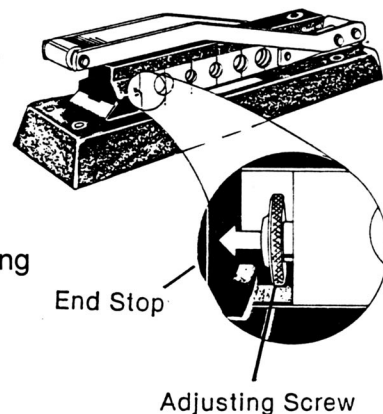


## HOSE FERRULE CRIMPING TOOL #1626

The HOSE FERRULE CRIMPING TOOL #1626 is equipped with mounting holes for permanent installations, or may be used as a portable tool for hose assembly in the field.



### **IMPORTANT! BEFORE USING THIS TOOL:**

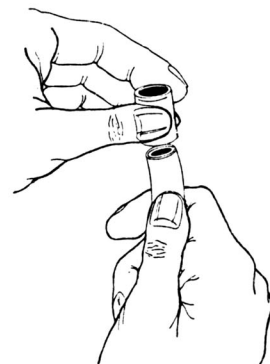
Make sure the crimping arm is in the closed (down) position and then set the adjusting screw so it touches the end stop. The screw should **NEVER** be set tighter than this end stop. When using oversized hoses, the screw may be set looser to avoid crimping too deeply.

### **OPERATION:**

#### **A. FERRULE**

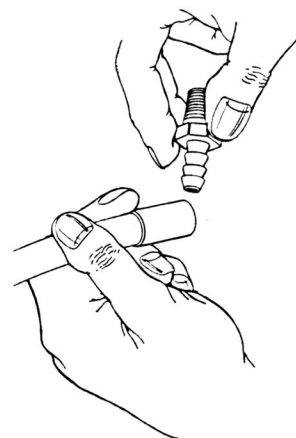
The proper ferrule should slip fit easily over the hose. Ideally, the ferrule should not fall off the hose when the hose is held vertically. It is better to use a slightly oversized ferrule as an undersized ferrule may make inserting the barbed fitting difficult. The chart below is just a guide. Rubber hose tolerances can vary up to  $\pm 1/32$ " on the outside diameter, so it is necessary to fit ferrules and fittings to each individual hose.

	1654-2	1654-3	1654-4	1654-5	1654-6	1654-7	1654-8	1654-9	1654-12
FITS HOSE	1/2" OD	9/16" OD	19/32" OD	5/8" OD	21/32" OD	11/16" OD	23/32" OD	3/4" OD	7/8" OD



#### **B. BARBED FITTING**

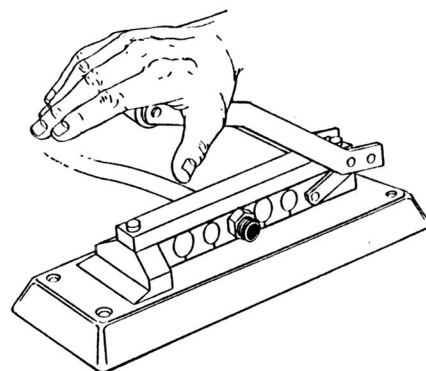
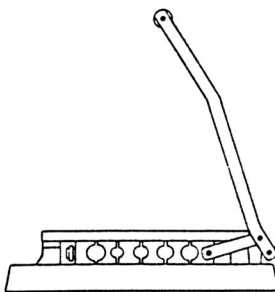
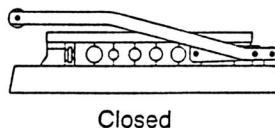
Dip the ferrule end of the hose into soapy water. Insert the chosen barbed fitting into the hose with a fair amount of force (even after being lubricated with soapy water). A barbed fitting that slides into a hose too easily will not crimp properly.



#### **C. CRIMPING DIE**

To find the proper crimping die, find the smallest die opening (1626 in closed position) which the hose will just pass through freely. Use the next smallest die to crimp. To crimp, center ferrule in the proper die and depress the crimping arm fully, making sure to keep fingers up and out of the way. Open the 1626, rotate the hose one quarter turn and repeat to finish the crimp. The chart below is an approximate guide for choosing the proper die.

DIE #	DIE ID	STANDARD HOSE
#1	.630	1/4" OR 5/16" ID x 5/8 OD DB
#2	.580	Undersize 5/8" OD DB
#3	.530	Undersize 9/16" or Oversize 1/2" OD
#4	.480	1/4" ID x 1/2" OD SB
#5	.680	3/8" ID x 22/32" OD DB
1626-1	.438	3/16" ID x 7/16" OD SB
1626-2	.813	1/2" ID x 7/8" OD DB



ID = Inside Diameter (inches)      DB = Double Braid  
OD = Outside Diameter (inches)      SB = Single Braid