

Equipment

T-460 Crimping Procedure



Refer to safety information regarding Coll-O-Crimp hose, hose fittings and assembly equipment compatibility on page 3.



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. Slide pusher to back of machine and insert proper size collet halves.

Note: Lubricate tapered cone seat with Lubriplate grease or equivalent before any crimping is done. Continued periodic lubrication is recommended.



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

IMPORTANT: Make sure hose is bottomed in end fitting.



3. 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' and 757 'E' Series hose ends, align top of collar on hose end with top surface of collet.



4. Refer to Tool Selector Chart for proper spacer ring. Place appropriate spacer ring, with proper side up, on top of collet. Hold uncrimped hose assembly in place throughout crimping operation.



5. Pull the pusher positioning handle as far forward as it will go. The pusher will now be in the proper position for crimping. Close valve located on rear of hand pump and start pumping to crimp.



6. When spacer ring contacts die ring, the crimp is complete. Open control valve on hand pump. Allow the ram and pusher to retract.

Slide pusher clear and remove spacer ring. Remove crimped assembly from below through the collet halves. Visually inspect the crimped end. 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 nominal crimp diameters of finished assemblies.

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

IMPORTANT: Make sure hose is bottomed in end fitting.



3. 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' and 757 'E' Series hose ends, align top of collar on hose end with top surface of collet.



4. Refer to spacer ring selector chart located in the back of this catalog. Place appropriate spacer ring, with proper side up, on top of collet. Hold uncrimped hose assembly in place throughout crimping operation.



5. Holding the uncrimped hose assembly in place throughout the crimping operation, pull the pusher positioning handle as far forward as it will go. The pusher will now be in the proper position for crimping. Hold down on activation button and start crimping.



6. When spacer ring contacts die ring, the crimp is complete. Hold the red lever down to allow the pusher to retract. Slide pusher clear and remove spacer ring. Remove crimped assembly from below through the collet halves. Visually inspect the crimped end. 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 nominal crimp diameters of finished assemblies.