



# CUSTOM CRIMP™

Innovating SMART Hose Assembly Solutions Since 1979



## IC485 Crimper With InfoCrimp™ Controller

Operators Manual

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# High-Level InfoCrimp™ Controller Capabilities

This version of the InfoCrimp™ controller is designed to take full advantage of the tablet interface and the connection to the cloud.

## InfoCrimp™ supports the following features enhanced features

### Ease of Use:

- Quick access to simple hydraulic and industrial crimping modes
- Optional semi and full automatic crimping modes
- New Touch screen interface with clear easy to read icon driven operations.
- Integrated measurement tools: Choice of USB wired or Bluetooth caliper provide direct measure input for crimp, diameters and industrial hose measurements.
- Integrated help and tutorial guides for easy feature reference.
- Ability to easily favorite crimp specifications, complete with notes, for easy reference and accurate repeat crimping.
- Ability to track and report on crimp measurements and crimp pressures.

### Integrated Crimping Tools:

- Integrated Industrial Crimp Calculator computes appropriate crimp diameter based on hose and fitting measurements.
- Support for foot petal and electronic backstop.

### Customizable:

- User account specific settings, such as choice of millimeters or inches as first choice for data entry.
- Create individual user logins (4 digit pins) to track usage and restrict machine configuration.

### Connected:

- Wi-Fi or Ethernet connections, for easy reference to manufacturer web content straight from the crimper, automatic configuration backup, and operations tracking.
- Ability to wirelessly update crimper software, providing up-to-date crimp specifications and new functionalities to crimper software.
- Reporting to provide various reports on assemblies, crimps and machine maintenance.

### Integrated Support and Maintenance:

- Simple on crimper support ticket creation, with enhanced technical diagnostics for quicker and more responsive help when needed most.
- Built-in tutorials and training, including feature tutorials on every screen
- Dynamic machine maintenance tracking and reporting, showing historical tracking of maintenance.
- Preventative maintenance alerts avoid machine downtime and costly repairs
- Detailed on-machine availability of machine capacities.

### Expansion Options:

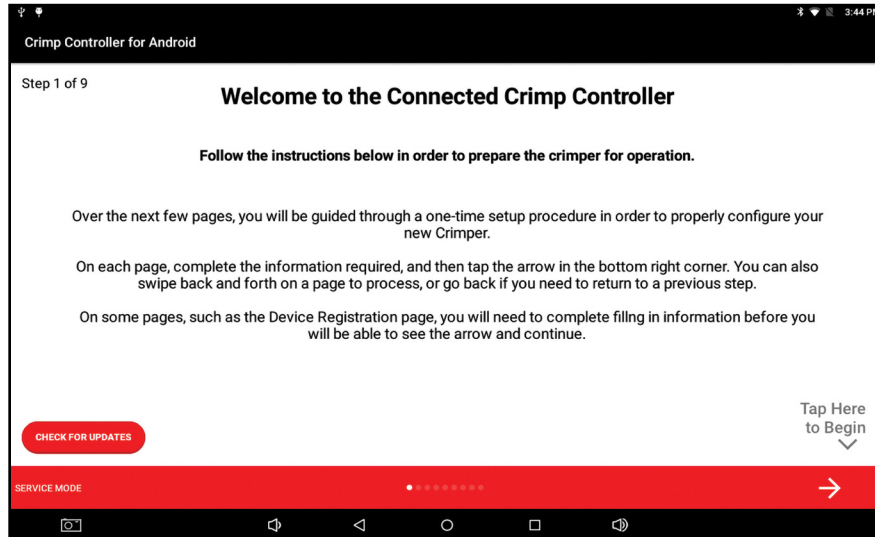
- Bluetooth 4.0 supports Bluetooth calipers and other approved accessories.
- 8GB on-device storage, for support of crimp specifications or other future applications.

# Initial Crimper Setup

## Overview

Before the crimper can be used for the first time, a brief setup process must be completed. This process sets some initial parameters, identifies this machine to the connection to the cloud system and allows the user to confirm the Terms and Conditions for use of this machine.

This process only needs to be completed once when the machine is installed. After that, the machine will power up and be ready for use.



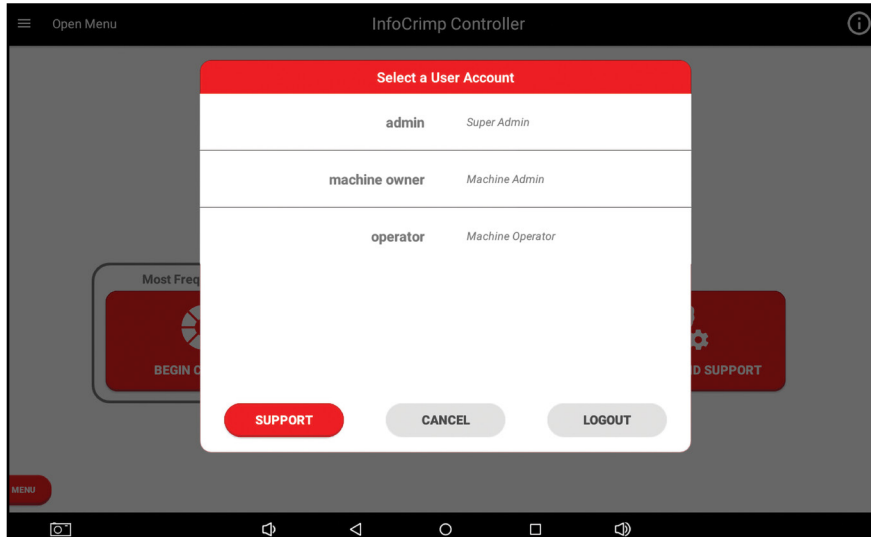


# Crimper Operations

## Logging In

To begin using the crimper, you must first login.

The crimper supports multiple users to allow tracking of activities as well as restrict access to some configuration type functions.



## Default User Accounts

The system comes with 3 users already created: admin, machine owner and user. Additional accounts can be added if required using the machine configuration menu.

Pin codes listed below are defaults, and can be changed by machine owners in the user menu:

If you have configured additional users, their names will appear in this list as well. Once you have logged in, you can begin using the crimper.

**Admin:** A private account for certified technicians and engineering maintenance.

**Machine Owner:** This account is an admin level account intended for the local administration. It has full access to all settings and functions. Default pin code is 9876.

**Operator:** This account has the permissions and capabilities to perform crimping operations but has limited access to settings and diagnostics/setup functions. Default pin code is 1234.

### Notes:

- The system will automatically log users out of the system after the machine is idle for 1 hour. This feature can be disabled or configured in the Machine Configuration screen.

# Navigating the InfoCrimp™ Controller

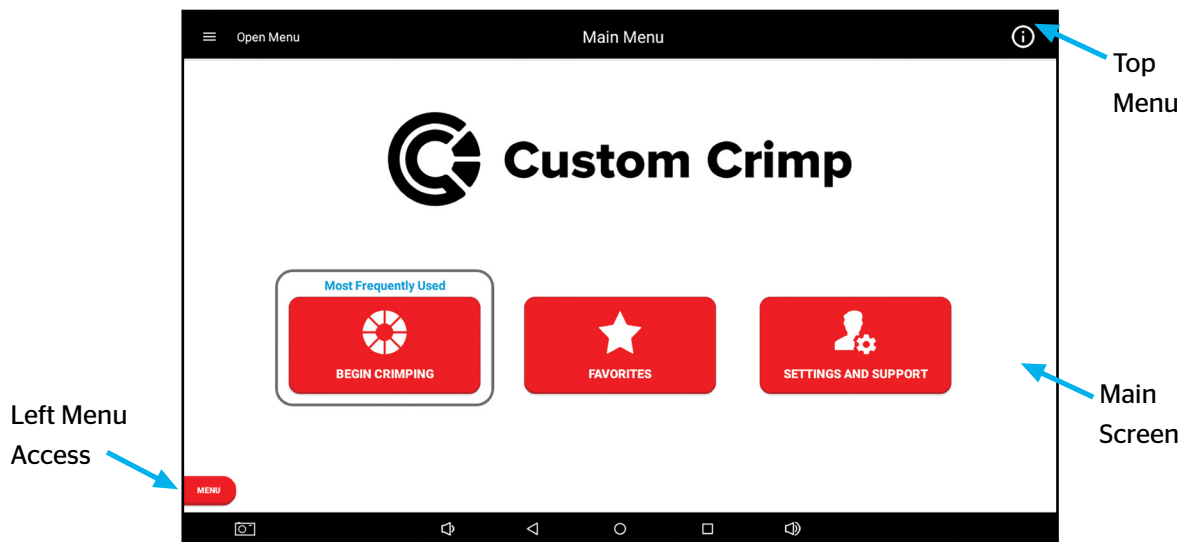
This section provide an introduction to the controller screens and functions that are common throughout the application.

## Basic Application Guide

This section outlines basic functions within the app that are common throughout the application. The basic outline and functionality is common throughout the application.

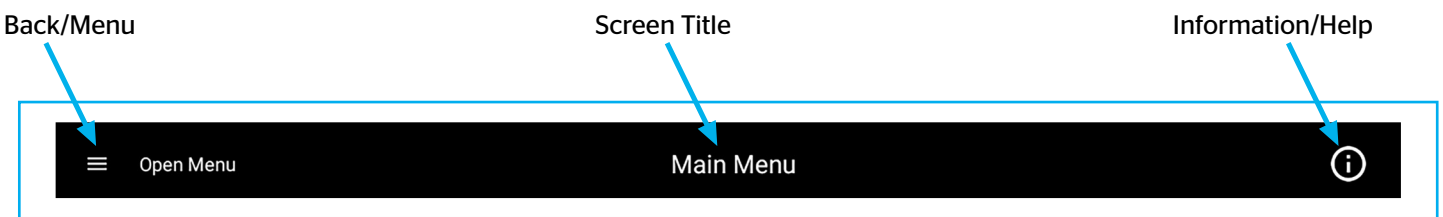
The screen is divided into the following sections:

- Top Menu:** This area of the screen provides high level application and controller information and access to help and settings.
- Main Screen:** Main screen with information and functions related to this screen (directly linked to the screen title).
- Left Menu:** Provides access to information and functions that need to be available from everywhere within the application. Access this with the menu button or by “swiping” left to right from the left side of the screen.



## Top Menu

The top menu includes a screen title, access to menus and information.



**Back/Menu:** This allows you to return one screen back (when you reach the main menu, it brings out the left slide out menu).

**Information / Help:** This option brings up help information relevant to the specific location within the app.

**Other:** There are a few other status indicates that may be helpful.

- Right section displays Wi-Fi strength, Bluetooth status and machine time.



## Left Slide-Out Menu

The left slide-out menu is available from anywhere within the crimp controller. It can be accessed by pressing the Menu button (always on the lower left side) or by swiping left from the left side of the screen.

Once opened, pressing anywhere on the right side of the screen (right of the left slide-out menu) will close the menu. The left menu contains information and functions that could be used at any time within the application.

## Left Slide-Out Menu Information

The left slide-out menu provides a quick status of the system. This information includes:

**Die Name:** Name of the die (if any) that is currently loaded in the machine:

**Position:** Position of the crimp head, relative to the die currently loaded.

**Target Diameter:** The crimp diameter target currently loaded into the machine. This is the diameter the crimper will close to given the size of the dies loaded into the machine.

**Previous Max Pressure:** Max pressure on the last successful crimp.

**Last Activity Sync:** The last time that the machine has synced with the cloud.



## Left Slide-Out Menu Functions

The left slide-out menu provides a functions that can be executed from anywhere at any time:

**Sync Activity:** Sync Activity sends the latest crimper activity to the connection to the cloud.

**Change Die Mode:** This mode allows the user to position the head to change dies. The machine tracks which dies are loaded and will update information according to which dies are loaded.

**Resume Previous Crimp:** Resume the last crimp setup. This enables a user to quickly restart the last crimp operation setup on the crimper.

**<User Name>** Change user function. This button displays the currently logged in user and provides a function to login as a different user.

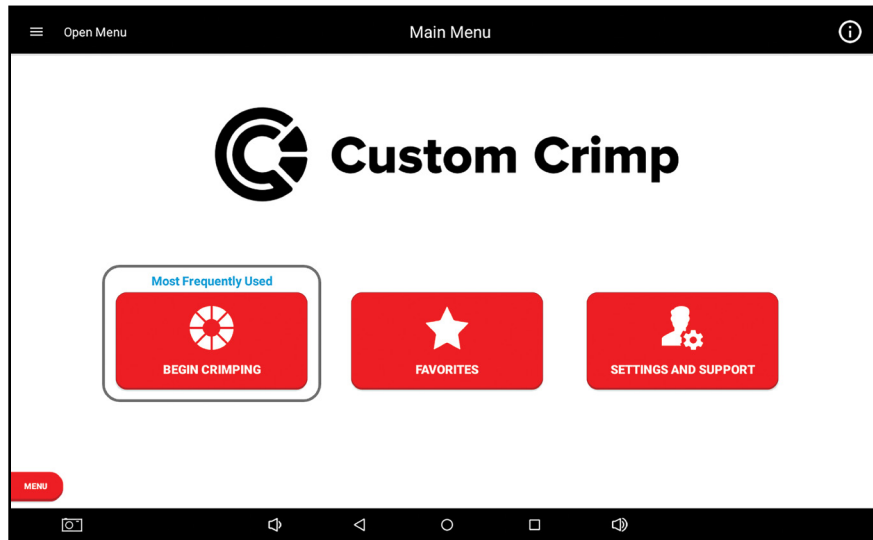
**Main Menu:** Return to the main menu of the application:

**Crimper Operations:** Return to the crimper operations menu:

**Technical Support:** Bring up the technical support function.

# Using the Main Menu

This screen provides the main functions of the crimper.



## InfoCrimp™ Controller Main Menu Screen Options

**Begin Crimping:** This button brings up the functions to perform hydraulic and industrial hose crimping.

**Favorites:** The Favorites button provides users with direct access to favorited crimp specifications.

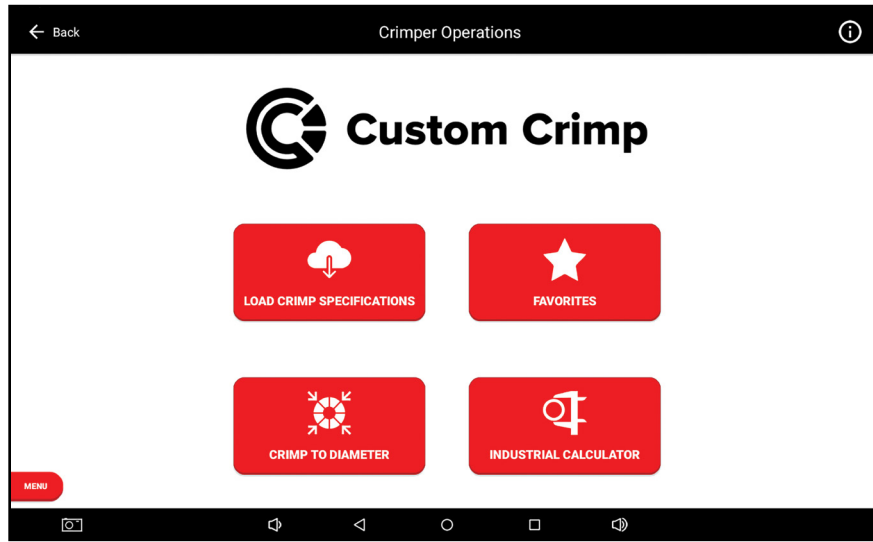
**Setting and Support:** This button brings up all of the support, information, training manuals and configuration options available for this machine.



# Crimper Operations

## Main Crimper Operations Screen

The Crimper operations screen is the starting point for setting up a crimping operation.



### Load Crimp Specifications:

### Favorites:

This function contains all of the crimp specifications that have been previously favorited.

### Crimp to Diameter:

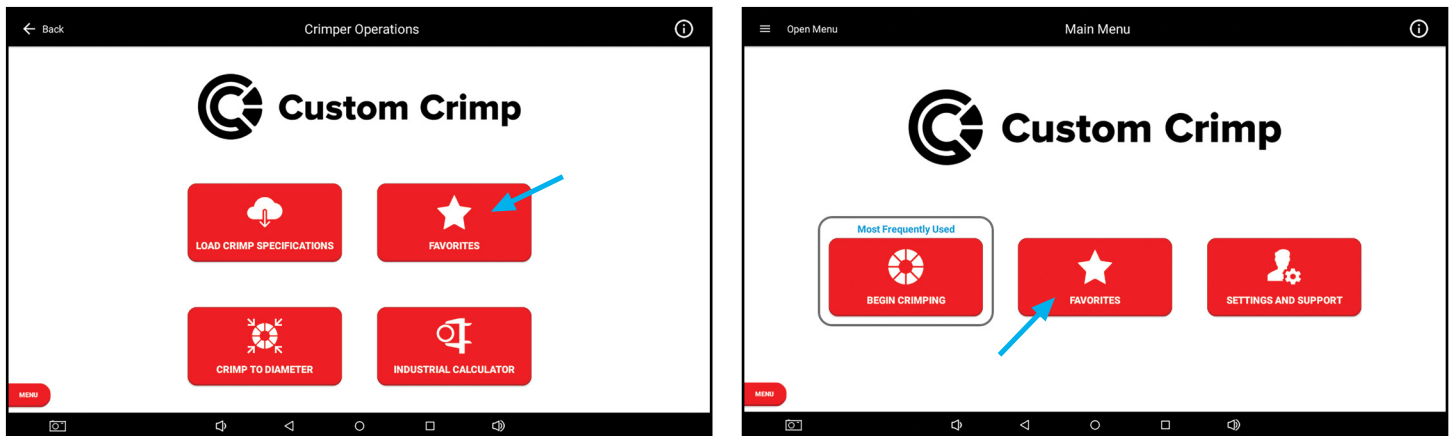
This function allows the user to directly enter a crimp diameter. Once entered, the system will commend a die and allow the user to proceed to Crimp Operations.

### MyCrimp® Industrial:

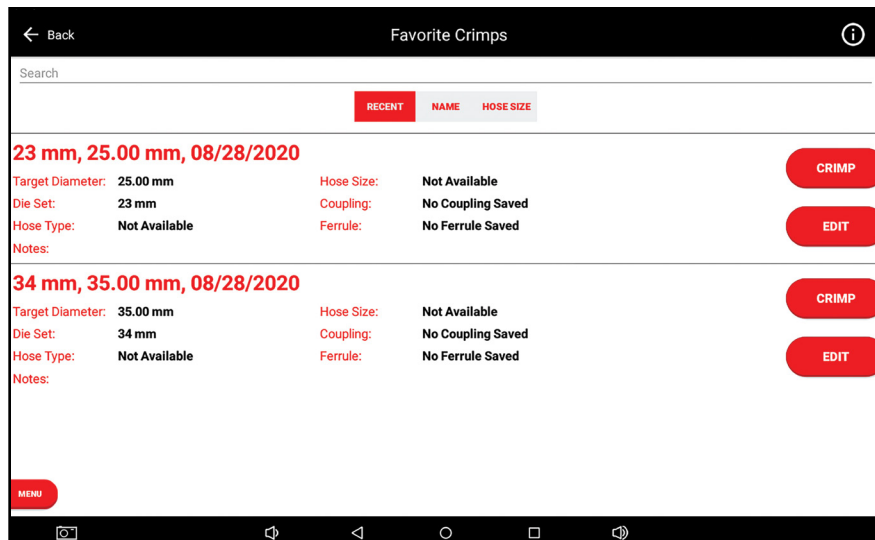
This brings up an Industrial crimp calculator. This calculator can determine the crimper setup based on the hose diameter or hose wall thickness.

# Favoriting Crimp Specifications

The user can save frequently crimped specifications for easy access and repeated crimping.

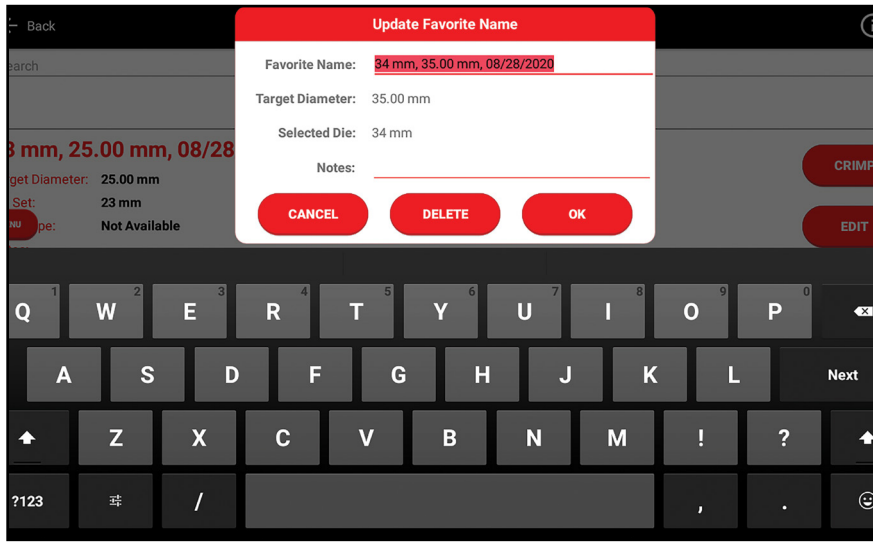


This brings up a list of all the favorites saved on this machine. This scrollable list can be sorted by date added (Recent), Favorite name (Name) or hose size.



## Editing a Favorite

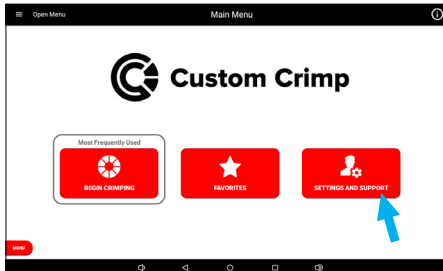
Users have the option to edit the Favorite name and notes. You also have the option to delete favorites that are no longer needed.



