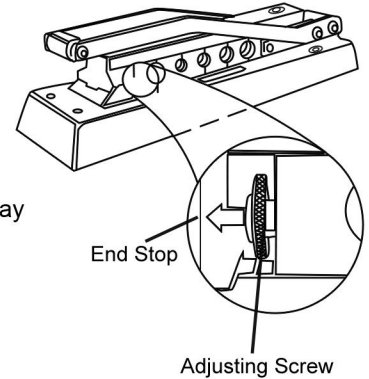
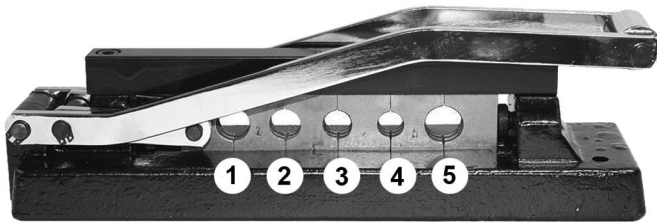


## HOSE FERRULE CRIMPING TOOL INSTRUCTION MANUAL

The Hose Ferrule Crimping Tool H8 is equipped with mounting holes for permanent installations on a work Bench, or may be used as a portable tool for hose assembly in the field. Crimps 1/4" to 3/8" I.D. hose in either one or two braid design

### IMPORTANT! BEFORE USING THIS TOOL:

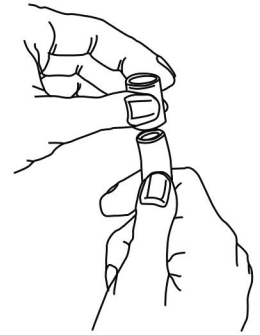
Make sure the crimping arm is in the closed (down) position and then set the adjusting screw so it touches the end stop. The screw should never be set tighter than this end stop. When using oversized hoses, the screw may be set looser to avoid crimping too deeply.



### OPERATION:

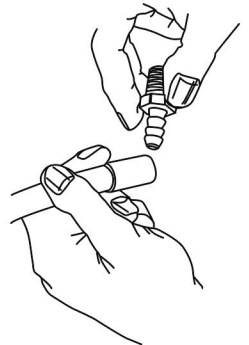
#### A. FERRULE

The proper ferrule should slip fit easily over the hose. Ideally, the ferrule should not fall off the hose when the hose is held vertically. It is better to use a slightly oversized ferrules as an undersized ferrule may make inserting the barbed fitting difficult. The chart below is just a guide, Rubber hose tolerances can vary up to  $\pm 1/32$ " on the outside diameter, so it is necessary to fit ferrules and fittings to each individual hose.



#### B. BARBED FITTING

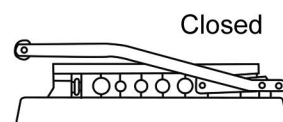
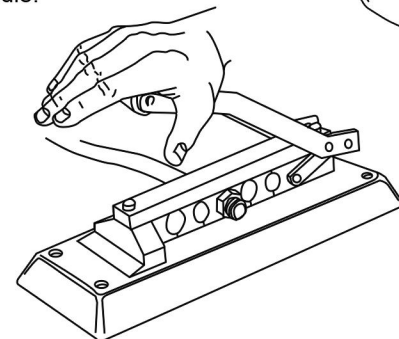
Dip the ferrule end of the hose into soapy water. Insert the chosen barbed fitting into the hose with a fair amount of force (even after being lubricated with soapy water). A barbed fitting that slides into a hose too easily will not crimp properly.



#### C. CRIMPING DIE

To find the proper crimping die, find the smallest die opening (H8 in closed position) which the hose will just pass through freely. Use the next smallest die to crimp. To crimp, center ferrule in the proper die and depress the crimping arm fully, making sure to keep fingers up and out of the way. Open the H8, rotate the hose one quarter turn and repeat to finish the crimp. The chart below is an approximate guide for choosing the proper die.

DIE#	DIE I.D.	STANDARD HOSE	DIE MODEL
#1	0.630	1/4" or 5/16" I.D. x 5/8" O.D. D.B.	H8-Die1 H8-Die2
#2	0.580	Undersize 5/8" O.D. D.B.	H8-Die2 H8-Die3
#3	0.530	Undersize 9/16" or Oversize 1/2" O.D.	H8-Die3 H8-Die4
#4	0.480	1/4" I.D. x 1/2" O.D. S.B.	H8-Die4 H8-Die5
#5	0.680	3/8" I.D. x 22/32" O.D. D.B.	H8-Die5 H8-Die6



Closed

Open

I.D. = Inside Diameter (inches)  
O.D. = Outside Diameter (inches)

D.B. = Double Braid  
S.B. = Single Braid