



Flo Supply Hose Crimp Machine And Dies

PART NUMBER: 60-20000

INSTALLATION INSTRUCTIONS

The Flo Supply Portable Hose Crimper is the perfect solution for small production or do it yourself projects. This Light weight hose crimper is easy to use and calibrate. The adjustable crimp position provides the ability to lock the crimper into a vertical position making it easier for transporting. Designed to work in conjunction with Flo Supply Crimp Hose Ends. Review the Flo Supply Crimp Spec chart to cross reference which dies are needed to properly crimp different Flo Supply Hose and fittings.

Features:

- Pneumatic operation for shop, home, or in the field use.
- Easy to set analog hose crimp depth set for easily repeatable crimps
- Die sizes ranging from 4AN - 20AN (10mm - 38mm)
- Powerful hydraulic ram produces 35tons of pressure for crimping
- The crimper's pusher has a cutout to allow for angled hose ends.
- Battery powered indicator to show when the crimp is complete.
- Heavy duty power with lightweight portability.
- Two piece die design gives visibility for aligning hose being crimped.

Available Die Sizes:

- 60-20000-D10
- 60-20000-D13
- 60-20000-D15
- 60-20000-D19
- 60-20000-D23
- 60-20000-D27
- 60-20000-D30
- 60-20000-D34
- 60-20000-D38



Initial Machine Setup:

- Mount the tubular steel frame of the machine to a workbench or something sturdy for use. If being used in a the field pack in a padded case between uses.
- The quick disconnect 10000psi Hydraulic hose needs to be installed between the foot pedal and the main hydraulic ram. Do not kink or put strain on the hose so position the pedal near enough to the machine where it does not put any part of the system in a bind.
- Store the dies, pressure crimp ring, and pusher where they can be protected from moisture and impacting each other. Nicks or damage on the surfaces can cause rapid wear on the machine.
- Never operate the machine without lubrication and store the machine greased or oiled to keep corrosion from damaging parts.



Step 1:

- Select Hose & Hose end assembly. Install hose end assembly on Hose. When selecting the hose type refer to the hose manufacturer to ensure it is compatible with the liquid or gas that it will be used with. Also make note of and never exceed the pressure ratings for a hose.

Note*: If using heat shrink to cover the crimped collar for cosmetic reasons. Install 2 lengths before putting the hose ends on the hose.



Step 2:

- Using Calipers measure the crimp collar to verify before crimp measurement. Then compare the measurement to the crimp chart on page 6.

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Nitro Dave's LLC accepts NO responsibility for injuries or damages resulting during and/or from the installation of any product(s). All products are intended for off-road use only.

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Step 3:

- Refer to the chart to select the correct die size. The die sizes are different between PTFE and Rubber hose for the same AN size.



Step 4:

- Lubricant comes with the hose crimp machine. Lubricate the “Fingers” of the die where the pressure ring rides as well as a light coat between the fingers.



Step 5:

- Apply lubricant to the pressure plate where the die sits during crimping.



Step 6:

- Place the back half of the die in the holder and ensure that the hose crimp collar fits within the fingers.

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Step 7:

- Place the front half of the die on the pressure plate and lubricate the inside surface of the crimp pressure ring.



Step 8:

- Insert the hose end to be crimped where the top of the crimp pressure ring sits evenly with the top of the die fingers and press with firm pressure the ring down to keep the hose in place.



Step 9:

- Place the pusher on the bottom of the hydraulic ram by sliding it from the front or at any angle to accommodate the hose end that will be crimped.

Note*: It can swivel or pivot to any angle but make sure it does not slide off the back.



Step 10:

- Now to prepare the machine for the crimp. Set the micrometer to the appropriate depth according to the chart included below. Subtract the final crimp diameter from the die size and this will give you the value to set the micrometer to.

Example: 12AN hose end finishing at 28.8mm would need to be as follows
 $28.8\text{mm (finished crimp diameter)} - 27\text{mm (die size)} = 1.8\text{mm crimp depth. (shown)}$

Note*: Each full rotation is 1mm and then the decimal on the rotating ring is .1mm

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Step 11:

- Before crimping, press the button to test that the light illuminates. This light will indicate that the crimper has reached the correct depth setting on the micrometer. This button only serves to show that the crimp is complete. It does not stop the machine automatically.



Step 12:

- An air compressor can be hooked up and the machine is ready to crimp. Clean dry air at 100Psi with air / water separators are encouraged.



Step 13:

- Press the back half of the pedal to crimp. The process takes around 10 seconds depending on pressure and hose size. Watch the red light for when the crimp is complete and release as soon as it lights.



Step 14:

- The crimper will remain tight until the front half of the pedal is pressed at which point the ram will retract.

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Step 15:

- Once the ram has retracted remove the pusher and the crimp pressure ring from the crimper.



Step 16:

- The crimp is complete.



Step 17:

- Using Calipers measure the crimp collar to verify after crimp measurement. Then compare the measurement to the crimp chart on page 6.



