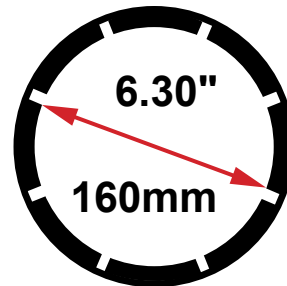


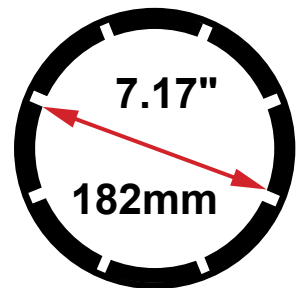


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Max Head Opening
W/O Dies



Max Head Opening
W/O Dies

**CC200 / CC400 CRIMPERS OPERATORS MANUAL
WITH DIAL MICROMETER STYLE ADJUSTMENT**



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SAFETY PRECAUTIONS



- READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER.
- CRIMPER CC200 CAN PRODUCE 340 TONS OF CRIMPING FORCE.
- CRIMPER CC400 CAN PRODUCE 265 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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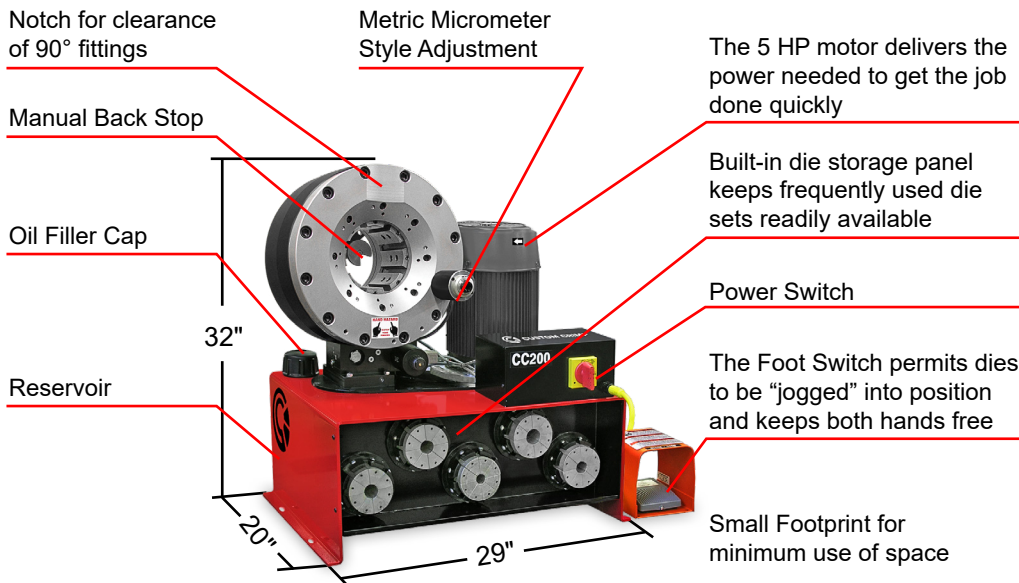
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CUSTOM CRIMP™

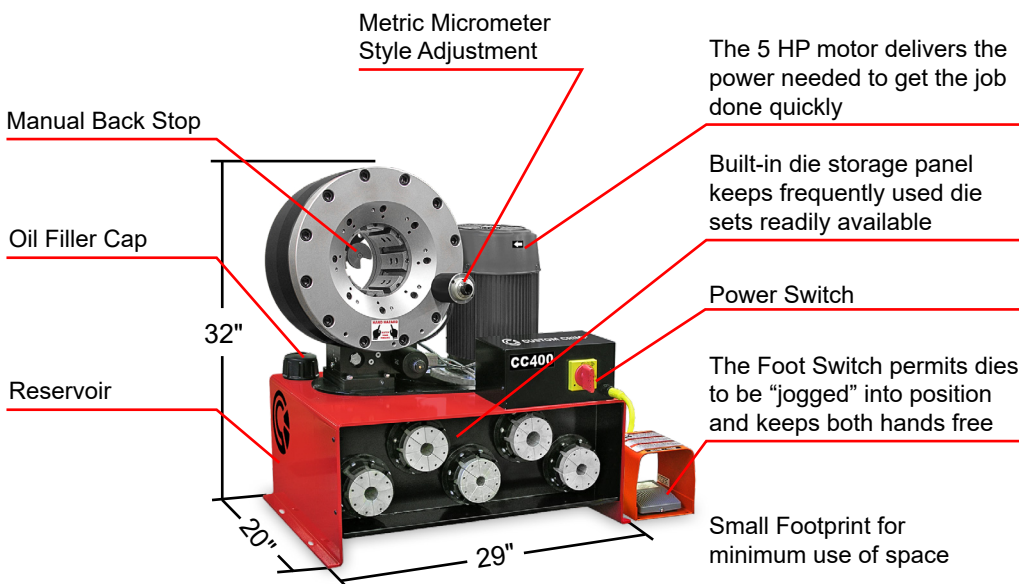
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COMPONENT PARTS & TECHNICAL DATA



CC200 Hydraulic Hose Crimper

CC200 Technical Specifications
Crimping Force: 340 Ton
Hydraulic Hose Capacity: 2 Spiral = 2½", 4 Spiral = 2½", 6 Spiral = 2"
Industrial Hose Capacity: 3"
Crimper Size: L: 20" x W: 29" x H: 32"
Crimper Weight: 635 lbs
Power: 5HP / 230V / 3Phase (Standard) 5HP / 440V / 3Phase (Optional) 5HP / 230 / 1Phase (Optional) 1HP / 12VDC & 24VDC (Optional)
Die series: 99S / 130S
Adjustability: Metric
Opening w/o dies: 160mm / 6.30"
Master die inside diameter: 130mm / 5.12"
Master die travel: 38mm / 1.5"
Reservoir capacity: 8 US Gallons
Oil type: ISO 46 Hydraulic Oil