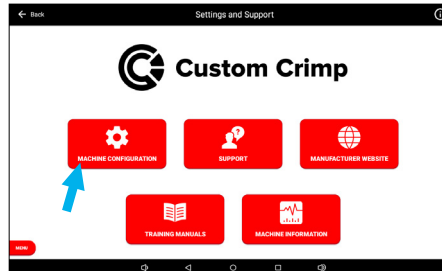
# InfoCrimp™ Specification Loader

The Crimp Specification Loader is a fast and simple way to load crimp specifications into your crimper. Using a CSV file prepared using Microsoft Excel, crimp specifications can be customized and added to your crimper in minutes. For more details, see the Crimp Specification Loader section.

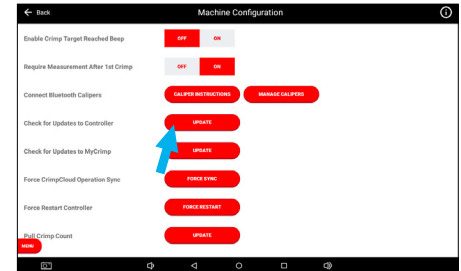
## Load Crimp Specs from USB



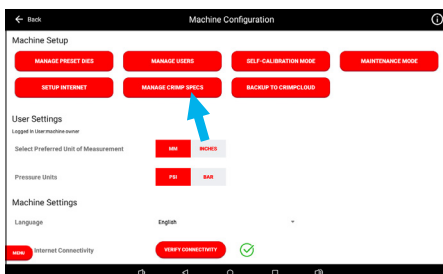
**Step 1:** Tap the **Settings and Support** button on the Main Menu screen.



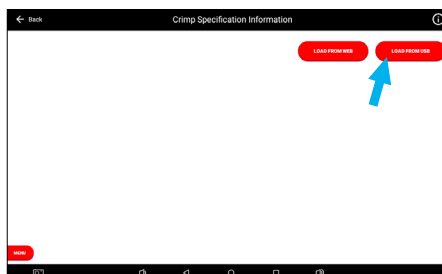
**Step 2:** Tap the **Machine Configuration** button on the Settings and Support screen.



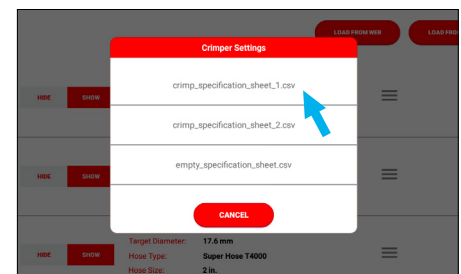
**Step 3:** Scroll down the page and check your **crimper for a software update**. You must be running version 1.1.8.0 or later to use the specification loader.



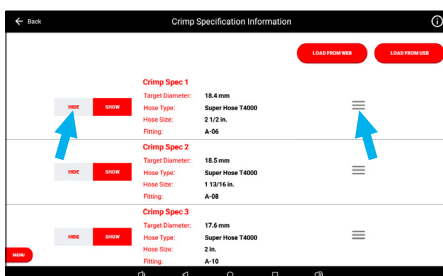
**Step 4:** Tap **Manage Crimp Specs** near the top of the Machine Configuration screen.



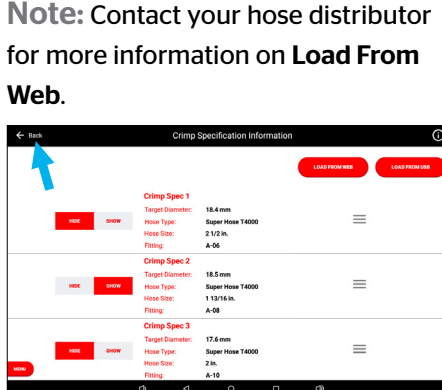
**Step 5:** Ensure USB is plugged into the USB port located next to the Emergency Stop on the controller housing then tap **Load From USB** in the top right corner of the Manage Crimp Specs screen.



**Step 6:** Select your **Crimp Spec CSV File** from the dialog.

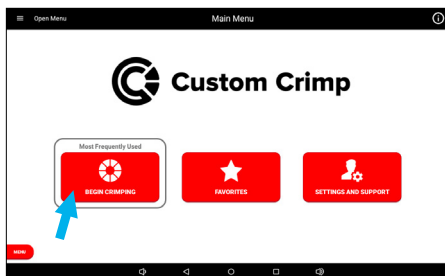


**Step 7:** Toggle on or off any crimp specs with the **Hide** or **Show** buttons. You can sort and reorder crimp specs by tap and holding the grab handle icon then dragging to your desired position and letting go.



**Step 8:** Tap the **Back** button in the top left of the screen until the Main Menu is reached.

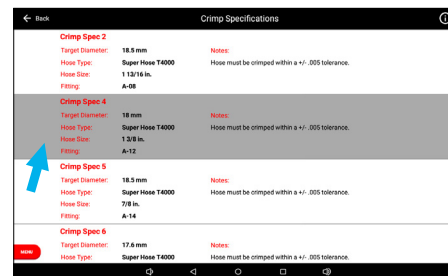
# Crimping Loaded Crimp Specs



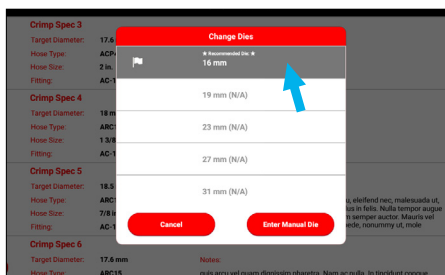
**Step 1:** Tap the **Begin Crimping** button on the Main Menu screen.



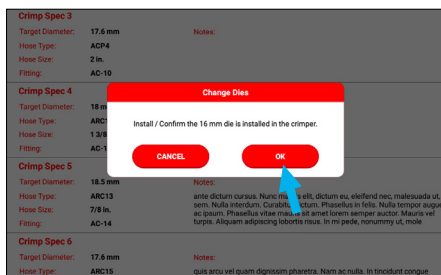
**Step 2:** Tap the **Load Crimp Specifications** button on the Begin Crimping screen.



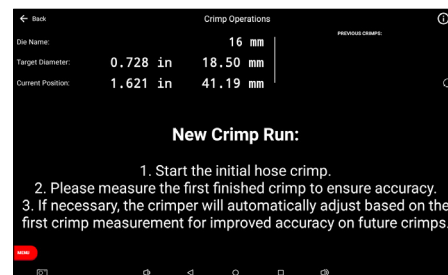
**Step 3:** Scroll through the loaded crimp specifications and tap a **Crimp Spec** to begin crimping.



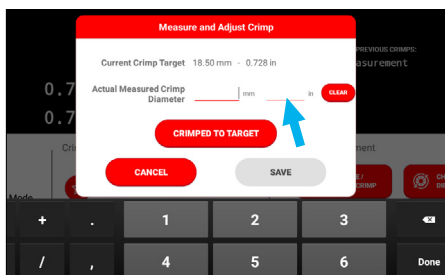
**Step 4:** Tap and select the appropriate die or enter a manual die.



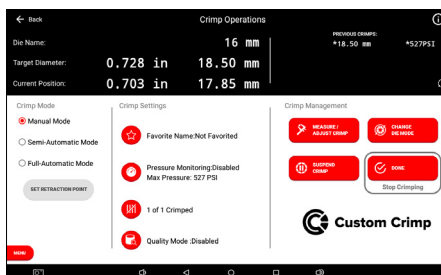
**Step 5:** Insert the selected die and tap **OK** when finished installing the die.



**Step 6:** Follow the **New Crimp Run** instructions that have appeared on the opening screen of Crimp Operations.



**Step 7:** Enter the measured crimp diameter for adjustment or select **Crimped To Target** if target diameter was met.



**Step 8:** The crimp operations screen will appear and the **Spec** is ready to continue the crimp run.



# Formatting CSV Crimp Specs

1	Name	Hose Type	Fitting Type	Hose Size	Target Diameter	Die Name	Notes
2	Example Crimp Spec 1	SuperHose - SAE 100R5	A-04	3/16"	18.4 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
3	Example Crimp Spec 2	SuperHose - SAE 100R5	A-08	1 13/16"	18.5 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
4	Example Crimp Spec 3	SuperHose - SAE 100R5	A-10	2"	17.6 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
5	Example Crimp Spec 4	SuperHose - SAE 100R5	A-12	1 3/8"	18 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
6	Example Crimp Spec 5	SuperHose - SAE 100R5	A-14	7/8"	18.5 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
7	Example Crimp Spec 6	SuperHose - SAE 100R5	B-04	1 1/8"	17.6 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
8	Example Crimp Spec 7	SuperHose - SAE 100R5	B-05	3/16"	18.6 16 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
9	Example Crimp Spec 8	SuperHose - SAE 100R5	B-06	1/8"	38.4 34 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
10	Example Crimp Spec 9	SuperHose - SAE 100R5	B-08	1 1/2"	38.5 34 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.
11	Example Crimp Spec 10	SuperHose - SAE 100R5	B-10	13/32"	37.6 34 mm		SAMPLE CRIMP SPECIFICATION - DO NOT USE ON HOSE OR FITTINGS. For more info visit CustomCrimp.com for more details.

**Step 1:** Open the **example\_crimp\_specification\_sheet.csv** template file provided by Custom Crimp®.

**Step 2:** Edit or change any necessary data within each of the data fields.

**Name:** Enter the desired name of the crimp spec.

**Hose Type:** Enter the hose type if applicable.

**Fitting Type:** Enter the fitting type if applicable.

**Hose Size:** Measure and enter the hose outer diameter.

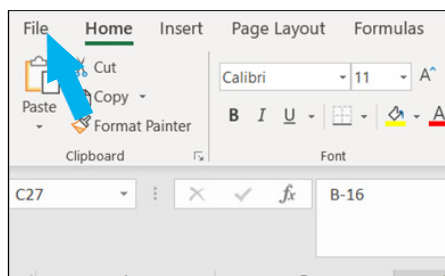
**Target Diameter:** Enter the desired target diameter in millimeters.

**Note:** **Target diameter must be in millimeters and must not include units of measure.**

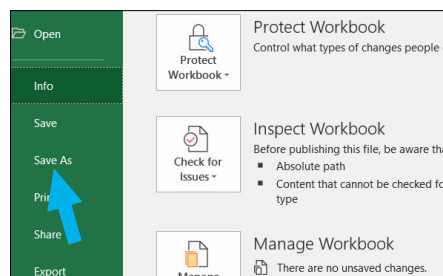
**Die Name:** Enter the recommended die name.

**Note:** **Must match die name setup on the machine.**

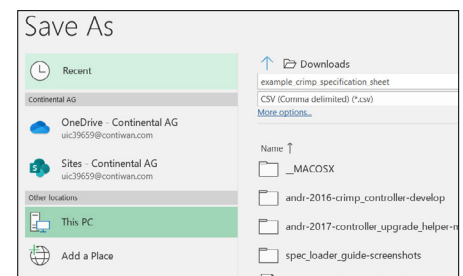
**Note:** Enter desired notes if any.



**Step 3:** Select **File** in the top left corner when the file is ready to be saved.



**Step 4:** Select Save to overwrite the current file or Save As to rename the file. The file must be saved as a .csv file type directly on the USB drive. Do not save the file inside a folder on the USB drive.



**Note:** In the above screenshot, please note the file extension of CSV (Comma Delimited). The file must be saved in this format in order to work properly.

## Frequently Asked Questions

### Will the specification loader work with standard Excel files? (xlsx, xls, etc ...)

- No it will not load excel files. The file format for specifications must be .csv (Comma Separated Value).

### My specifications aren't loading!

- First, if loading via USB, verify that the file format on your USB Drive is in the .csv format.
- If the format is correct, please verify that your file contains data in the same structure and order as the examples in this document.
- If your file contains additional columns or if you are missing data, the specifications may not load.
- If you are attempting to load specifications via the web and the specifications are not loading, please ensure that you are connected to the internet.

### How do I know my crimp specifications?

- If you are uncertain as to your crimp specifications, please contact the manufacturer of your hose and fittings for more information.

### Can I have custom die names?

- No, the Die Name needs to be in a specific format of the size (expressed in MM) a space and MM, as they are formatted in the example specification document, and on your InfoCrimp crimper.

### Can I inches / Imperial measurements?

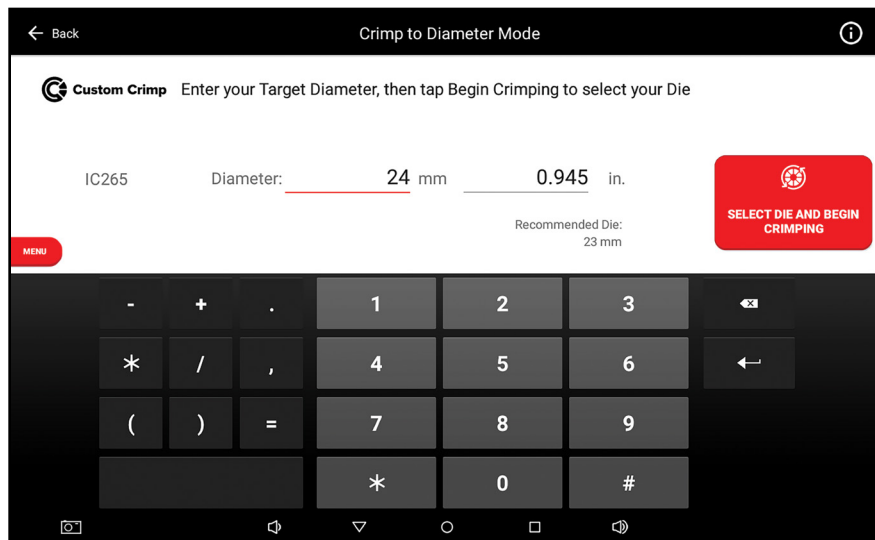
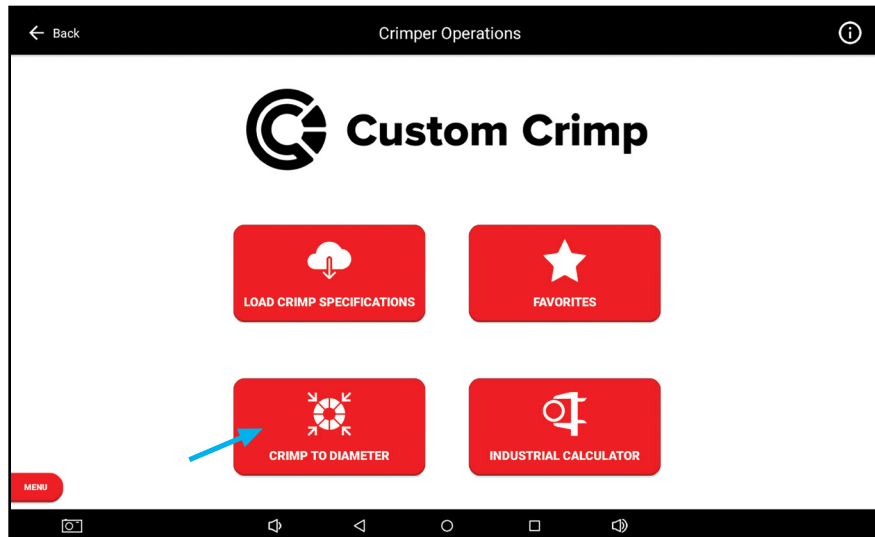
- No, the Target Diameter and Die name must be in metric (MM) measurements. The Hose Size can be expressed in Inches.

# Crimp to Diameter

If you already have the crimp specification information, you can enter this directly and begin crimping. Simply choose the Crimp to Diameter option from the Crimper Operations page.

Enter the appropriate crimp diameter target (in inch or mm). As you enter a target diameter, the crimp automatically calculates the equivalent measurement in the other unit of measure.

The system will recommend a die and you can proceed to crimping.

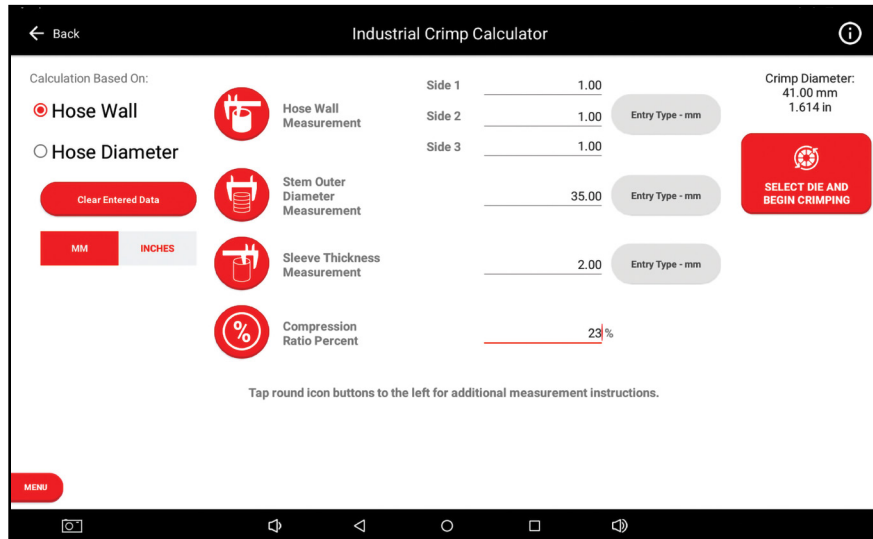


## Note:

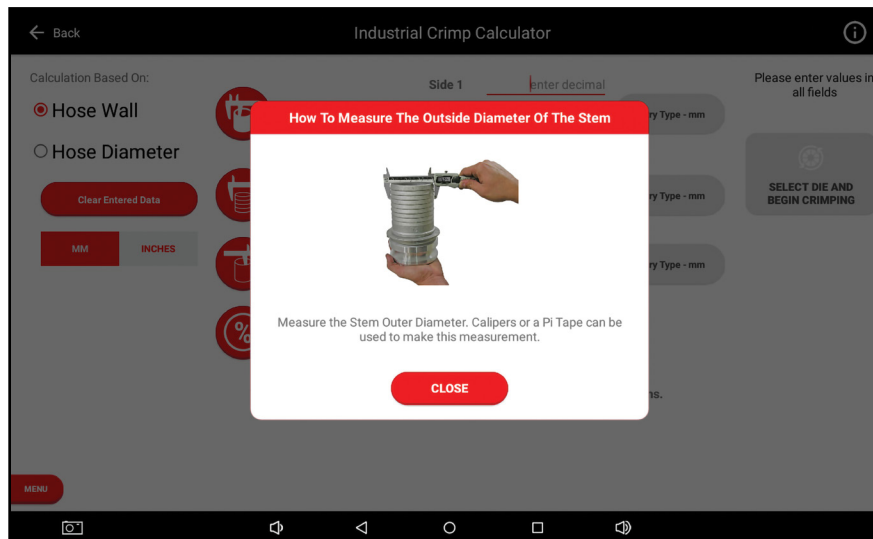
- If the keyboard is not visible, tap Diameter data entry area and the keyboard will appear.

# MyCrimp® Industrial

The industrial crimp calculator allows users to enter information about the industrial hose, stem and sleeve along with a compression ratio. The calculator will then calculate the appropriate crimp diameter.



The calculator provides additional details on each required values. Press on the measurement icon and a more detailed description pops up.



## Entering Industrial Measurements

**Hose Wall:** Allows users to perform the calculation based on 3 measurements (averaged) of the hose wall thickness.

**Hose Diameter:** A single hose diameter measurement.

**Stem Outer Diameter:** The diameter of the stem.

**Sleeve Thickness:** The thickness of the sleeve.

**Compression Ratio:** Compression ratios are available from hose & fitting manufactures. Ratios must be between 10% and 35%.

As data is entered, the calculator will determine the final crimp diameter (users cannot proceed to crimping until all field have information entered).

Once the data is entered and the calculation complete, you can proceed to crimping.



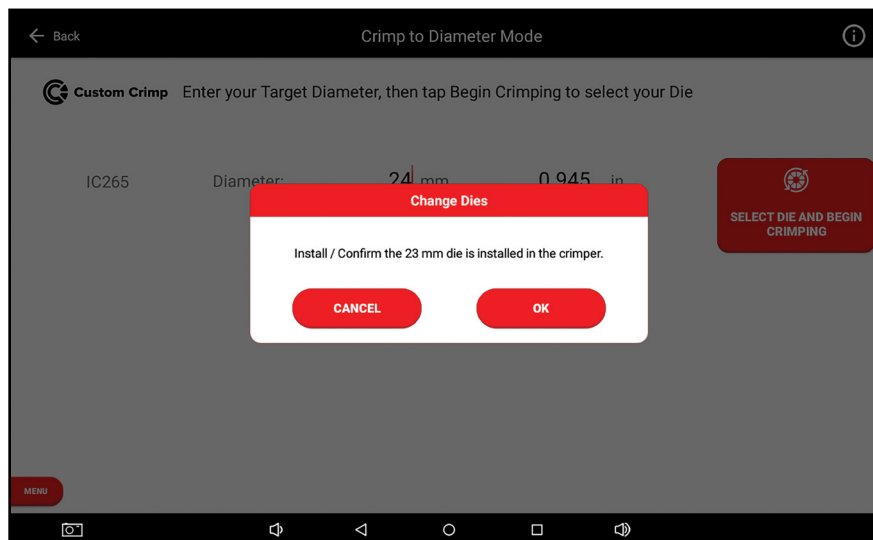
# Beginning a Crimp

## Loading Dies

Regardless of how the crimp specification / crimper was setup, the first step in crimping is to load the correct die into the crimper.

