CUSTOM® CRIMP

CC25 HYDRAULIC CRIMPER
OPERATORS MANUAL

SAFETY PRECAUTIONS

READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER

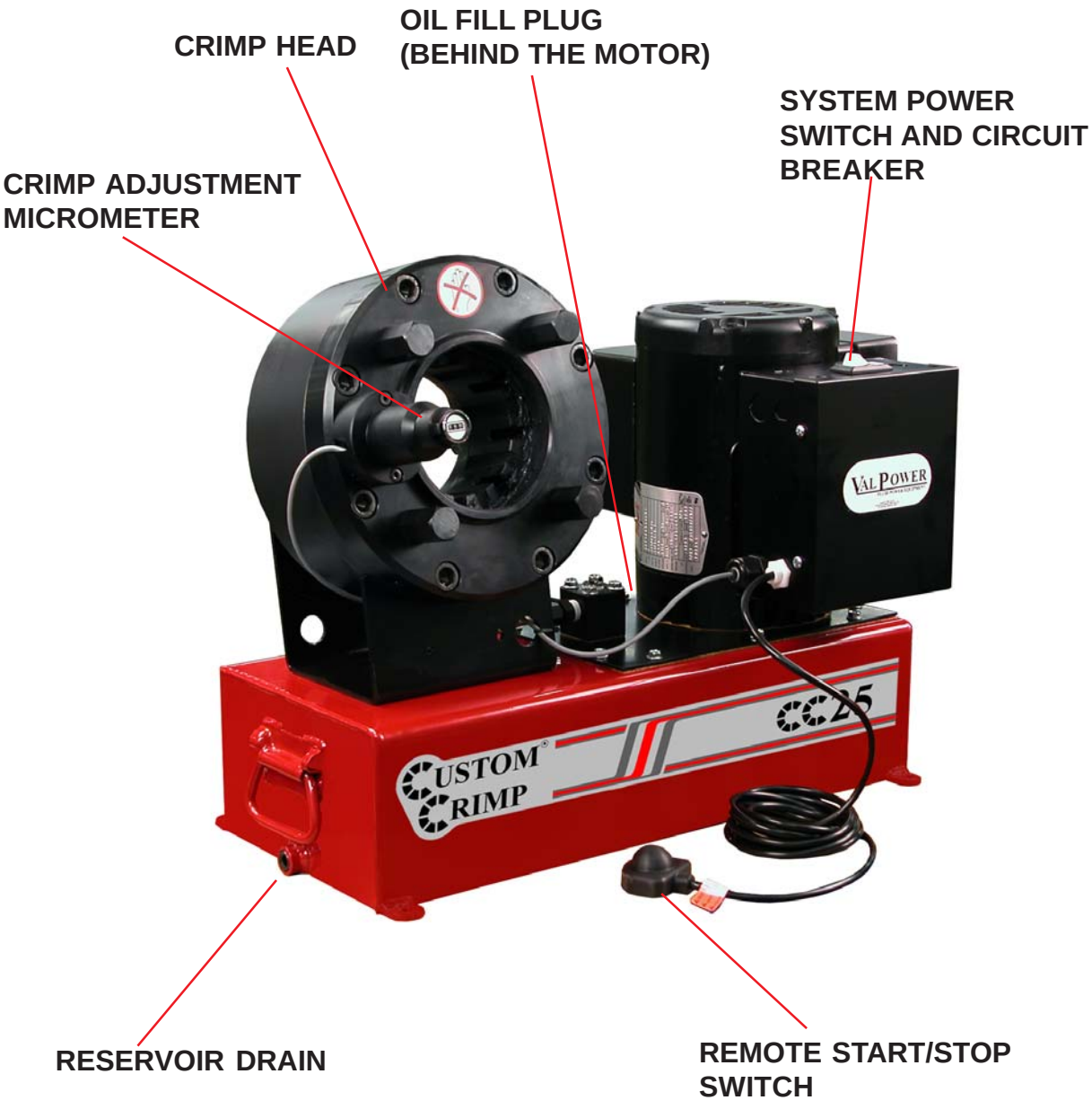
CRIMPER CAN PRODUCE 137 TONS OF FORCE. KEEP BOTH HANDS AWAY FROM PINCH POINTS

CONSULT HOSE AND FITTING MANUFACTURER'S SPECIFICATIONS FOR CORRECT MACHINE SETTINGS AND CRIMP MEASUREMENTS

ALWAYS WEAR EYE PROTECTION

For Parts and Service, Contact:
Custom Machining Services, Inc.
Valparaiso, In 46383
(219) 462-6128

CC25 COMPONENT IDENTIFICATION



CC25 SPECIFICATIONS

Master Die Diameter----------80mm

Crimping Force----------137 Ton

Maximum Hose Diameter (2 Wire)----------1-1/4”

Maximum Hose Diameter (4 Wire) ----------1-1/4”

Maximum Hose Diameter (6 Wire)----------1”

Maximum Die Opening (Die Size Plus)----------18mm

Maximum Opening w/o Dies----------86mm

Length----------21”

Width----------11”

Weight----------195 lb

Electrical Power Requirement (Std)----------110V

Electrical Power Requirement (Optional)----------220V 1 Ph

Pump HP----------1 Hp

Oil Capacity----------13 Qt

Oil Type----------ISO Viscosity Grade 46

Manual/Automatic Crimping----------Manual Only

Inch/Metric Settings----------Metric Only

Custom Crimp Die Series----------80S

CRIMPING WITH THE CC25 CRIMPER

Select the correct die set for the combination of hose and fitting being crimped. Consult the hose and fitting manufacturer's specifications for the correct die to use.

