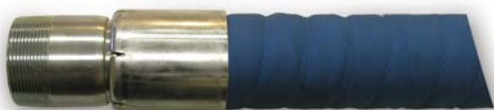


670-T / 660-T Ferrule Vise Hose Crimpers



The 660-T Manual and the 670-T Air operated foot pedal Ferrule Vise Hose Crimpers offer a cost effective solution for light duty hose crimping.



670-T / 660-T OPERATORS MANUAL



SAFETY PRECAUTIONS



SAFETY PRECAUTIONS



- READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING THE 670-T / 660-T FERRULE VISE CRIMPERS.
- 670-T FERRULE VISE HOSE CRIMPER CAN PRODUCE APPROXIMATELY 630 LBS OF CRIMPING FORCE @ 90 PSI.
- KEEP BOTH HANDS AWAY FROM PINCH POINTS.
- CONSULT HOSE AND FITTING MANUFACTURER'S SPECIFICATIONS FOR CORRECT CRIMP MEASUREMENTS.
- ALWAYS WEAR EYE PROTECTION WHEN OPERATING FERRULE VISE CRIMPER.

660-T / 670-T Ferrule Vise Hose Crimpers



The 660-T Manual and the 670-T Air operated foot pedal Ferrule Vise Hose Crimpers offer a cost effective solution for light duty hose crimping.



660-T Manual



670-T Air operated

FERRULE VISE DIES	STRAIGHT DIES	RIBBED DIES
Closed Dia. (Inch)	Part Number	Part Number
0.275	662-T-275	
0.310	662-T-310	
0.350	662-T-350	
0.375	662-T-375	664-T-375
0.400	662-T-400	664-T-400
0.425	662-T-425	664-T-425
0.450	662-T-450	664-T-450
0.475	662-T-475	664-T-475
0.500	662-T-500	664-T-500
0.525	662-T-525	664-T-525
0.550	662-T-550	664-T-550
0.575	662-T-575	666-T-575
0.600	662-T-600	666-T-600
0.625	662-T-625	666-T-625
0.650	662-T-650	664-T-650 666-T-650
0.675	662-T-675	666-T-675
0.700	662-T-700	666-T-700
0.725	662-T-725	666-T-725
0.750	662-T-750	666-T-750
0.775	662-T-775	666-T-775
0.800	662-T-800	666-T-800
0.825	662-T-825	666-T-825
0.850	662-T-850	666-T-850
0.875	662-T-875	666-T-875

FERRULE VISE DIES	STRAIGHT DIES	RIBBED DIES
Closed Dia. (Inch)	Part Number	Part Number
0.900	662-T-900	666-T-900
0.925	662-T-925	666-T-925
0.950	662-T-950	666-T-950
0.975	662-T-975	666-T-975
1.000	662-T-1000	666-T-1000
1.025	662-T-1025	666-T-1025
1.050	662-T-1050	666-T-1050
1.075	662-T-1075	666-T-1075H
1.100	662-T-1100	666-T-1100H
1.125	662-T-1125	666-T-1125H
1.150	662-T-1150	666-T-1150H
1.175	662-T-1175	666-T-1175H
1.200		666-T-1200H
1.225		666-T-1225H
1.250		666-T-1250H
1.275		
1.300	662-T-1300	
1.325		666-T-1325H

Wide variety of available dies in either ribbed or straight configuration. Custom die sets also available.

660-T / 670-T Ferrule Vise Hose Crimpers



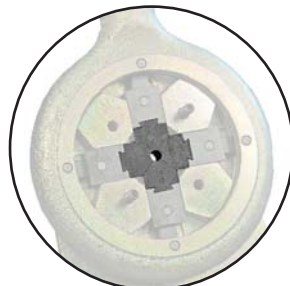
The Ferrule Vise Hose Crimper is an ideal solution for light duty repetitive hose crimping. With a wide variety of available dies in either ribbed or straight configuration these crimpers will consistently produce good looking accurate crimps time after time.

The positive over center action of the crimper assures a consistent and repeatable crimp diameter with no need for adjustment.

The rugged cast iron frame and base is designed to provide years of dependable service and both the 660-T and the 670-T models have mounting holes which permit them to be securely mounted to a work bench.



