



CS205



CS205-CS206 HYDRAULIC HOSE CRIMPER OPERATORS MANUAL

Models Covered:
CS205 (2 HP - 220V SINGLE PHASE)
CS206 (1 HP - 110V)



SAFETY PRECAUTIONS



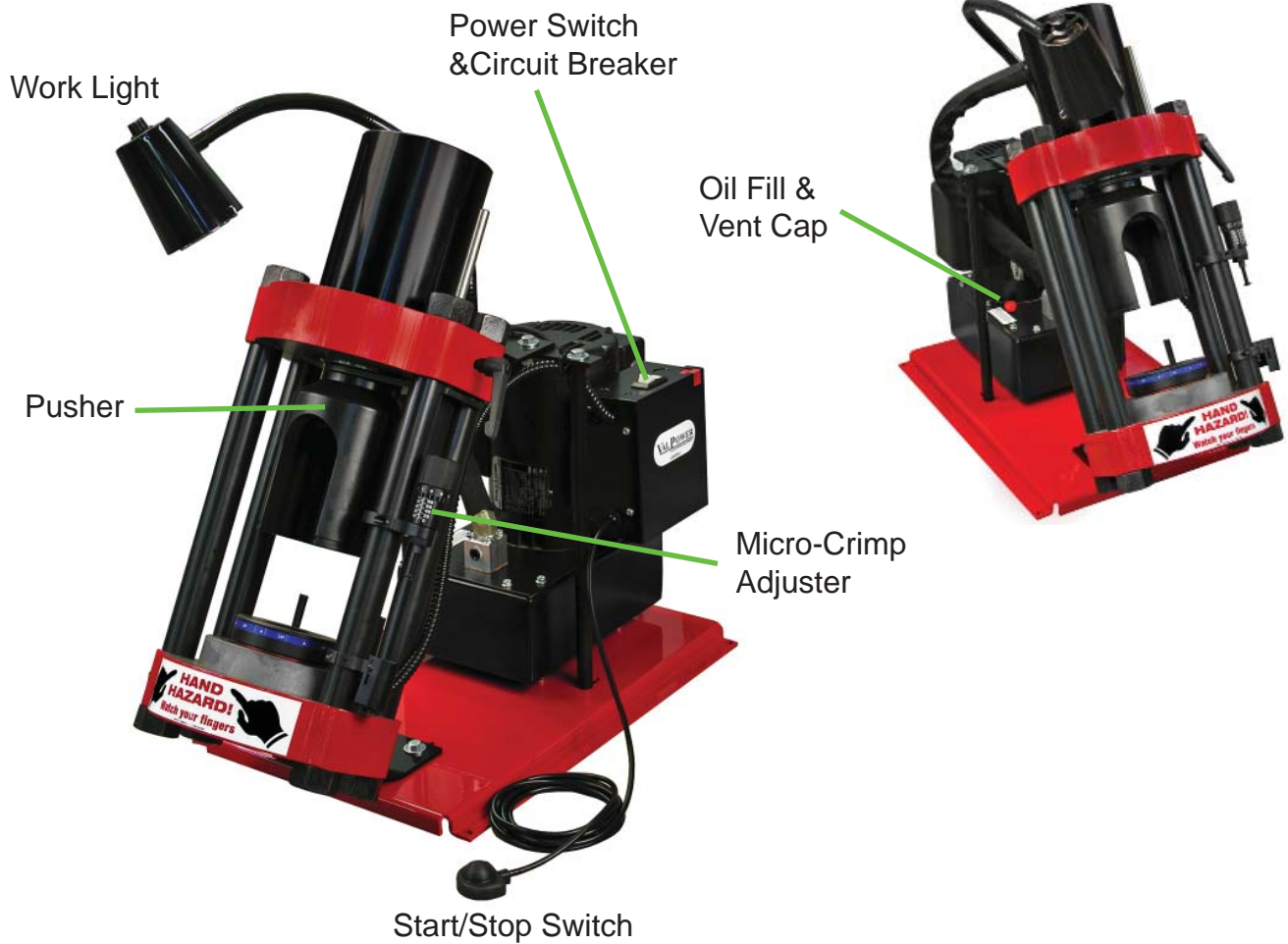
READ AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER

CRIMPER CAN PRODUCE 80 TONS OF FORCE. KEEP BOTH HANDS AWAY FROM PINCH POINTS

CONSULT HOSE AND FITTING MANUFACTURERS SPECIFICATIONS FOR CORRECT MACHINE SETTINGS AND CRIMP MEASUREMENTS.

