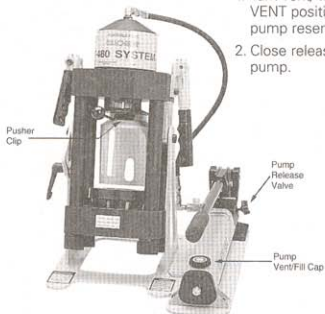


Equipment

Portable T-480-HP 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. Turn vent/ fill cap to VENT position to vent pump reservoir.
2. Close release valve on pump.



Note: Periodically lubricate die cavity with Weatherhead T-400-G lubricant.

3. Release the pusher clip and slide pusher back.
4. Select the proper Weatherhead hose, end fittings, and tooling (refer to the Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.



5. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.
6. Holding uncrimped hose assembly in place, position T-480-68 blue pusher extension ring on top of collet.
7. Slide pusher forward, making sure pusher clip has locked.

8. Operate pump handle until T-480-68 blue pusher extension ring contacts the base plate, indicating that the crimp is complete. Open the RELEASE valve to retract pusher. Release the pusher clip and slide the pusher back. Remove the blue pusher extension ring from top of collet and then the crimped hose assembly from below.

Note: Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

FOR T-400 TOOLING

Note: The T-480-68 blue extension ring is NOT used with T-400 tooling.

9. When crimping with Coll-O-Crimp I tooling the procedure is the same except:
 - a. Insert the T-420-25 adapter die ring into the base plate die cavity.
 - b. Periodically lubricate the T-420-25 adapter die ring or base plate die cavity.
 - c. Use T-400 collets and spacer rings.
 - d. Align dimples on the end fitting 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.

Equipment

Coll-O-Crimp T-440



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



Reference pages 356-367 for Coll-O-Crimp tooling, tooling packages and pumps.

Note: Seal kits for T-410 and T-440 are not sold separately. Crimpers must be sent in and torqued by Weatherhead.

Refer to safety information regarding Coll-O-Crimp crimping procedures on pages 349-350.

The Coll-O-Crimp II Plus is ideal for factory, high performance machine operations, construction and mine locations. This machine offers the capabilities of crimping all of the crimp style hose ends Weatherhead offers. With this coverage, this heavy-duty crimper can handle all of your crimping needs.

CAUTION

The Coll-O-Crimp power source has the pressure relief valve set at 5000 PSI. Damage to the press will result if higher pressures are used and warranty may be voided.

Capacity: 3/16" I.D. 1 fiber braid through 2" 6 spiral hose; for hoses other than 4 and 6 spiral, conversion tooling is required. See page 356-361 for details.

Mounting: Bench

Size: 27" high, 12" wide, 21" deep

Weight: 450 lbs.

Pump Required (sold separately): T-441, see page 347.

Note: These packages include tooling to crimp H430 hose. For additional tooling order from pages 356-361.

Note: For T-410 press, use T-410-BB switch.

T-440-N • Coll-O-Crimp II Plus Package

Includes one each of the following:

CATALOG NUMBER	DESCRIPTION
T-440-1	C-O-C II Plus Press, T-440-M Instructions and 140-06741 Switch
T-441	220v 2-stage Electric Pump
T-410-4CN	430 'U' N/S Collet - 1/2" I.D.
T-410-5CN	430 'U' N/S Collet - 3/4" I.D.
T-410-6CN	430 'U' N/S Collet - 1" I.D.
T-410-7CN	430 'U' N/S Collet - 1-1/4" I.D.
T-410-8N	430 'U' N/S Collet - 1-1/2" I.D.
T-410-9N	430 'U' N/S Collet - 2" I.D.
T-410-22	36" Pump to Press Hose Assembly

Repair & Replacement Items:

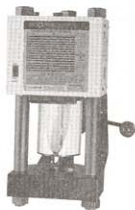
CATALOG NUMBER	DESCRIPTION
T-410-26R	Base Plate Insert (7") (T-440-1)
T-410-26	Base Plate Insert (6") (T-410-1)
T-410-28	Tool Locator Bracket
T-410-B	Pusher Bolt and Washers
T-410-E	Shroud Decal
T-440-M	Instructions for T-440-1
T-410-P	Pusher Set (2) for T-410-1 and T-440-1
T-410-1M	Microswitch for T-410-1 & T-440-1
T-421-FP	4 prong female electrical outlet See page 245 for illustration.
T-400-G	1.5 oz. Tube High Efficiency * Grease
140-06741	Pump Switch for the T-440-1 crimper using T-441 pump
T-410-BB	Pump Switch for T-410-1 crimper using T-421U or T-421U-110 pump only

Equipment

Coll-O-Crimp Super I T-420



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



The Coll-O-Crimp Super I is a versatile machine ideal for your shop, factory, construction, and mine locations. Big capacity combined with lever activated crimping gives you wide coverage and a quick and simple way to make factory-quality hose assemblies.

