CUSTOM CRIMP™

Innovating **SMART** Hose Assembly Solutions Since 1979

CC150MOB CRIMPER OPERATORS MANUAL WITH DIAL MICROMETER

SAFETY PRECAUTIONS

- READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER.
- CRIMPER CC150MOB CAN PRODUCE 240 TONS OF CRIMPING FORCE.
- KEEP BOTH HANDS AWAY FROM PINCH POINTS.
- CONSULT HOSE AND FITTING MANUFACTURER FOR CORRECT MACHINE SETTINGS AND CRIMP MEASUREMENTS.
- ALWAYS WEAR EYE PROTECTION.

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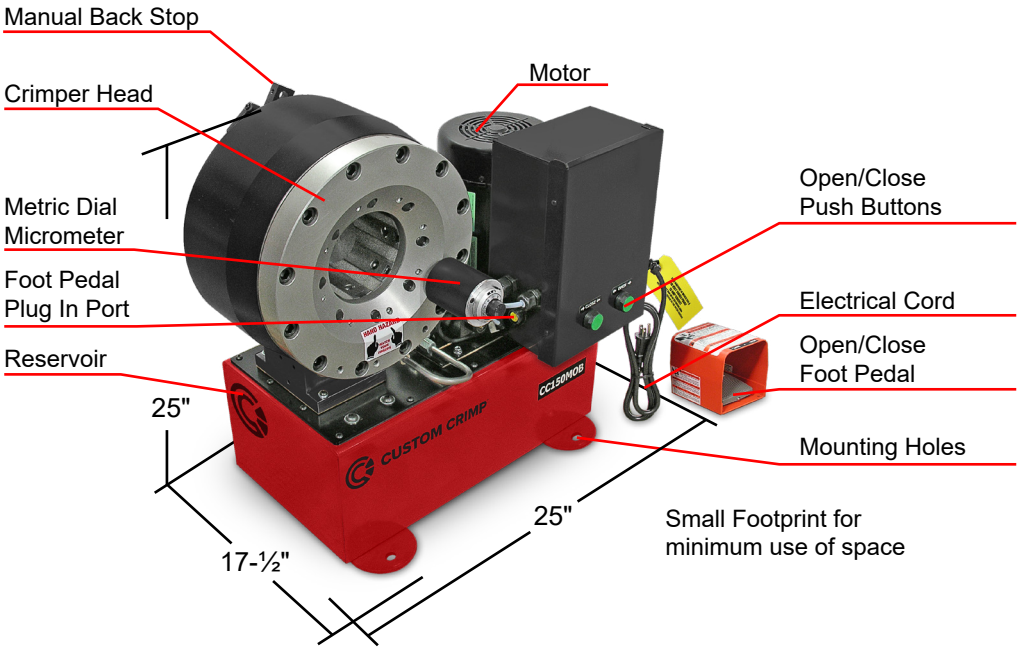
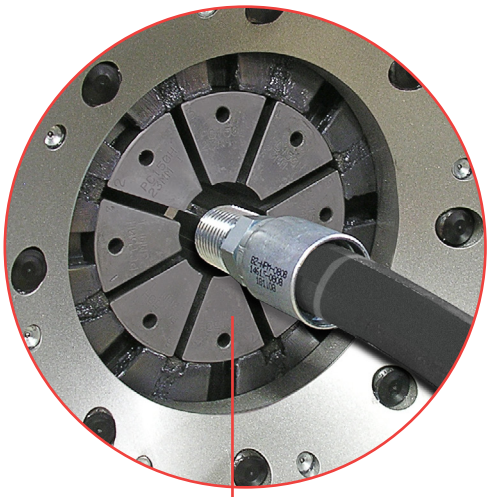
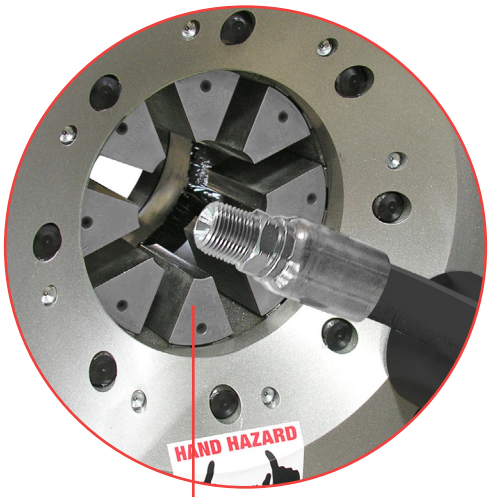
COMPONENT PARTS & TECHNICAL DATA



