

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.

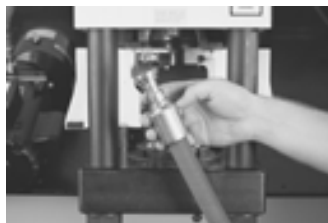
T-440 used in example.

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. 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.