As part of the crimper configuration, the dies available to this crimper have been configured (see Managing Preset Dies on page 35). This pre-determined list of dies allows the crimper to determine which die to recommend for each crimp.

Crimp specifications and favorited crimp specs all include a recommended die. If that die is configured for this crimper, the user is prompted to install the recommended die.



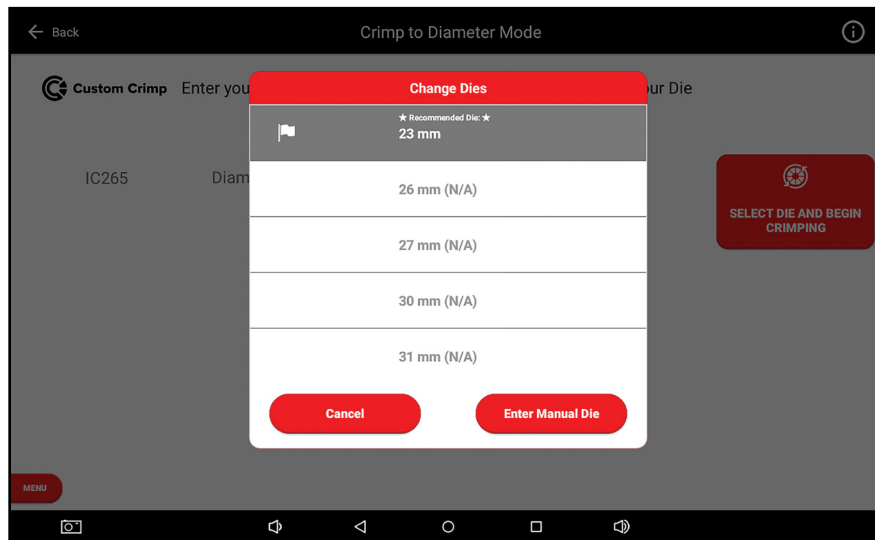
### Notes:

- CustomCrimp® dies use color coding to help the user select the correct die set.
- The crimper will always prompt the user to “Install / Confirm” that the die is loaded. Therefore, even if the recommended die is already loaded, the user will always be prompted to confirm that the correct die is installed in the crimper.
- While on the Change Die screen, the pump is on and the open / close button are enabled. The user can move the crimp head as required to install the dies.
- In rare situations, the user may need to over-ride the recommended die. This can be done by pressing the Die Options button. This will bring up the list of available dies (described below).
- **Caution:** In change die mode, the crimper head will close to the die diameter.

## Selecting a Die

If a non-recommended die or no die is set, the controller will prompt the user with a list of configured dies. The InfoCrimp™ controller will recommend a die that can crimp the required crimp diameter.

Once a die is selected, the machine will prompt the user to confirm/install the die in change die mode (described above).



### Notes:

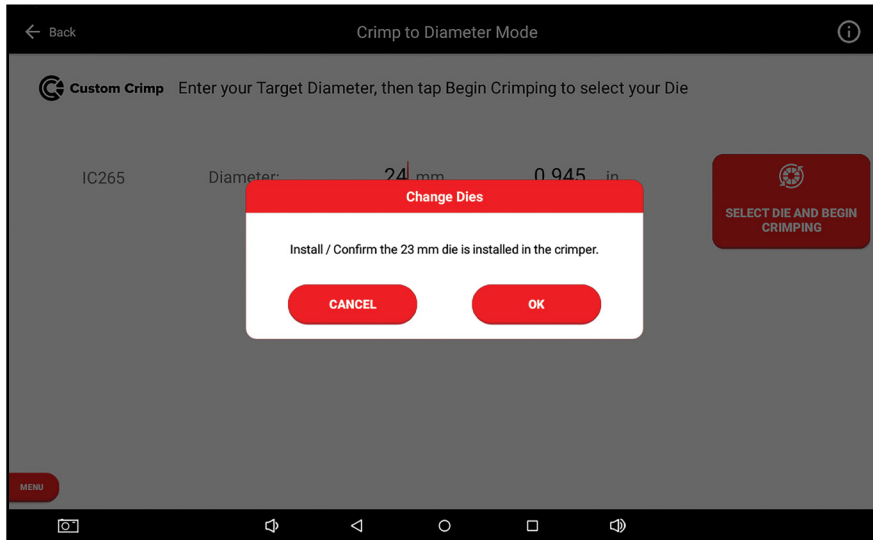
- Dies that are greyed out are excluded because they are not capable of reaching the crimp diameter.
- This list is scrollable, you can slide the list up and down but in general, the list will be centered on the dies that can be used for this crimp.
- This list is limited to the dies configured when the initial machine setup was completed (either in the factory or during the initial machine setup).
- If you have a die appropriate for this crimp but it is not in the list of dies, you can manually enter this die by choosing the Enter Manual Die option on the bottom right.
- If the selected die cannot crimp to the required crimp diameter, the crimper will display a warning.

## Change Die Mode

When you select the die, the pump will start and the Open/Close buttons will work to allow you to load the die in the crimper. Once the die has been loaded, press the OK to continue.

### Note:

- If the desired die is already loaded, simply press OK to continue.



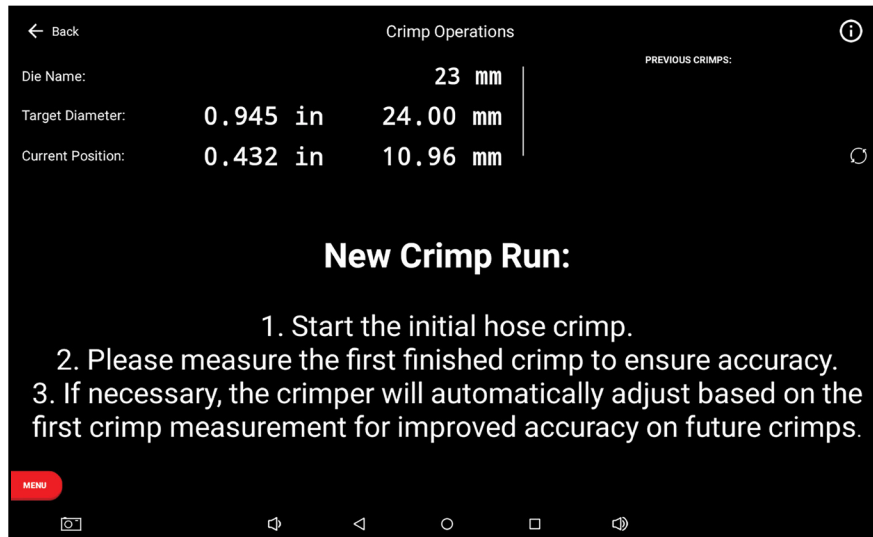
# Crimp Operations

## Performing the First Crimp

The first crimp always needs to be measured to ensure the crimp is within tolerance of the crimp diameter.

### Note:

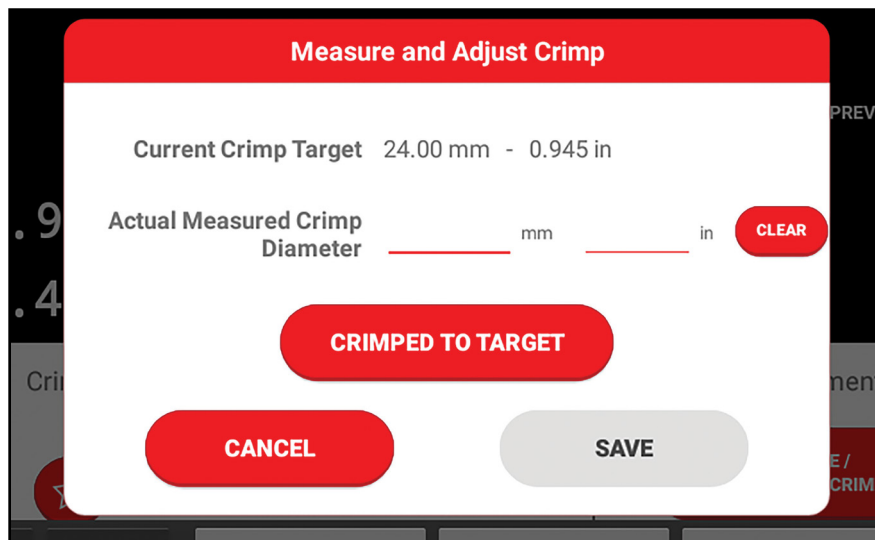
- Once the calibration crimp has been completed, and an initial crimp diameter entered (manually entered or entered via USB InfoCrimp™ calipers), the crimper will automatically adjust to accurately crimp subsequent crimps.



## Measuring a Crimp

The crimper will always prompt the User to measure the first crimp. The crimper uses this measurement to adjust the crimper to correctly crimp the next crimps.

When prompted, enter the measured crimp diameter. Measurements can be entered in inch or mm (the cursor will be placed in either field based on the preferred units of measure setup in the machine configuration).



### Notes:

- If the crimp diameter measurement matches the current crimp target, the user can press the Crimped to Target button to automatically enter the measurement with a single button press.
- If a value is incorrectly entered, simply press the clear button.
- Once the measurement has been entered, the save button is enabled and saves the measured crimp diameter for quality assurance reporting.
- A keyboard will pop up on the bottom of the screen to allow users to enter crimp diameter data.
- If calipers are connected to the crimper, measurements can automatically be transferred into the measurement field.
- The preferred units of measure are setup per user and can be configured in the machine settings.

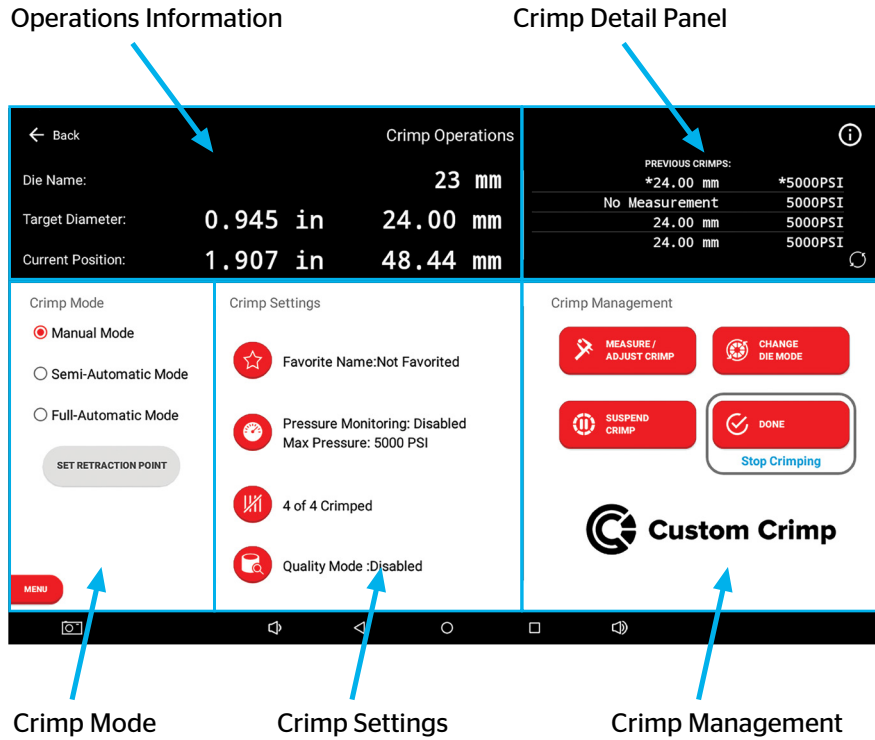


## Crimp Operations Screen

This screen provides the main controls for operating the crimper. While on this screen, the pump is running and the open / close buttons are enabled (limited by Crimp Mode).

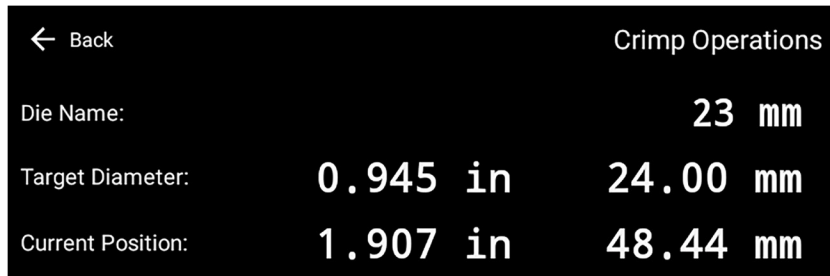
## Crimp Operations Screen Sections

The operations screen is divided into 5 sections: Operations Information, Crimp Detail Panel, Crimp Mode, Crimp Settings and Crimp Management.





## Operational Information



← Back	Crimp Operations	
Die Name:	23 mm	
Target Diameter:	0.945 in	24.00 mm
Current Position:	1.907 in	48.44 mm

**Die Name:** The name of the die that is currently installed in the machine.

**Target Diameter:** The diameter the machine is set to crimp to.


**Current Position:** Current Die Opening in inches and millimeters.

### Crimp Detail Panel

This area of the screen provides the user with additional information about the crimping processes. The data in this area rotates through a series of screens with different information. Users can cycle through each view with the icon in the lower right section of this screen area.



**Last 9 Diameters:** A list of the last 9 crimp diameters measured/entered into the InfoCrimp™ controller.

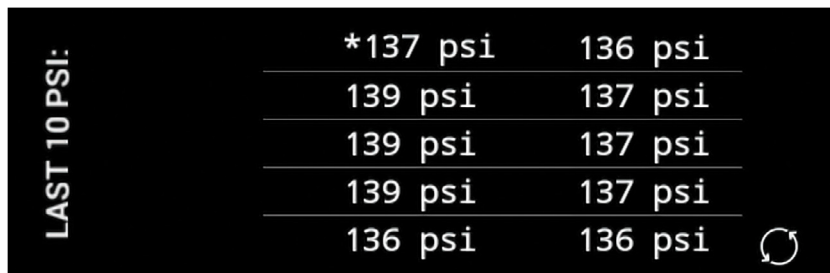


LAST 9 DIAMETERS:		
*25.00 mm	25.00 mm	25.00 mm
25.00 mm	25.00 mm	24.90 mm
25.00 mm	25.20 mm	25.00 mm

#### Note:

- The most recent is noted with a “\*”

**Last 10 pressures:** The last 10 maximum crimping pressures measured in PSI.



LAST 10 PSI:	*137 psi    136 psi	
	139 psi	137 psi
	139 psi	137 psi
	139 psi	137 psi
	136 psi	136 psi

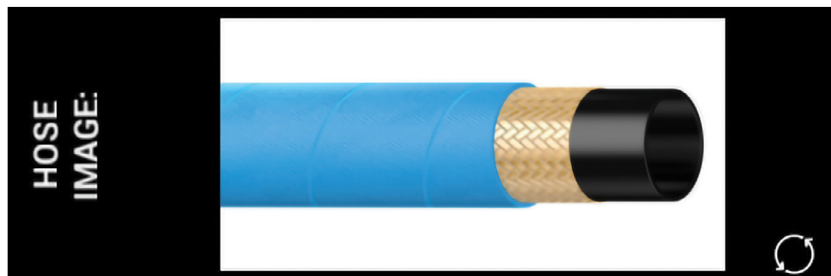
**Combined view:** This view combines the measurement and the max pressure view into one. Note, Users may not be required to measure every crimp.

PREVIOUS CRIMPS:	*25.00 mm	1221 psi
	25.10 mm	1221 psi
	24.80 mm	1221 psi
	No Measurement	1221 psi
	25.00 mm	1221 psi

**Crimp Spec:** Hose, fitting and hose size information, when loading a MyCrimp® specification.

SPEC INFORMATION:	Hose Type:	DR15N
	Coupling Type:	B2-16
	Hose Size:	1.000 in

**Hose Image:** The last 10 maximum crimping pressures measured in PSI or BAR.



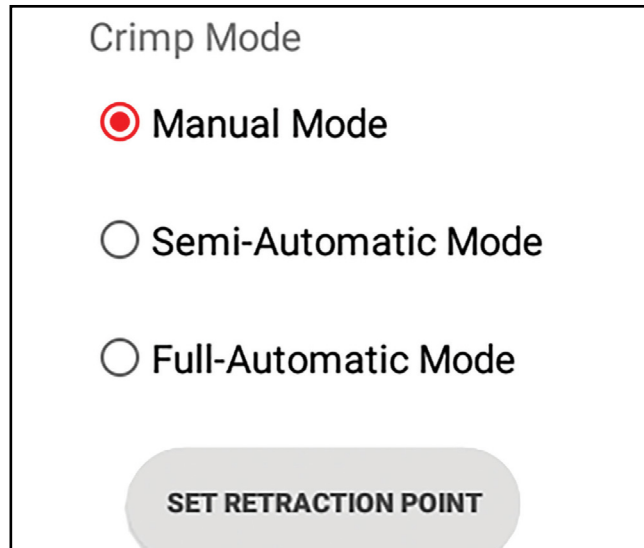
**Spec Notes:** This view shows the crimp specifications notes.

**NOTES:** Crimp Diameter tolerance +/- 0.005" or +/-0.127mm.

**Industrial Crimp:** This view summarizes the values entered into the Industrial Crimp calculator.

Hose Wall Average:	2.04 mm
Stem Outer Diameter:	22.00 mm
Sleeve Thickness:	5.50 mm
Compression Ratio:	21%

## Crimp Mode



The crimper can operation in any of 3 different modes:

**Manual Mode:** Use this mode to manually open/close the head. Holding the close button will close the head to the target position and no further.

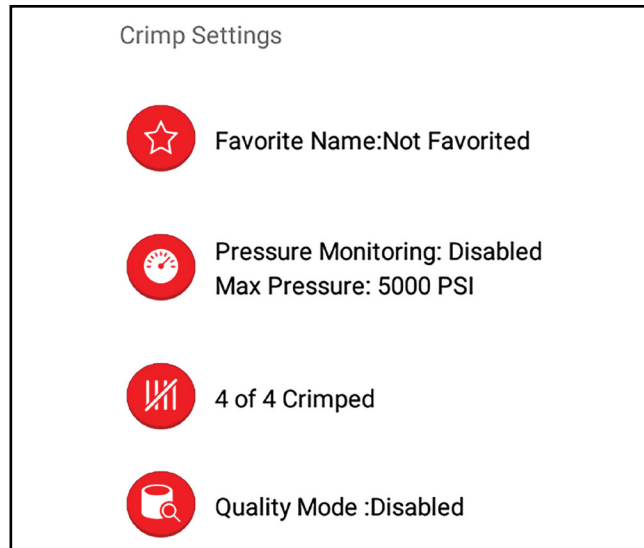
**Semi-Automatic Mode:** This mode allows the user to manually close the head to the target position. Once the crimper reaches the target position, the crimper will automatically open back to the retraction point (see below).

**Full Automatic Mode:** This mode allows the crimper to complete a complete cycle (close then open) with just a single push of the close button. Once the hose and fitting are correctly positioned, press the close button once and the crimper will close to the target position and then automatically open back to the retraction point (see below).

**Note:**

- In either of the automatic modes, the foot pedal can also be used in place of the close button.

## Crimp Information



The Crimp Settings section contains status information and also a number of configurable settings that the user can change to adjust the crimp run.

Note each of these information areas can be configured by pressing the icon to the left of the information.

**Favorite:** If this crimp specification has been saved as a favorite, the name of the favorite will be displayed here. To save a new favorite, simply press the favorite icon on the left.

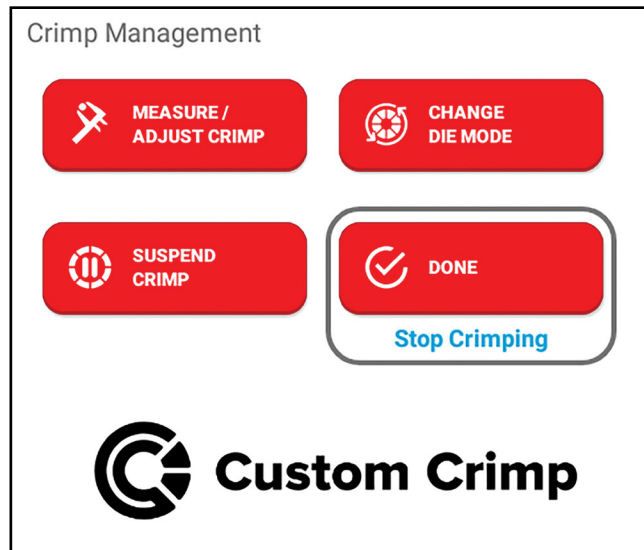
**PSI Monitoring / Max PSI:** The InfoCrimp™ controller has the option to monitor the crimping pressure and alert the user if the PSI is out of range. Press the PSI icon to configure the target PSI and tolerance.

**Crimp Count:** The InfoCrimp™ controller keeps track of the crimps completed. By default, this count goes up but you can also set it to count down. This is configured using the count icon on the left. Users also have the option to “bump” the count up or down if needed.

**Quality Mode:** Quality mode automatically stops the crimping process after a specified number of crimps and prompts the user to measure the crimp diameter.

## Crimp Management Function Buttons

This section provides buttons to configure and operate the crimper.



**Measure / Adjust Crimp:** This button allows the user to measure and record the crimp diameter. When activated, the user can enter a crimp diameter measurement.

**Change Die Mode:** This mode allows the user to change die.

**Suspend Crimp:** Suspend Crimp is intended to put the crimper in a safe mode when the user needs to step away from the machine for a short time. While suspended, the pump is turned off and the open/close buttons are disabled.