CC400 Hydraulic Hose Crimper

CC400 Technical Specifications
Crimping force: 260 Ton
Hydraulic hose capacity: 2 Spiral = 2½", 4 Spiral = 2½", 6 Spiral = 1½"
Industrial hose capacity: 4"
Crimper size: L: 20" x W: 29" x H: 32"
Crimper weight: 660 lbs
Power: 5HP / 230V / 3Phase (Standard) 5HP / 440V / 3Phase (Optional) 5HP / 230 / 1Phase (Optional) 1HP / 12VDC & 24VDC (Optional)
Die series: 99S / 145S / 102819
Adjustability: Metric
Opening w/o dies: 182mm / 7.17"
Master die inside diameter: 145mm / 5.71"
Master die travel: 60mm / 2.4"
Reservoir capacity: 8 US Gallons
Oil type: ISO 46 Hydraulic Oil



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INITIAL SET UP & MAINTENANCE

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

Mount the crimper on a sturdy surface.

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

Electrical Requirements:

230 Volt 3 Phase Current (Standard)

440 Volt 3 Phase Current (Optional)

230 Volt single phase (Optional)

DO NOT RUN CRIMPER ON AN EXTENSION CORD.

Check to be certain that the motor rotates in the direction of the arrow shown on the motor housing. If motor rotation is opposite of the direction of the arrow, reverse any two hot wires in the electrical plug.

(NOTE: THIS IS APPLICABLE TO 3 PHASE CIRCUITS ONLY).

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

Check the oil level in the sight glass on the rear of the crimper. 8 U.S. gallons of ISO 46 hydraulic oil are required to completely refill the tank.

Oil can be drained from either of the two ports at the bottom of the tank.

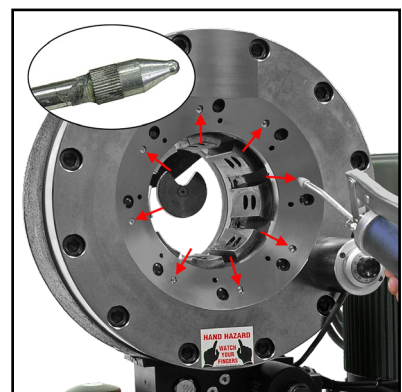
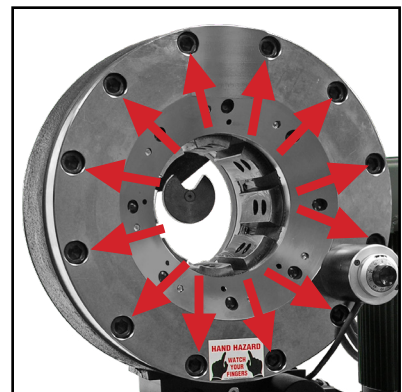
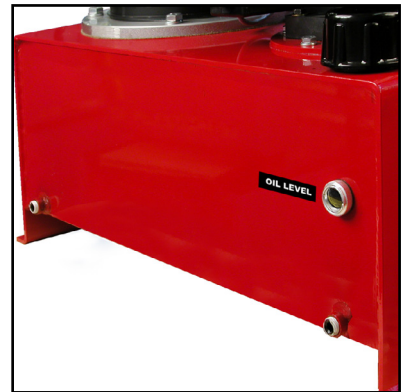
An additional oil cooler, while not normally required, can be plumbed into the two ports at the rear of the crimper.

Front Flange Bolts: Periodically, every 6-12 months depending upon usage, the front flange bolt torque should be checked. The correct torque is 332NM (245 Ft-Lbs).

Lubricate the crimping head after each 100 crimping cycles or at the start of each shift if the crimper is used in a production setting.

- Bring the master dies to the fully closed position and lubricate the die fingers through the 8 lubrication fittings in the front flange face.
- Bring the dies to the fully open position and lubricate all 8 fittings again.

Use CRIMPX Die Lubricant Grease or high quality moly-disulfide grease. Failure to do so may result in damage to the wearing surfaces.





INTERMEDIATE ADAPTER DIE INSTALLATION

- Dies are available for the CC200 crimper in 84S, 99S and 130S Series
- Dies are available for the CC400 crimper in 84S, 99S and 145S Series
- A set of 130mm O.D - 99mm I.D. Intermediate Dies is furnished with the CC200 crimper.
- A set of 145mm O.D - 99mm I.D. Intermediate Dies is furnished with the CC400 crimper.

The I.D. of the intermediate die must match the O.D. of the hydraulic die or accurate crimps are not possible.

INDUSTRIAL DIE INSTALLATION INTERMEDIATE ADAPTER DIE INSTALLATION

Turn on the crimper at the master power switch.

Bring the master dies to the full open position as shown in photo A, or to the position where the die removal tool can be inserted to release the retaining spring.

Insert the die removal tool in the release hole to release the retaining spring as shown in photo B.

Attach either an Intermediate Adapter Die or an Industrial Die to the Master Die as shown in photo C.

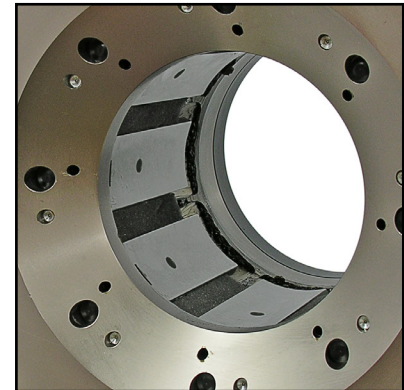
Note: The numbers stamped on the face of the die should face the operator.

Note that on some crimpers the master dies must be slightly closed in order to completely insert the die removal tool.

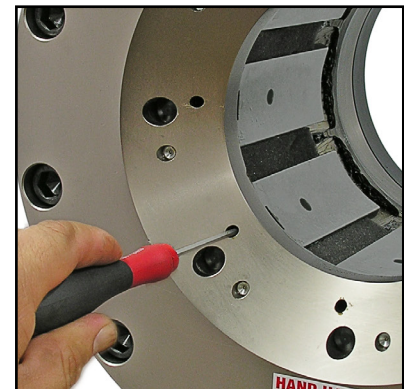
Mount all 8 dies in a similar manner as shown in photo D.