CC150MOB Technical Specifications
Crimping Force: 240 Ton
Hydraulic Hose Capacity: 2SP: 2", 4SP: 1-½", 6SP: 1-¼"
Industrial Hose Capacity: 2"
Crimper Size: L: 17-½" x W: 25" x H: 25"
Crimper Weight: 400 lbs
Power: 2HP / 220V / 1Phase (Standard) 1.5HP / 110V / 1Phase (Optional) 1HP / 12VDC & 24VDC (Optional)
Die series: 84S
Adjustability: Metric
Opening w/o dies: 120mm / 4.72"
Master die inside diameter: 84mm / 3.31"
Master die travel: 38mm / 1.5"
Reservoir capacity: 6 Gallons
Oil type: ISO 46 Hydraulic Oil

FOOT SWITCH OPEN / CLOSE FUNCTION





Foot Switch Close Function:

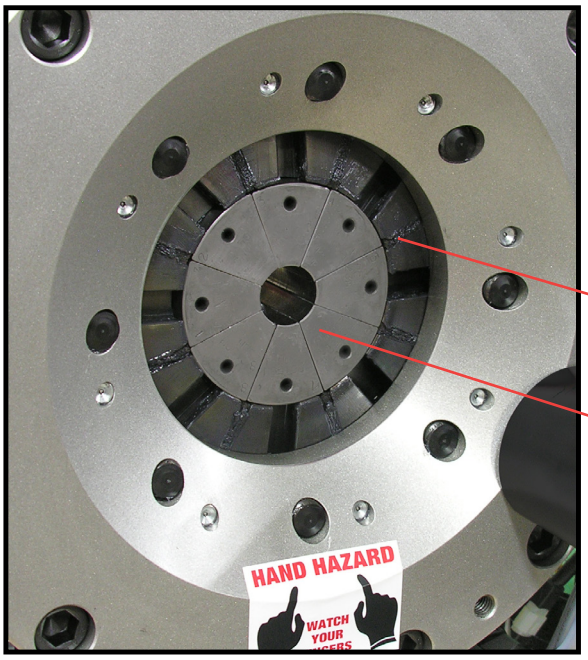
The foot switch permits dies to be “jogged” into position and accurately position the fitting prior to crimping.

Foot Switch Open Function:

Allows the user to open the crimper head the amount needed to remove the crimped assembly.

The foot switch allows the user to operate the crimper head, while keeping both of their hands free to provide a quick and accurate crimp. Keeping both hands free the user can make crimps fast, accurate and much easier.

DIE PART IDENTIFICATION



A) Master Die

B) 84mm Hydraulic Die

INITIAL SET UP

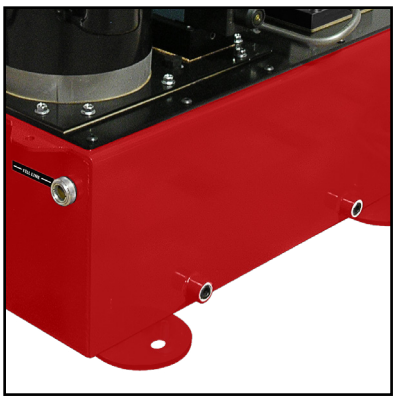
Caution: Do not lift the machine by the crimper head.
Lift with a fork lift under the tank.

Mount the crimper on a sturdy surface. Workbench should be able to support crimper weight of 400 lbs.

Check electrical circuit to be certain that it matches the crimper requirements shown on the tag attached to the crimper cord.

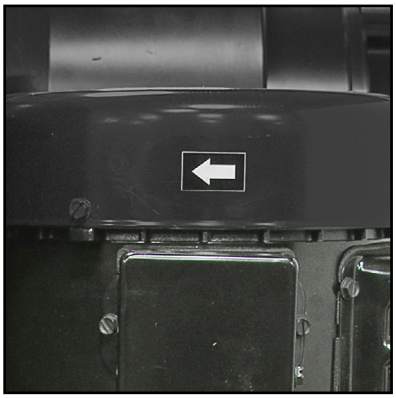
DO NOT RUN CRIMPER ON AN EXTENSION CORD.