660-T Manual



Interchangeable Dies: Allow crimping of a wide variety of hose sizes.



Quickly Exchangeable Dies: Remove the cover plate and slip another die finger into position.



Adjustable Back Stop: Is ideal solution for fast, accurate, and repetitive crimps. (Available only for 670-T Air operated Ferrule Vise crimper).

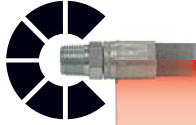


670-T Air operated



Ferrule Vise Dies: Wide variety of available dies in either ribbed or straight configuration. Custom die sets also available.

670-T Ferrule Vise Hose Crimper



670-T FERRULE VISE HOSE CRIMPER OPERATORS MANUAL

Mount the air operated 670-T ferrule vise crimper with base as shown in photo 1 to a sturdy work bench. Secure with bolts and nuts or a strong "C" clamp. Locate the foot pedal in a convenient location. Connect air pressure supply line to the foot pedal valve regulated between 60 to 90 psi.



Keep hands away from pinch points, and always wear eye protection when operating 670-T / 660-T ferrule vise crimpers.

OPERATION:

This ferrule vise crimper and dies are used for making low pressure hose assemblies with barbed inserts and aluminum ferrules. This tool is ideal for high volume assembly operations.

1. Cut hose squarely to desired length with a sharp cutter as shown in photo 2. (Do not use abrasive cut-off blade).

2. Select the appropriate size ferrule according to the hose O.D. as shown in photo 3. There should be some clearance for expansion of the hose end in the ferrule when the barbed insert is installed.

3. Insert the hose end into the aluminum ferrule until the hose bottoms out on the shoulder as shown in photo 4.

4. Insert the KF series brass barb fitting through the ferrule and into the I.D of the hose as shown in photo 5.

Note: Oil or water may be used to aid in the assembly process. Push the fitting inward until the hex of the barb fitting is flush with the ferrule as shown in photo 5.



Photo 1



Photo 2



Photo 3



Photo 4



Photo 5

670-T Ferrule Vise Hose Crimper



INSERTING FERRULE VISE DIES

5. Select dies that correspond to the ferrule size, “A” dimension as shown in photo 6.

(Ex: 500-81 ferrule, use 662-T-500 dies).

INSERTING FERRULE VISE DIES:

1. To access to the die holder blocks is accomplished by removing the wing nuts and cover plate as shown in photo 7.

2. Insert each die finger into the grooves of the die holders blocks as shown in photo 8.

3. Reinstall cover plate and finger tighten the two wing nuts as shown in photo 9.

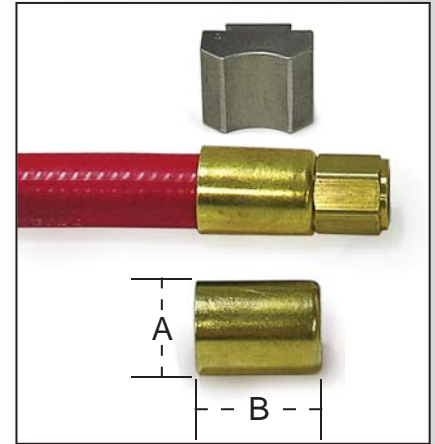


Photo 6

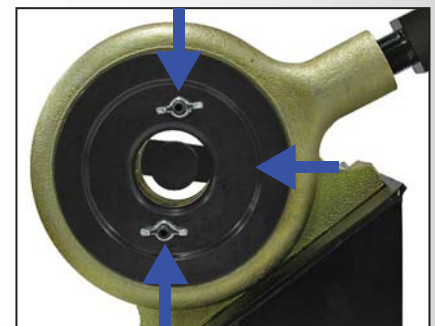


Photo 7

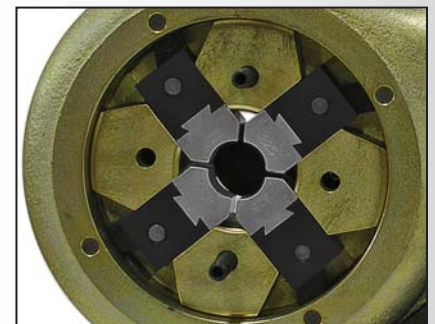
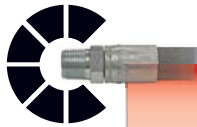


Photo 8



Photo 9

670-T Ferrule Vice Hose Crimper



CRIMPING PROCEDURE & MAINTENANCE

CRIMPING PROCEDURE:

1. Insert the hose assembly into the crimper and position the ferrule end flush with end of the dies as shown in photo 10.