**Done:** This button should be used when the user has finished all crimps with these settings.

# Setting and Support

In addition to the basic crimping operations, the InfoCrimp™ controller offers a number of other capabilities. These include:

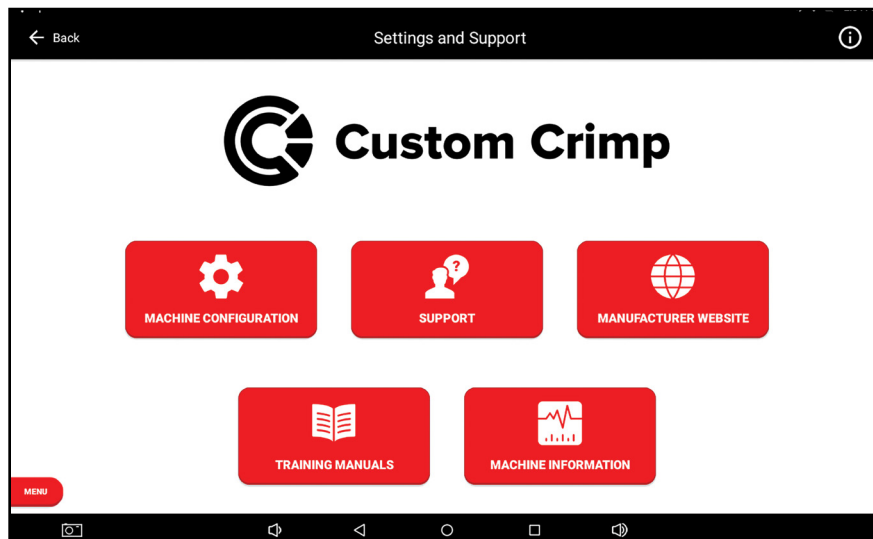
**Machine Configuration:** Crimp setup/configuration page with all of the configurable options of this device. See **Machine Configuration** below.

**Support:** Support page which allows users to request support directly from the machine. See the **Support** below.

**Manufacturer Website:** Access to all of the information on the Custom Crimp® corporate website.

**Training Manuals:** Direct access to setup, guides and training manuals for the machine and controller. See **Training Manuals** below.

**Machine Information:** Informational pages that provide users with basic machine stats and operational information.





## Machine Configuration

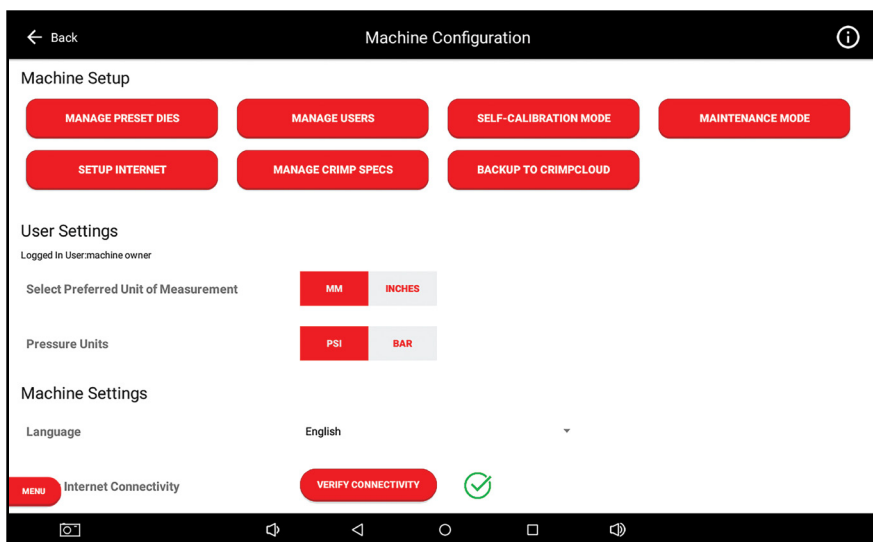
The InfoCrimp™ controller has a number of configuration options that allow the machine operation to be customized to meet the needs of each installation.

Main configuration functions are grouped into menu options at the top of the page. The rest of the configuration screen provides access to all the remaining configuration settings.

### Notes:

- The options available vary by user type. Operators have very limited options and Machine Owners have access to all options.
- After making configuration changes, the InfoCrimp™ controller will attempt to back these changes up to the connection to the cloud.

**This backup requires an Internet connection to complete.**



## Machine Configuration Options

**Manage Preset Dies:** Setup the dies that are available for crimping on this machine. See [Manage Preset Dies](#) below.

**Manage Users:** Edit and setup machine users. See [Manage Users](#) below.

**Self-Calibration:** Check the crimper Calibration. See [Self-Calibration Mode](#) below.

**Maintenance Mode:** List of maintenance tasks, schedules and due dates for machine maintenance. See [Maintenance Mode](#) below.

**Setup Internet:** Configure and verify a tablet Internet connection. See [Setup Internet](#) below.

**Backup to the Connection to the Cloud:** Backup InfoCrimp™ controller configuration to the connection to the cloud. See [Backup to the Connection to the Cloud](#) below.

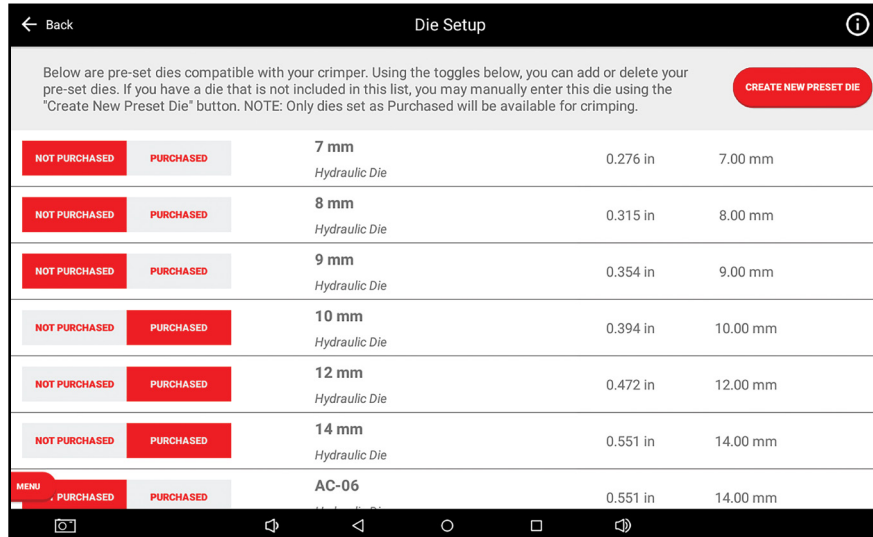
**General Configuration:** Other Configuration settings. See [General Configuration](#) below.

## Managing Preset Dies

This screen provides a list of all of available dies for this crimper. Administrators can set each die to Not Purchased / Purchased to allow the InfoCrimp™ controller to filter the list of dies the user sees to only dies that are available with this machine.

Each die has a name, type, size in mm and size in inches. If there is a color code associated with the die that is also displayed.

Administrators also have the option to create additional dies. Select the “Create New Preset Die” button and setup additional dies.



Below are pre-set dies compatible with your crimper. Using the toggles below, you can add or delete your pre-set dies. If you have a die that is not included in this list, you may manually enter this die using the "Create New Preset Die" button. NOTE: Only dies set as Purchased will be available for crimping.

NOT PURCHASED	PURCHASED	Die Name	Size (in)	Size (mm)
<input type="checkbox"/>	<input type="checkbox"/>	7 mm <i>Hydraulic Die</i>	0.276 in	7.00 mm
<input type="checkbox"/>	<input type="checkbox"/>	8 mm <i>Hydraulic Die</i>	0.315 in	8.00 mm
<input type="checkbox"/>	<input type="checkbox"/>	9 mm <i>Hydraulic Die</i>	0.354 in	9.00 mm
<input type="checkbox"/>	<input checked="" type="checkbox"/>	10 mm <i>Hydraulic Die</i>	0.394 in	10.00 mm
<input type="checkbox"/>	<input checked="" type="checkbox"/>	12 mm <i>Hydraulic Die</i>	0.472 in	12.00 mm
<input type="checkbox"/>	<input checked="" type="checkbox"/>	14 mm <i>Hydraulic Die</i>	0.551 in	14.00 mm
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	AC-06	0.551 in	14.00 mm

## Managing Users

The crimper comes configured with three user accounts but Administrators have the option to setup additional users. Additional users can be useful to track what each user/admin is doing on the machine. Information on the default users is available in the Key User Information: above.

This setup screen allow Administrators to create new users and edit existing users.

**Edit User:** User name, 4 digit passcode and user type can be changed with this menu.  
This is where an Administrator would reset the pin for a user who has forgotten their pin.

**Create New User:** Enter the user name, 4 digit passcode and user type to create a new user.

The InfoCrimp™ controller has been configured with multiple user types. Each type has different capabilities within the crimper. The goal is to provide users with all the privileges they require to do their tasks but no more.

**Machine Admin:** This is the highest privilege user type that can be configured. This user type can change all machine settings, access all support information and perform all crimp operations.

**Machine Tech:** This type has privileges to maintain the machine but cannot perform crimping tasks.

**Supervisor:** This type has privileges to monitor machine operations but cannot perform maintenance tasks.

**Machine User:** This type has privileges to use the machine, perform all crimping related tasks, and has limited ability to change machine configuration.

## Self Calibration Mode

Self-calibration is a built in test that verifies the accuracy of the crimper is within tolerance of its initial factory setup. If the test fails (out of tolerance), a warning message is displayed showing the difference from its initial set point.

To run the test, follow the instructions on the screen. At a high level the test flows as follows:

- Load dies into the crimper (any standard hydraulic dies work). Make sure the crimp head is at least 1/3 open.
- Begin the self-calibration mode. This will prompt the user the press the close button. The test then runs automatically and returns a success / failure result.

## Default User Accounts

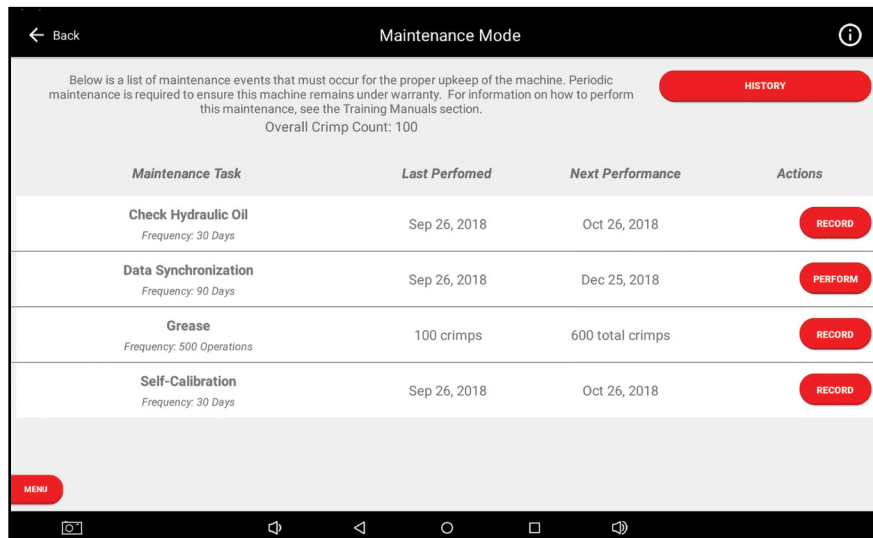
To learn more about Default User Accounts, refer to page 8.

## Maintenance Mode

This machine keeps track of a number of different periodic maintenance tasks. Tasks are based on machine model.

Maintenance tasks are either triggered by the number of crimps or the number of days since the last maintenance.

Tasks include: Check Hydraulic Oil, Grease the Crimper, Perform Self Calibration and data Synchronize. Most of these are self-explanatory with the exception of Data Synchronization (Update crimp specification, check for application updates and sync data with the connection to the cloud).



Maintenance Task	Last Performed	Next Performance	Actions
Check Hydraulic Oil <i>Frequency: 30 Days</i>	Sep 26, 2018	Oct 26, 2018	RECORD
Data Synchronization <i>Frequency: 90 Days</i>	Sep 26, 2018	Dec 25, 2018	PERFORM
Grease <i>Frequency: 500 Operations</i>	100 crimps	600 total crimps	RECORD
Self-Calibration <i>Frequency: 30 Days</i>	Sep 26, 2018	Oct 26, 2018	RECORD

### Notes:

- When a maintenance event is triggered (by crimp count or date), the user gets a popup indicating that the maintenance needs to be performed. To limit the interference with operations, tasks can be delayed until a later date (Snoozed).
- Maintenance tasks are either triggered by the number of crimps or the number of days since the last maintenance, based on the requirements of the task.
- Users can come to this Maintenance Mode screen and perform maintenance tasks or wait for the popup alert.
- Recording a maintenance task provides the user with an opportunity to add notes. The logged in user and date/time are recorded with the maintenance task.
- A complete history of maintenance performed is also available via the history button on the Maintenance Mode screen.

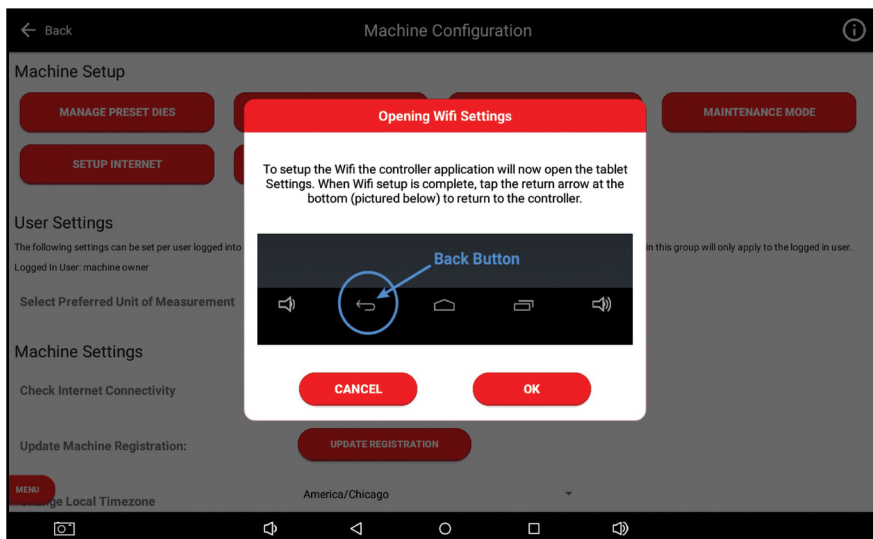
## Setting Up an Internet Connection

This process allows users to configure/verify Internet connections. An Internet connection is not required for day to day operation but is beneficial. This section describes how to configure different types of Internet connections and verify these connections are working.

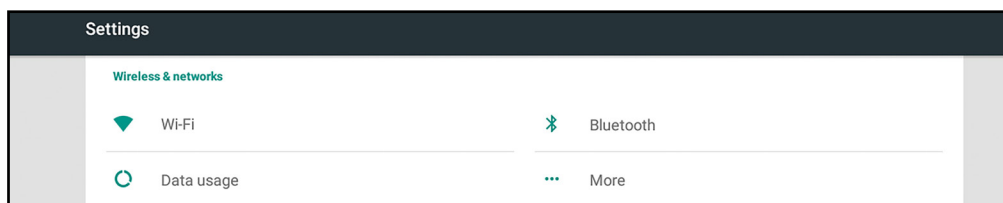
## Using an Ethernet Connection

Plug the Ethernet cable into the base of the controller. The tablet will take a few moments to configure the connection. Once successful, the connectivity status will turn green.

## Using a Wi-Fi Connection



Initiating the Wi-Fi setup process brings the user to the standard Android Wi-Fi setup screens. Choose the appropriate Wi-Fi Network, enter in any required credentials and connect.



When the connection has been established, use the return arrow to return to the InfoCrimp™ controller application.

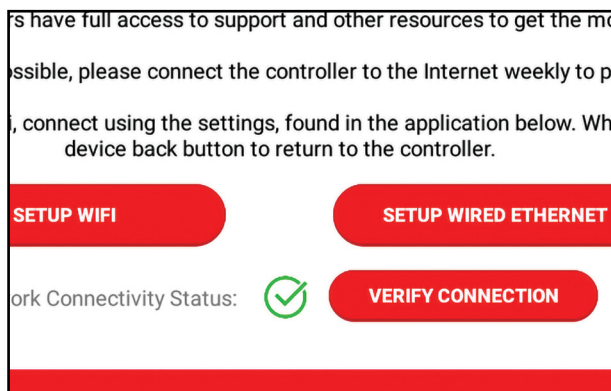


## Connecting to a Captive Portal

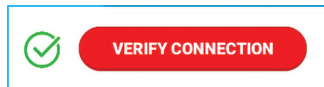
Some customer locations have restrictions on which machines can connect to the company's internal network. If this is the case, see the additional connection options section below.

## Verifying Connections Status

When the Internet connection has been successfully established, the connection status will change to a green check mark. Please verify the connection before moving on to the next step.



## Testing Proper Connectivity



You can use the “verify connection” button to verify that the crimper can reach the Internet. Users should see the CustomCrimp® home page. If you don’t see this page, please contact your network administrator to enable access from the InfoCrimp™ controller to the Internet.

Once the InfoCrimp™ controller is connected to the Internet, use the back button to go back to the setup process and then continue to the next step by pressing the arrow in the bottom right of the screen.



## Additional Connection Options

In some cases, network administrators may restrict which machines can access the company network. There are 2 alternative connection options to complete the crimp setup process:

### 1. Temporarily connect to a guest network:

The controller supports connecting to guest networks to complete the installation. The InfoCrimp™ controller needs an Internet connection but does not require access to any internal company resources. A guest network can be used to complete the setup and update processes for the controller. Simply enter the guest network credentials and the setup can continue.

- a. Enter the guest Wi-Fi credentials (via the Android Wi-Fi setup screens) and verify the connection is active (as described above). The setup process only takes a few minutes after which the Wi-Fi connection is not needed.
- b. Some facilities Wi-Fi connection use a web page to request user Wi-Fi login credentials. The controller supports this. After setting selecting the appropriate network, return to the InfoCrimp™ controller setup screen. Use the verify connection option to bring up the CustomCrimp® home page. The local network will then prompt for the required credentials.

### 2. Connect with a hot spot from a mobile device:

In some cases, the facility’s network administration policies will not allow the InfoCrimp™ controller to access any network. In the case, users must setup a Wi-Fi hotspot and use this connection to complete the setup process.

## Internet Access Requirements

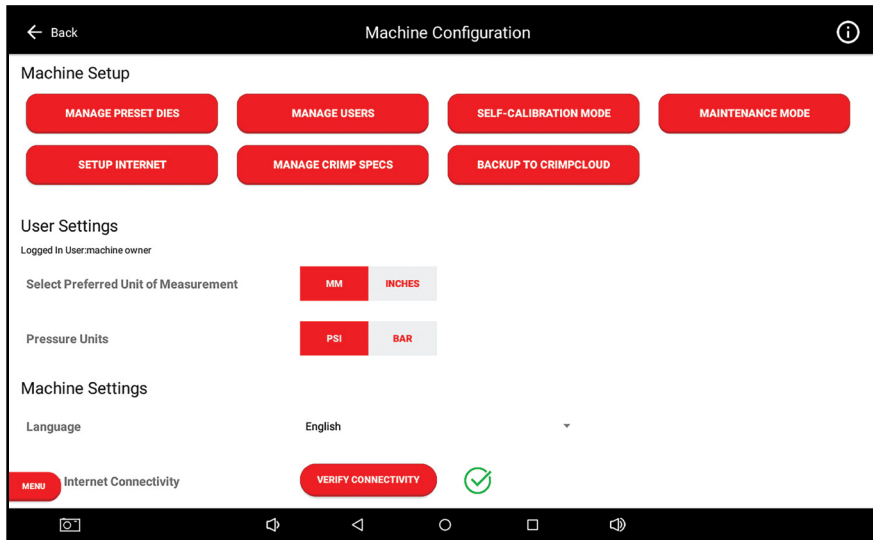
The InfoCrimp™ controller was designed to work with or without a dedicated Internet connection. If a dedicated connection is not available, all of the essential crimping functions will work. The Internet associated features will not work because they require an active Internet connection to operation. Periodically, users will be prompted to connect to the Internet to allow the InfoCrimp™ controller to sync information with the connection to the cloud. This sync ensures the crimper has the latest software, crimp specifications and updates. It also ensures the machine configuration and operational history is backed up to the connection to the cloud. Operational information is used to generate reports and other features available to users from the connection to the cloud.

## Backup to Connection to the Cloud

InfoCrimp™ has the ability to provide reports on crimper operation and maintenance. In addition, it stores the configuration of the InfoCrimp™ controller (Users, dies, favorites, ...). Saving this configuration allows InfoCrimp™ to replace the controller tablet pre-loaded with all the backed up configuration. Simply press “Backup to the connection to the cloud” and the backup is performed.

## General Configuration

The following is a collection of other settings available to Administrators to configure the InfoCrimp™ crimper to meet their specific needs.



**User Settings: Preferred Units:** Each user can have own settings for default units. Default units determine which data entry field the cursor is placed in.

**Update Machine Registration:** The Machine registration information provides the CustomCrimp® support team with location and contact information used to support the crimper.



**Check Internet**

This feature is used to verify the Internet connection. A green checkmark indicates a successful network connection via Ethernet or Wi-Fi. A red exclamation point (!) indicates there is no network connection. There are circumstances where the Wi-Fi signal is present but the tablet still cannot access the Internet. To confirm the connection to the Internet, the “Verify Connection” brings up the CustomCrimp® home page in a web browser. If the site comes up, the InfoCrimp™ controller has a connection to the Internet.

**Change Local Time zone:** Output field to let Administrators know which time zone the tablet is set to. This information is important for logging and reporting. This can be changed by selecting the correct time zone from the drop down list.

