



The Right Connection®



1765A
Brass Ferrule Crimper
Operating Manual
April 2, 2018

Air Operated
Positive Stroke - High Speed

INSTRUCTIONS FOR USE OF 1765A FERRULE CRIMPER

DESCRIPTION:

The 1765A crimper is an air operated, high speed ferrule crimping machine. It is used in a fixed location where continuous service is necessary for high production runs.

The 1765A crimper is designed for the production or repair of hose assemblies using light or medium weight ferrules for air and or water hose.

INSTALLATION:

The 1765A ferrule crimper is shipped fully assembled, less crimping dies. It should be secured to a bench, with the foot pedal in a convenient location.

- The normal operating air pressure is 110 PSI
- Air consumption per cycle is .209 cu. ft. at 80 PSI

MAINTENANCE:

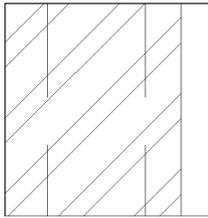
The 1765A ferrule crimper is greased at time of assembly. Periodic inspection, cleaning and greasing of all moving parts is necessary (use a WD40 type spray).

OPERATION:

1. Stop No. 22, movable on Stud No. 21 must be adjusted to locate the crimp on the ferrule.
2. Insert the pre-assembled hose that has the proper stem and ferrule, through the opening between the dies until the fitting butts against the stop.
3. Holding the assembly steadily against the stop, depress the Foot Pedal No. 30, once. A fast, easy crimp will occur, after a slight pause, as the dies pass through center. Do not maintain pressure on the pedal after crimp has occurred.

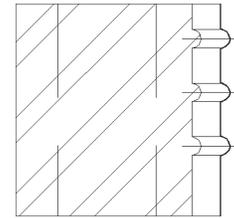
DIE CHANGE:

1. Turn air supply off, and bleed air cylinder by depressing Foot Pedal No. 30 several times.
 2. Move stop No. 22 down by releasing thumb screw No. 23.
 3. Remove wing nuts No. 6 and lock washers No. 7. Die holder plate No. 3 can now be removed exposing the crimping dies as well as the die holders No.10, links No. 11 and their pins No.'s 12 & 13.
2. Crimping dies will slide in and out of the mating dovetails freely.
 3. All crimping dies are stamped with their part number. When the die holder plate is removed, this number is visible on each die. When changing dies, be sure to install each die with the numbered side facing the die holder plate. This is very important when using ribbed dies for proper rib orientation.



