves. Align dimples on hose end with top of collet. When crimping 229 'P', 265 'P', 338 'P' or H757 'E' Series hose ends, align top of collar on hose end with top surface of collet.



5. Reference Tool Selector Chart for proper spacer ring. Place appropriate spacer ring, with proper side up, on top of collet.



6. Replace pusher by hanging it from ramplate with bolt on top. Slide it back for centering. Close valve on hand pump and start pumping to crimp.



7. When spacer ring contacts die ring, the crimp is complete. Open valve on hand pump. Allow the ram and pusher to retract.
8. Remove pusher and spacer ring. Remove crimped assembly from below through the collet halves. Visually inspect the crimped end.
9. To insure a proper crimp has been completed, measure the nominal crimp diameter. Refer to Hose End and Tool Selector Chart in the back of this catalog for procedure and crimp diameters.