

Procedure 2307: Air King™ Crimp with Light Duty Ferrules

effective 06/16

Selection

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

Preparation

- 1. Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

Notes

- 1. Each end of the hose to be assembled must be measured accurately.
- 2. Crimp diameters can be located in the current DPL or by calling 877-963-4966.
- 3. Hold the finished crimp diameter for 3 to 5 seconds. This allows the metal to retain its new diameter.
Tip: Use the crimp die closest to the crimp diameter without going over for the best results (ex. crimp diameter 31mm, use 30mm die).
- 4. Finished crimp diameter must be measured for each fitting. Tolerance is ± 0.010 " from published crimp diameter.
- 5. If the finished crimp diameter is larger than the tolerance, re-crimp. If the crimp diameter is smaller than the tolerance, consult Dixon®.

Process

- 1. Slide the ferrule over the hose until the turnover end contacts the hose end.
- 2. Insert the fitting to the locking groove.
- 3. Set the crimp diameter on the crimper.
- 4. Bring the hose with the fitting and ferrule through the back of the crimper so that it is facing the operator.
- 5. Slowly jog the dies closed. Make sure the dies clear the Air King™ head.
- 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 Air King™ hose stop 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 the change crimper specifications.
- 11. Inspect the ferrule for folds and creases and to ensure the ferrule engages the locking groove.