Photo 10

2. Set the positioning fixture stop against the fitting end and lock with the wing nut as shown in photo 11.

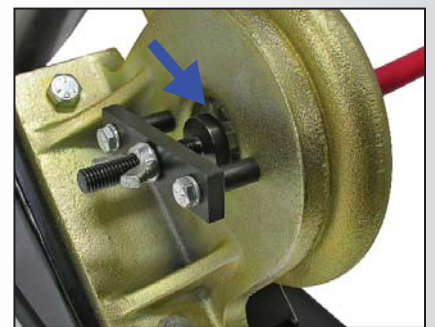


Photo 11

Note: On the shorter ferrules (23/32" long, "B" dimension see photo 6), the end of the ferrule must be located 1/4" past the end of the dies.

3. Complete the assembly by depressing the foot pedal as shown in photo 12, which will close the dies. Then, release the foot pedal to open the vise. Remove the finished assembly from the crimper.

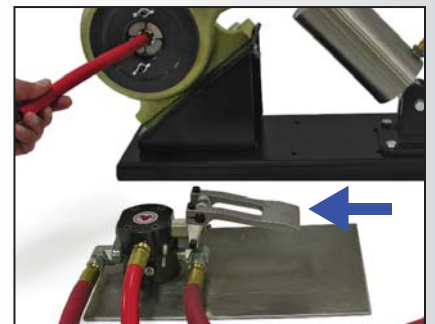


Photo 12

MAINTENANCE:

The 670-T crimper is lubricated at the factory. Periodic inspection, cleaning and lubrication of all moving parts is necessary for proper operation of the 670-T ferrule vice crimper.



