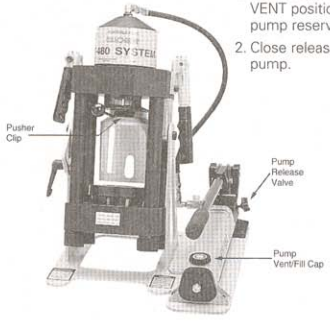
## Equipment

# Portable T-480-HP Crimping Procedure

**⚠ 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.




1. Turn vent/ fill cap to VENT position to vent pump reservoir.
2. Close release valve on pump.

**Note:** Periodically lubricate die cavity with Weatherhead **T-400-G** lubricant.

3. Release the pusher clip and slide pusher back.
4. Select the proper Weatherhead hose, end fittings, and tooling (refer to the Hose End and Tool Selector Chart. Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.

5. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.

6. Holding uncrimped hose assembly in place, position **T-480-68** blue pusher extension ring on top of collet.
7. Slide pusher forward, making sure pusher clip has locked.

8. Operate pump handle until **T-480-68** blue pusher extension ring contacts the base plate, indicating that the crimp is complete. Open the RELEASE valve to retract pusher. Release the pusher clip and slide the pusher back. Remove the blue pusher extension ring from top of collet and then the crimped hose assembly from below.

**Note:** Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

**FOR T-400 TOOLING**

**Note:** The **T-480-68** blue extesion ring is NOT used with T-400 tooling.

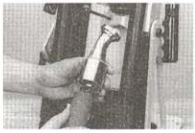
9. When crimping with Coll-O-Crimp I tooling the procedure is the same except;
   a. Insert the **T-420-25** adapter die ring into the base plate die cavity.
   b. Periodically lubricate the **T-420-25** adapter die ring or base plate die cavity.
   c. Use **T-400** collets and spacer rings.
   d. Align dimples on the end fitting with top of collet. When crimping 229 'P', 265 'P', 338 'P' and 757 'E' Series hose ends, align top of collar on hose end with top surface of collet.

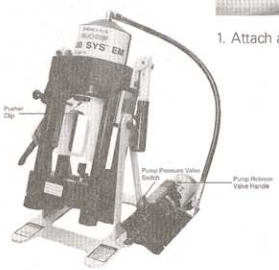
## Equipment

# Portable T-480-AH Crimping Procedure

**⚠ 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.






1. Attach air supply to pump.

**Note:** Periodically lubricate the die ring with Weatherhead **T-400-G** lubricant.

2. Release the pusher clip and slide pusher back.
3. Select the proper Weatherhead hose, end fittings and tooling (refer to Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.

4. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.
5. Holding uncrimped hose assembly in place, position **T-480-68** blue extension ring on top of collet.
6. Slide pusher forward, making sure pusher clip has locked.
7. Press ACTIVATION button and hold until **T-480-68** blue pusher extension ring contacts the base plate, indicating that the crimp is complete. Depress PRESSURE valve to retract pusher. Release the pusher clip and slide the pusher back. Remove the blue pusher extension ring from top of collet and then crimped hose assembly from below.

**Note:** Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

**FOR T-400 TOOLING**

**Note:** The **T-480-68** blue extesion ring is NOT used with T-400 tooling.

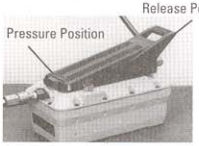
8. When crimping with Coll-O-Crimp I tooling the procedure is the same except;
   a. Insert the **T-420-25** adapter die ring into the base plate die cavity.
   b. Periodically lubricate the **T-420-25** adapter die ring or base plate die cavity.
   c. Use **T-400** collets and spacer rings.
   d. Align dimples on the end fitting with top of collet. When crimping 229 'P', 265 'P', 338 'P' and 757 'E' Series hose ends, align top of collar on hose end with top surface of collet.

# Equipment

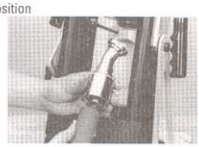
## Portable T-480-TA Crimping Procedure

**⚠ 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.




1. Connect hose assembly to pump and crimper.
2. Attach air supply to pump.
3. Vent pump by opening vent screw 1-2 turns.



**Note:** Periodically lubricate the die ring with Weatherhead **T-400-G** lubricant.

4. Release the pusher clip and slide pusher back.
5. Select the proper Weatherhead hose, end fittings and tooling (refer to Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.

6. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.

7. Holding uncrimped hose assembly in place, position **T-480-68** blue extension ring on top of collet.
8. Slide pusher forward, making sure pusher clip has locked.

9. Depress the PRESSURE end of treadle and hold until **T-480-68** blue pusher extension ring contacts the base plate, indicating that the crimp is complete. Depress the RELEASE end of treadle to retract pusher. Release the pusher clip and slide the pusher back. Remove the blue pusher extension ring from top of collet and then the crimped hose assembly from below.