If 130mm O.D. Dies are being used, proceed to crimping Operating instructions and set up the crimper for the correct crimp diameter.

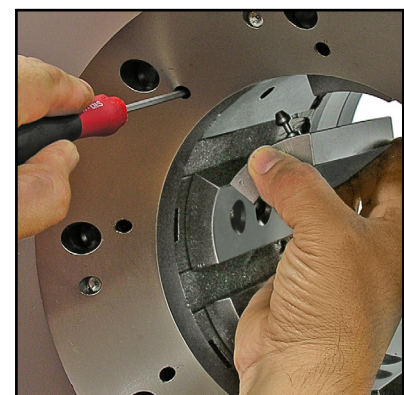
If Hydraulic Dies are being used, see Hydraulic Die Installation instructions.



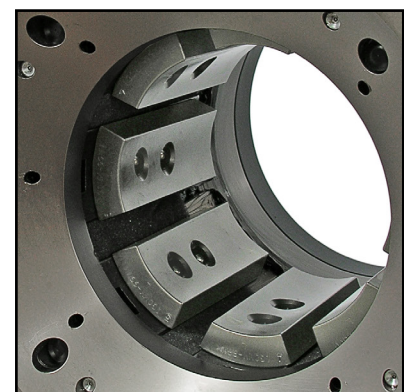
A



B



C



D



HYDRAULIC DIE INSTALLATION

Install Intermediate Adapter Dies as shown previously making certain that the Intermediate Adapter Die I.D. matches the Hydraulic Die O.D.

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

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

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

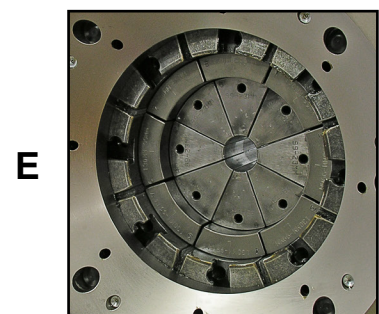
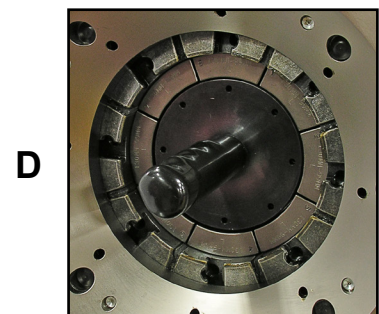
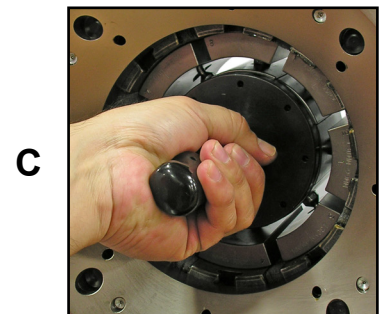
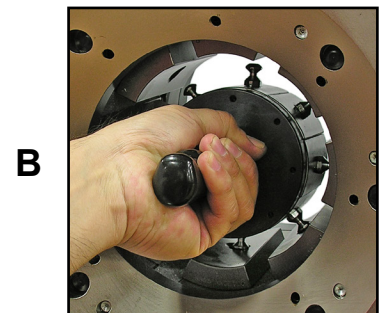
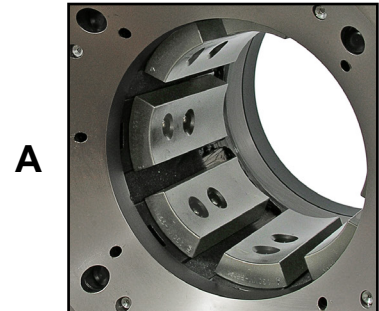
Remove the quick change tool as shown in photo E.

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

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

For Hydraulic Die removal, bring the crimper head to the fully closed position.

Insert the quick change tool and open the crimper head releasing the Hydraulic Dies from their spring retention holes.





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AccuStop™ COUPLING STOP SET UP

The AccuStop™ coupling 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.

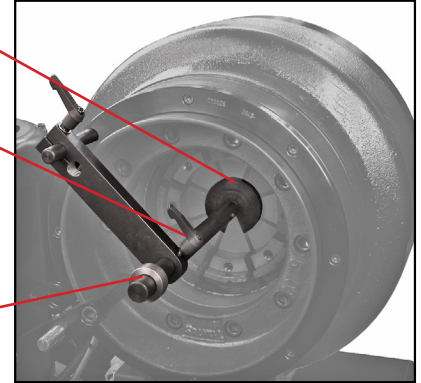
With the Coupling Stop retracted, load the appropriate set of dies and set crimp diameters as required.

With the crimper in the **MANUAL** mode, bring the dies to a fully closed position.

Coupling Stop

Coupling Stop Clamp

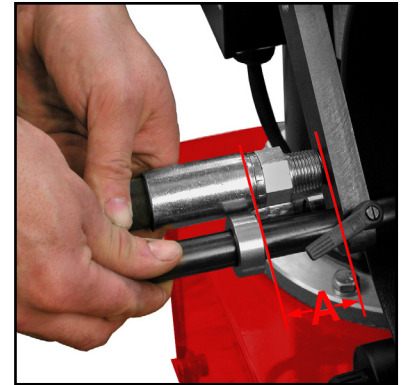
Coupling Stop Guide



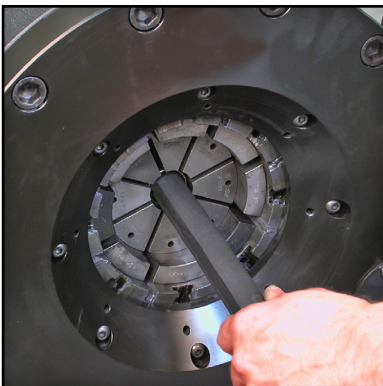
Loosen the Coupling Stop Clamp and position the Coupling Stop against the back face of the dies.