ALWAYS WEAR EYE PROTECTION

For Parts and Service, Contact:
Couplamatic Systems, Inc.
Scottsbluff, NE 69361
(308) 632-2112



Bent Tube
Pusher Plate



Standard
Pusher Plate



CC020 Die
Series
(Not included)



Cone Insert

Die Stack with
CC020 Series Dies

CC032 Die
Series
(Not included)

Large Pusher Plate



Die Stack with
CC032 Series Dies

Die Series (1)-----	CC020/CC032
Maximum Cylinder Force-----	80 Ton
Maximum Hose Diameter (2 Wire)-----	2"
Maximum Hose Diameter (4 Wire)-----	2"
Maximum Hose Diameter (6 Wire)-----	2"
Crimper Depth-----	32"
Crimper Width-----	16.5"
Crimper Height-----	28.5"
Weight-----	420 Lb
Pump-----	Electric
Maximum Pump Pressure-----	10,000psi
Pump HP (D205WB)-----	2 HP (220V)
Pump HP (D206WB)-----	1 HP (110V)
Reservoir Capacity-----	1 Gal
Oil Type-----	ISO Viscosity Grade 46
Electric Power Requirement (D205WB)-----	220V 1 Ph
Electric Power Requirement (D206WB)-----	110V

(1) Dies Interchange with Dayco NP and WB Series



FOLLOW THESE STEPS BEFORE USING THE CRIMPER FOR THE FIRST TIME

■ Remove reservoir plug and replace with Oil Fill and Vent Cap. The Oil Fill and Vent cap and the work light bulb are found in the accessories box. *(Note that the CS205 work light is furnished with a special 220 volt bulb. Do not replace with a standard 110 volt bulb)*

■ Place the crimper on a sturdy bench in a well lit area, and plug the crimper directly into a 220V Single Phase outlet (CS205) or a 115 V 15 Amp wall outlet (CS206). *Do not run the crimper on an extension cord as low voltage can damage the motor.*

■ The oil level in the pump should be approximately 1-1/2 inches below the fill plug. If necessary, replenish with ISO Viscosity Grade 46 hydraulic oil.

Note: The crimper is calibrated prior to shipment, but a calibration check is recommended prior to using the crimper for the first time.

■ Lubricate all contact surfaces and place the Cone Insert, any CC020 Series die set and the Standard Pusher in the crimper in the order shown. Note that a hose and fitting are not required for an initial calibration check. *Note: failure to lubricate all contact surfaces can cause the Cone Insert and/or the dies to seize in the cone base.*

■ Slide the Pusher onto the stud on the hydraulic ram.

■ Set the Micro-Crimp adjuster at "95"

■ Press and hold the start switch bulb.

■ If the ram extends and the crimper shuts off approximately 1 second after the dies are completely closed and the pump starts to build pressure, the crimper is correctly calibrated.

■ If the time to shut off is not approximately 1 second, the crimper must be recalibrated. Recalibrate as follows:



CALIBRATION INSTRUCTIONS

■ Hold the micrometer barrel with a 5/16 inch open end wrench and rotate the stem either in or out with a 5/32 inch hex key wrench.

■ If the motor shuts off too quickly or before the dies are completely closed, rotate the stem in.

■ If the motor does not shut off or shuts off in substantially more than 1 second, rotate the stem out.

■ Recheck calibration.





Lubricate all contact surfaces of the cone insert and place it squarely in the base of the crimper.



Lubricate die fingers, all contact surfaces and die cones.
WARNING: Failure to lubricate will cause damage to die sets and crimper.