**Note:** Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

**FOR T-400 TOOLING**

**Note:** The **T-480-68** blue extension ring is NOT used with T-400 tooling.

10. When crimping with Coll-O-Crimp I tooling the procedure is the same except;
    a. Insert the **T-420-25** adapter die ring into the base plate die cavity.
    b. Periodically lubricate the **T-420-25** adapter die ring or base plate die cavity.
    c. Use T-400 collets and spacer rings.
    d. Align dimples on the end fitting with top of collet. When crimping 229 'P', 265 'P', 338 'P' and 757 'E' Series hose ends, align top of collar on hose end with top surface of collet.

## Equipment

# Portable T-480-EP Crimping Procedure

**⚠ 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.

1. Connect hose assembly to pump and crimper. Check all connections to be sure they are tight and leak free.
2. Open the pump vent plug by turning it 1-2 turns.

**Note:** Periodically lubricate the die ring with Weatherhead T-400-G lubricant.

3. Release the pusher clip and slide pusher back.
4. Select the proper Weatherhead hose, end fittings and tooling (refer to Hose End and Tool Selector Chart). Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting.

5. Loosen knob and tilt press as necessary. Insert one end of hose assembly from below the base plate and between the collet halves. Align knurl on end fitting with top of collet, making sure that collet halves are evenly aligned.

6. Holding uncrimped hose assembly in place, position **T-480-68** blue extension ring on top of collet.
7. Slide pusher forward, making sure pusher clip has locked.

8. Turn pump switch, located on side of shroud, to "ON" position. Press ADVANCE on pendant switch and hold until blue spacer extension ring contacts the base plate, indicating that the crimp is complete. Press RETRACT on the pendant switch and pusher will retract. Remove the blue pusher extension ring from top of collet and then the crimped hose assembly from below.

**Note:** Visually inspect the crimped end. Measure the nominal crimp diameter and verify that the crimp is within 1/16" from the locating knurl on the collar, see figure C, page 342.

**FOR T-400 TOOLING**

**Note:** The **T-480-68** blue extension ring is NOT used with T-400 tooling.

9. When crimping with Coll-O-Crimp I tooling the procedure is the same except;
   a. Insert the **T-420-25** adapter die ring into the base plate die cavity.
   b. Periodically lubricate the T-420-25 adapter die ring or base plate die cavity.
   c. Use T-400 collets and spacer rings.
   d. Align dimples on the end fitting with top of collet. When crimping 229 'P', 265 'P', 338 'P' and 757 'E' Series hose ends, align top of collar on hose end with top surface of collet.

### Insertion Depth

Push hose end on hose until hose is bottomed in end fitting. To insure that hose is bottomed in collar, mark the insertion depth on the hose before inserting it into the hose end.

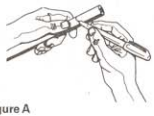


Figure A

| HOSE I.D. | 'U' SERIES RUBBER | 'E' SERIES NYLON/ | 069 'E' SERIES TRUCK HOSE | 757 'E' SERIES REFRIGERANT HOSE |
|---|---|---|---|---|
| 3/16 | — | 7/8 | 1 | — |
| 1/4 | 1-1/2 | 7/8 | 1 | — |
| 5/16 | — | 15/16 | 1-3/32 | 1 |
| 3/8 | 1-7/16 | 15/16 | — | — |
| 13/32 | — | — | 1-3/32 | 1-1/8 |
| 1/2 | 1-7/16 | 1-1/16 | 1-3/32 | 1-3/32 |
| 5/8 | 1-15/16 | — | 1-5/16 | 1-3/32 |
| 3/4 | 2-1/8 | 1-1/4 | — | — |
| 7/8 | — | — | 1-5/16 | — |
| 1 | 2-3/16 | 1-11/32 | — | — |
| 1-1/8 | — | — | 1-3/8 | — |

### Coll-O-Crimp Spacer Ring

Typical spacer ring illustrating both sides of ring.

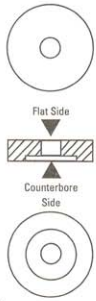



Figure B

### Nominal Crimp Diameter Measurement

Measuring crimp diameters should be a part of the normal hose assembly procedure. To insure a proper crimp diameter reading, follow these steps:

1. Measure the diameter in the middle of crimped portion of the hose end.
2. Place the caliper in a position to allow a measurement across the pressed (flat) portion of the crimp.
3. Refer to Hose End and Tool Selector Chart for nominal crimp diameter.

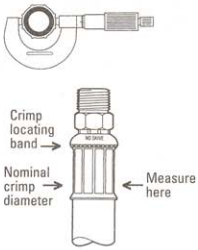



Figure C

**Note:** In the larger sizes, calipers may be used; however, in the smaller sizes, and in the 'E' Series thermoplastic hose ends, a point micrometer will provide an accurate reading.

### 757 'E' Series Hose End

757 'E' Series hose ends must be positioned with top of collar level with top of collet.

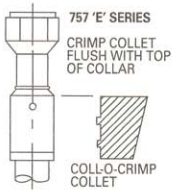



Figure D