Procedure 1103: Set-up 5111A/1765A Crimping Machines

effective 06/16

Preparation

☐ Using the appropriate table from the Brass Fitting section of the current DPL (Dixon® Product List), select the proper ferrule and die.

Notes

☐ 1. The ID (Inside Diameter) of the correct ferrule should be between 0.010" and 0.031" larger than the OD (Outside Diameter) of the hose.
☐ 2. Using ribbed dies or plain dies is a matter of preference.
☐ 3. When using ribbed dies with some ferrules, one 'rib' may crimp on the end of the ferrule resulting in an unacceptable appearance. If this happens, insert all die segments with numbers facing in.
☐ 4. **DO NOT** use the machine without the cover plate in place. ⚠
☐ 5. If the wing nuts are too tight, the die holders may bind.

Process

For 5111A Machines

☐ 1. Remove the two wing nuts and the cover plate on the machine.
☐ 2. Insert the dies into the die holders with segment numbers facing out.
☐ 3. Replace cover plate and install wing nuts.

For 1765A Machines

☐ 1. Disconnect air supply.
☐ 2. Remove the two wing nuts and the cover plate on the machine.
☐ 3. Insert the dies into the die holders with numbers on all die segments facing out.
☐ 4. Replace cover plate and install wing nuts.
☐ 5. Loosen the thumbscrew on the stop and swing the stop down.
☐ 6. Ensure the machine is in the retracted (fully-open) position.
☐ 7. Slide the hose with stem and ferrule through the die opening.
☐ 8. For BFM and BFW style ferrules, align the end of the ferrule closest to the hose with the face of the dies.
☐ 9. For BF850, BFMW1050 and BFL style ferrules align the end of the ferrule closest to the hex on the stem with the face of the dies.
☐ 10. Swing the stop up and position it so that it contacts the end of the stem. Re-tighten the thumbscrew.
☐ 11. Reconnect air supply and crimp ferrule.
☐ 12. If necessary, adjust stop to position crimp in desired location on ferrule.

Tip: After the dies have been inserted, and before the cover plate has been put on, cycle the machine so the dies are in the fully-closed position. If a gap is present between any die segments, the machine needs a full rebuild. **DO NOT** *use the machine until this condition has been corrected.*