

# Equipment

## Coll-O-Crimp T-400 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. Place die ring **T-400-8** on base plate against front stops.
2. Insert properly-sized matched collet halves in the die ring. See chart on press.



3. Place the correct Coll-O-Crimp hose end on hose. Be sure hose is bottomed in hose end.



4. Insert hose assembly from below between the collet halves. Align the dimples on the hose end collar with the top of the collet. When crimping 229 'P', 265 'P', or 338 'P' or 757 'E' Series ends, the collar should be flush with the top of the collet.



5. Place specified side of spacer ring face down on collet with uncrimped hose assembly held in place. Refer to the Hose End & Tool Selection Chart in the back of this catalog for further instruction.
6. Slide entire assembly back against rear locating stops.



7. Activate pump to crimp hose end to hose. When spacer ring contacts die ring, crimping is complete. Release the electric switch to retract pusher. Slide entire assembly forward and remove spacer ring.



8. Remove factory-quality crimped hose assembly and visually inspect the crimped end. The crimp on the collar should be located  $\pm 1/16$ " from the dimples or ridges.
9. To insure a proper crimp has been completed, measure the nominal crimp diameter. Refer to Hose End and Tool Selector Chart in back of catalog for procedure and crimp diameters.