**Dual Pump: Slow Start Offset (mm):** Larger crimpers has a dual pump configuration to improve the speed of operation. This setting indicates how far above the target crimp the pump/crimper switches from fast to full power crimping mode.

**Note:**

- The default value generally does not need to be changed.

**User Timeout Length:** Length of time idle (in minutes) before the machine automatically locks and requires a pin to login.

**Note:**

- This feature has an option to turn off (disables user timeout).

**Die Selection Tolerance:** This setting helps the crimper recommend the best die for each crimp. This tolerance value ensures that the crimper does not recommend a die that is too close to the target crimp diameter that cannot crimp to the required diameter.

**Note:**

- The default value generally does not need to be changed.

**Pressure Compensation Mode:** On/Off for Pressure Compensation. Pressure compensation uses the crimp pressure as feedback to improve the accuracy of the first crimp.

**Note:**

- Turning this feature on or off affects the behavior of the first crimp in crimp operations. It turns the calibration crimp screen on or off, respectively.

**Screen Brightness:** Adjust the screen brightness for best viewing.

**Enable Crimp Target Reached Popup:** On/Off for the popup letting the user know that the crimper has successfully reached the target.

**Enable Crimp Target Reached Beep:** On/Off for the sound letting the user know that the crimper has successfully reached the target.

**Require Measurement After 1st Crimp:**

On/Off setting for measurement popup on the initial crimp. CustomCrimp® recommends that users ALWAYS measure the initial hydraulic crimp to ensure that the crimp target is being reached (within tolerance). Turning this setting on always cause the crimper to trigger the measurement popup on the initial crimp.

**Connect Bluetooth Calipers:**

Configuration and support to setup Bluetooth connected calipers.

**Check for Update to InfoCrimp™ controller:**

Trigger the InfoCrimp™ controller to connect to the connection to the cloud and check for application updates. If found, the controller will download and install the latest version of the application.

**Note:**

- Internet connection is required.

**Force Connection To The Cloud Operation Sync:**

Trigger the InfoCrimp™ controller to upload all operational data to the connection to the cloud.

**Note:**

- In general, Administrators should not need to manually sync data. The controller will automatically sync data to the connection to the cloud when appropriate.

**Product Information: Email Terms of Service:**

Provides a way for the Administrator to view the Terms of Service and if required, email them to the main contact for this machine.

**View Source Attribution:**

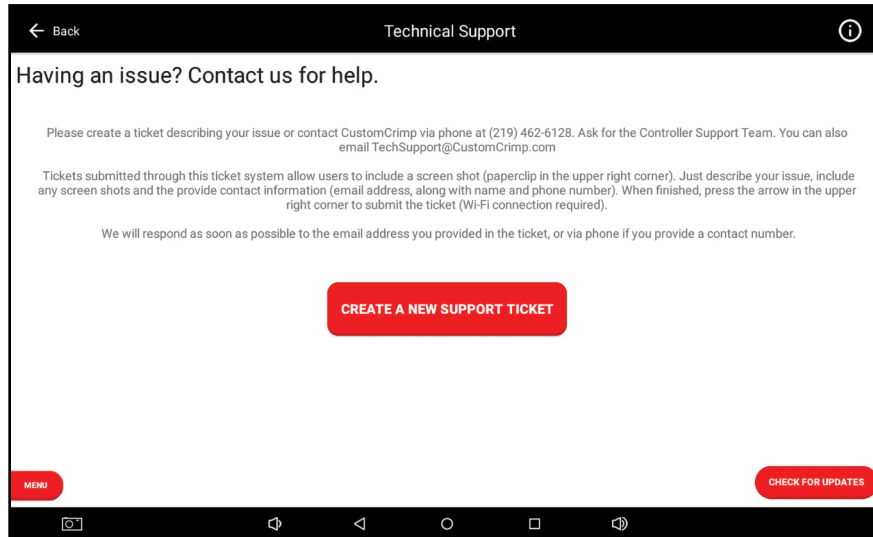
Provides information on open source software incorporated into the InfoCrimp™ controller.

# Support

The application provides the user with a Technical Support system. This system allows the user to create a support ticket from within the app. The support ticket and machine status information are automatically uploaded to the CustomCrimp® support staff.

## Note:

- The system must be connected to the internet for this function to work.



The user has several options to get support:

## Create a Ticket

This option allows the user to enter text to describe their issue. They can attach an image (using the camera button on the bottom menu bar to capture the screen where the error is encountered). Once submitted, this information is sent to CMS technical support staff for review and resolution.

## Note:

- The machine must have Internet access to use this function.

## Create a Ticket

**Request Support**


Enter your email address

In order for us to most quickly resolve your issue, please type in this area and provide the following information:

- 1) A description of your issue.
- 2) A device screenshot if possible (paperclip in upper right)
- 3) Your contact information.

Then, press the send (arrow in upper right) to submit your ticket. We will respond as soon as possible to the email address you provide in the ticket, or via phone if you provide a contact number.

To create a ticket, follow these steps:

- 1) Enter your email address:** It is very important that this is entered correctly to ensure the support team can quickly respond directly to the person having the issue.
- 2) Describe your problem:** Enter a detailed description of the issue you are encountering so that the support team can quickly provide support.
- 3) Attach an image:** The InfoCrimp™ controller allows users to capture image of any screen (using the camera button in the bottom row of icons). Images can be attached by pressing the paperclip icon in the upper right corner of the screen. 
- 4) You can attach multiple images to the ticket and add text to explain your issue.**
- 5) To complete the process and send the support ticket, press the arrow icon in the upper right section of the screen.**

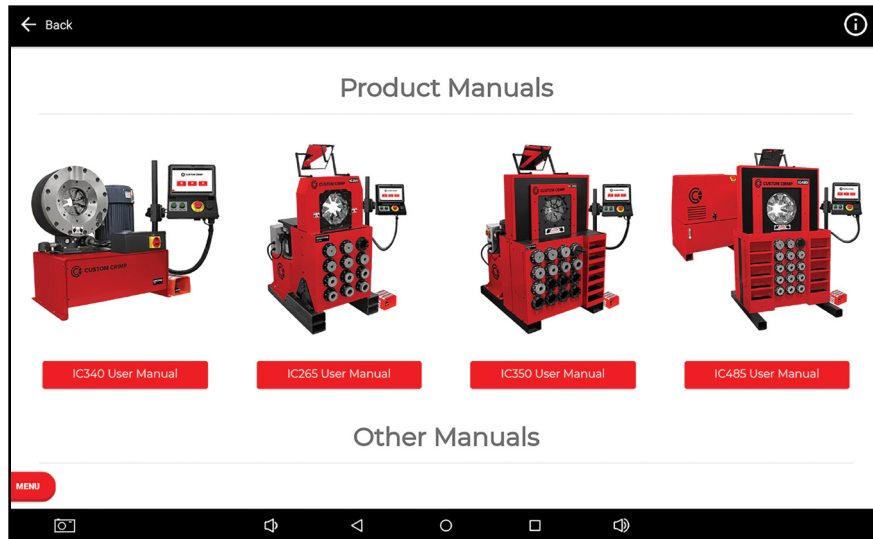
## What Happens Next?

Once you submit the ticket, the information you entered (along with machine status and diagnostics) are sent to the Tech Support team. The team will review your ticket along with the diagnostic information and respond back to the email address provided.

The system will also send you a copy of the with a link to allow users to follow up on status or with additional information.

## Training Manuals

The controller provides access to a number of different training manuals.



The page lists a number of support resources available to machine users. These files are downloaded as requested from the Internet (Internet connection required).

## Machine Information

The Machine Information screen provides operations and administrators with access to a range of operational and machine information.

# Other Topics

## Integrated Caliper Measurements

The InfoCrimp™ controller supports direct integration of measurements (Crimp Diameter). This integration saves time and reduces the chance that measurements are incorrectly entered.

## Configuring InfoCrimp™ Calipers (Bluetooth)

The InfoCrimp™ controller supports Bluetooth calipers to input crimp diameter measures. Setting up bluetooth calipers:

**Note:**

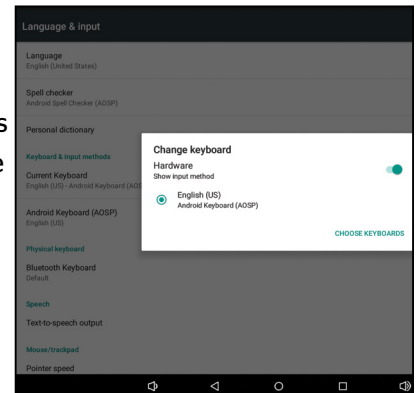
- Bluetooth Calipers are included with all IC Series Crimpers, and should already be setup and paired with the InfoCrimp™ Controller. But if you have any issues, follow the "Connecting Bluetooth Calipers" guide on page 47 in order to set up the accessory.

- Insert the Bluetooth dongle into the top of the calipers after removing the connection cover. The "SMART" label should be facing toward the display screen.
- Tap the Bluetooth cell to see the list of Bluetooth devices toggle to turn Bluetooth ON.
- Tap the toggle in the Bluetooth cell to turn Bluetooth ON.
- Hold the button on the Bluetooth module until the blue light starts blinking.
- The calipers should appear in the list of Bluetooth devices as "Bluetooth Keyboard" in the list of AVAILABLE DEVICES.
- Select "Bluetooth Keyboard" from the list of devices to pair. If you don't see this, turn off and then on Bluetooth.
- The "Bluetooth Keyboard" should say Pairing while it is pairing with the tablet and moved to list of PAIRED DEVICES once it is paired. The iGaging dongle will also beep when pairing is complete.

**Note:**

- If your keyboard is not showing on the tablet, make sure the **Show Input Method** toggle is ON. (As shown in the screenshot below) You can access the toggle by tapping on **Language & Input** in the general settings. Once there, tapping **Current Keyboard** under the "Keyboards and input methods" section.

- Select the appropriate units (in/mm).
- Make sure the units match the default units in the crimper settings menu (Main Menu → Crimper Settings → Select Preferred Unit of Measurement).



- When saving measurements from the calipers to the tablet there is a slight delay. This is due to the power saving mode of the iGaging dongle. Please give the transfer a few seconds to complete.

## Configuring InfoCrimp™ Calipers (USB)

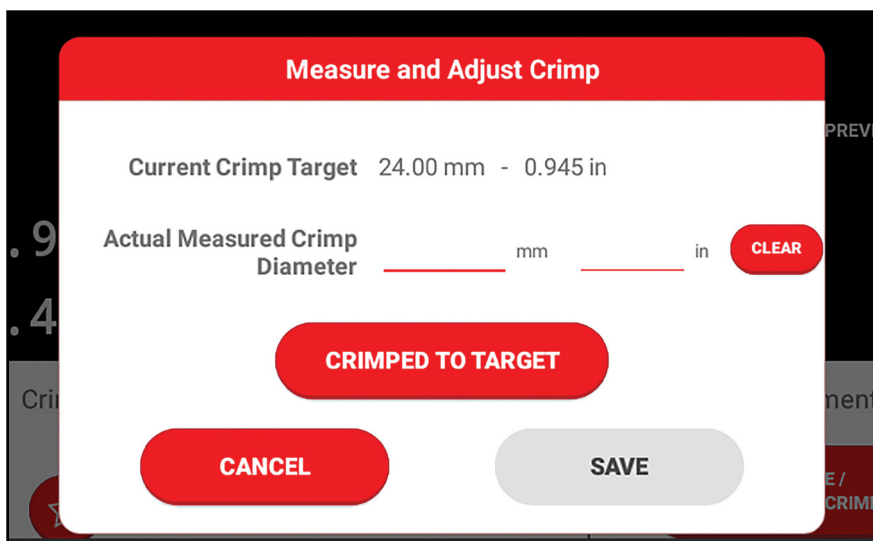
The InfoCrimp™ controller supports USB calipers to input crimp diameter measures.

### Setting Up USB Calipers

- Insert the USB cable into the top of the calipers after removing the connection cover. The “DATA” label should be facing toward the display screen.
- Plug the other end of the cable (standard USB Connection), into the USB connection on the front of the controller box.
- Turn on the calipers
- Select the appropriate units (in/mm).
- Make sure the units match the default units in the crimper settings menu (Main Menu → Crimper Settings → Select Preferred Unit of Measurement).



### Using InfoCrimp™ Calipers



Once the calipers are connected to the controller, they can be used to enter measurements within the InfoCrimp™ controller screens.

- The calipers are now ready to use. Whenever a measure is required (Measure/Adjust Crimp in Crimper Operations screen), the caliper’s measurement can be directly entered into the text box. Simply place the cursor in the correct field and press the DATA button on the calipers. Whatever value is displayed on the caliper display will automatically be transferred into the controller.
- If calipers are connected to the controller, number entry keypads do not always appear. Simply press in the data entry field and a keypad will appear. For example, if changing users with the USB calipers connected, no keypad will appear to allow the user to enter a pin. Simply press once in the entry field and a keypad will pop up.

# Connecting Bluetooth Calipers

The InfoCrimp™ Controller supports the ability to integrate with Bluetooth Calipers, allowing for fast and easy wireless transfer of measured crimp diameter to the controller.



Caliper with Bluetooth Dongle



Caliper with Wireless Bluetooth

## Initial Setup:

### Caliper with Bluetooth Dongle

**Step 1:** Verify that the batteries are installed into the calipers and into the Bluetooth dongle.

**Note:**

- To replace batteries when needed, use a SR44SW 1.55V battery for the calipers, and CR2032 3V battery for the Bluetooth dongle.

**Step 2:** If necessary, remove the standard port cover from the top of the calipers above the Mitutoyo logo with a paperclip. Insert dongle into port facing same direction as caliper screen.

**Note:**

- There may be a cover installed over caliper accessory port. Remove with a paper clip. Then, insert the Bluetooth Accessory into the calipers, with the button facing toward the calipers screen and measurement panel.

### Caliper with Wireless Bluetooth

**Step 1:** Use the small flat screw driver supplied, to open the battery compartment and install the battery then insert it into the calipers.

**Note:**

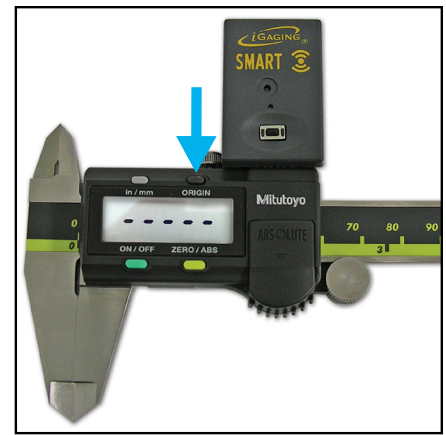
- To replace battery when needed, use a CR2032 3V battery for the wireless bluetooth calipers.





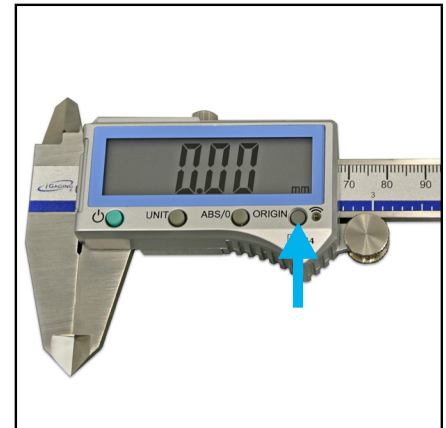
## Caliper with Bluetooth Dongle

**Step 3:** With the caliper fully closed, hold the origin button for 2 seconds. After this is complete, the caliper screen should show 0.00 inches/millimeters when at the zero position.

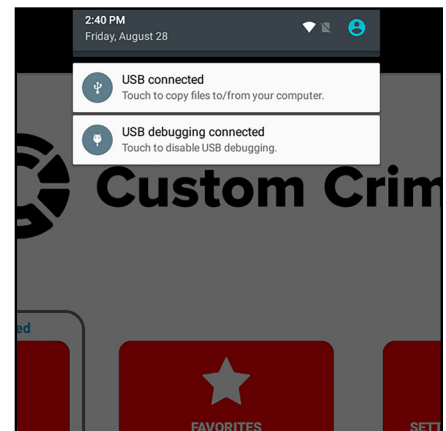


## Caliper with Wireless Bluetooth

**Step 3:** With the caliper fully closed, the caliper screen should show 0.00 inches/millimeters when at the zero position. If needed hold the origin button for 2 seconds to reset at the zero position.

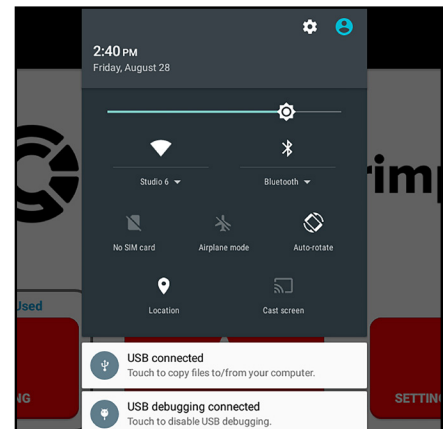


**Step 4:** **Access the device's Bluetooth Settings:** Swipe down from the upper right of the device screen, to reveal an options panel. Tap the Bluetooth button to open the Bluetooth management page.

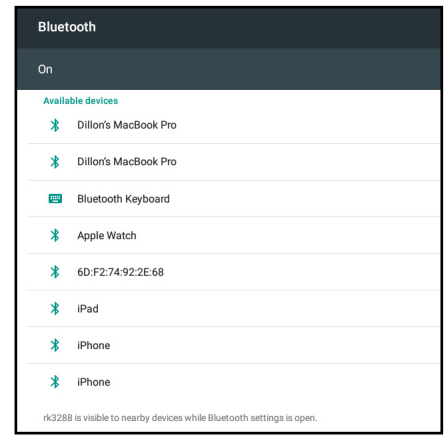


Android 5.1 Above

**Step 5:** Tap gray area in pull down menu and tap the Gear icon to show full settings menu.



**Step 6:** Tap the Bluetooth Button and launch the Bluetooth Menu.



## Caliper with Bluetooth Dongle

**Step 7:** Hold Bluetooth Accessory button, until the blue light blinks.

- Note:**
- Firmly press and hold on the Bluetooth accessory's click button for approximately 5 seconds, or until the blue light begins to flash.



## Caliper with Wireless Bluetooth

**Step 7:** Hold Bluetooth Accessory button, until the blue light blinks.

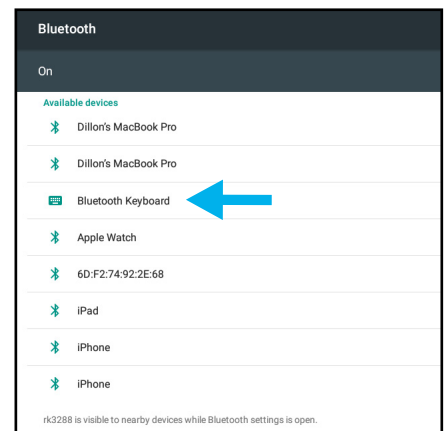
- Note:**
- Firmly press and hold on the Bluetooth accessory's click button for approximately 5 seconds, or until the blue light begins to flash.



**Step 8:** **Find the Bluetooth Accessory in the list of all available devices:** First, make sure that the Bluetooth feature switch is in the On position. When Bluetooth is enabled and the blue light on the adaptor is flashing, the device should appear on the list with the name “**Bluetooth Keyboard**”, and you should see other devices available as well, for nearby phones or computers. It is possible that the device will appear with no name, or a name such as

OF : 5E : 12 : 9A : B4

, or any other group of letters and numbers. If a series of letters appears, you should still see the gray keyboard icon to the left of the device name. Tap on this item in the list while the blue light is still flashing on the calipers to begin the syncing process.



**Step 9: Test Using the Caliper:** The calipers will still work in text entry fields in the app where a diameter needs to be entered. Just make your measurement and tap once on the silver entry button on the Bluetooth Accessory.

**Note:**

- The accessory automatically powers itself off when not in use (you still need to power the caliper screen off between each use), and will turn back on after pressing the button. With this behavior, it may take a second for the calipers to register a measurement when performing a first measurement of the day.

## Troubleshooting: Number Pad Not Showing

If you find testing the calipers that the number pad isn't displaying on screen to manually enter values or login as different Users it is because the **Show Input Method** setting is off. This should be turned ON during setup but if it is ever missed it can be fixed manually.

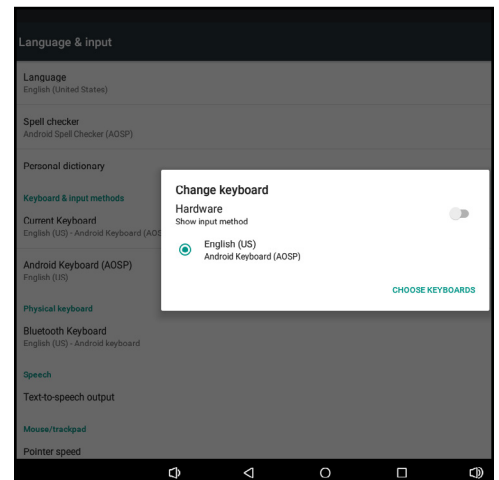
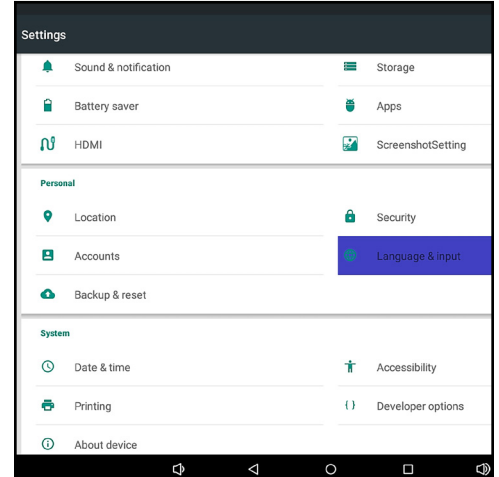
### **Solution:**

**Step 1:** First go to the Android Settings screen outlined in Step 1.

**Step 2:** Then scroll down, and in the **Personal** section, tap on **Language & Input**

**Step 3:** Once in Language & Input, tap **Current Keyboard** in the Keyboards & input methods section.

**Step 4:** A dialog will appear. Tap **Hardware: Show input method** to turn it's toggle to the ON position. The dialog should close automatically.