Alignment of the hose and fitting in the die set is shown. Reference hose and fitting manufacturers specifications for correct locations



Use care to be certain that the die halves do not overlap.



Place the die set and hose and fitting loosely in the cone insert.



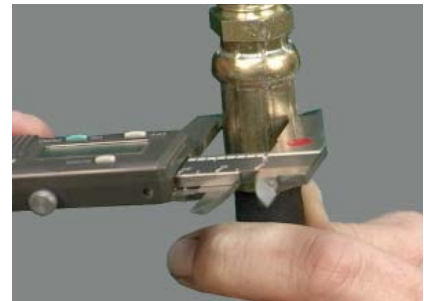
Place the Pusher Plate on top of the die set.



Slide the Pusher onto the stud on the hydraulic ram.



Press and hold the start switch until the motor shuts off.



Check the finished crimp diameter to be certain that it is within the hose and fitting manufacturers crimp specification limits.

Crimping with CC032 series dies is essentially identical to crimping with the CC020 series dies except that the Cone Insert is removed from the crimper base



Remove the Cone Insert from the crimper base and lubricate all contact surfaces of the die set.

WARNING: Failure to lubricate will cause damage to die sets and crimper



Insert the die set and Pusher Plate in the order illustrated.

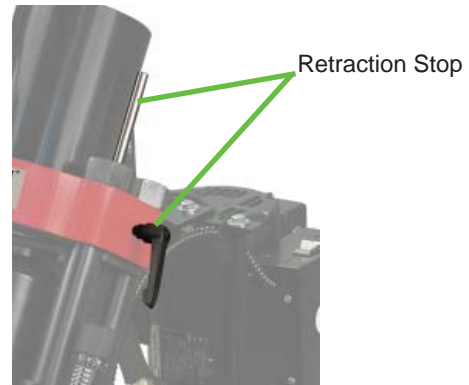


Align the hose and coupling as recommended. Load the Pusher Plate and Pusher and press and hold the start/stop switch until the crimper shuts off. Check the final crimp diameter to be certain that it is within specifications.

ADDITIONAL CS205/CS206 FEATURES



The easily removable Coupling Stop makes repetitive crimps faster by not having to visually align the fitting before each crimp.



The adjustable retraction stop limits the retraction of the ram to only the amount required to easily remove the hose and fitting. This feature saves time when doing multiple crimps.

PROBLEM: CRIMPER WILL NOT RUN AT ALL

- The white rocker switch is also a circuit breaker. Check to see that the circuit breaker has not been tripped
- Check the wall outlet. The crimper comes from the factory wired for a 220 volt single phase (D205WB) or a 115 volt single phase circuit. (D206WB) Use of extension cords or outlets with inadequate power can damage the motor. Do not run the crimper from a portable power source.
- Check the stop switch mounted to the switch bracket under the Micro-Crimp Adjuster. This is a normally closed switch and if it does not close the crimper will not operate.
CAUTION: Do not operate the crimper with this switch jumpered as the pump will not shut off and the brackets can be damaged.
- Check the pneumatically actuated switch in the electrical box mounted on the motor. This switch controls power to the motor and is actuated with air pressure from the pendant switch bulb.