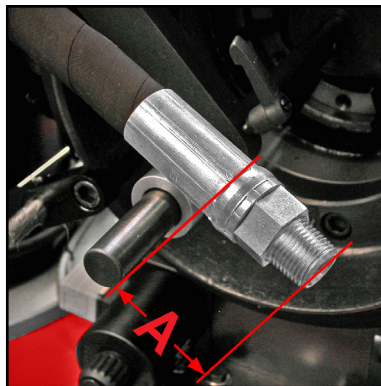
Slide the Coupling Stop Guide against the Coupling Stop Arm.



Hold the fitting against the Coupling Stop Arm with draw 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.



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CRIMPING

CRIMPING

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

The final crimp diameter will be the closed diameter stamped on the face of the die plus the number shown on the micrometer gage. See the micrometer setting example below:

Micrometer Setting Example

Each 100 on the micrometer dial represents 1 mm above the closed diameter of the die set. For example, with a 57mm die set installed and the micrometer set at 240 as shown in the photo, the final crimp diameter would be 59.4 mm (57mm + 2.4mm)

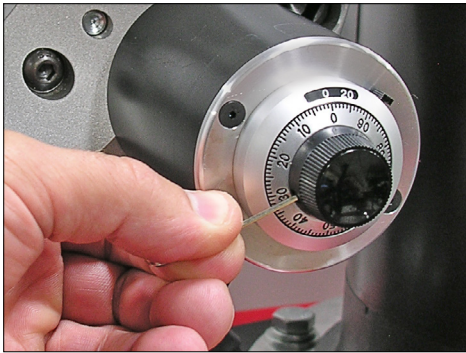
Insert the hose and fitting in the crimper head to the correct depth and press and hold the foot switch until the crimper shuts off. If the AccuStop™ coupling stop is being used make settings according to instructions.

Check the finished crimp diameter with calipers to be certain that it is within the hose manufacturer's specifications.





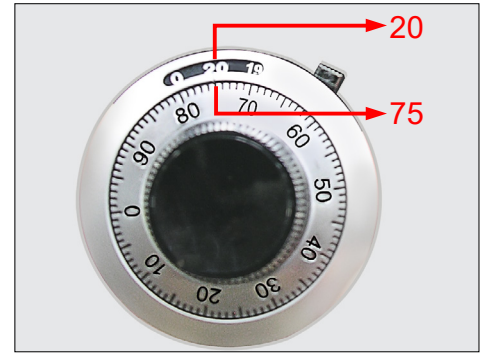
CALIBRATION



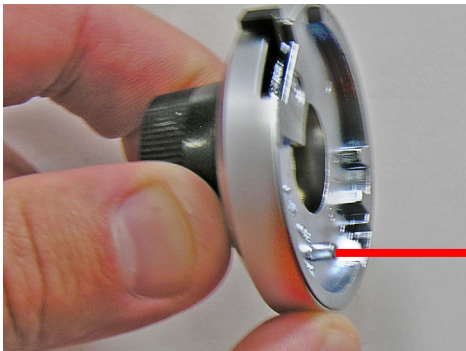
Step 1. Use a 0.050" allen wrench to loosen the set screw on the black knob to remove the micrometer dial.



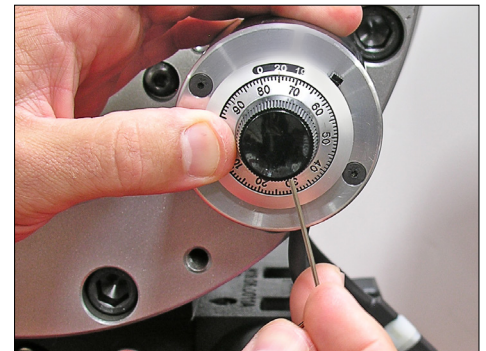
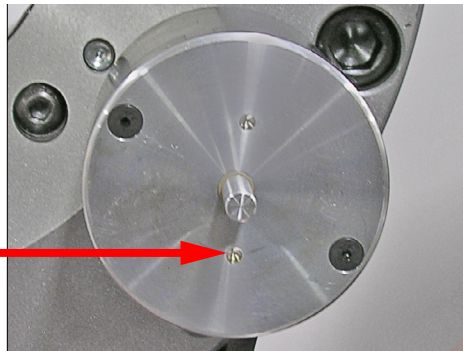
Step 2. Rotate the micrometer shaft counter clockwise until the shaft stops spinning.



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 loose 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 is outside of these numbers, or you need additional assistance please call technical service at 219.462.6128.



TROUBLESHOOTING

PROBLEM: CRIMPER RUNS BUT IS SLOW OR NON-FUNCTIONAL

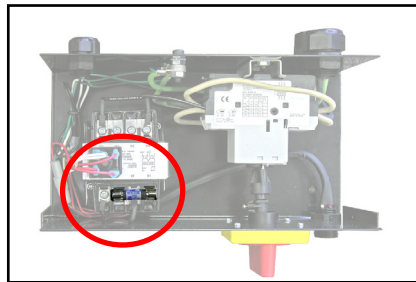
- Check supply voltage to see that it matches the voltage specified on the tag attached to the crimper.
- If the crimper is connected to a three phase circuit, check all three legs of the circuit to be certain that all legs are hot.
- Measure the voltage to the crimper when the crimper is under load. 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 as shown in the photo below.