Plain Dies

1765A CRIMPING DIE CHART

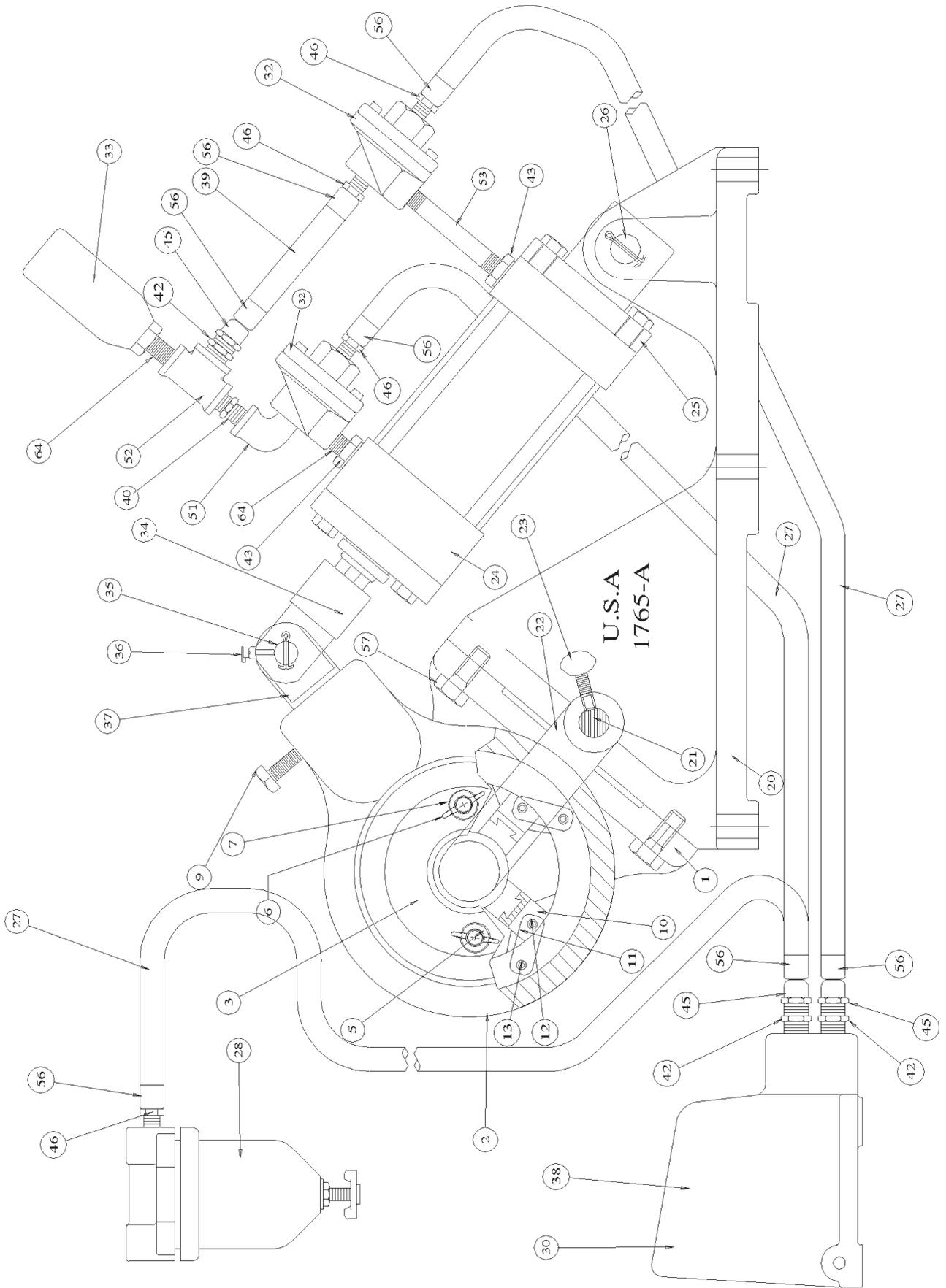


Ribbed Dies

Die #	Bore	Die #	Bore
P1	1.450	P26	.825
P2	1.425	P27	.800
P3	1.400	P28	.775
P4	1.375	P29	.750
P5	1.350	P30	.725
P6	1.325	P31	.700
P7	1.300	P32	.675
P8	1.275	P33	.650
P9	1.250	P34	.625
P10	1.225	P35	.600
P11	1.200	P36	.575
P12	1.175	P37	.550
P13	1.150	P38	.525
P14	1.125	P39	.500
P15	1.100	P40	.475
P16	1.075	P41	.450
P17	1.050	P42	.425
P18	1.025	P43	.400
P19	1.000	P44	.375
P20	.975	P45	.350
P21	.950	P46	.325
P22	.925	P47	.300
P23	.900	P48	.275
P24	.875	P49	.250
P25	.850	P50	.225

Die #	Bore	Die #	Bore
R1	1.450	R26	.825
R2	1.425	R27	.800
R3	1.400	R28	.775
R4	1.375	R29	.750
R5	1.350	R30	.725
R6	1.325	R31	.700
R7	1.300	R32	.675
R8	1.275	R33	.650
R9	1.250	R34	.625
R10	1.225	R35	.600
R11	1.200	R36	.575
R12	1.175	R37	.550
R13	1.150	R38	.525
R14	1.125	R39	.500
R15	1.100	R40	.475
R16	1.075	R41	.450
R17	1.050	R42	.425
R18	1.025	R43	.400
R19	1.000	R44	.375
R20	.975	R45	.350
R21	.950	R46	.325
R22	.925	R47	.300
R23	.900	R48	.275
R24	.875	R49	.250
R25	.850	R50	.225

1765A EXPANDER



Parts List for 1765A Expander

Item #	Part Description	Part #
20	Base	251765SP20
21	Stud Stop	251765SP21
22	Stop	251765SP22
23	Thumb Screw	251765SP23
24	Air Cylinder	251765SP24
25	Mounting Bracket	251765SP25
26	Mounting Bracket Pin	251765SP26
27	Hose Assembly (6 feet)	251765SP27
28	Air Line Filter	251765SP28/F16-03M
30	Foot Pedal	251765SP30
32	Quick Exhaust Valve	251765SP32
33	Exhaust Muffler	251765SP33
34	Connecting Link	251765SP34
35	Connecting Link Pin	251765SP35
37	Connecting Stud	251765SP37
38	Foot Pedal Guard	251765SP38
39	4½" Hose Assembly	251765SP39
40	113RB-6-1.5 - 3/8 x 1½ Nipple	251765SP66
42	1/4 Brass Hex Nipple	BCN25
43	3/8 FNPT x 1/2 MNPT	HB3F4M
45	1/4 x 1/4 Female Hose Barb	BFS22
46	3/8 x 1/4 Male Hose Barb	BN23
50	Gitts Oil Cup	251765SP50
51	3/8 x 3/8 Street Elbow	SE3F3M
52	101A-COB - 3/8 x 3/8 x 1/4 Reducing T	251765SP60
53	113RB-6-3.5 - 3/8 x 3½ Nipple	251765SP65
56	Brass Ferrule	BFM625
64	3/8" Brass Hex Nipple	BCN37
5111A Crimper		
1	Die Holder Base	2551110001
2	Die Link Ring	2551110002
3	Die Holder Plate	2551110003
5	Stud (2)	2551110005
6	Wing Nut (2)	2551110006
7	Lock Washer (2)	2551110007
8	Handle	2551110008
9	Set Screw	2551110009
10	Die Holder (4)	2551110010
11	Link (4)	2551110011
12	Die Holder Pin (short) (4)	2551110012
13	Link Pin (long) (4)	2551110013