PROBLEM: CRIMP DIAMETER TOO LARGE

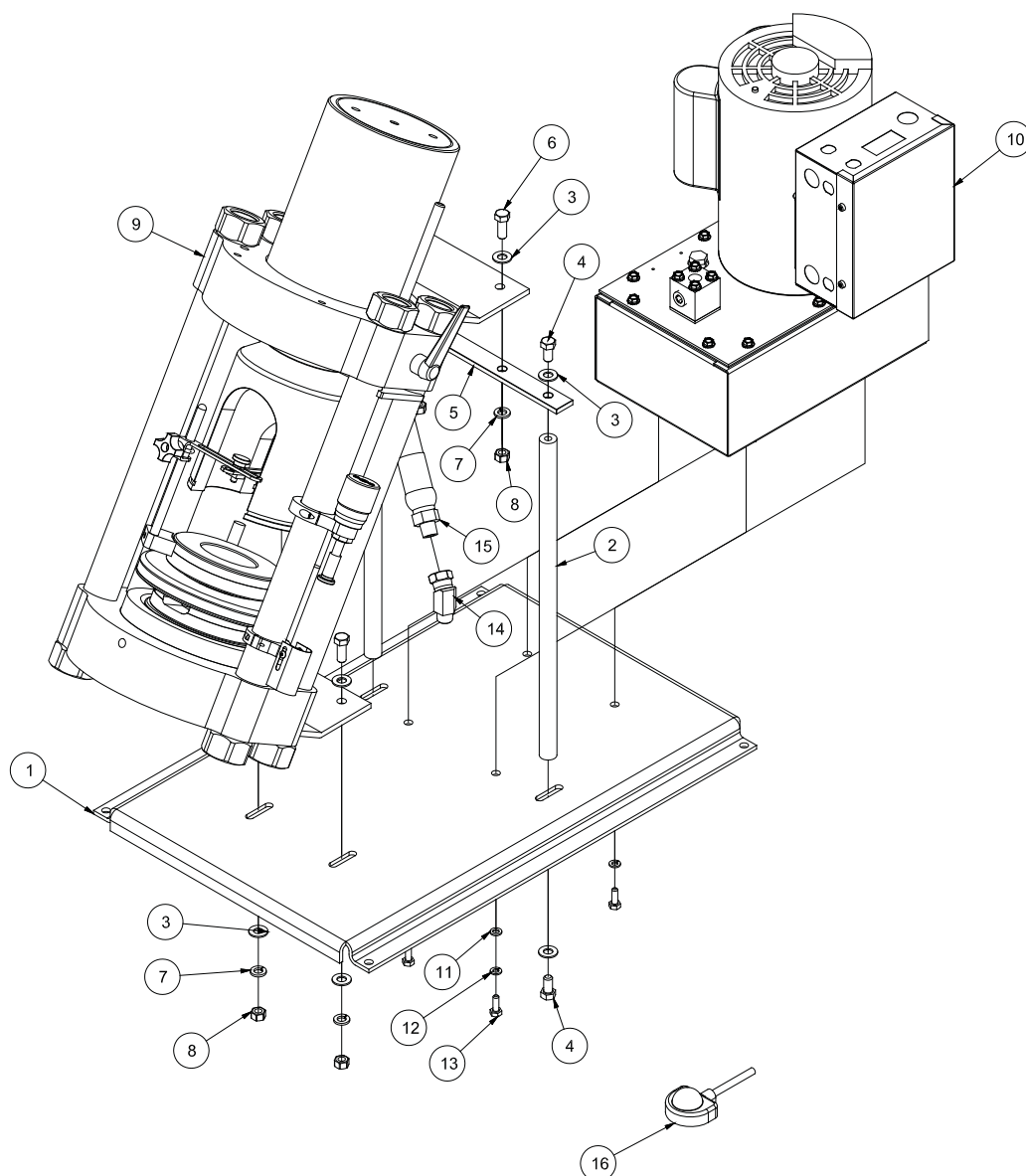
- Incorrect setting of the Micro-Crimp Adjuster. Check crimp specifications.
(NOTE: All published machine settings are approximate. To correct for slight variances, the gauge settings may be adjusted for the specific hose, fitting and size combination.)
- Incorrect die being used. Each die has a range of approximately 3mm (.120 in) above the closed diameter of the die. The closed diameter is the die size stamped on the die ring.
- Check crimper calibration and re-calibrate if required.
- Inadequate pump pressure. Check oil level in the pump. It should be 1-1/2 to 2 inches below the fill plug. Replenish with ISO Viscosity Grade 46 hydraulic oil.
- Inadequate lubrication of the dies and compression ring causing the pump to work harder than normal to reach the required diameter. Use only the grease shipped with the machine or equivalent.
- Inadequate pressure being generated by the pump. This is most likely if the crimper can crimp the smaller size hoses and not the larger hoses. When correctly adjusted, the pump should generate approximately 10,000 psi.
Do Not adjust pump to produce in excess of 10,000 psi as damage to components or personal injury may result.
- No pressure being generated by the pump. There should be a definite change in pitch of the pump as it cycles into high pressure mode and begins to "work" harder.