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

- Fitting is too 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 gage 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



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CC200 / CC400 REPLACEMENT ACCESSORIES



Dial Micrometer Assembly
CC200 Crimper P/N:102941-450
CC400 Crimper P/N:102941-60



Foot Pedal Assembly
P/N:104118



99mm Quick Change Tool
P/N:102571



Intermediate Die Removal Tool
P/N:5691A13



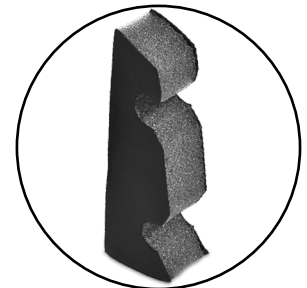
Manual Back Stop
P/N:MBS-60



Die Rack 9 Station Die Holders
P/N:102616-99mm



Crimper Stand 16 Station
Die Holders P/N:101247-99



Protective Master Die Foam Pad
CC200 Crimper P/N:102529
CC400 Crimper P/N:102530



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



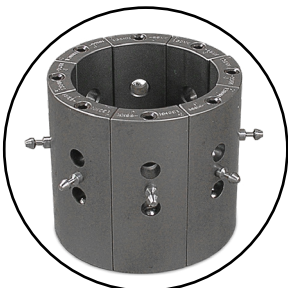
CRIMPX Die Lubricant 3 oz mini
grease tube P/N:103887



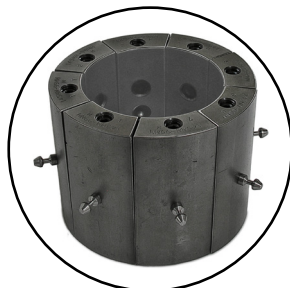
CRIMPX Die Lubricant 14 oz
large grease tube P/N:103888



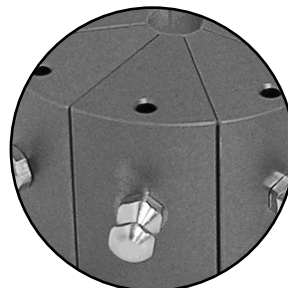
CustomCrimp® Notched Digital
Caliper IN/MM P/N:CC-Caliper



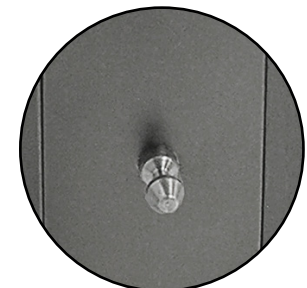
Adapter Die Set 130mm OD to
99mm ID P/N:101575



Adapter Die Set 145mm OD to
99mm ID P/N:103726



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



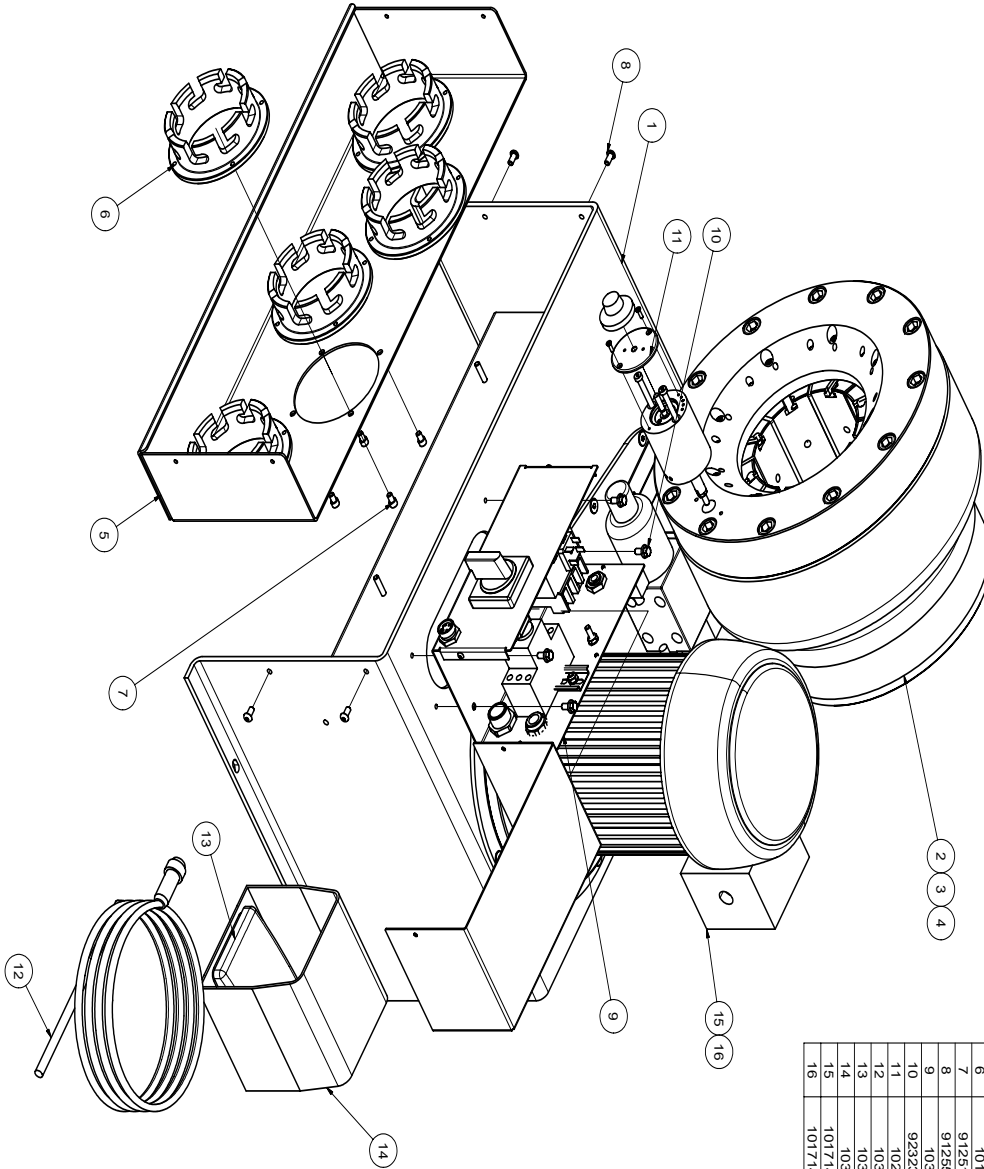
Die Lock Pin For 130S/145S
Die Series P/N:101403



