

Equipment

T-420 & T-440 Crimping Procedure



Procedure when using T-410 or T-420 series collets. Spacer ring may be required, please refer to Hose End & Tool Selector Chart in the back of this catalog for tooling specifications.



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.

T-440 Used In Example



1. Open pusher halves. Select proper size collet for hose type being crimped. Insert collet as shown.



2. Place proper size Coll-O-Crimp hose end on hose. Be sure hose is bottomed in hose end.



3. Insert hose assembly from below, between collet halves. Crimp locating knurls must align with top surface of collet.

- 2a. When making a hose assembly on the T-440-1 C-O-C machine using a 47032E-632 on each end, you must manually remove the spring loaded collet retainer ring in order for the hose end to fit through the opening.



4. **T-440-1:** Close pusher halves and activate pump by turning on switch. When pusher contacts the base plate, the crimp is complete.
4. **T-420-1:** Pull activating lever down. Pusher halves will close. Continue to pull activating lever down (pump will activate) until pusher contacts the base plate. The crimp is complete. Release activating lever. Pusher will automatically return, and pusher halves will open. Remove hose assembly and measure nominal crimp diameter (see step 6).



5. **T-440-1:** Release switch. Pusher will automatically return. Open pusher halves. Remove factory crimped assembly and inspect.



6. To insure a proper crimp has been completed, measure the nominal crimp diameter. Refer to the Hose End and Tool Selector Chart in back of catalog for procedure and crimp diameter.

¹When using sizes 24 and 32 of 430 'U' series hose ends on T-440 Press.

¹When using 430 'E' Series Hose Ends and when using size 12 through 32 of 430 'U' series hose ends.

^{*}When using H35016 and H54516 with 430 'U' Series Hose ends.

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T-420 & T-440 Crimping Procedure



Procedure when using T-400 series collets. Please refer to Hose End & Tool Selector Chart in the back of this catalog for tooling specifications.



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.

T-420 Used In Example



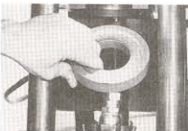
1. Hold switch "ON," As ram starts down, rotate the ram return stops "OUT" from their "IN" position. Release switch. Ram will return to the full up position allowing enough clearance for insertion of required tooling.



2. Open pusher halves and place adapter ring in the base plate cavity. Select proper size collet for hose type and size being crimped. Insert collet halves in adapter ring.



3. Place proper size Coll-O-Crimp hose end on hose. Be sure to bottom on hose.



4. Select proper spacer ring. Reference Spacer Ring Selector Chart located on front of press, or Hose End and Tool Selector Chart in back of catalog. Insert hose assembly from below, between collet halves. Align the dimples on the hose end collar with the top of the collet. When using the 229'P', 265'P', 338'P' and 757'E' series hose ends, the collar should be flush with the top of the collet.

5. Place appropriate side of spacer ring on top of collet.



6a. T-440-1: Close pusher halves. Hold switch on. When spacer ring bottoms on adapter ring the crimp is complete.

6b. Release switch to shut off pump and retract pusher halves. Open pusher halves. Remove factory-crimped hose assembly and inspect the crimp.

7a. T-420-1: Pull activating lever down. Pusher halves will close. Continue to pull activating lever down (pump will activate) until pusher contacts the base plate. The crimp is complete.



7b. Release activating lever. Pusher will automatically return and pusher halves will open. Remove factory-crimped hose assembly and inspect the crimp.

8. 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.