Check reservoir oil level with sight glass at the rear of the crimper. The reservoir requires 6 gallons of ISO 46 hydraulic oil for a complete fill. If necessary, oil can be drained from either of the two ports on the rear of the reservoir.



Check to be certain that the motor rotates in the direction of the arrow shown on the motor housing.

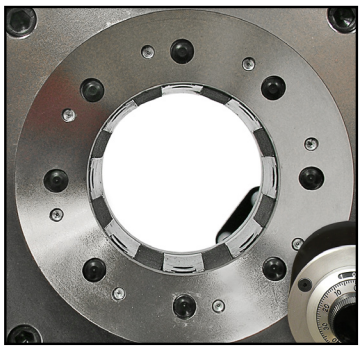
Damage to the pump can result if the motor does not rotate in the correct direction.



HYDRAULIC DIE INSTALLATION

Bring the crimper head to fully opened position as shown in photo A.

A

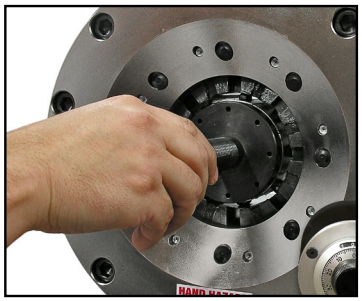


Install the Hydraulic Dies with the quick change tool as shown in photo B.

Note: The die size stamped on the face of the die should face toward the operator.

Note: Consult your hose and fitting manufacturer's specifications for the correct die set for the hose and fitting being crimped.

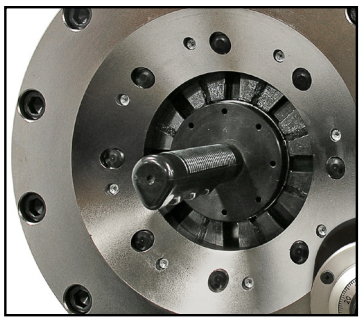
B



Align the studs of the Hydraulic Dies with the holes in the Master Dies and SLOWLY close the crimper head on the die set as shown in photo B.

Bring the crimper head to a fully closed position as shown in photo C.

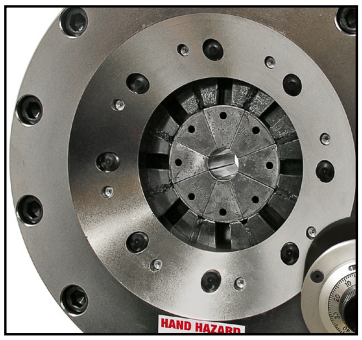
C



Remove the quick change tool as shown in photo D.

Note: The dies may also be inserted manually with the crimper head in the fully open position.

D

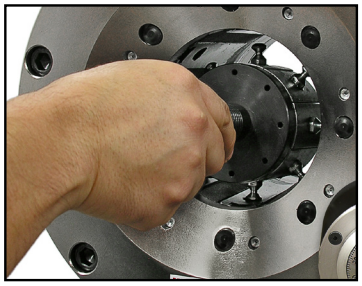


Proceed to the Crimping Instructions to set up the crimper for the hose and fitting being crimped.

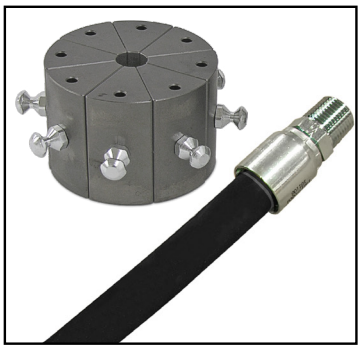
Note: **For Hydraulic Die Removal**, bring the crimper head to the fully closed position as shown in photo D.

Insert the quick change tool and open the crimper head releasing the Hydraulic Dies from their spring retention holes as shown in photo E.

E



CRIMPING PROCEDURE

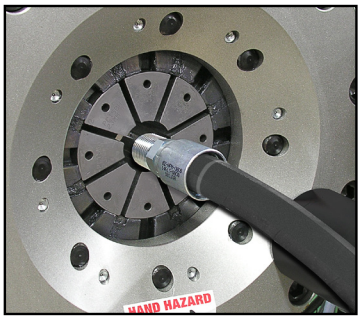


To begin, use your hose and fittings manufacturer's crimp specifications to select the correct hose, fitting, die and final crimp diameter for your project

Note: Prior to crimping the hose it is important to verify the insertion length. This number should be provided by your hose and fitting manufacture, or in your hose and fittings manufacturer's specifications manual.