## **Additional Notes about the Bluetooth Caliper Accessory:**

- If power is lost to the Bluetooth Accessory (for example, if the battery dies) replace the battery and hold the send button on the module until it beeps and the blue light blinks. This should reconnect the module to the tablet. If the device does not connect automatically, follow the steps above to reconnect the accessory.

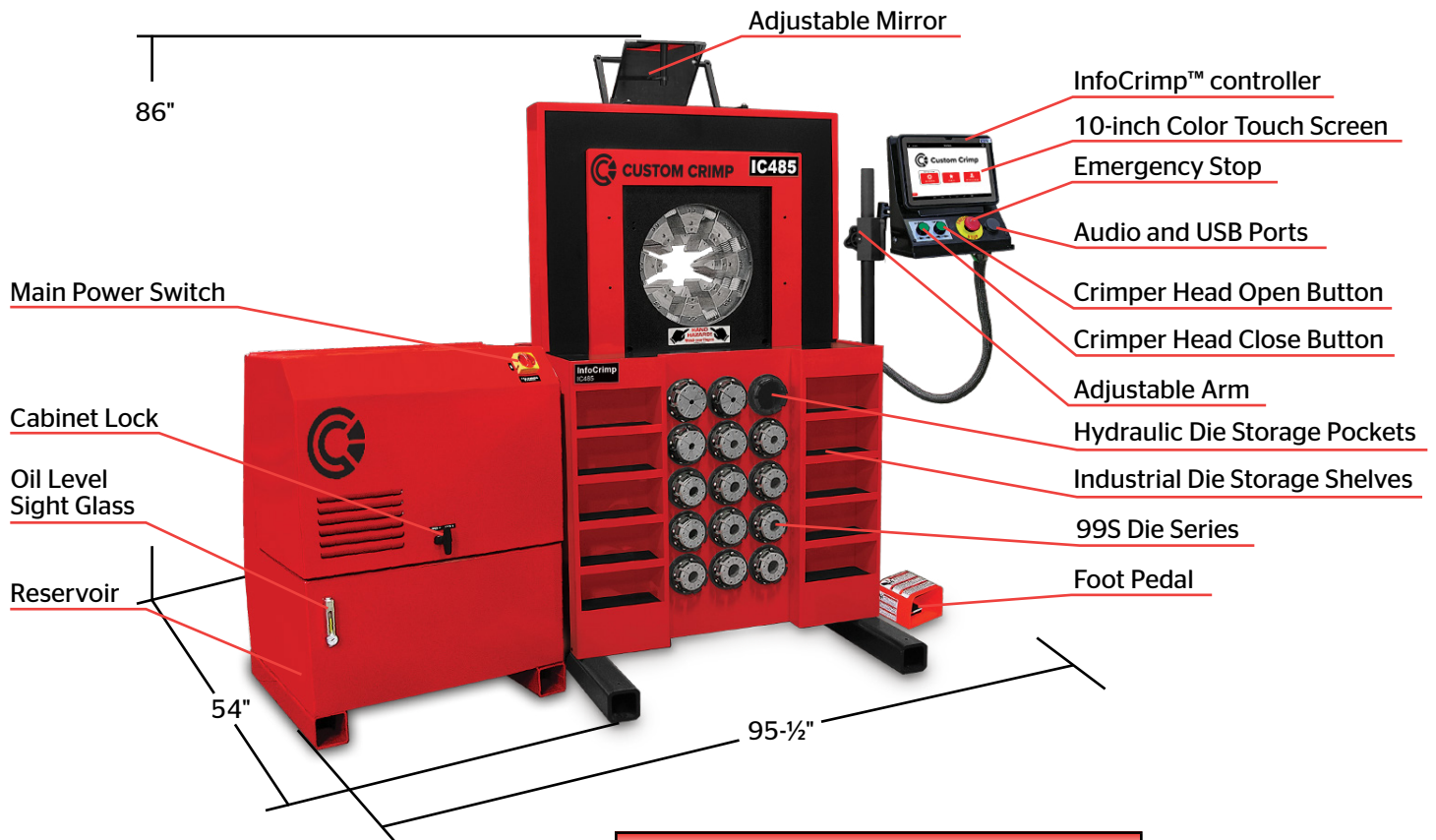
# IC485 Safety Precautions



## SAFETY PRECAUTIONS

- Read instructions and identify all component parts before using the crimper.
- IC485 crimper can produce 485 tons of crimping force.
- Keep both hands away from pinch points.
- Consult your hose and fitting manufacturer for the correct crimper setting and crimp measurements.
- Always wear eye protection.

# IC485 Specifications



Overall Dimensions

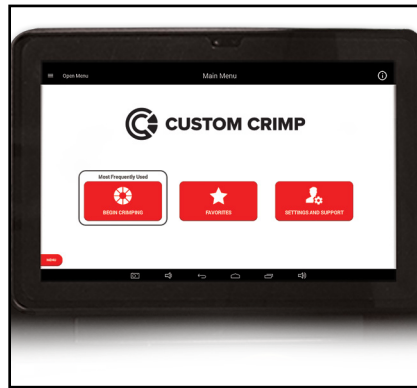
IC485 Specifications
Crimping force: 485 Ton
Hydraulic hose capacity: 1-2 wire: 3", 4SP & 6SP: 3"
Industrial hose capacity: 10"
Crimper size: L: 54" x W: 62" x H: 86"
Power unit size: L: 28" x W: 33-1/2" x 45"
Crimper weight: 6,185 lbs
Power: 7.5HP/230V/3Phase (Standard) 7.5HP/440V-480V/3Phase (Optional) 5HP/230V/1Phase (Optional)
Hydraulic die series: 99S
Adapter die series: 145mm to 99mm 230mm to 145mm
Industrial die series: 230 OB
Adjustability: Inch / Metric
Opening w/o dies: 350mm / 13.75"
Master die inside diameter: 230mm / 9.1"
Master die travel: 125mm / 4.9"
Reservoir capacity: 45 US Gallons
Oil type: ISO 46 Hydraulic Oil



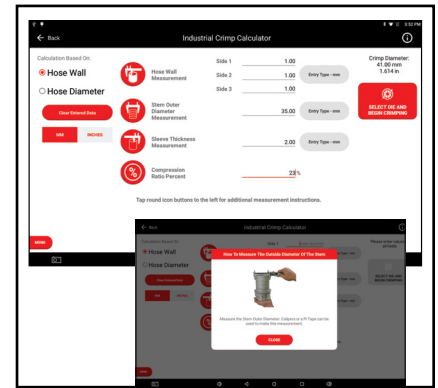
# IC485 Features



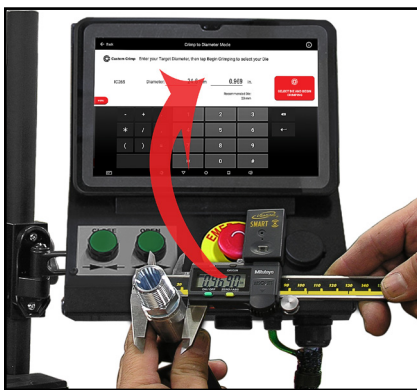
CustomCrimp® InfoCrimp™ controller, the future of crimping at your fingertips.



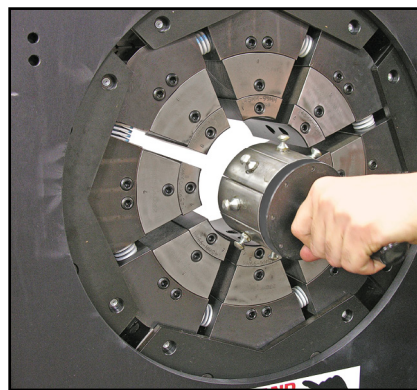
10-inch color capacitive touch screen and user friendly navigation.



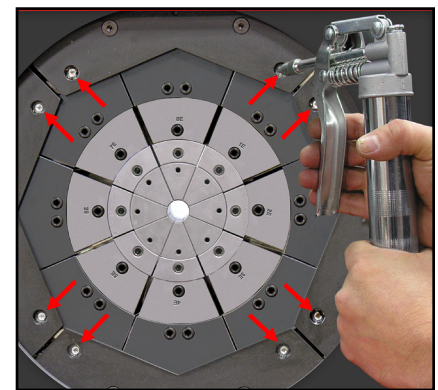
Intuitive screens lead the operator through the setup and crimping process.



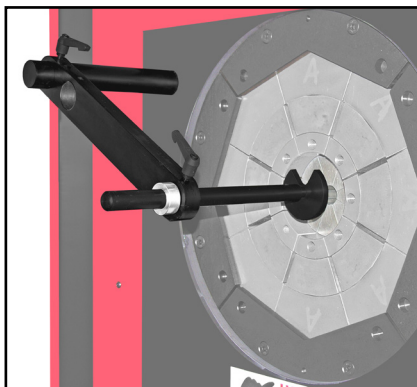
CustomCrimp® InfoCrimp™ controller supports bluetooth calipers to input crimp diameter measurements. Saving time and entering accurate measurements.



Quick Change Tool makes die changes a quick and simple process.



Easy grease maintenance through the lubrication fittings.



Manual Back Stop makes hydraulic hose production crimping fast and accurate.



Foot Pedal for use in Semi and Full automatic mode.



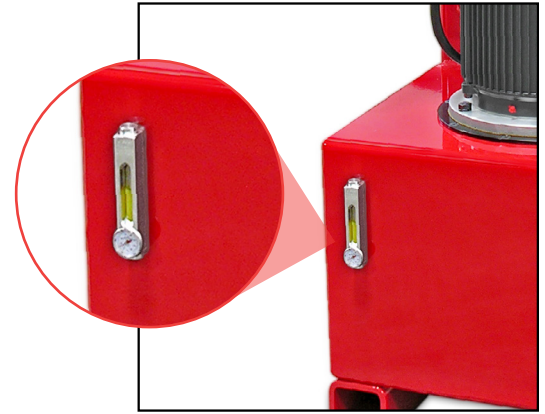
Built-in Die Shelves and Storage Pockets keeps frequently used die sets readily available.

# IC485 Initial Crimper Setup

**Hydraulic Oil Check:** Check the hydraulic oil level in the sight glass window on the front of the reservoir

**Notes:**

- The reservoir requires 45 gallons of ISO grade 46 hydraulic oil for complete fill.
- If necessary, oil can be drained from either of the two ports at the bottom of the reservoir.



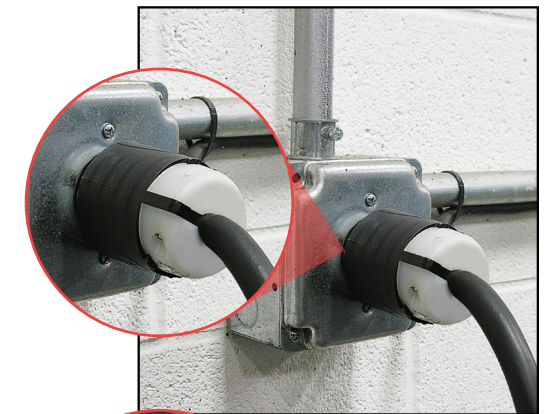
**Voltage Tag Check:** Check electrical circuit to be certain that it matches the crimper's requirements shown on the voltage tag attached to the crimper cord.

**Notes:**

- Plug the IC485 crimper directly into the appropriate electrical circuit / wall outlet.
- Electrical Requirements:
  - 7.5HP / 230V / 3Phase (20 Amp)
  - 7.5HP / 440V-480V / 3Phase (20 Amp)
  - 5HP / 230V / 1Phase (30 Amp)

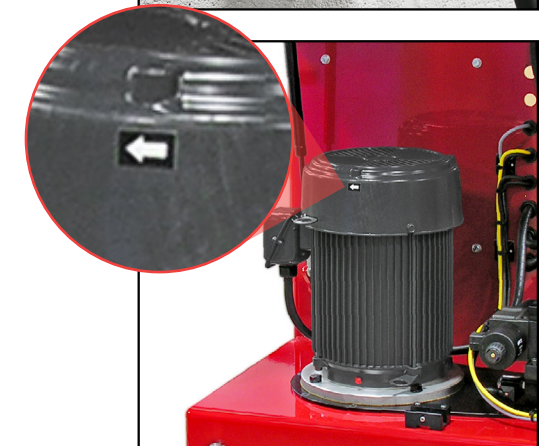


**Caution:** Do not run the crimper on an extension cord as low voltage can damage the motor and / or electrical components.



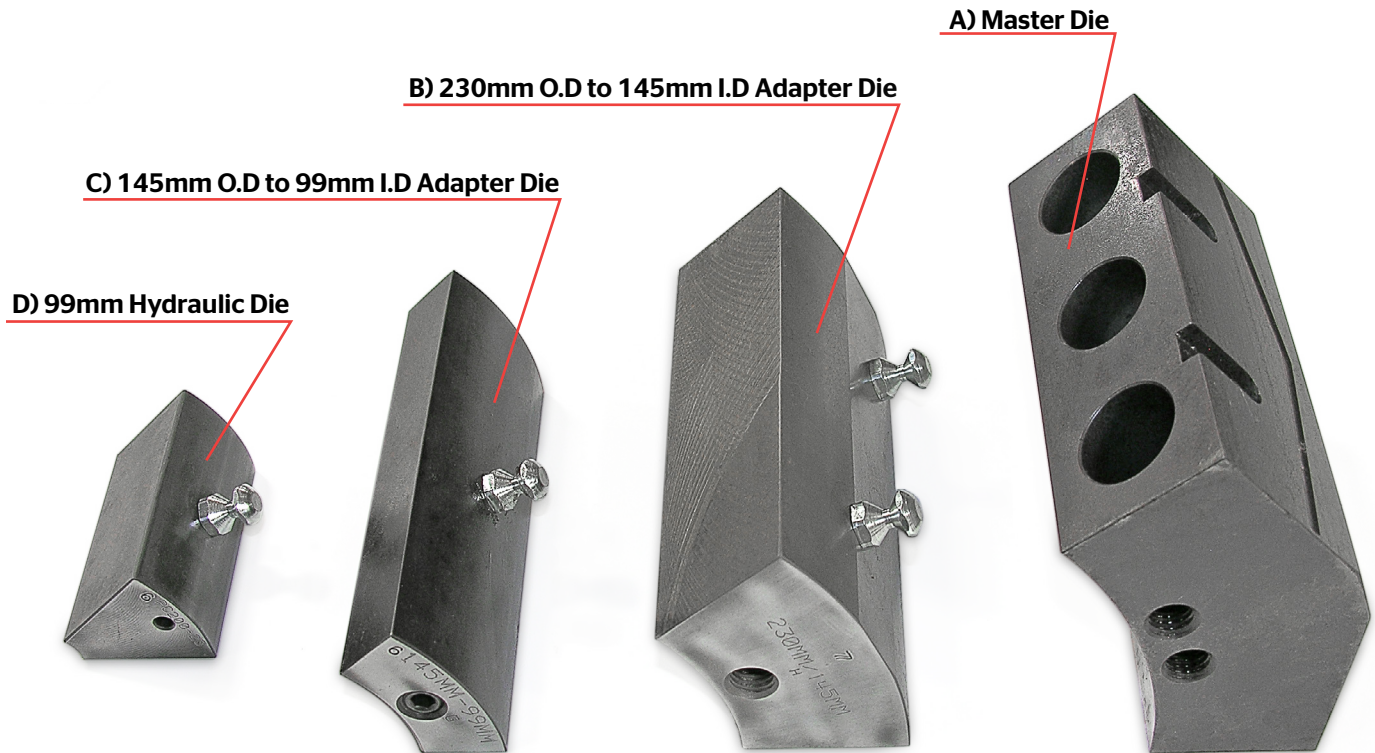
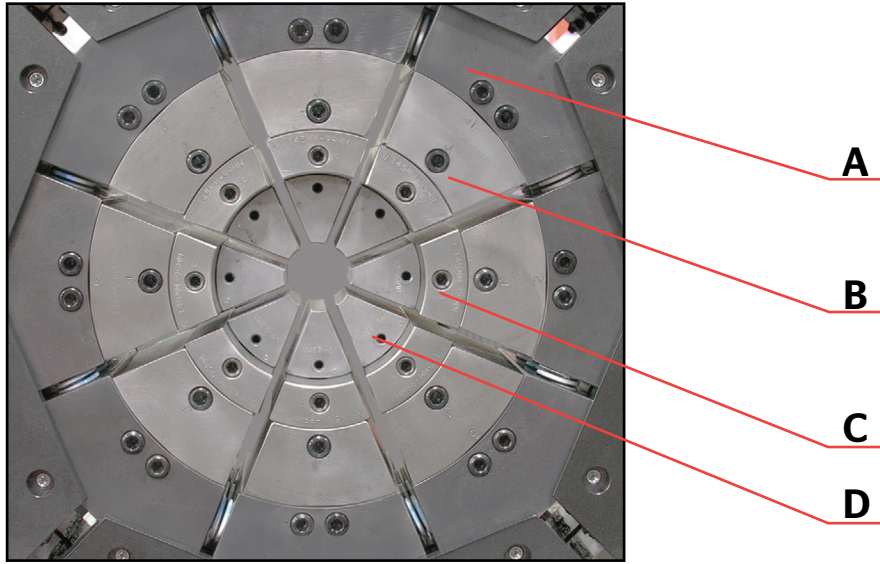
**Rotation of the Motor Check:** Check to be certain that the motor rotates in the direction of the arrow shown on the motor housing.

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





# IC485 Die Part Identification





# IC485 Die Installation and Management

## Adapter Die Installation

### Notes:

- The 230 mm O.D to 145 mm I.D and 145 mm O.D to 99 mm I.D Adapter Dies are available with the crimper. Adapter dies are held in place by the die locking pins (as shown in photo #1).
- The I.D of the adapter dies must match the O.D of the corresponding hydraulic die or accurate crimps can not be made.

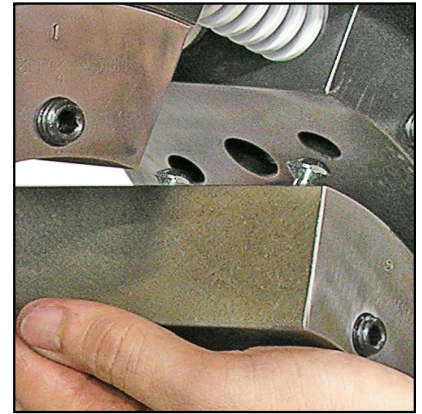


Photo #1

To begin, first bring the master dies to the fully opened position to have access to the master die locking studs (as shown in photo #2).

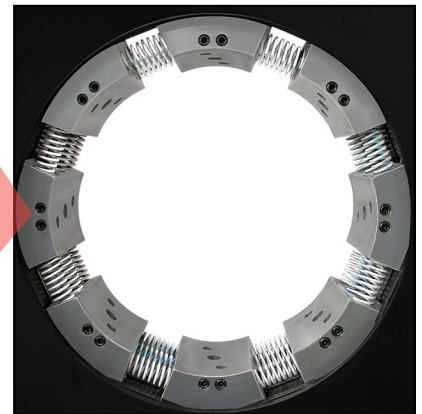
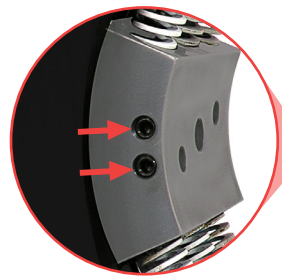


Photo #2

Next, install the 230 mm O.D to 145 mm I.D Adapter Die, each finger individually (as shown in photo #3).

### Notes:

- Use the T-Handle Wrench provided with the crimper to tighten the (2) master die locking studs to secure the adapter die finger. Repeat the same step for the remaining 7 adapter die fingers.
- The die size stamped on the face of the adapter dies should face toward the operator.

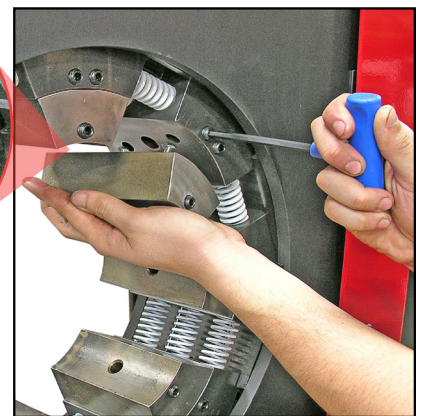
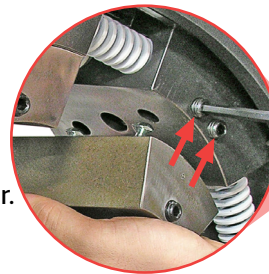


Photo #3

Then, install the 145 mm O.D to 99 mm I.D Adapter Dies each finger individually (as shown in photo #4).

### Note:

- Use the T-Handle Wrench provided with the crimper to tighten the die locking stud to secure the adapter die finger. Repeat the same step for the remaining 7 adapter die fingers.
- The die size stamped on the face of the adapter dies should face toward the operator.

