

Instructions for operation of 5111A Ferrule Crimper

Description

The 5111A ferrule crimper is hand operated. It is used in a fixed location for small production runs, or mounted on a carrier as a mobile hose repair unit.

The 5111A crimper is designed for the production or repair of hoses using light or medium weight ferrules and stems for air or water hose.

Installation

The 5111A ferrule crimper is shipped fully assembled, (except for installing handle), less crimping dies. It should be secured to a bench or carrier.

Maintenance

The 5111A ferrule crimper is greased at time of assembly. Periodic inspection, cleaning, and greasing of all moving parts is necessary (use a WD40 type spray).

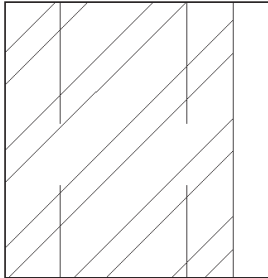
Operation

1. Install proper stem and ferrule onto hose.
2. Place assembly into opening between the crimping dies and pull handle No. 8 until crimping dies contact ferrule. A steady pull on the handle will bring the dies through center completing the crimping operation.

Die Change

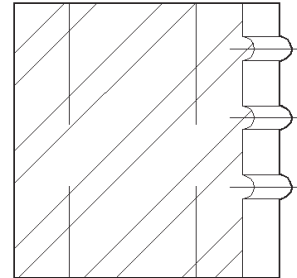
1. Remove wing nuts No. 6 and lock washers No. 7. Die holder plate No. 3 can now be removed exposing the crimping dies as well as the die holders No.10, links No. 11 and their pins Nos. 12 and 13.
2. Crimping dies will slide in and out of the mating dovetails freely.

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

5111A Crimping Die Chart

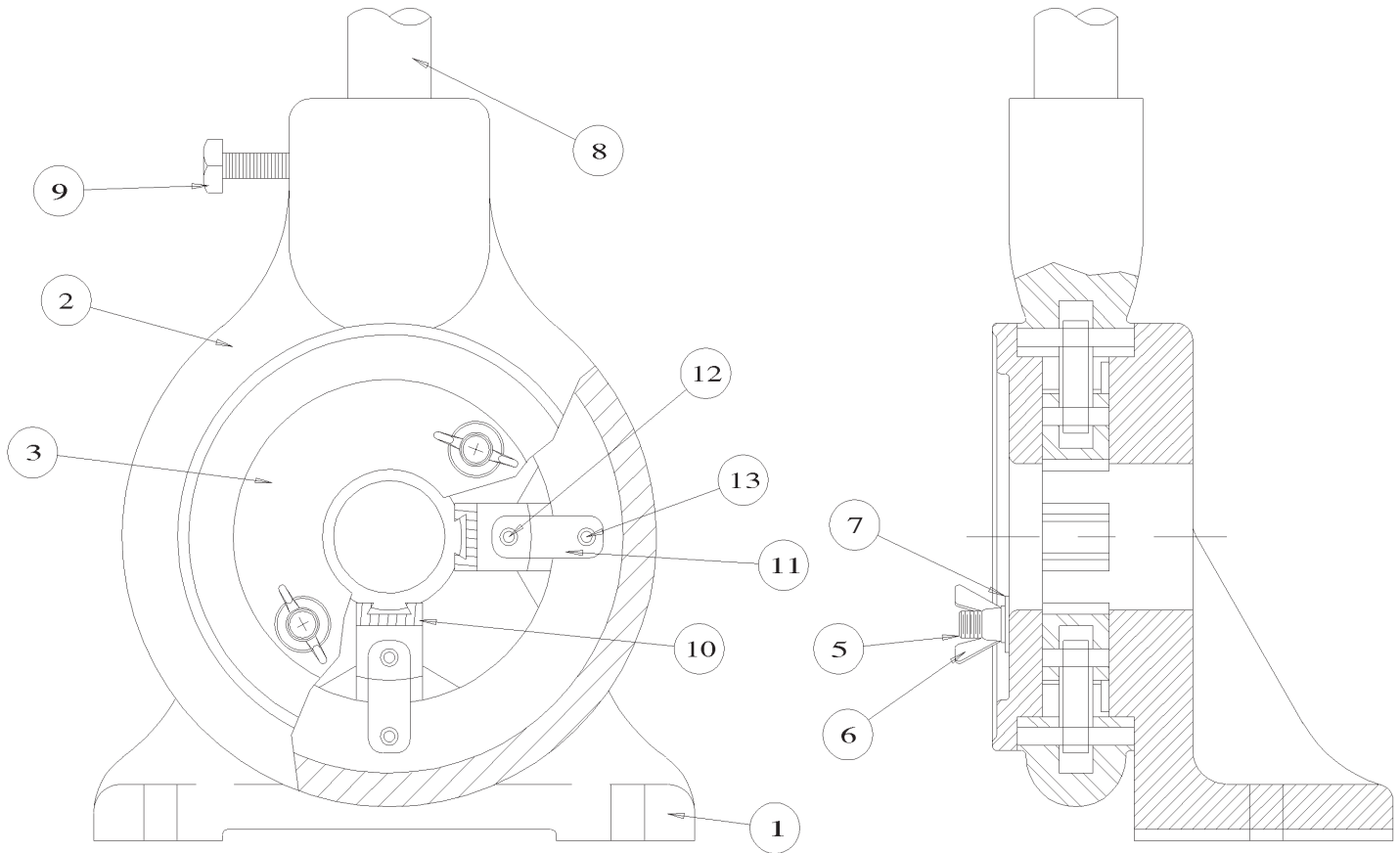


Ribbed Dies

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

5111A Crimper



Parts List

Item #	Description	Qty	Part #
1	Die holder base	1	2551110001
2	Die link ring	1	2551110002
3	Die holder plate	1	2551110003
5	Stud	2	2551110005
6	Wing nut	2	2551110006
7	Lock washer	2	2551110007
8	Handle	1	2551110008
9	Set screw	1	2551110009
10	Die holder	4	2551110010
11	Link	4	2551110011
12	Die holder pin (short)	4	2551110012
13	Die holder link pin (long)	4	2551110013



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