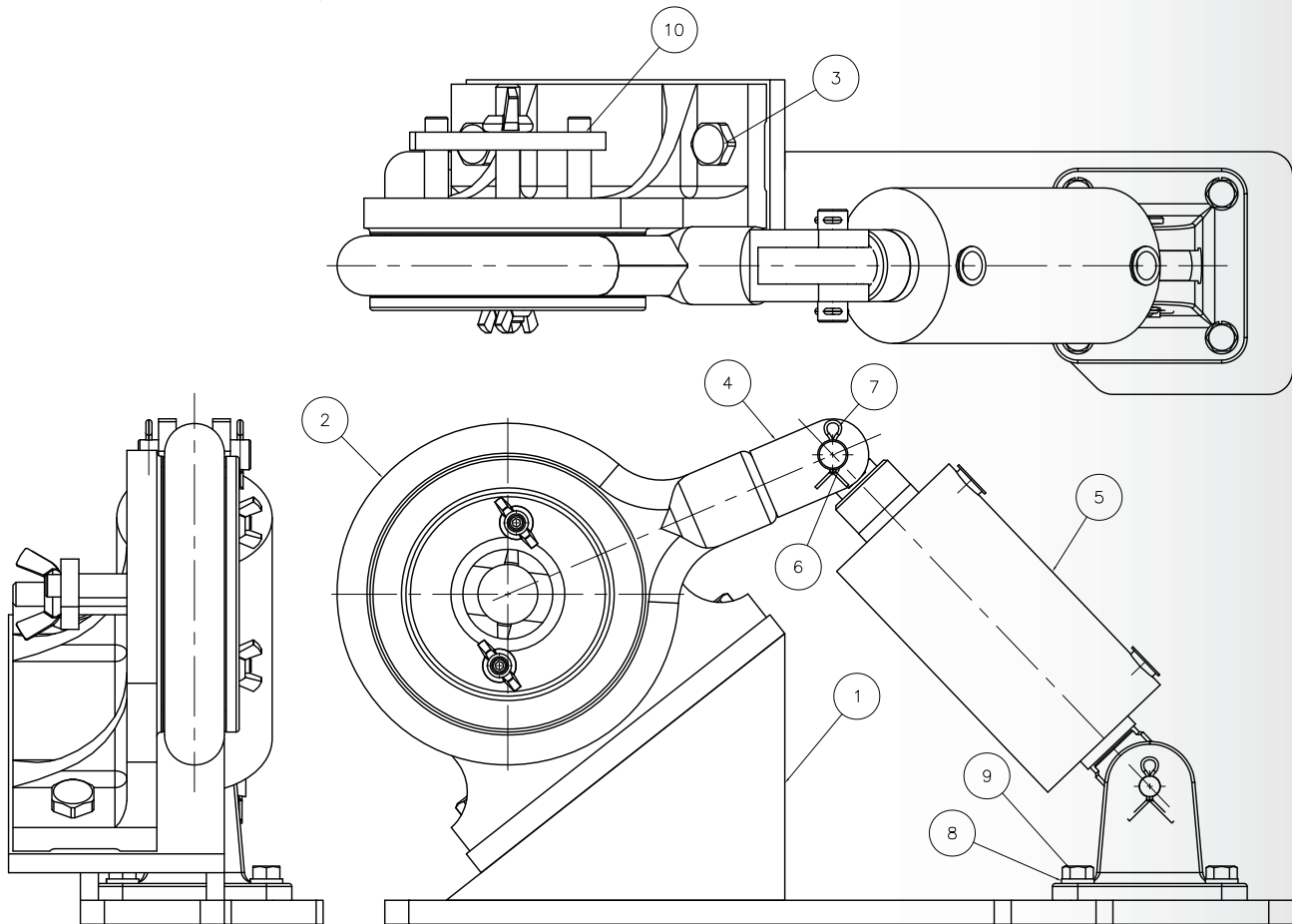
670-T Ferrule Vise Hose Crimper



670-T FERRULE VISE HOSE CRIMPER PARTS VIEW

670-T Ferrule Vise Crimper

Item	Part Number	Description
1	611202-23	Base Assembly
2	611202-10	Z660T Ferrule Vise W/O Handle
3	92865A714	1/2-13 X 1 1/4 Hex. Hd Screw
4	611202-1	Connecting Link
5	611202-28	670T-28 Cyl. Assy W/Bracket
6	611202-5	Connecting Pin
7	98338A180	Cotter Pin
8	91102A031	3/8 Lock Washer
9	92865A623	3/8-16 X 7/8 Hex. Hd Screw
10	611202-11	Positioning Fixture



660-T Ferrule Vise Hose Crimper



660-T FERRULE VISE HOSE CRIMPER OPERATORS MANUAL

Mount the 660-T ferrule vise crimper with base to a sturdy work bench.
Secure with bolts and nuts

OPERATION:

Making a hose assembly, and Inserting ferrule vise dies is the same procedure as the 670-T model.

MAINTENANCE:

The 660-T Ferrule Vise Crimper is lubricated at the factory. Periodic inspection, cleaning and lubrication of all moving parts is necessary for proper operation of the 660-T ferrule vice crimper.

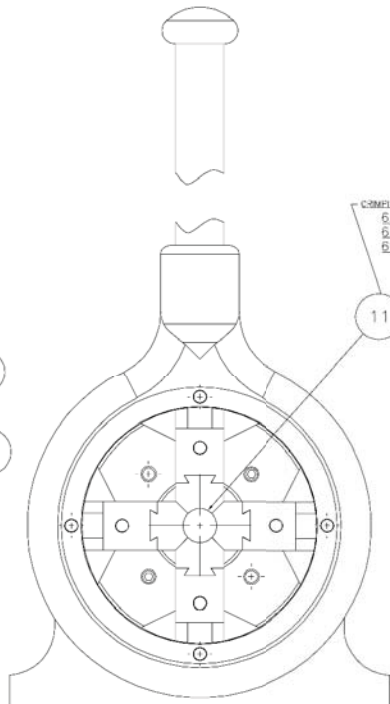
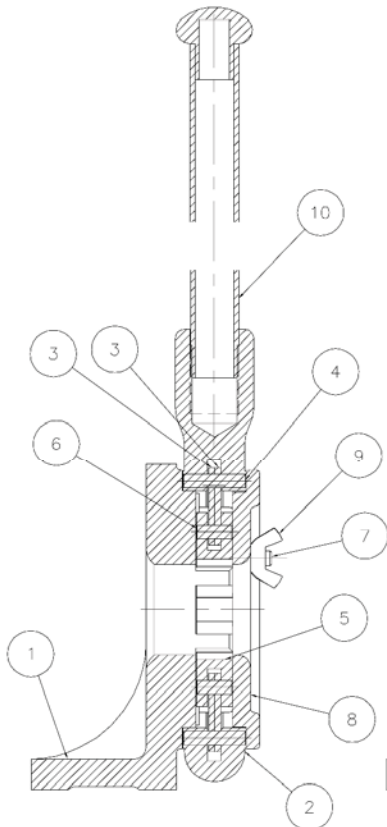