Set the dial micrometer to the setting recommended by your hose and fitting manufacturer for the combination of hose and fitting being crimped, then lock the micrometer.

Micrometer Setting Example:
Each 100 on the Micrometer represents 1 mm above the closed diameter of the die set. For example, with a 50mm die installed and the Micrometer set at 250, the finished crimp diameter would be 52.5 mm.
(50mm + 2.5mm) = 52.5 mm

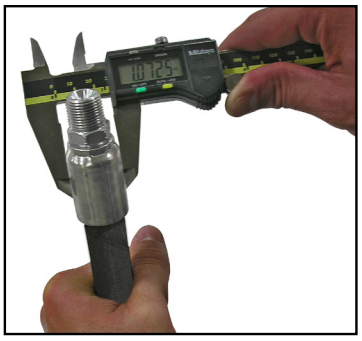


Insert the hose assembly from either direction into the crimper, taking care not to disturb the die set. Hold the assembly in place until the crimp is complete.

Note: Consult your hose and fitting manufacturer's specifications for the correct insertion depth for the hose and fitting being crimped.

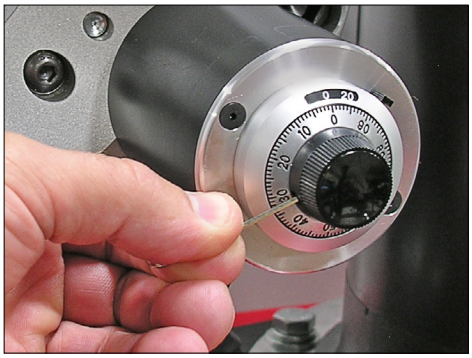
- Activate the crimp cycle by pressing and holding the green close button or the foot switch, until the crimper shuts off indicating the crimp is complete.

- After the dies retracted remove the hose assembly.

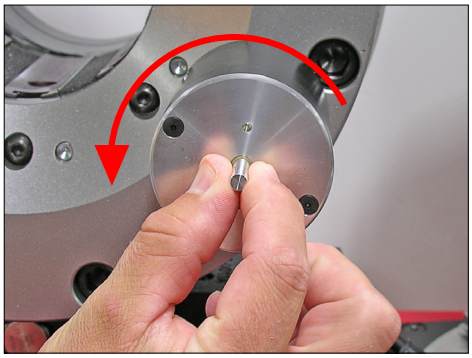


Check the crimp diameter of the finished assembly with calipers or micrometers, to be certain that it is within the specifications as outlined in your hose and fittings manufacturer's crimp specifications.

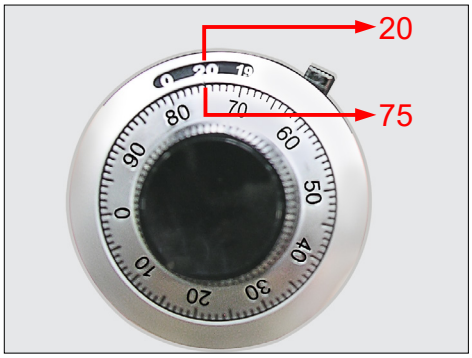
CALIBRATION



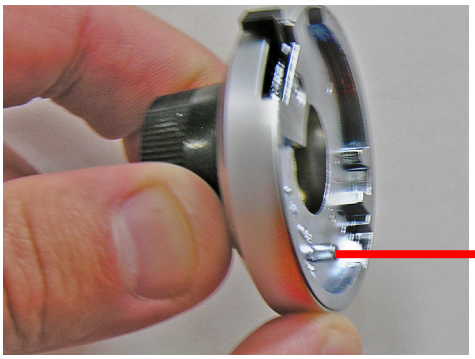
Step 1. Use a 0.050" allen wrench to loosen the set screw on the black knob to remove the micrometer dial.

