

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

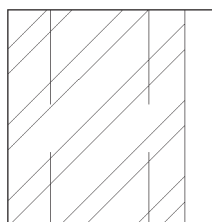
The 1765A ferrule crimper is greased at time of assembly. Periodic inspection, cleaning, and greasing of all moving parts is necessary (use a WD40 type spray).

Operation

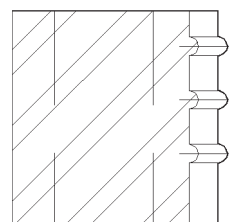
1. Stop No. 8, movable on stud No. 7 must be adjusted to locate the crimp on the ferrule.
2. Insert the preassembled hose that has the proper stem and ferrule, through the opening between the dies until the fitting butts against the stop.
3. Holding the assembly steadily against the stop, depress the foot pedal No. 12, once. A fast, easy crimp will occur, after a slight pause, as the dies pass through the 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. 12 several times.
2. Move stop No. 8 down by releasing thumb screw No. 9.
3. Remove wing nuts No. 2. Die holder plate No. 1 can now be removed, exposing the crimping dies as well as the die holders No.3, links No. 4, and their pins No.'s 5 and 6.
4. Crimping dies will slide in and out of the mating dovetails freely.
5. 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.

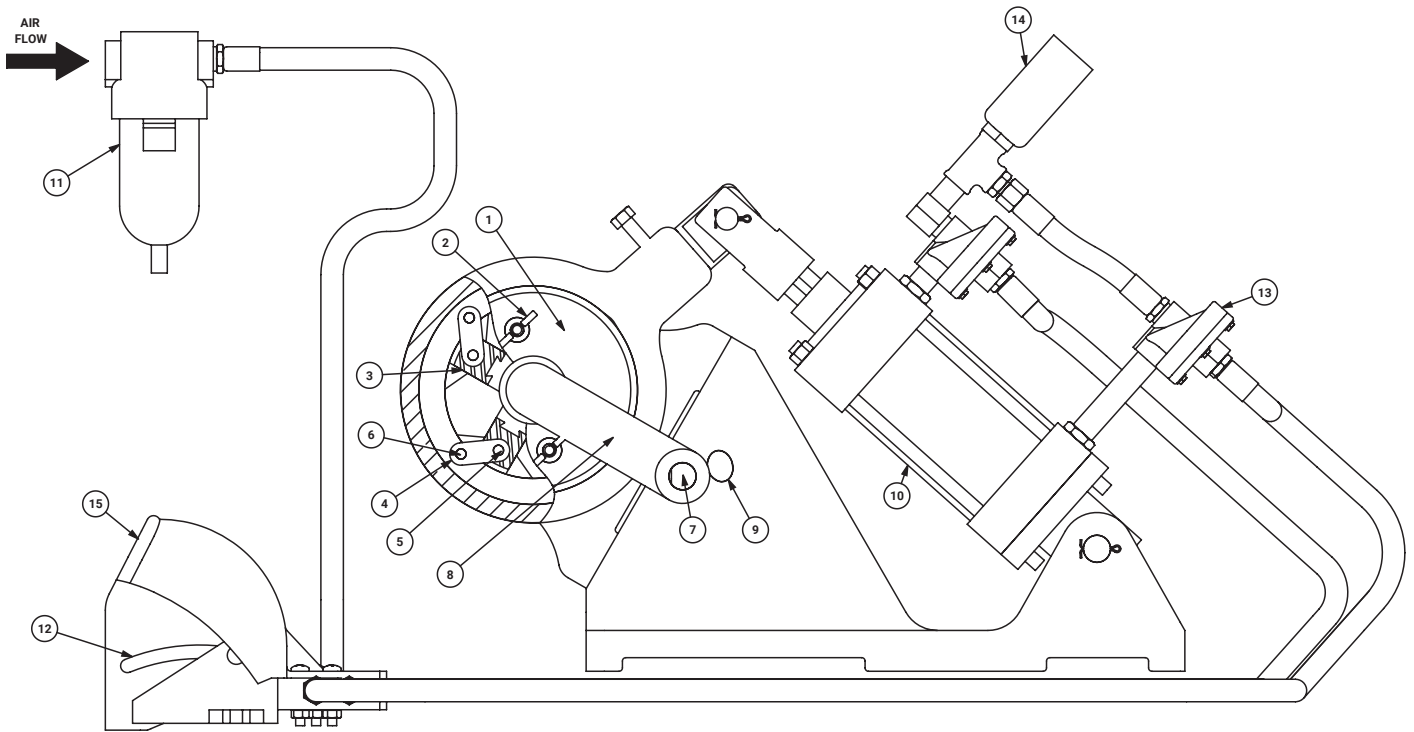


Plain Dies



Ribbed Dies

1765A Crimper



Parts List

Item #	Description	Qty	Part #
1	die holder plate	1	2551110003
2	3/8" - 16 wing nut	2	2551110006
3	die holder	4	2551110010
4	link	4	2551110011
5	die holder pin (short)	4	2551110012
6	link pin (long)	4	2551110013
7	stop stud	1	251765SP21
8	stop	1	251765SP22
9	thumb screw	1	251765SP23
10	air cylinder	1	251765SP24
11	air line filter	1	F16-03M
12	foot pedal	1	251765SP30
13	quick exhaust valve	2	251765SP32
14	exhaust muffler	1	251765SP33
15	foot pedal guard	1	251765SP38