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COMPONENT PARTS BREAKDOWN



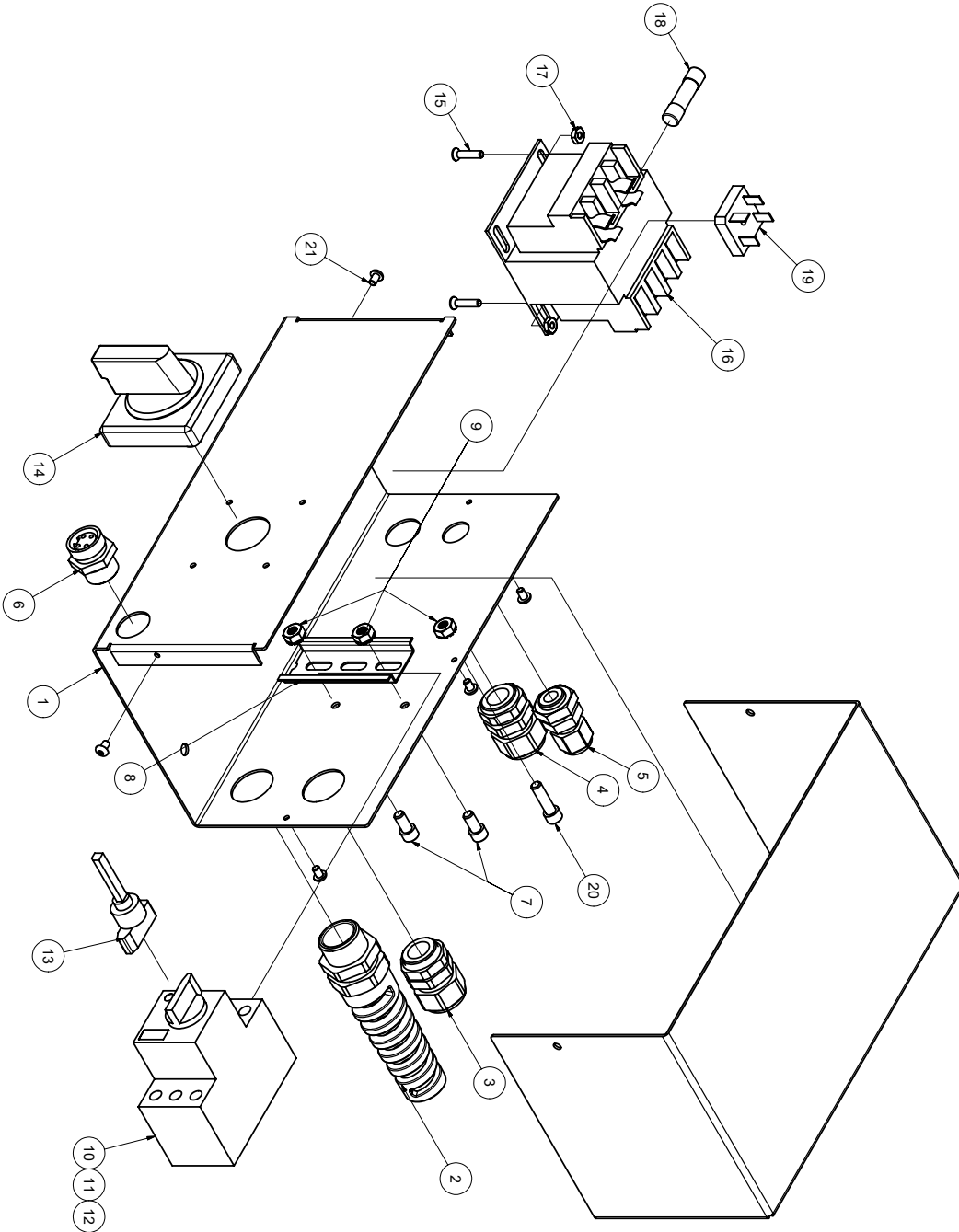
ITEM	PART NUMBER	DESCRIPTION	QTY
1	102618-WELD	CC Crimper Reservoir	1
2	102800	CC-50 Head Assembly	1
3	102513	CC-450 Head Assembly	1
4	102594	CC-38 Head Assembly	1
5	102946	Front Die Panel	1
6	101243	99MM Die Holder	5
7	91251A535	1/4-20 x 3/8" SHCS	20
8	91255A537	1/4-20 x 1/2 BHCS	4
9	103053	Electrical Box Assembly	1
10	92323A512	1/4-20 x 1/2 SHCS	4
11	102941	Dial Micrometer Assembly	1
12	103061	4 Pin Plug/12 Foot Cord	1
13	103058	Foot Switch	1
14	103054	Full Guard for Foot Switch	1
15	101714-5-8-3	5 HP/3 Ph/8cc Motor and Pump	1
16	101714-5-8-1	5 HP/1 Ph/8cc Motor and Pump	1