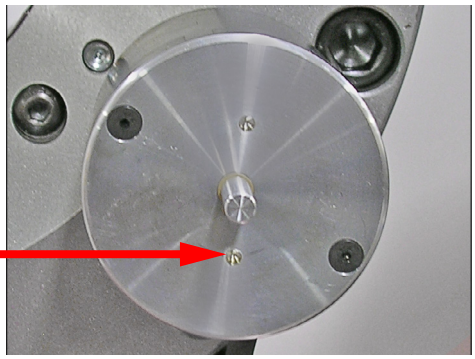


Step 2. Rotate the micrometer shaft counter clockwise until the shaft stops spinning.

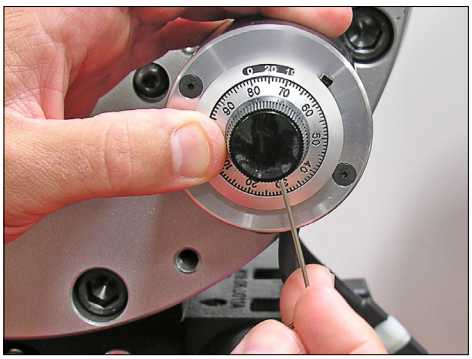


Step 3. Align the numbers on the dial so that 20 is shown in the black and 75 is shown in the silver.





Step 4. Align the post on the bottom of the dial to the bottom hole on the micrometer face as shown.



Step 5. Make sure the dial is sitting flat against the micrometer then retighten the set screw on the black knob.

Step 6. Load correct die set into crimper for your test crimp. Put the proper setting into the micrometer then perform test crimp. If crimp is still tight or loose follow steps 7 thru 10.

Step 7. If the crimp diameter is too tight by 0.004” spin the dial to 2 at the top and 00 at the bottom. Loosen the set screw on the black knob, spin the dial to 1 at the top and 90 at the bottom and then retighten the set screw. Return the dial to your setting and crimp another fitting.

Step 8. If the crimp diameter is too tight by 0.008" spin the dial to 2 at the top and 00 at the bottom. Loosen the set screw on the black knob, spin the dial to 1 at the top and 80 at the bottom and then retighten the set screw. Return the dial to your setting and crimp another fitting.

Step 9. If the crimp diameter is too loose by 0.004" spin the dial to 2 at the top and 00 at the bottom. Loosen the set screw on the black knob, spin the dial to 2 at the top and 10 at the bottom and then retighten the set screw. Return the dial to your setting and crimp another fitting.

Step 10. If the crimp diameter is too loosen by 0.008" spin the dial to 2 at the top and 00 at the bottom. Loosen the set screw on the black knob, spin the dial to 2 at the top and 20 at the bottom and then retighten the set screw. Return the dial to your setting and crimp another fitting.

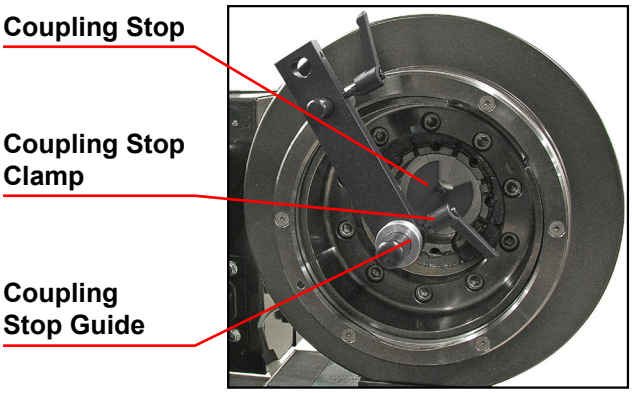
Step 11. If your crimp it outside of these numbers, or you need additional assistance please call technical service at 219.462.6128.

MANUAL BACK STOP SETUP

The Manual Back Stop eliminates guesswork allowing the operator to visually observe exactly where the crimp will be positioned on the fitting without the need for trial and error and product scrap due to poor crimp positioning.

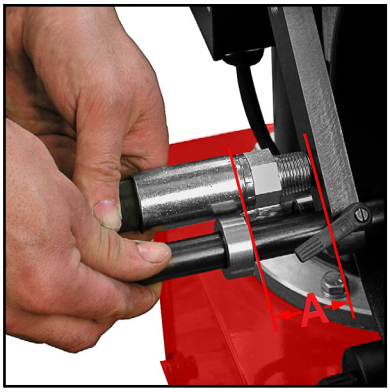
With the Coupling Stop retracted, load the appropriate set of dies and set crimp diameters as required.