Capacity: 3/16" I.D. 1 fiber braid through 1-1/4" 6 spiral hose; for hoses other than 4

and 6 spiral, conversion tooling is required. See pages 284-287 for details.

Mounting: Bench or C-40X cabinet.

See pages 296-299 for cabinet (not included).

Size: 22" high, 10" wide, 20-1/2" deep

Weight: 210 lbs.

Pump Required (sold separately): T-421U or T-421U-110

T-420-1 • Coll-O-Crimp Super I Press ONLY Includes T-420-M Instructions

CAUTION

The Coll-O-Crimp power source has the pressure relief valve set at 4000 to 4200 PSI. Damage to the press will result if higher pressures are used and warranty will be voided.

T-420-N • Coll-O-Crimp Super I Package

Includes one each of the following:

CATALOG NUMBER	DESCRIPTION
T-420-1	Coll-O-Crimp Super I Press and T-420-M Instructions
T-421U	220v Electric Pump
T-400-2C	'U' Series Collet- 1/4"
T-400-3C	'U' Series Collet- 3/8"
T-400-4C	'U' Series Collet- 1/2"
T-400-5C	'U' Series Collet- 3/4"
T-400-6C	'U' Series Collet- 1"
T-400-10	Spacer Ring- Black
T-400-11	Spacer Ring- Silver
T-400-62	Spacer Ring Yellow
T-410-22	36" Pump to Press Hose Assembly
T-420-25	Adapter Ring for T-400 Series Collets
T-420-4CN	430 'U' Series Collet- 1/2"
T-420-5CN	430 'U' Series Collet- 3/4"
T-420-6CN	430 'U' Series Collet- 1"
T-420-7CN	430 'U' Series Collet- 1-1/4"

T-420N-110 • Coll-O-Crimp Super I Package

Includes one each of the following:

CATALOG NUMBER	DESCRIPTION
T-420-1	Coll-O-Crimp Super I Press and T-420-M Instructions
T-421U-110	110v Electric Pump
T-400-2C	'U' Series Collet- 1/4"
T-400-3C	'U' Series Collet- 3/8"
T-400-4C	'U' Series Collet- 1/2"
T-400-5C	'U' Series Collet- 3/4"
T-400-6C	'U' Series Collet- 1"
T-400-62	Spacer Ring- Yellow
T-400-10	Spacer Ring- Black
T-400-11	Spacer Ring- Silver
T-410-22	36" Pump to Press Hose Assembly
T-420-25	Adapter Ring for T-400 Series Collets
T-420-4CN	430 'U' Series Collet- 1/2"
T-420-5CN	430 'U' Series Collet- 3/4"
T-420-6CN	430 'U' Series Collet- 1"
T-420-7CN	430 'U' Series Collet- 1-1/4"

Coll-O-Crimp Super I Repair and Replacement Items

CATALOG NUMBER	DESCRIPTION	CATALOG NUMBER	DESCRIPTION
T-420-1M	Micro-Switch for T-420-1 Press	T-420-G	Linkage Assembly
140-0677	Tool Locator Bracket	T-420-2R	Rack
T-420-B	Pusher Bolt and Washers	T-420-2K	Pinion Shaft Assembly
T-420-E	Shroud Decal	T-420-2S	Replacement Pinion Gear Shaft
T-420-H	Handle	T-420-2G	Replacement Pinion Gear
T-420-L	Light Bulb	T-400-G	1.5 oz. Tube High Efficiency * Grease
T-420-LA	Light Assembly	T-421U-BC	Breather Cap for T-421U Pump
T-420-LS	Light Switch	140-06745	Pusher Wear Plates includes (1) Left and (1) Right
T-420-M	Instructions for T-420-1	140-06748	Pusher Wear Plates Screws (1)
T-420-P	Pusher Set (2) with Wear Plates and Screws		See pages 364 for replacement pumps.
T-420-S	Press Shroud with Decals		Refer to pages 356-367 for Coll-O-Crimp tooling, tooling packages and pumps.
T-420-26	Insert - Base Plate		Refer to safety information regarding Coll-O-Crimp crimping procedures on pages 349-350.

Equipment

Coll-O-Crimp T-400

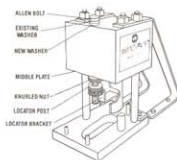


Refer to safety information regarding Coll-O-Crimp hose, hose fittings and assembly equipment compatibility on page 3.