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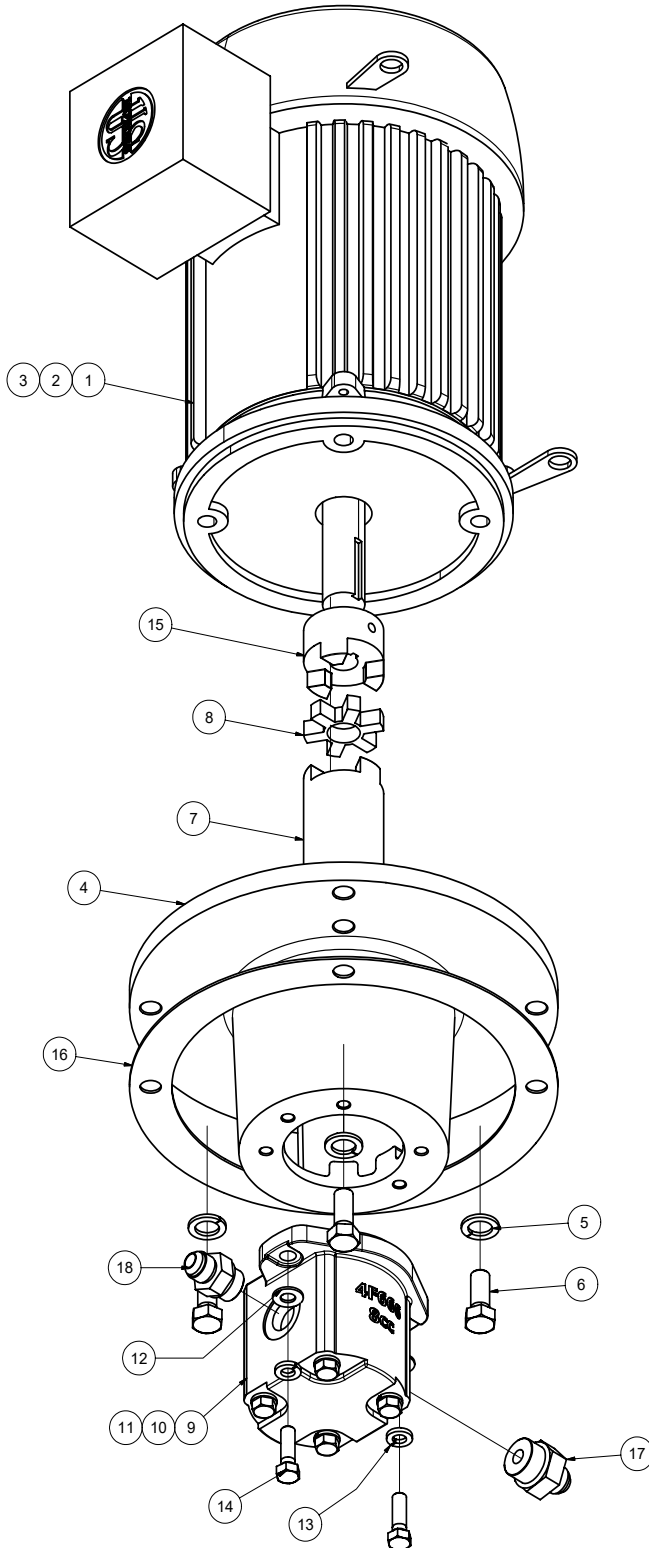
COMPONENT PARTS BREAKDOWN



ITEM	PART NUMBER	DESCRIPTION	STOCK NUMBER	QTY	ITEM	PART NUMBER	DESCRIPTION	STOCK NUMBER	QTY
1	102945	Electrical Box Metal Assembly	102945	1	12	103057-4603	Manual Starter with Overload - 460V 3Ph	BM3RHB-004	1
2	69915K65	Cable Strain Relief	69915K65	1	13	103059-LINK1.355L	Starter Switch Linkage	BZ0VYRL	1
3	69915K66	3/4 NPT Cord Grip	69915K66	1	14	103059	External Starter Handle and Linkage	BZ0VYRL	1
4	7807K64	Multi-Wire Cord Grip	7807K64	1	15	90273A197	#8-32 x 3/4 CS Screw	90273A197	2
5	69915K51	3/8 NPT Cord Grip	69915K51	1	16	103055	230/460-24VAC Transformer	PT500G	1
6	103060	4 Pin Receptical	1R4004A20A120	1	17	90480A009	#8-32 Nut	90480A009	2
7	91251A537	1/4-20 x 1/2 SHCS	91251A537	2	18	MEN2	Time-Delay 2 Amp Fuse	MEN2	1
8	3.125LDIN	3.125 Length DIN Rail	3.125LDIN	1	19	103056	Bridge Rectifier	MP1505	1
9	90675A029	1/4-20 Nut with Tooth Washer	90675A029	3	20	91251A541	1/4-20 X 7/8" SHCS	91251A541	1
10	103057-2303	Manual Starter with Overload - 230V 1Ph	BM3RHB-016	1	21	91255A190	#8-32 x 1/4 BHCS	91255A190	5
11	103057-2301	Manual Starter with Overload - 230V 1Ph	BM3RHB-032	1					



COMPONENT PARTS BREAKDOWN



CC Motor and Pump Assembly (101714)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	101541	5 HP 1800 RPM Motor	1
2	101540	7.5 HP 1800 RPM Motor	1
3	102994	10 HP 1800 RPM Motor	1
4	101539	Motor Mounting Flange	1
5	91101A033	1/2 Lock Washer	4
6	92865A714	1/2-13 x 1 1/4" Bolt	4
7	101543-01	Motor Coupling	1
8	101543-03	Coupling Spider Insert	1
9	101713	8cc Gear Pump	1
10	101542	11cc Gear Pump	1
11	102992	14cc Gear Pump	1
12	98023A31	3/8 Washer	2
13	91102A031	3/8 Lock Washer	2
14	92865A626	3/8-16 x 1 1/4" Bolt	2
15	101543-02	3/4" Shaft Coupling	1
16	101539-01	Flange Gasket	1
17	6400-8-12	8 JIC 37 M to 12 SAE Adapter	1
18	6400-8-10	8 JIC 37 M to 10 SAE Adapter	1