With the dial micrometer at 0, bring the dies to a fully closed position.

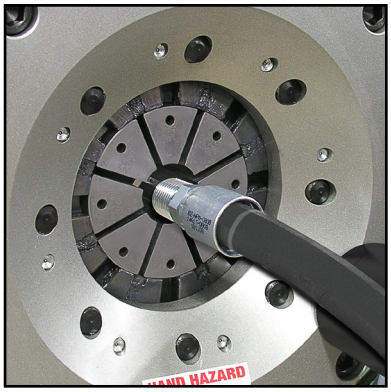


Loosen the Coupling Stop Clamp and position the Coupling Stop against the back face of the dies.

Slide the Coupling Stop Guide against the Coupling Stop Arm.



Hold the fitting against the Coupling Stop Arm withdraw the Coupling Stop Rod such that the Guide is aligned with the desired crimp position. Lock the Coupling Stop Clamp.



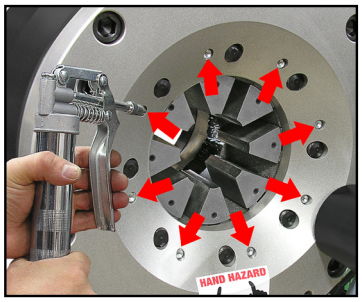
Position the fitting against the Coupling Stop and actuate the crimper in the normal manner.

The dimension from the face of the fitting to the crimp position will now be the dimension established in the previous step.

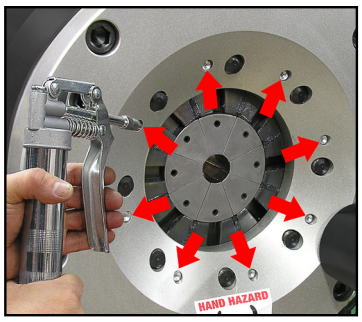
LUBRICATION AND MAINTENANCE

Proper lubrication is essential to prevent damage to the machine and to assure accurate crimping.

- Use the mini grease gun with flush fitting adapter with grease (supplied with the crimper) or a high-pressure moly grade grease can be used as well.
- Failure to lubricate the crimper can cause premature failure, loss of accuracy and may result in damage to the crimper.
- Lubricate the crimping head after each 250 - 400 crimping cycles or at the start of each shift if the crimper is used in a production setting.

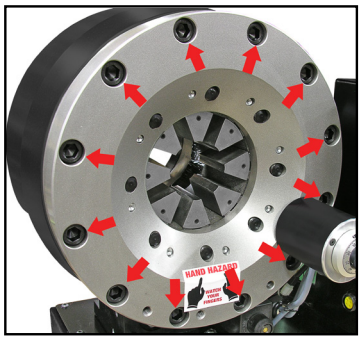


To begin, first bring the master dies to the fully opened position and lubricate the die fingers through the 8 lubrication fittings in the front flange face.

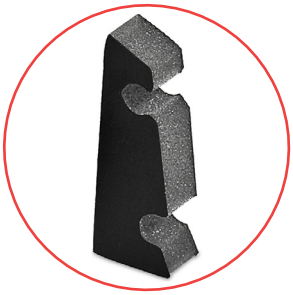


Next, bring the master dies to the fully closed position, and lubricate the master dies through the 8 lubrication fittings again.

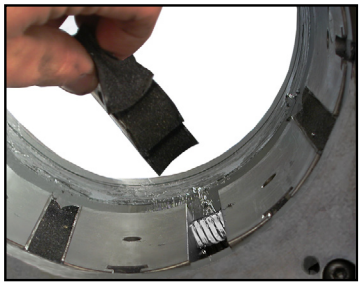
Note: Use only a high-quality moly-disulfide grease. Failure to do so may result in damage to the wearing surfaces.



Front flange bolts: Periodically, every 6-12 months depending upon usage, the front flange bolt torque should be checked. The correct torque is 199NM (147 ft-lbs).



The Protective Master Die Foam Pads: Periodically you need to check them for dirt, oil, and other debris. The protective pads
(as shown in photo #3) should be replaced if damaged, missing, or not retracting properly.