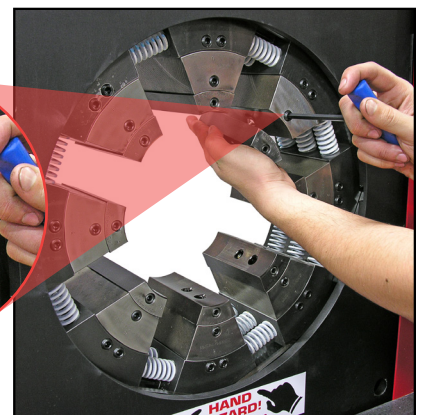
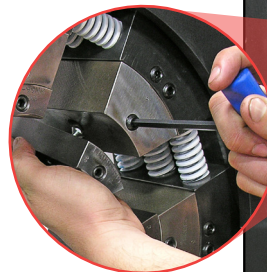


Photo #4

# Hydraulic Die Installation

## Notes:

- With the 230 mm O.D to 145 mm I.D and 145 mm O.D to 99 mm I.D Adapter Dies installed, use the Quick Change Tool to install the 99S hydraulic die set.
- The I.D of the adapter dies must match the O.D of the corresponding hydraulic die or accurate crimps can not be made.

To begin, first bring the crimper head to the fully opened position and install the 99s Hydraulic Die set with the quick change tool (as shown in photo #1).

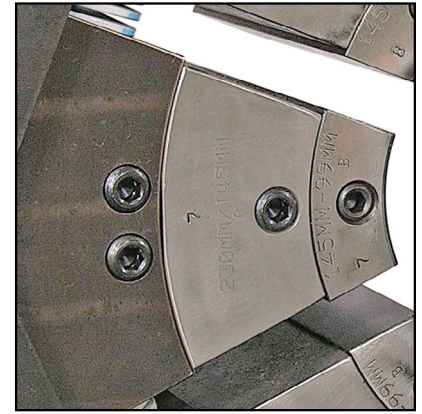


Photo #1

## Note:

- The die size stamped on the face of the hydraulic dies should face toward the operator.

Align the studs of the Hydraulic Dies with the holes in the Adapter Dies and with the crimper in manual mode SLOWLY close the crimper head on the hydraulic die set (as shown in photo #2).

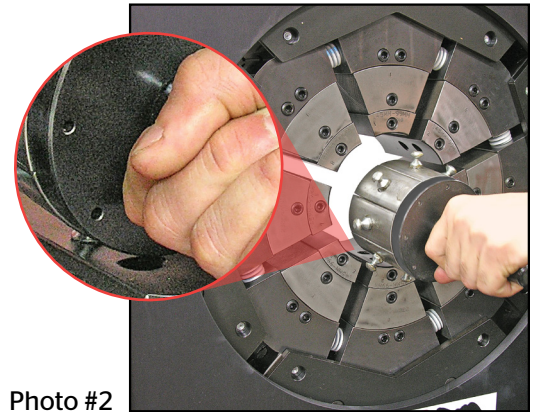


Photo #2

Next, bring the crimper head to the fully closed position (as shown in photo #3).

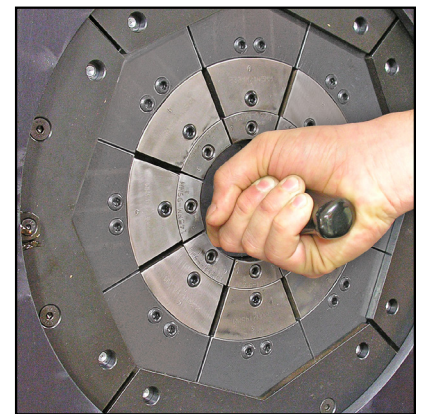


Photo #3

Remove the quick change tool as shown in photo #4).

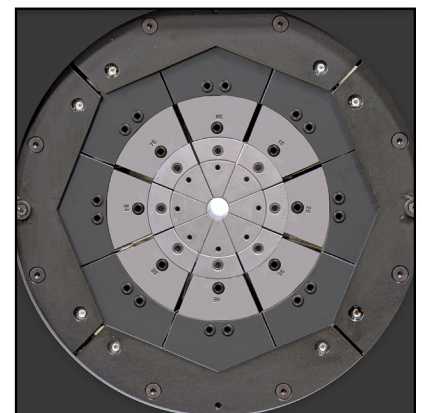


Photo #4

## Notes:

- The 99S Hydraulic Die set may also be inserted manually (each finger individually) with the crimper head in the fully open position.
- For Hydraulic Die removal, place the crimper in manual mode and bring the crimper head to the fully closed position. Insert the quick change tool and open the crimper head releasing the 99S Hydraulic Die set from their spring retention holes.



# IC485 Lubrication Procedure

## Notes:

- Use the mini grease gun w/ flush fitting adapter with grease (supplied with the crimper) as shown in photo # 1 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 400 crimp cycles or at the start of each shift if the crimper is used in a production setting.

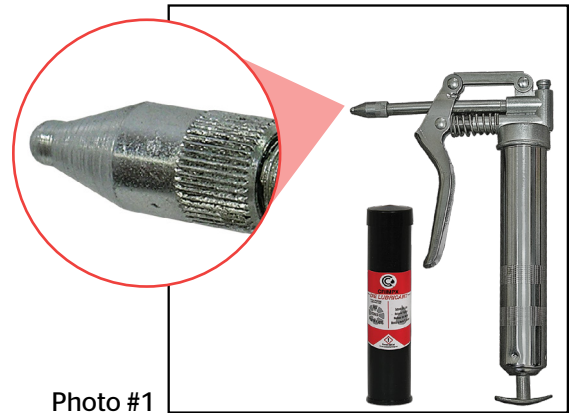


Photo #1

To begin, first bring the master dies to the fully closed position, (as shown in photo #2).

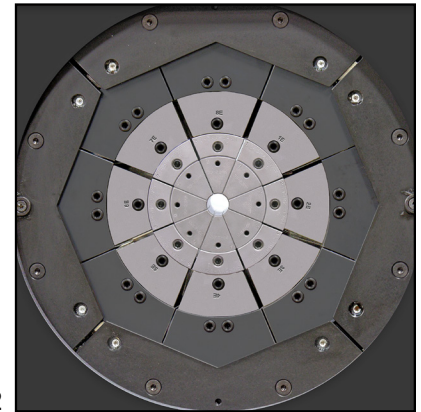


Photo #2

Next, lubricate the master dies through the 8 lubrication fittings in the protective plates (as shown in photo #3).

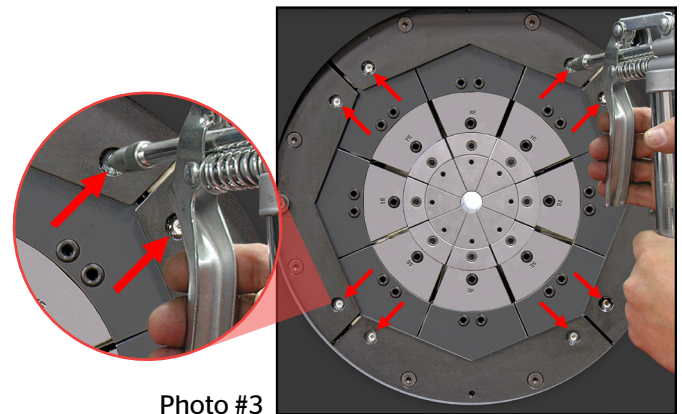


Photo #3

With the dies still in the fully closed position, lubricate the (2) lubrication fittings visible through the two bottom lubrication fittings in the face of the crimper (as shown in photo #4).

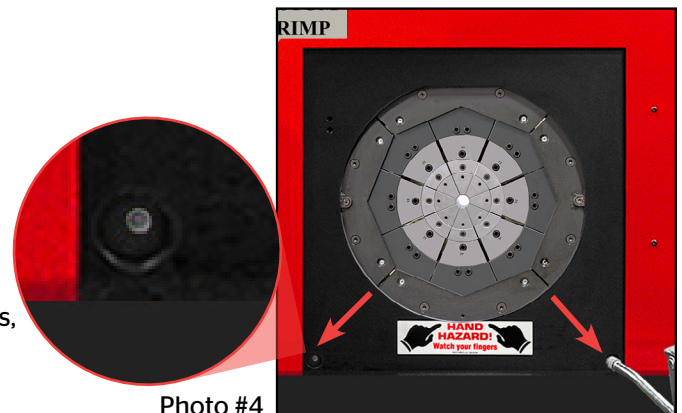


Photo #4

## Notes:

- Parking the crimper in the fully open position when is not in use will prolong the life of the master die springs.
- Check the wear surfaces for grease. If the surfaces show any signs of wear, apply more grease. If you touch the wear surfaces, you should see a thin layer of grease on your finger.

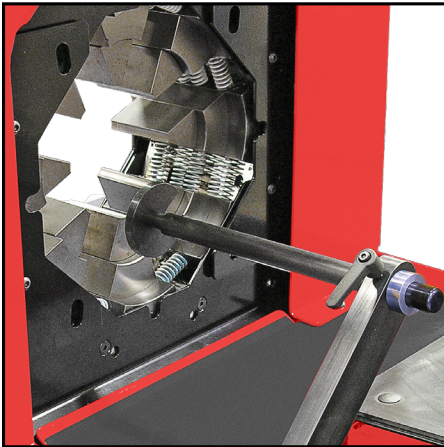
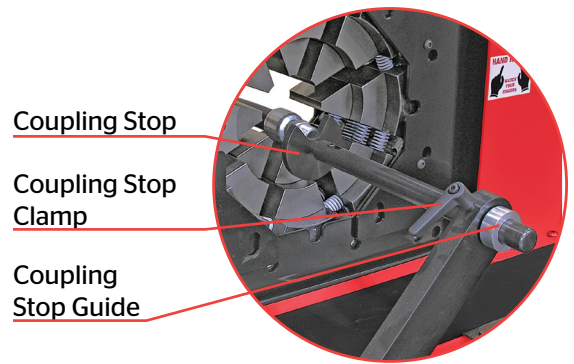


# IC485 Manual Back Stop Setup

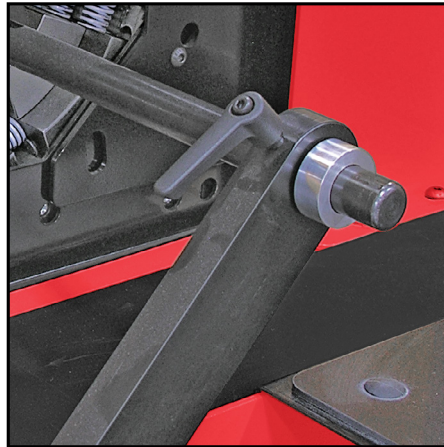
The Manual Back Stop eliminates guesswork allowing the operator to visually observe exactly where the crimp will be positioned on the fitting without the need for trial and error and product scrap due to poor crimp positioning.

With the manual back stop retracted, load the appropriate set of dies and set crimp diameters as required.

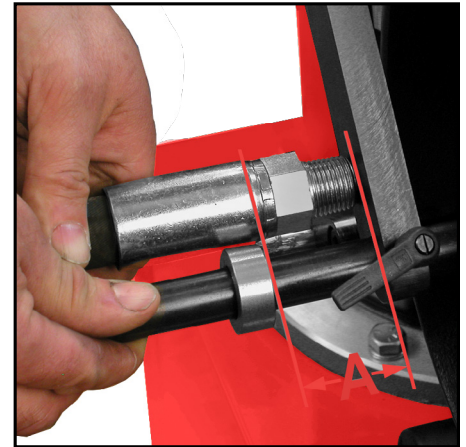
With the crimper in the MANUAL mode, bring the dies to a fully closed position.



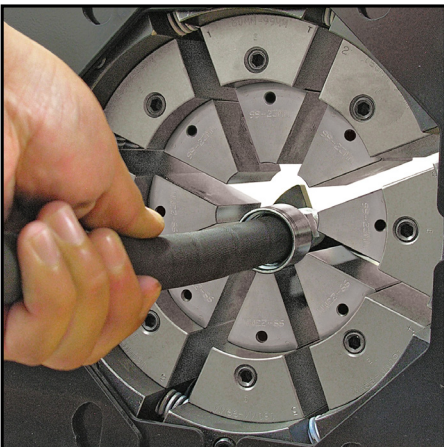
Loosen the Coupling Stop Clamp and position the Coupling Stop against the back face of the dies.



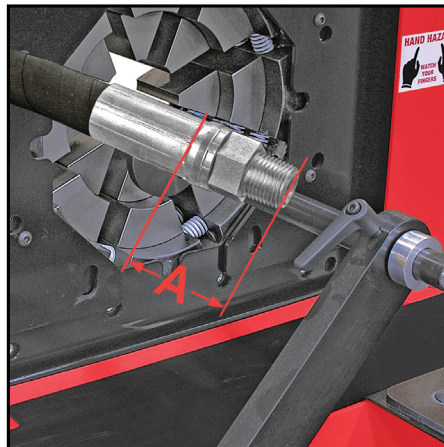
Slide the Coupling Stop Guide against the Coupling Stop Arm.



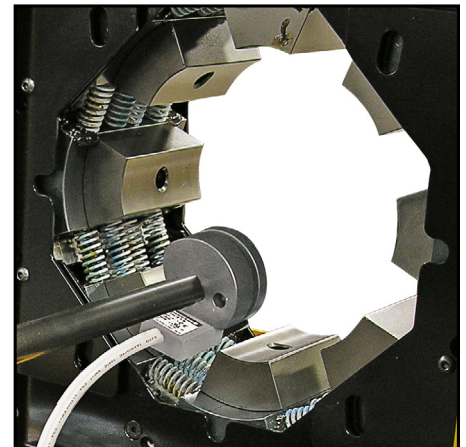
Hold the fitting against the Coupling Stop Arm withdraw the Coupling Stop Rod such that the Guide is aligned with the desired crimp position. Lock the Coupling Stop Clamp.



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.

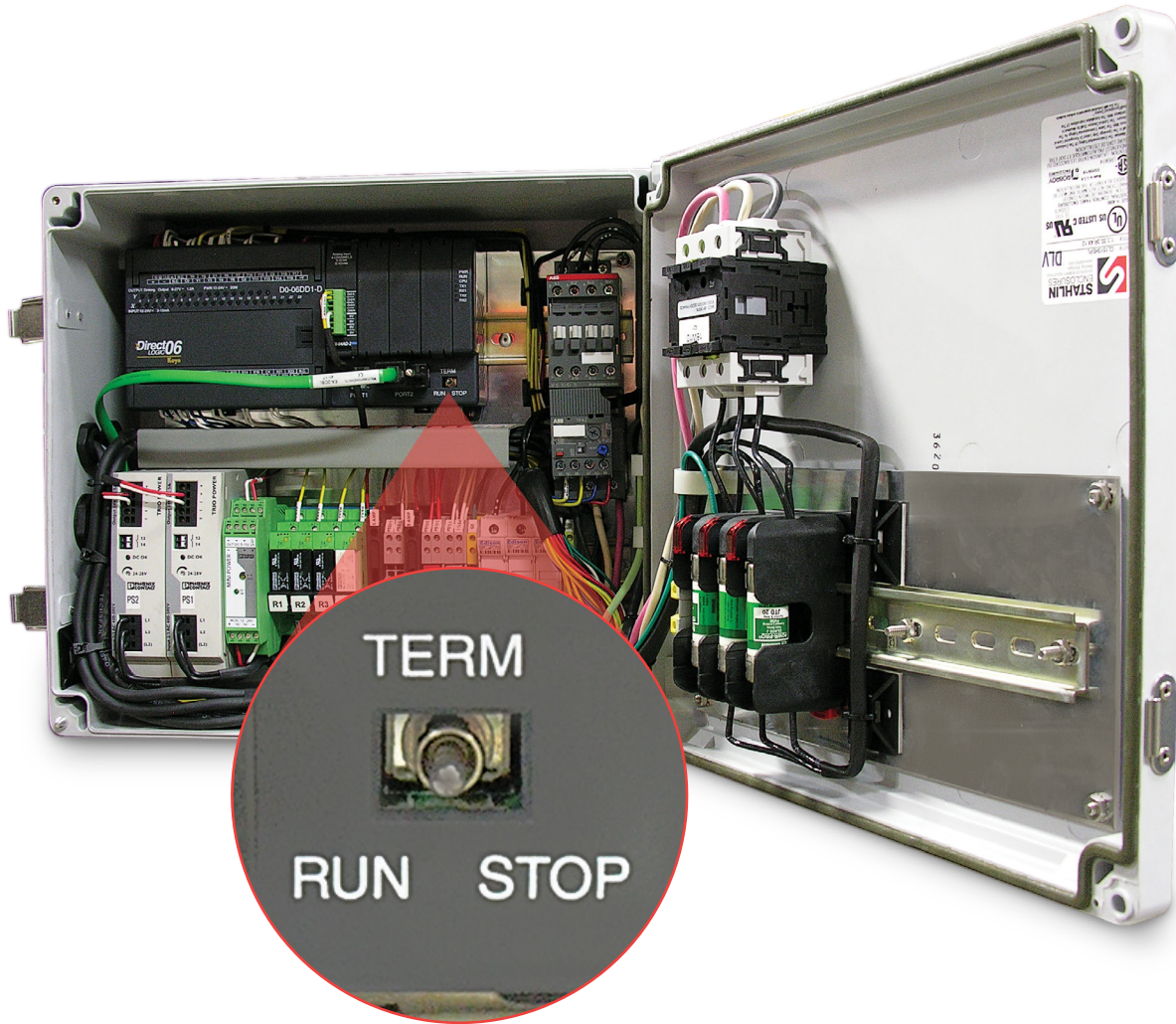


An electronic Back Stop is available. Set up is identical, but when the fitting touches the Coupling Stop, the crimp cycle will start automatically.

**CAUTION: When using an electronic Coupling Stop, disconnect it from the controller prior to setup. Failure to do so will cause the crimper to actuate during the set up process.**



# IC485 PLC Reset Procedure



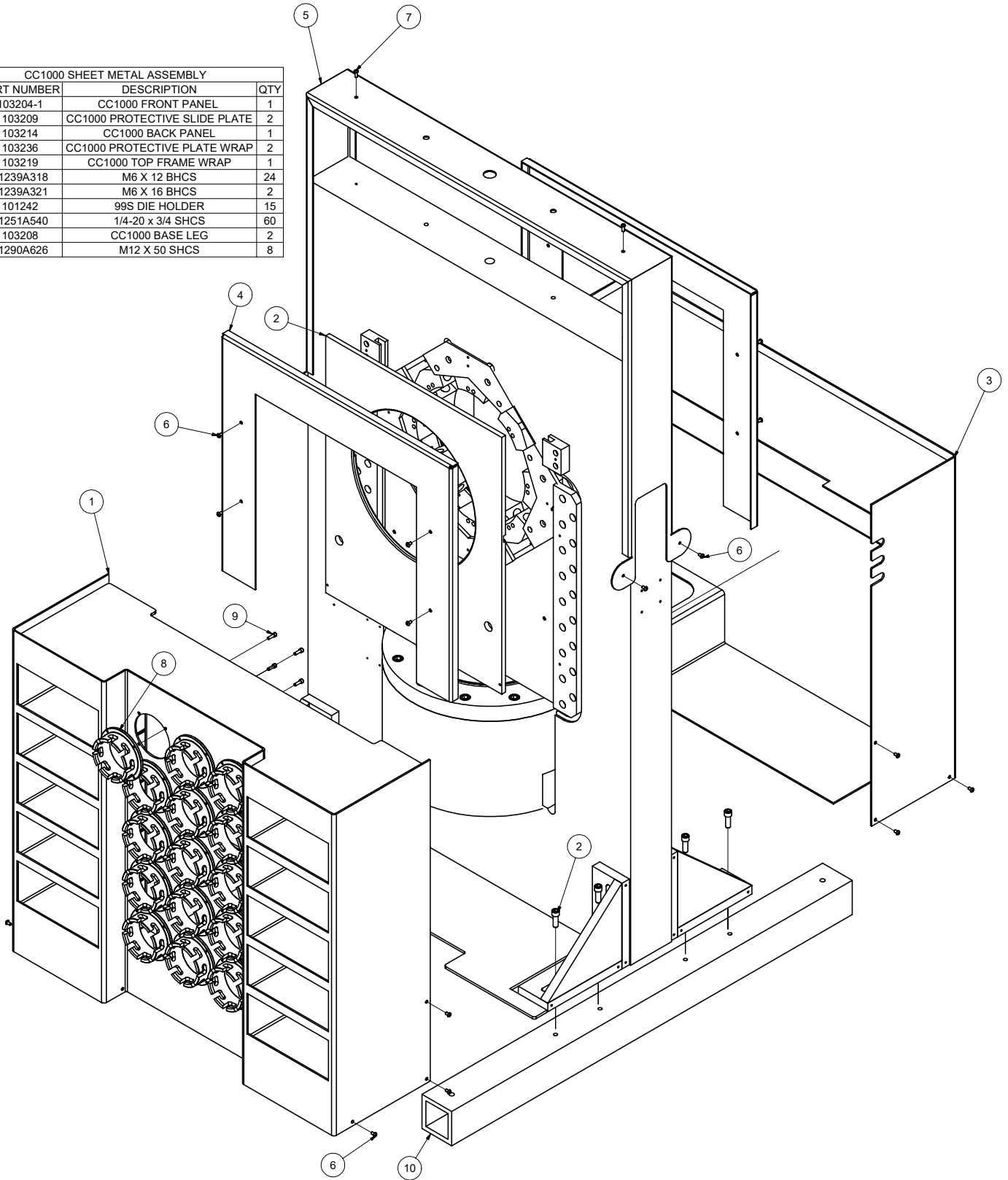
The PLC (Programmable Logic Controller) requires a relatively constant source of electrical power. Power surges, outages or drops in power can cause the PLC to lose its settings. This may result in missing or misplaced information on the controller screen.

