

# ET1000 Crimping Procedures for Large Collets

## Description of Components



ET1000 Crimp Machine



Die Ring  
Adapter

Split Collet  
Assembly



Spacer Rings

## Crimping Procedures (using larger collets)



### Step 1:

Slide the pusher to the back position.

Using the Collet/Spacer Ring Selector Chart, select the proper collet assembly and spacer ring.

Lubricate the inside cone of the die ring and external surfaces of the collet assembly with a high-efficiency PTFE based lubricant.

Insert the collet assembly into the base die ring.



### Step 2:

Insert the hose assembly through the bottom of the base die ring and between the two collet assembly halves. Align the fitting with the top of the collet halves as referenced on the Collet/Spacer Ring Selector Chart.



### Step 3:

Place the spacer ring in the appropriate position on top of the collet assembly (either flat-side up or flat-side down as referenced in the Collet/Spacer Ring Selector Chart).



### Step 4:

Pull the pusher forward into the detent holding position with the pusher positioning handle.

### Step 5:

Begin crimping by actuating the pump. **When the spacer ring bottoms out against the base die ring**, the crimping is complete.

**Note:** Visually inspect the crimp and verify the correct crimp diameter and length.

# ET1000 Crimping Procedures for Small Collets

## Crimping Procedures (using smaller collets)



### Step 1:

Slide the pusher to the back position.

Using the Collet/Spacer Ring Selector Chart, select the proper collet assembly and spacer ring.

Lubricate the inside cone of the base die ring and the outside cone of the die ring adapter plate.

Place the die ring adapter plate into the base die ring.



### Step 2:

Lubricate the external surfaces of collet assembly halves with a high-efficiency PTFE- based lubricant.

Insert the collet assembly into the die ring adapter plate.



### Step 3:

Insert the hose assembly through the bottom of the base die ring and up between the two collet assembly halves. Align the fitting with the top of the collet halves as referenced on the Collet/Spacer Ring Selector Chart.



### Step 4:

Place the spacer ring in the appropriate position on top of the collet assembly (either flat-side up or flat-side down as referenced in the Collet/Spacer Ring Selector Chart).



### Step 5:

Pull the pusher forward into the detent holding position with the pusher positioning handle.

### Step 6:

Begin crimping by actuating the pump. **When the spacer ring bottoms out against the die ring adapter plate**, the crimping is complete.

**Note:** Visually inspect the crimp and verify the correct crimp diameter and length.