TROUBLESHOOTING

PROBLEM: CRIMPER RUNS BUT IS SLOW OR NON-FUNCTIONAL

- Check supply voltage to see that it matches the voltage specified on the tag attached to the crimper.
- If the crimper is connected to a three phase circuit, check all three legs of the circuit to be certain that all legs are hot.
- Measure the voltage to the crimper when the crimper is under load. Voltage should be a minimum of 90% of line voltage when the crimper is under load.

Many performance problems are the result of low voltage or inadequate electrical service.

- Check motor rotation and be certain that the motor rotates in the direction of the arrow on the motor housing. For three phase units rotation can be reversed by switching any two wires in the plug.
- The circuit in the crimper is protected by a thermal overload relay. If the relay trips after resetting it from the master power switch, call for technical service.

PROBLEM: MOTOR RUNS BUT FOOT SWITCH WILL NOT OPERATE

- Power to the secondary circuit is supplied from a 24 volt step down transformer. If the motor runs normally but the foot switch will not function check the 2 amp slo blow fuse located in the control box.

PROBLEM: CRIMPER WILL CLOSE ON FITTING BUT DOES NOT DEVELOP POWER TO COMPLETE THE CRIMP

- Fitting is to large for selected crimp die. Select a crimp die that is closer to final crimp diameter. Machine has built-in safety bypass to protect internal components from damage due to incorrect die selection.
- Check oil level. Position dies to the fully open position and check oil sight glass in rear of machine. Be sure the oil level is in the middle of the sight glass. Use ISO 32 or 46 weight hydraulic oil.

If problem(s) persist contact Customer Service for additional troubleshooting assistance

REPLACEMENT ACCESSORIES


Dial Micrometer Assembly
P/N:102941-38


Foot Pedal Assembly
P/N:104118


84mm Quick Change Tool
P/N:102572


Manual Back Stop
P/N:MBS-60

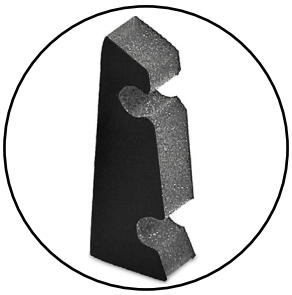

Die Rack 9 Station Die Holders
P/N:102616-84mm

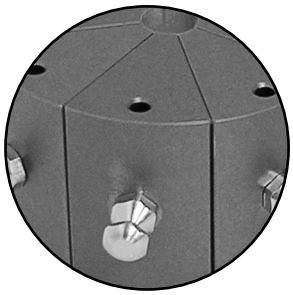

Crimper Stand 16 Station
Die Holders
P/N:101247-84


Mini Grease Gun w/ CRIMPX Die
Lubricant 3 oz mini grease tube
P/N:103889


CRIMPX Die Lubricant 3 oz mini
grease tube P/N:103887


CRIMPX Die Lubricant 14 oz
large grease tube P/N:103888


Protective Master Die Foam Pad
P/N:102531


Die Lock Pin For 84S/99S Die
Series P/N:101582


CustomCrimp® Notched Digital
Caliper IN/MM P/N:CC-Caliper

CUSTOMCRIMP® "NO-NONSENSE" WARRANTY STATEMENT

All Custom Crimp® Products are warranted to be free of defects in workmanship and materials for one year from the date of installation. This warranty ends when the product becomes unusable for reasons other than defects in workmanship or material.

Any Custom Crimp® Product proven to be defective in workmanship or material will be repaired or replaced at no charge. To obtain benefits of this warranty, first, contact Warranty Repair Department at Custom Machining Services at **(219) 462-6128** and then deliver via prepaid transportation the complete hydraulic product to:

ATTN: WARRANTY REPAIR DEPT.
Custom Machining Services, Inc.
318 North Co. Rd 400 East
Valparaiso IN 46383

If any product or part manufactured by Custom Crimp® is found to be defective by Custom Crimp®, at its option, Custom Crimp® will either repair or replace the defective part or product and return via ground transportation, freight prepaid.

Custom Crimp® will not cover any incoming or outgoing freight charges for machines sold outside The United States.

This warranty does not cover any product or part which is worn out, abused, altered, used for a purpose other than for which it was intended, or used in a manner which was inconsistent with any instructions regarding its use.

Electric motors are separately warranted by their manufacturer under the conditions stated in their separate warranty.

CRIMP

CUT TEST

CUSTOM CRIMP®, YOUR SINGLE SOURCE FOR HOSE ASSEMBLY PRODUCTS.

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