## Resetting the PLC to its original settings

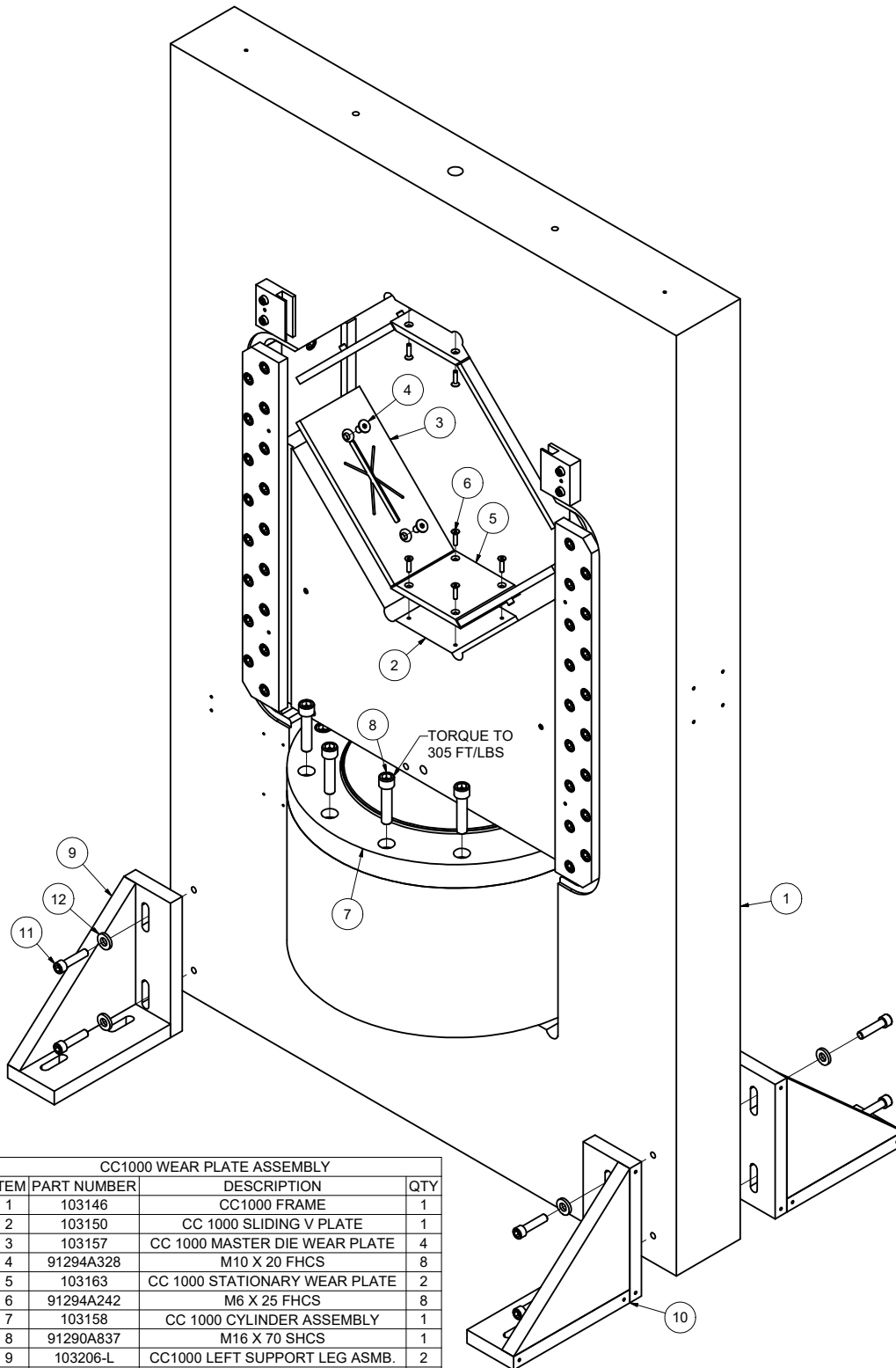
- Open the back electrical enclosure.
- Power up the crimper from the main power switch. The crimper must be powered on during the PLC reset procedure.
- Move the three position toggle switch on front of the PLC right to the STOP position and then left to the RUN position.
- Return the toggle switch to the center TERM position.
- Cycle the main power off and back on.
- The PLC and the crimper should now operate normally.
- Close the electrical enclosure.

# IC485 Component Parts Breakdown

CC1000 SHEET METAL ASSEMBLY			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103204-1	CC1000 FRONT PANEL	1
2	103209	CC1000 PROTECTIVE SLIDE PLATE	2
3	103214	CC1000 BACK PANEL	1
4	103236	CC1000 PROTECTIVE PLATE WRAP	2
5	103219	CC1000 TOP FRAME WRAP	1
6	91239A318	M6 X 12 BHCS	24
7	91239A321	M6 X 16 BHCS	2
8	101242	99S DIE HOLDER	15
9	91251A540	1/4-20 x 3/4 SHCS	60
10	103208	CC1000 BASE LEG	2
11	91290A626	M12 X 50 SHCS	8



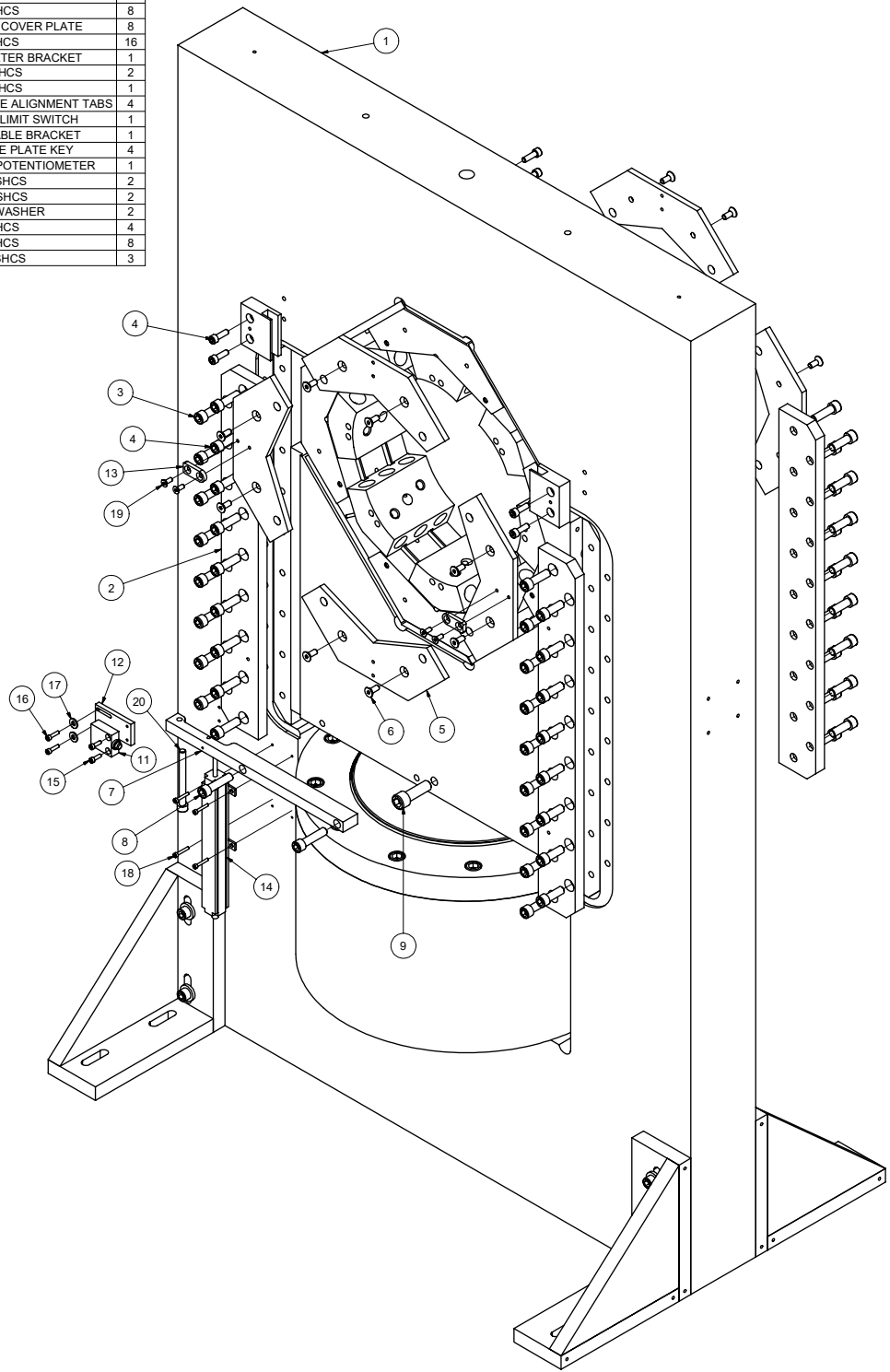
# IC485 Component Parts Breakdown



CC1000 WEAR PLATE ASSEMBLY			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103146	CC1000 FRAME	1
2	103150	CC 1000 SLIDING V PLATE	1
3	103157	CC 1000 MASTER DIE WEAR PLATE	4
4	91294A328	M10 X 20 FHCS	8
5	103163	CC 1000 STATIONARY WEAR PLATE	2
6	91294A242	M6 X 25 FHCS	8
7	103158	CC 1000 CYLINDER ASSEMBLY	1
8	91290A837	M16 X 70 SHCS	1
9	103206-L	CC1000 LEFT SUPPORT LEG ASMB.	2
10	103206-R	CC1000 RIGHT SUPPORT LEG ASMB.	2
11	91290A626	M12 X 50 SHCS	8
12	91166A290	M12 WASHER	8

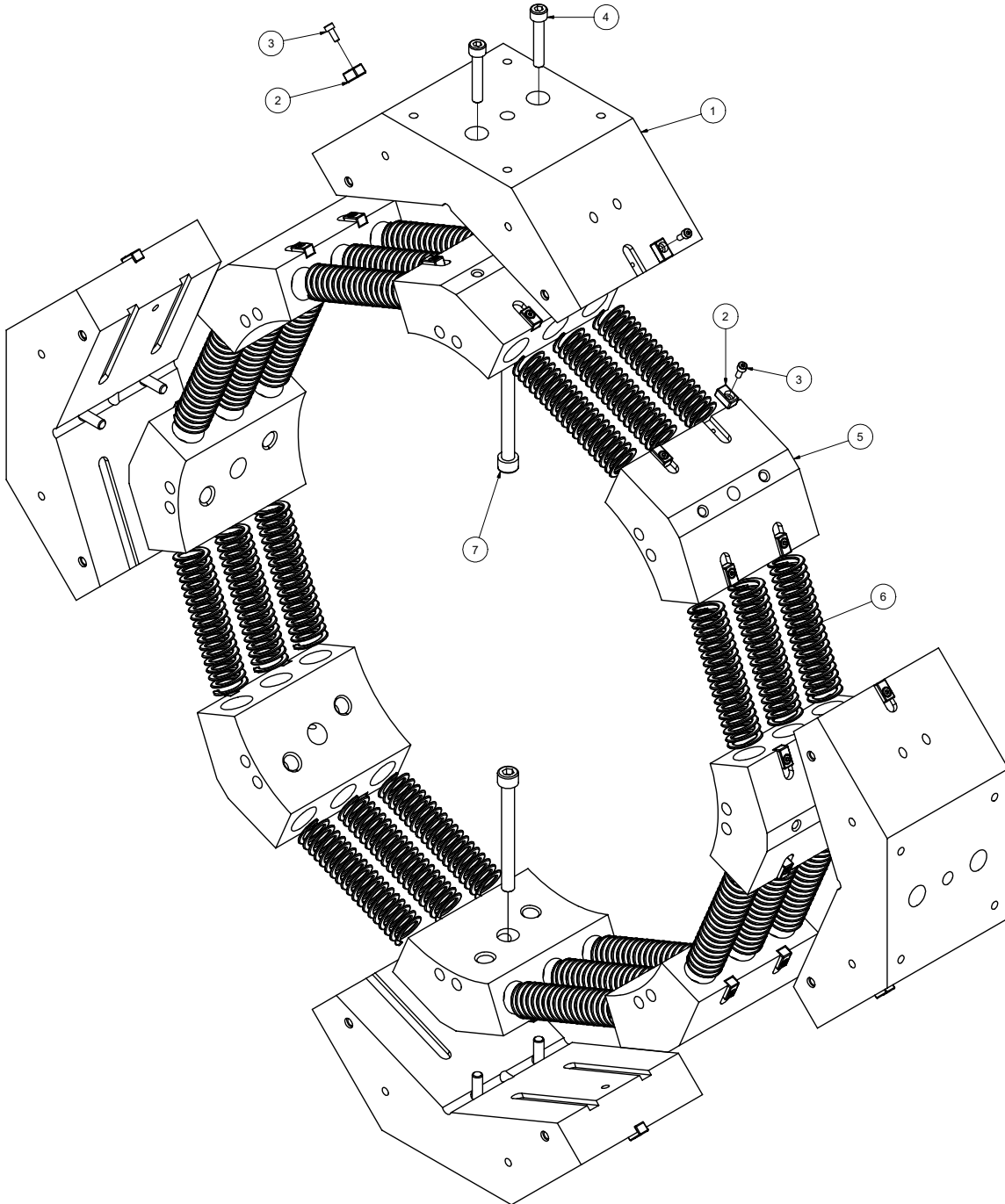
# IC485 Component Parts Breakdown

CC1000 PROTECTIVE PLATES AND GUIDES ASSEMBLY			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103146	CC1000 FRAME	1
2	103193	CC 1000 SIDE GUIDE PLATE	4
3	91290A620	M12 X 35 SHCS	68
4	91290A432	M8 X 25 SHCS	8
5	103196	CC 1000 MASTER DIE COVER PLATE	8
6	91294A284	M8 X 20 FHCS	16
7	103248	CC1000 POTENTIOMETER BRACKET	1
8	91290A626	M12 X 50 SHCS	2
9	91290A820	M16 X 50 SHCS	1
10	103230	CC1000 PROTECTIVE PLATE ALIGNMENT TABS	4
11	103473	CC600/1000 ROLLER LIMIT SWITCH	1
12	103349	CC600/1000 ADJUSTABLE BRACKET	1
13	103448	CC1000 PROTECTIVE PLATE KEY	4
14	103472	CC600/CC1000 LINEAR POTENTIOMETER	1
15	91251A244	10-24 X 5/8 SHCS	2
16	91251A345	10-24 X 3/4 SHCS	2
17	91255A549	10-24 ROUND WASHER	2
18	91290A176	M4 X 25 SHCS	4
19	91294A237	M6 X 14 FHCS	8
20	91290A548	M10 X 100 SHCS	3



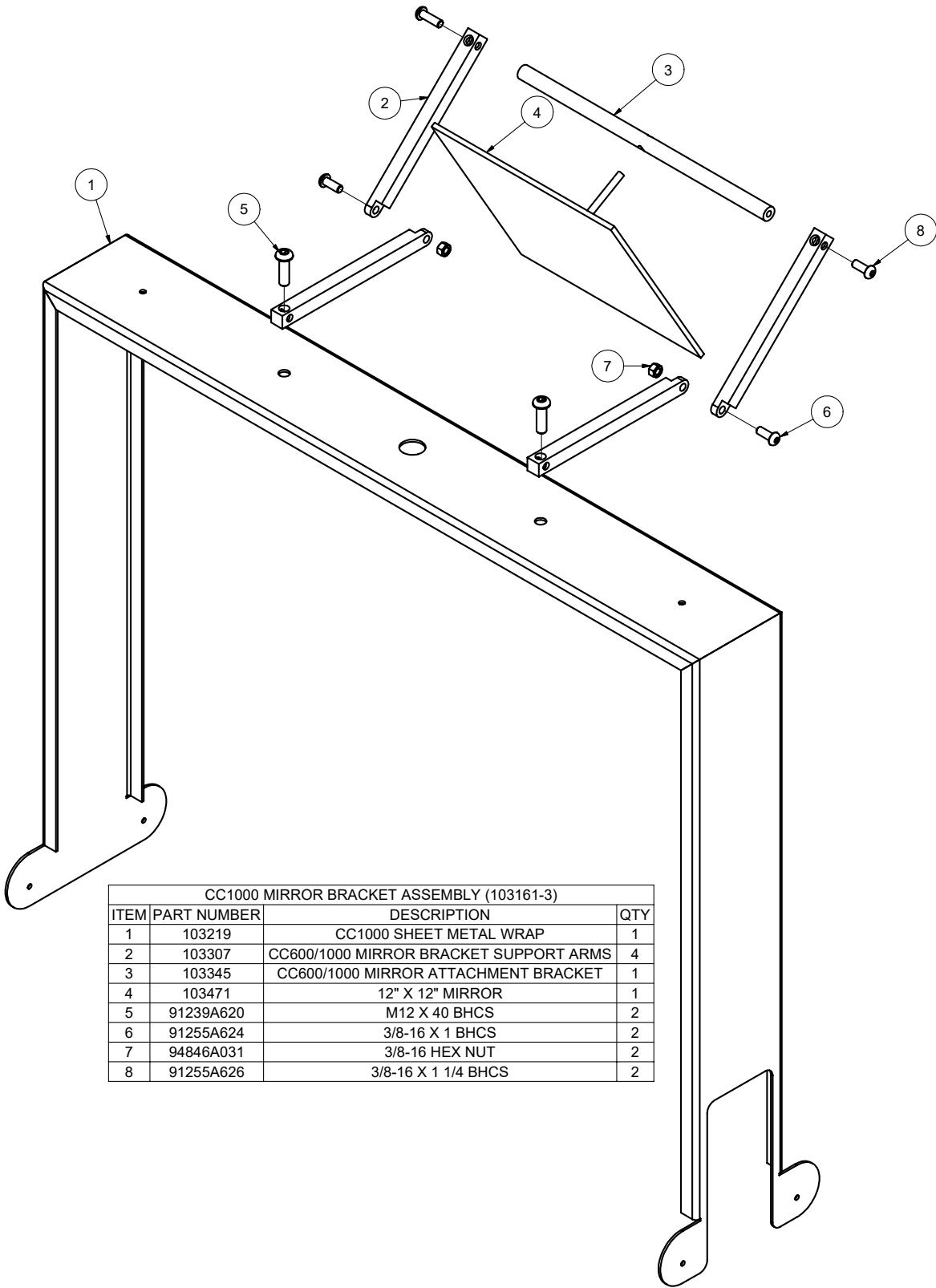


# IC485 Component Parts Breakdown



CC1000 MASTER DIE ASSEMBLY			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103147	CC1000 MASTER DIE CARRIER	4
2	103249	CC1000 MASTER DIE ALIGNMENT NUT	40
3	91290A144	M4 X 10 SHCS	40
4	91290A446	M8 X 45 SHCS	8
5	103156	CC1000 MASTER DIE SHOE	8
6	103470	DIE SPRING	24
7	91290A548	M10 X 100 SHCS	2

# IC485 Component Parts Breakdown



CC1000 MIRROR BRACKET ASSEMBLY (103161-3)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	103219	CC1000 SHEET METAL WRAP	1
2	103307	CC600/1000 MIRROR BRACKET SUPPORT ARMS	4
3	103345	CC600/1000 MIRROR ATTACHMENT BRACKET	1
4	103471	12" X 12" MIRROR	1
5	91239A620	M12 X 40 BHCS	2
6	91255A624	3/8-16 X 1 BHCS	2
7	94846A031	3/8-16 HEX NUT	2
8	91255A626	3/8-16 X 1 1/4 BHCS	2

# IC485 Replacement Parts



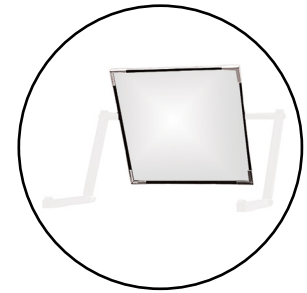
InfoCrimp™ 10 inch Tablet  
P/N:105001



InfoCrimp™ Digital Caliper IN/MM  
P/N:105002



InfoCrimp™ Bluetooth Dongle  
P/N:104996



CC-Mirror  
P/N:103471



Quick Change Tool  
99mm Die Series P/N: 102571



CC-Foot Switch  
P/N:CC-FOOTSWITCH



Manual Back Stop  
P/N: MBS-60



Industrial Die Compartment  
P/N: 103572-Red



IC265/IC350/IC485/IC830  
Intermediate Die Removal  
T-Handle Hex P/N: 6954A25



Industrial Hose O.D Tape  
(Pi Tape) P/N:103901



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



84S/99S/160S/230S  
Die Lock Stud  
P/N: 101582



130S/145S  
Die Lock Stud  
P/N: 101403



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

# IC485 Troubleshooting

## **PROBLEM: THE CRIMPER WILL NOT RUN AT ALL:**

- Check the E-Stop switch to be certain that is not depressed. A slight twist is required to release switch after it has been depressed.
- The PLC (Programmable Logic Control) must be reset. See instructions on the previous page.

## **PROBLEM: THE CRIMPER RUNS BUT IS SLOW OR NON-FUNCTIONAL:**

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

### **Note:**

- For three phase units rotation can be reversed by switching any two wires in the plug.

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

- Position the master dies to the fully opened position and check the hydraulic oil level in the sight glass window on the front of the reservoir. Be sure that the oil level is in the middle of the sight glass window.

### **Note:**

- Use ISO grade 46 hydraulic oil.

## **PROBLEM: THE CRIMPER WILL NOT OPEN TO RETRACT POSITION IN AUTO MODE:**

- The retract position must be at least 3 mm larger than the final crimp diameter.

**If problems persist contact Customer Service for additional troubleshooting assistance.**

# IC485 Warranty

## Custom Crimp® “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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[www.customcrimp.com](http://www.customcrimp.com) (219) 462-6128

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