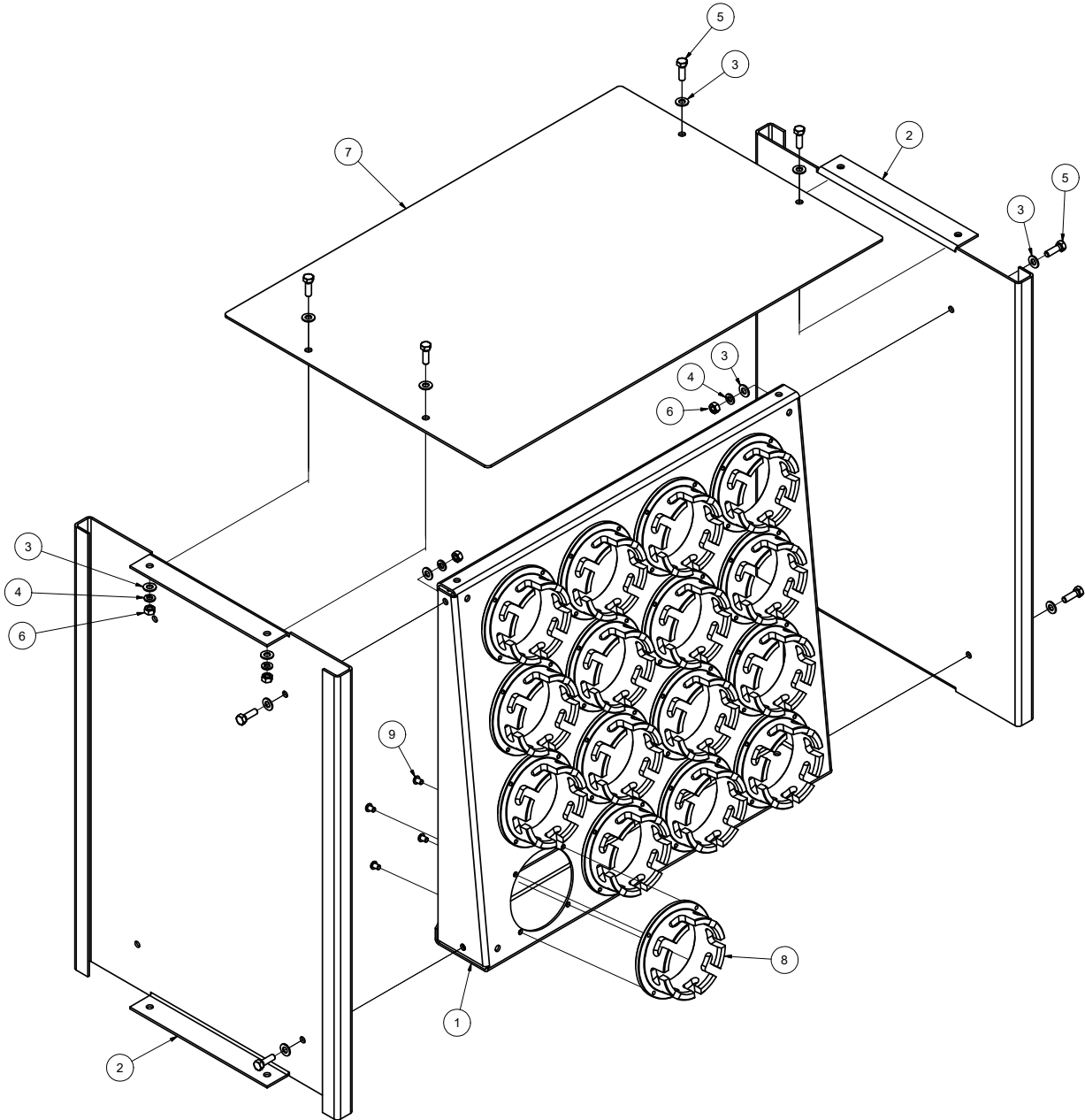
FINAL ASSEMBLY PART NUMBER CREATION:
 101714-"MOTOR HP"- "PUMP SIZE"- "PHASE (IF REQ'D)"
 EX. 7.5 HP MOTOR WITH 11cc PUMP: 101714-7.5-11
 EX. 5 HP MOTOR WITH 8cc PUMP, SINGLE PHASE: 101714-5-8-1



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COMPONENT PARTS BREAKDOWN



CC Crimper Table Assembly (101755)			
Item	Part Number	Description	Qty
1	101244	Die Panel	1
2	101246	End Panel	2
3	90108A030	5/16 Flat Washer	16
4	91102A030	5/16 Lock Washer	8
5	92865A581	5/16-18 X 1 Hex Bolt	8
6	95462A030	5/16-18 Hex Nut	8
7	101754	CC Crimper Table Top	1
8	101242	99MM Die Holder	16
8	101243	84MM Die Holder	16
9	91255A535	1/4-20 X 3/8 BHCS	64



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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**

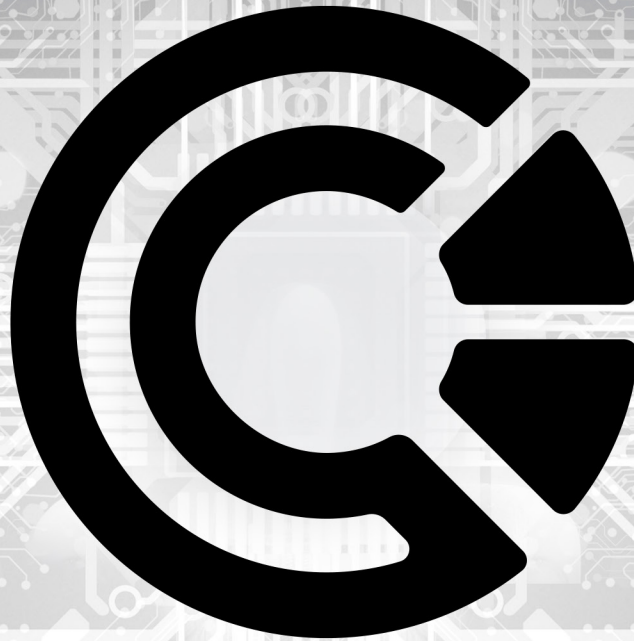
If any product or part manufactured by Custom Crimp® is found to be defective by Custom Crimp®, at its option, Custom Crimp® will either repair or replace the defective part or product and return via ground transportation, freight prepaid.

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.

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