

Procedure 2401: King Crimp™ with Ferrules

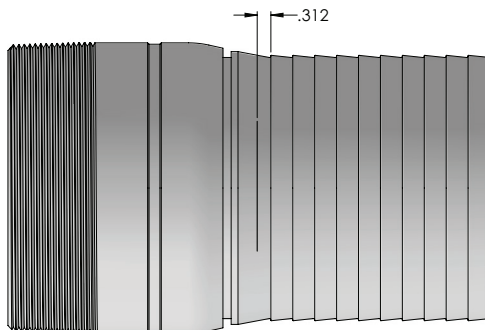
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Selection

- 1. Measure the OD (Outside Diameter) of each end of the hose with a Dixon® diameter tape.
Tip: Mark hose OD on the hose after measuring to avoid mistakes on crimp dimensions/sleeve selection.
- 2. From the current Dixon® catalog, select the correct ferrule for the hose OD just measured.

Preparation

- 1. Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. For 6" ferrules and larger, place a mark on the shank $\frac{5}{16}$ " (0.312") from last serration. This is the insertion depth (See illustration below).



Notes

- 1. Each end of the hose to be assembled must be measured accurately.
- 2. $\frac{5}{16}$ " (0.312") insertion depth may need adjustment based upon hose construction and the presence or absence of metal reinforcement.
- 3. Crimp diameters are in the current Dixon® Product List (DPL), on the ferrule or by calling Dixon® at 877-963-4966.
- 4. Hold the finished crimp diameter for 3 to 5 seconds. This allows the metal to retain its new diameter.
- 5. Finished crimp diameter must be measured for each fitting. Tolerance is ± 0.010 " from published crimp diameter.
Tip: Use the crimp die closest to crimp diameter without going over for the best results (ex. crimp diameter 31mm, use 30mm die).
- 6. If the finished crimp diameter is larger than tolerance, recrimp. If the crimp diameter is smaller than tolerance, consult Dixon®.
- 7. Consult the King Crimp™ Pressure Recommendation Chart or Dixon® for coupling working pressures and for working pressures above **70°F (21°C)**.

Process

- 1. Slide the ferrule over the hose until the turnover end contacts the hose end.
- 2. Insert the fitting into locking groove or insertion depth mark.
- 3. Set the crimp diameter on the crimper.
- 4. Bring the hose with fitting and ferrule through the back of the crimper so that it is facing the operator.
- 5. Slowly jog dies closed. Make sure the dies clear the coupler head, adapter hose stop or King™ Combination nipple body.
- 6. Position the ferrule so the turnover end is even with the end of the crimp dies.
- 7. Slowly close the dies until they just contact the ferrule. Make positioning adjustments if necessary.
- 8. Push the coupler head, adapter hose stop or King™ Combination nipple locking groove shoulder against the turnover end of the ferrule making sure the dies clear the coupling.
- 9. Close the dies until the machine has reached the set crimp diameter and hold for 3 to 5 seconds.
- 10. Open the dies, pull the assembly forward and measure the crimp diameter.
Tip: Crimp all hose ends having the same OD to speed up the crimping process by not having to continually change crimper specifications.
- 11. Inspect the ferrule for folds and creases and to ensure the gripping fingers engage the locking groove.