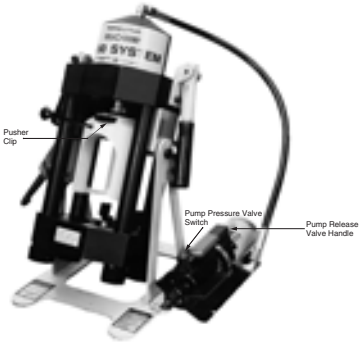
Equipment

Portable T-480-AH Crimping Procedure



1. Attach air supply to pump.

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

2. Release the pusher clip and slide pusher back.
3. Select the proper Boston 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 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 untill 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.

FOR T-400 TOOLING

Note: The T-480-68 blue extesion 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.

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.