

# Equipment

## 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.**

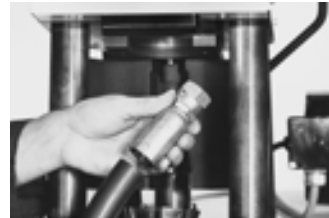
**T-420 used in example.**



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. Refer to the Spacer Ring Selector Chart located on front of press, or Hose End & 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.



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 & Tool Selector Chart in back of catalog for procedure and crimp diameters.



#### 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.

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