Packages continued from previous page.



Refer to safety information regarding Coll-O-Crimp crimping procedures on page 345.



T-400 Coll-O-Crimp I Press/ Pump Packages Continued

The T-400 Coll-O-Crimp I Press and tooling package can be supplied with a variety of power units for your particular needs. Listed below are press/power unit packages. For cabinets see page 371-374.

T-400-9 • Crimp Locator

The T-400-9 allows you to make large volumes of hose assemblies by automatically aligning hose ends in proper crimp location.

Installation Procedure

1. Remove the front Allen bolt using an Allen wrench or tool provided with kit.
2. Add the washer provided with the kit to existing washer as shown and

T-403 • C-O-C I & Hand Pump Package

Includes one each of the following:

CATALOG NUMBER	DESCRIPTION
T-400	Press and tooling package/Less T-400-16
T-403-2	Hand Pump
T-400-19	60" hose assembly and fittings

T-4 14 • C-O-C I & 12v Electric Pump Package

Includes one each of the following:

CATALOG NUMBER	DESCRIPTION
T-400	Press and tooling package
T-412	12 volt DC Electric Pump

Note: 25 ton (T-400-1 is C-O-C press only)

torque the bolt down to approximately 75 ft.-lbs.

3. Attach the locator post of the pre-assembled locator to the bottom of the middle plate and lock it in place with one of the knurled nuts.
4. Align the dimples on the first assembly with top of collet to locate the crimp. Drop the locator bracket down to rest on top of the hose end. Lock the

bracket in position with remaining two knurled nuts. The locator now can be used, instead of dimples, to locate crimp accurately and consistently on the remaining hose ends of the same size and type.

Note: Remove locator assembly when crimping bent tube ends.

T-400-1 Coll-O-Crimp I Repair and Replacement Items

CATALOG NUMBER	DESCRIPTION
T-400-B	Pusher Bolt
T-400-BB	Switch to interface T400-1 crimper to T421U pump or T-421U-110 pump
T-400-G	1.5 oz. Tube High Efficiency * Grease
T-400-K1	Seal Replacement Kit for T-400-1 Press
T-400-E	Shroud Decal
T-400-M	Instructions for T-400-1
T-400-S	Replacement press shroud with Decals.
T-400-8	Die Ring
T-400-13	Replacement collet cage for T-400 'U' Series collets, 1/4" and 3/8" sizes only, and 229 'P' Series collets, all sizes, with a 'C' suffix (2 required for each collet).
T-400-14	Replacement collet cage for T-400 'U' Series collets with a 'C' suffix, 1/2" through 1" only, (2 required for each collet).
T-400-90	Replacement collet cage for T-400 'E', 069 'E', and 'E' Series collets with a 'C' suffix (2 required for each collet).
T-432-15	Pusher



CAUTION

The Coll-O-Crimp power source has the pressure relief valve set at 4000 to 4200 PSI. Damage to the press will result if higher pressures are used and warranty may be voided.

Equipment

Portable T-480-EP 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. Connect hose assembly to pump and crimper. Check all connections to be sure they are tight and leak free.
2. Open the pump vent plug by turning it 1-2 turns.

Note: Periodically lubricate the die ring with Weatherhead T-400-G lubricant.



3. Release the pusher clip and slide pusher back.
4. Select the proper Weatherhead hose, end fittings and tooling (refer to Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.



5. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.



6. Holding uncrimped hose assembly in place, position T-480-68 blue extension ring on top of collet.
7. Slide pusher forward, making sure pusher clip has locked.



8. Turn pump switch, located on side of shroud, to "ON" position. Press ADVANCE on pendant switch and hold until blue spacer extension ring contacts the base plate, indicating that the crimp is complete. Press RETRACT on the pendant switch and pusher will retract. Remove the blue pusher extension ring from top of collet and then the crimped hose assembly from below.

Note: Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

FORT-400 TOOLING

Note: The T-480-68 blue extension ring is NOT used with T-400 tooling.

9. When crimping with Coll-O-Crimp I tooling the procedure is the same except:
 - a. Insert the T-420-25 adapter die ring into the base plate die cavity.
 - b. Periodically lubricate the T-420-25 adapter die ring or base plate die cavity.
 - c. Use T-400 collets and spacer rings.
 - d. Align dimples on the end fitting 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.

Equipment

Portable T-480-TA 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. Connect hose assembly to pump and crimper.
2. Attach air supply to pump.
3. Vent pump by opening vent screw 1-2 turns.



- Note:** Periodically lubricate the die ring with Weatherhead T-400-G lubricant.
4. Release the pusher clip and slide pusher back.
 5. Select the proper Weatherhead hose, end fittings and tooling (refer to Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.



6. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.



7. Holding uncrimped hose assembly in place, position T-480-68 blue extension ring on top of collet.
8. Slide pusher forward, making sure pusher clip has locked.



9. Depress the PRESSURE end of treadle and hold until T-480-68 blue pusher extension ring contacts the base plate, indicating that the crimp is complete. Depress the RELEASE end of treadle to retract pusher. Release the pusher clip and slide the pusher back. Remove the blue pusher extension ring from top of collet and then the crimped hose assembly from below.

Note: Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

FORT-400 TOOLING

Note: The T-480-68 blue extension ring is NOT used with T-400 tooling.

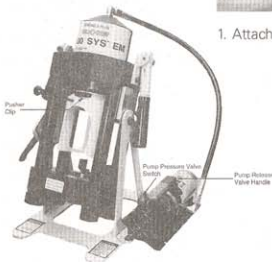
10. When crimping with Coll-O-Crimp I tooling the procedure is the same except:
 - a. Insert the T-420-25 adapter die ring into the base plate die cavity.
 - b. Periodically lubricate the T-420-25 adapter die ring or base plate die cavity.
 - c. Use T-400 collets and spacer rings.
 - d. Align dimples on the end fitting 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.

Equipment

Portable T-480-AH 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. Attach air supply to pump.



Note: Periodically lubricate the die ring with Weatherhead T-400-G lubricant.

2. Release the pusher clip and slide pusher back.
3. Select the proper Weatherhead hose, end fittings and tooling (refer to Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.



4. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.

5. Holding uncrimped hose assembly in place, position T-480-68 blue extension ring on top of collet.

6. Slide pusher forward, making sure pusher clip has locked.

7. Press ACTIVATION button and hold until T-480-68 blue pusher extension ring contacts the base plate, indicating that the crimp is complete. Depress PRESSURE valve to retract pusher. Release the pusher clip and slide the pusher back. Remove the blue pusher extension ring from top of collet and then crimped hose assembly from below.

Note: Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

FOR T-400 TOOLING

Note: The T-480-68 blue extension ring is NOT used with T-400 tooling.

8. When crimping with Coll-O-Crimp I tooling the procedure is the same except;
 - a. Insert the T-420-25 adapter die ring into the base plate die cavity.
 - b. Periodically lubricate the T-420-25 adapter die ring or base plate die cavity.
 - c. Use T-400 collets and spacer rings.
 - d. Align dimples on the end fitting 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.

Equipment

Collet Kits



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



Collet Cage Replacements

CATALOG NUMBER	DESCRIPTION
T-400-13	Replacement collet cages for: T-400-2C, T-400-3C, T-400-80C, T-400-81C, T-400-82C, T-400-83C, T-400-100C, T-400-101C
T-400-14	Replacement collet cages for: T-400-4C, T-400-5C, T-400-6C, T-400-64C, T-400-105C, T-400-106C, T-400-107C, T-400-108C, T-400-109C, T-400-110C, T-400-111C, T-400-120C, T-400-121C, T-400-122C, T-400-123C
T-400-15	Replacement collet cages for: T-400-31C, T-400-32C, T-400-46C, T-400-47C, T-400-102C, T-400-103C, T-400-113C
T-400-90	Replacement collet cages for: T-400-33C, T-400-34C, T-400-35C, T-400-36C, T-400-48C, T-400-49C, T-400-54C, T-400-55C, T-400-56C, T-400-57C, T-400-58C, T-400-59C, T-400-60C, T-400-61C
T-420-14NS	Replacement collet cages for: T-410-4CN, T-410-5CN, T-410-6CN, T-410-7CN, T-410-72CN, T-410-73CN, T-420-4CN, T-420-5CN, T-420-6CN, T-420-7CN
T-420-14	Replacement collet cages for: T-410-4C, T-410-5C, T-410-6C, T-410-7C, T-410-8C, T-420-4C, T-420-5C, T-420-6C, T-420-7C, T-420-8C, T-420-9C, T-420-10C, T-420-30C, T-470-8C, T-470-12C, T-470-16C

Note: These items are half cages. Order 2 for complete cage.

Adapter Die Rings

CATALOG NUMBER	DESCRIPTION
T-400-8	Adapter Die Ring for T-400 Collets (T-400-1 Press)
T-410-25	Adapter Die Ring for T-400 Collets (T-410-1, T-440-1 Presses)
T-420-25	Adapter Die Ring for T-400 Collets (T-420-1 Press) and T-480 Packages

Die Ring Lubricant

CATALOG NUMBER	DESCRIPTION
T-400-G	1.5 oz. Tube High Efficiency Grease