Step 18:

- Visually inspect the hose, clean any debris with compressed air or a gentle cleaner. Leak and or pressure test the hose to the manufacturer's specifications.

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CRIMP & DIE SET SPEC CHART

Hose Material:	Fitting Size:	Hose PN#	Hose End PN#	Die Size	Before Crimping		After Crimping		Micrometer Setting
					mm	in	mm	in	
Stainless Steel Braided Hose - PTFE Liner	4AN	60-58204-04	60-22xxx-04	10 mm	13.3 mm	0.524 in	11.1 mm	0.437 in	1.1 mm
	6AN	60-58204-06	60-22xxx-06	13 mm	16.1 mm	0.634 in	14.1 mm	0.555 in	1.1 mm
	8AN	60-58204-08	60-22xxx-08	15 mm	18.73 mm	0.737 in	16.7 mm	0.657 in	1.7 mm
	10AN	60-58204-10	60-22xxx-10	19 mm	22.9 mm	0.902 in	20.8 mm	0.819 in	1.8 mm
	12AN	60-58204-12	60-22xxx-12	23 mm	26 mm	1.024 in	24 mm	0.945 in	1 mm
	16AN	60-58204-16	60-22xxx-16	30 mm	33.05 mm	1.301 in	30.7 mm	1.209 in	0.7 mm
	20AN	60-58204-20	60-22xxx-20	34 mm	38 mm	1.500 in	36.17 mm	1.424 in	2.17 mm
Black Nylon Covered Stainless Steel Braided Hose - PTFE Liner	4AN	60-58206-BLK-04	60-22xxx-04	10 mm	13.3 mm	0.524 in	11.4 mm	0.449 in	1.4 mm
	6AN	60-58206-BLK-06	60-22xxx-06	13 mm	16.1 mm	0.634 in	14.1 mm	0.555 in	1.1 mm
	8AN	60-58206-BLK-08	60-22xxx-08	15 mm	18.73 mm	0.737 in	17 mm	0.669 in	2 mm
	10AN	60-58206-BLK-10	60-22xxx-10	19 mm	22.9 mm	0.902 in	20.9 mm	0.823 in	1.9 mm
	12AN	60-58206-BLK-12	60-22xxx-12	23 mm	26 mm	1.024 in	24 mm	0.945 in	1 mm
	16AN	60-58206-BLK-16	60-22xxx-16	30 mm	33.05 mm	1.301 in	31.3 mm	1.232 in	1.3 mm
	20AN	60-58206-BLK-20	60-22xxx-20	34 mm	38 mm	1.500 in	36.9 mm	1.453 in	2.9 mm
Stainless Steel Braided Hose - Rubber Liner	4AN	60-58201-04	60-21xxx-04	13 mm	14.7 mm	0.579 in	13.2 mm	0.520 in	0.2 mm
	6AN	60-58201-06	60-21xxx-06	15 mm	17.85 mm	0.703 in	16.2 mm	0.638 in	1.2 mm
	8AN	60-58201-08	60-21xxx-08	19 mm	22.1 mm	0.870 in	20.5 mm	0.807 in	1.05 mm
	10AN	60-58201-10	60-21xxx-10	23 mm	25.7 mm	1.012 in	23.6 mm	0.929 in	0.6 mm
	12AN	60-58201-12	60-21xxx-12	27 mm	31.2 mm	1.228 in	28.8 mm	1.134 in	1.8 mm
	16AN	60-58201-16	60-21xxx-16	30 mm	35.1 mm	1.382 in	32.8 mm	1.291 in	2.8 mm
	20AN	60-58201-20	60-21xxx-20	38 mm	41.8 mm	1.646 in	39.6 mm	1.559 in	1.6 mm
Black Nylon Covered Stainless Steel Braided Hose - Rubber Liner	4AN	60-58202-BLK-04	60-21xxx-04	13 mm	14.7 mm	0.579 in	13.1 mm	0.518 in	0.1 mm
	6AN	60-58202-BLK-06	60-21xxx-06	15 mm	17.85 mm	0.703 in	16.2 mm	0.638 in	1.2 mm
	8AN	60-58202-BLK-08	60-21xxx-08	19 mm	22.1 mm	0.870 in	20.05 mm	0.789 in	1.05 mm
	10AN	60-58202-BLK-10	60-21xxx-10	23 mm	25.7 mm	1.012 in	23.6 mm	0.929 in	0.6 mm
	12AN	60-58202-BLK-12	60-21xxx-12	27 mm	31.2 mm	1.228 in	28.8 mm	1.134 in	1.8 mm
	16AN	60-58202-BLK-16	60-21xxx-16	30 mm	35.1 mm	1.382 in	32.5 mm	1.280 in	2.5 mm
	20AN	60-58202-BLK-20	60-21xxx-20	38 mm	41.8 mm	1.646 in	39.31 mm	1.548 in	1.31 mm



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