Note:-

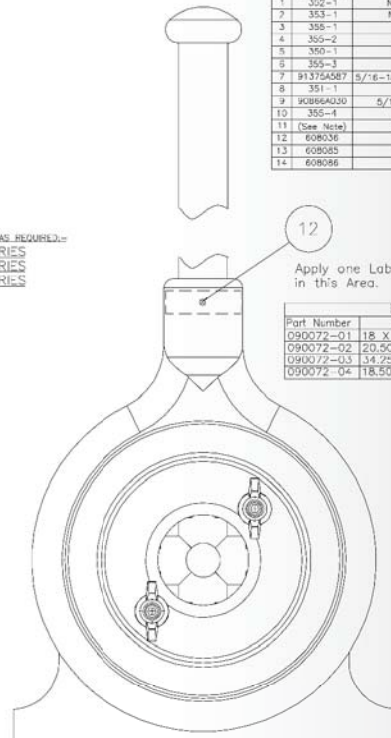
Oil All Moving Parts When Assembling.

When Assembling Components 350-1, 355-1, & 355-3 To 353-1, Use Slip-Fit Pins in Place of 355-2 and Check With Gage #1334. When Sub-assembly Gages Properly, Remove Slip-Fit Pins and Press Fit Assemble 355-2 Pins and Re-check with Gage #1334.

Apply 2 Labels (Item 12, One Each End) on Box 090072-01.



FRONT VIEW ASSEMBLY
(COVER PLATE REMOVED)



FRONT VIEW ASSEMBLY
(COVER PLATE IN PLACE)

660-T Manual Ferrule Vise Crimper	
Item/Part Number	Description
1	352-1 No.660 Crimping Vise Body
2	353-1 No.660 Crimping Vise Ring
3	355-1 Link
4	355-2 .281 X 1.281 Link Pin
5	355-3 Die Holder Block
6	355-4 .281 X .719 Link Pin
7	913154567 5/16-18 X 1 1/2 Cup Point Set Screw
8	351-1 No.660 Cover Plate
9	90866A030 5/16-18 Cover Plate Wing Nut
10	355-4 Crimping Vise Handle
11	(See Note) Crimping Die (As Req'd.)
12	660036 Label
13	660085 660T Instruction Sheet
14	660086 660T Parts List

CRIMPING DIES AS REQUIRED:-
622 SERIES
664 SERIES
666 SERIES

Apply one Label (Item 12) in this Area.

Boxing Components	
Part Number	Description
090072-01	18 X 10.80 X 5.75 Carton
090072-02	20.50 X 6.75 Liner
090072-03	34.75 X 4.75 Liner
090072-04	18.50 X 8.75 Liner

670-T / 660-T Ferrule Vise Hose Crimpers



670-T / 660-T FERRULE VISE HOSE CRIMPERS WARRANTY



CustomCrimp® “No-Nonsense” Warranty Statement

All CustomCrimp® 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 CustomCrimp® 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:

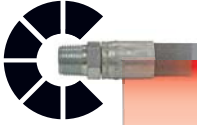
**ATTN: WARRANTY REPAIR DEPT.
Custom Machining Services, Inc.
318 North Co. Rd 400 East
Valparaiso IN 46383**

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

CustomCrimp® 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.



CONTACT US

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Products and services to support industry wide hose assembly needs.

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Fax: (219) 464-2773
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