Insert each die finger individually making certain that the die size (number stamped on the face of the die) faces the front of the machine. The die should click into place when it is properly positioned.

Release the micrometer locking tab, and adjust the micrometer to the hose and fitting manufacturer's recommended setting.

Note on Micrometer Settings
Each 100 on the Micrometer represents 1 mm above the closed diameter of the die set. For example, with a 57mm die installed and the Micrometer set at 150 the finished crimp diameter would be 58.5 mm (57mm + 1.5mm)

Insert the hose and fitting in the crimper head and press and hold the start button. When the crimper reaches the correct diameter, the crimper will shut off. Release the start switch and remove the hose and fitting. When possible, the hose fitting should be centered axially in the die set to assure a uniform crimp with minimum taper.

Measure the finished diameter to be certain that it is within manufacturer's specifications. If the finished diameter is not within specifications, see calibration instructions.

Calibration Check:

Set the Micrometer at 000 and press and hold the start switch. If the dies are fully closed before the crimper shuts off, the crimper is correctly calibrated and does not require calibration..

Calibration:

If the crimper needs to be recalibrated, remove the shoulder bolts holding the Micrometer in place taking care not to lose the springs.

If the crimper does not shut off when the dies are completely closed, loosen the jam nut on the end of the micrometer and turn the set screw out slightly. Retighten the jam nut and check calibration.

If the dies are not fully closed when the crimper shuts off, the set screw should be turned in slightly and calibration rechecked.

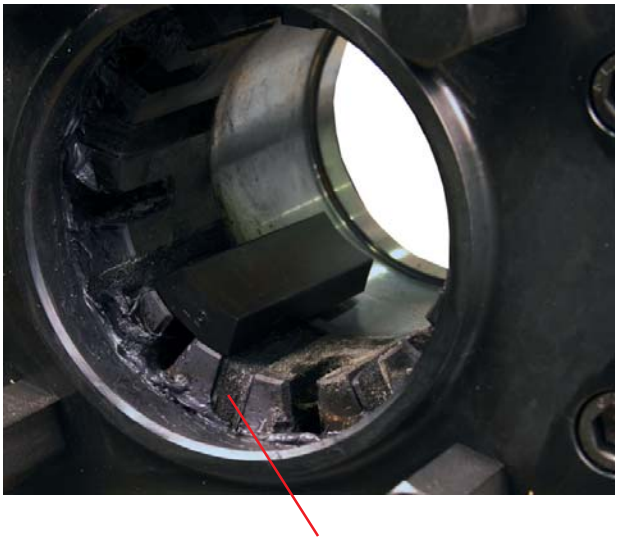
Note that when reinstalling the Micrometer, it must be free to move slightly on the shoulder bolts in order to release the micro switch located in the base of the Micrometer mount.

Check the tank dipstick for proper reservoir oil level. If additional oil is required fill with ISO Grade 46 hydraulic oil.

Crimper Head Lubrication
Remove the sponge rubber filler pads and spray a moly-disulfide lubricant into the area between the master die fingers. Be certain to replace the pads as they prevent dirt and debris from falling between the master die fingers and destroying the finished surfaces of the master dies.

With the die fingers removed, move the master dies in and out by adjusting the micrometer setting to expose the sliding surfaces. Brush a moly disulfide lubricant in the exposed areas.

P/N DMA-12 Spray Lubricant is available
P/N MTB-10(10 oz can) and MTB-16(16 oz can) brush lubricant is available



Rubber Filler Pads

TROUBLESHOOTING

PROBLEM: CRIMPER WILL NOT RUN AT ALL

- The white rocker switch is also a circuit breaker. Check to see that the circuit breaker has not been tripped.

- Check the wall outlet. Use of extension cords or outlets with inadequate power can damage the motor . Do not run the crimper from a portable power source.

- Check the pneumatically actuated switch in the electrical box mounted on the motor. This switch controls power to the motor and is actuated with air pressure from the bulb on the end of the hose going into the box.

- Check the micro switch located in the base of the micrometer. this is a normally closed switch and must be closed for the crimper to operate.

PROBLEM: CRIMP DIAMETER TOO LARGE

- Check crimper calibration and re-calibrate if required.
- Incorrect die being used. Each die has a range of approximately 3mm (.120 in) above the closed diameter of the die. The closed diameter is the die size stamped on the die ring.
- Incorrect setting of the micrometer. Check hose manufacturer's specifications.
- Inadequate pump pressure. Check oil level in the pump. It should be 1-1/2 to 2 inches below the fill plug. Replenish with ISO Viscosity Grade 46 hydraulic oil.
- Inadequate lubrication causing the pump to work harder than normal to reach the required diameter.
- Inadequate pressure being generated by the pump. This is most likely if the crimper can crimp the smaller size hoses and not the larger hoses. When correctly adjusted, the pump should generate approximately 5,000 psi.
  Do Not adjust pump to produce in excess of 5,000 psi as damage to components or personal injury may result
- No pressure being generated by the pump. There should be a definite change in pitch of the pump as it cycles into high pressure mode and begins to "work" harder.

PROBLEM: CRIMP DIAMETER TOO SMALL

- Check crimp diameter and re-calibrate if necessary
- Incorrect die being used (See die range under Crimp Diameter too Large)
- Incorrect setting of the micrometer. Check hose manufacturer's specifications.