PROBLEM: CRIMP DIAMETER TOO SMALL

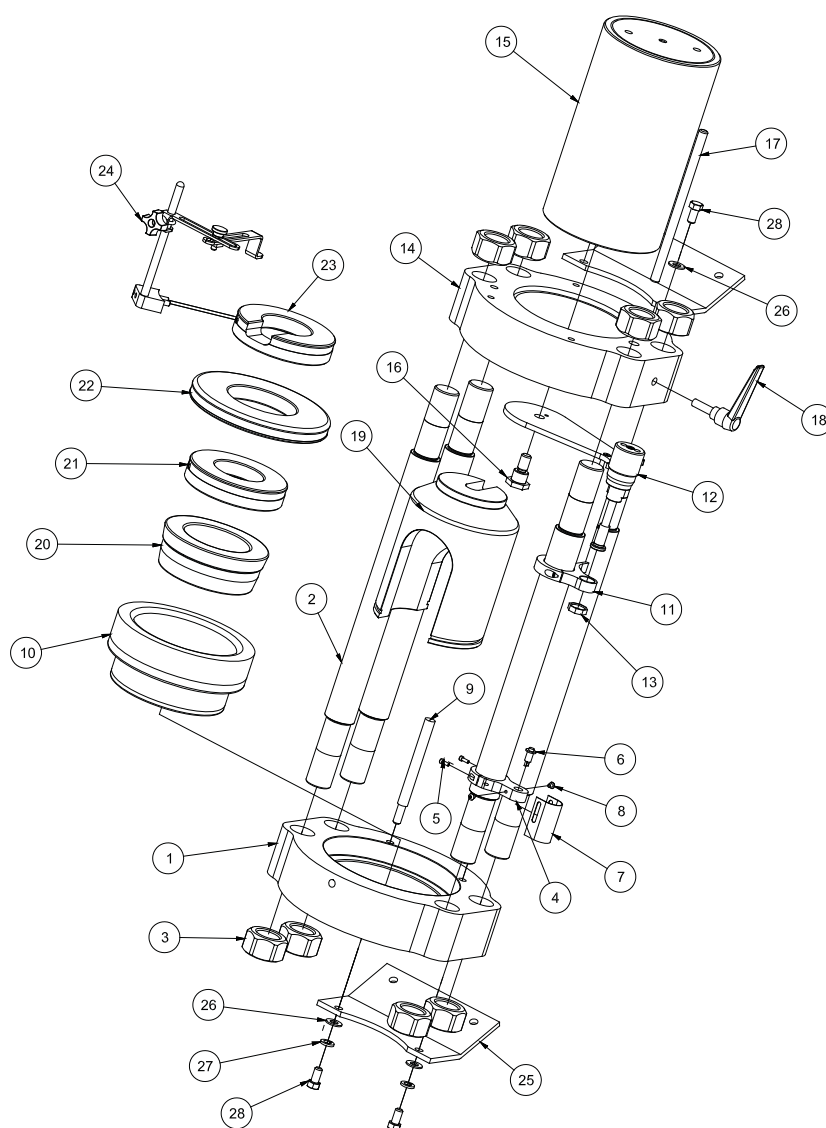
- Incorrect setting of the Micro-Crimp Adjuster. Check crimp specifications.
(NOTE: All published machine settings are approximate. To correct for slight variances, the gauge settings may be adjusted for the specific hose, fitting and size combination.)
- Incorrect die being used (See die range under Crimp Diameter too Large)
- Check crimp diameter and re-calibrate if necessary

PROBLEM: DIES STICKING IN COMPRESSION CONE

- Inadequate lubrication of the compression cone and die surfaces. Use only the grease shipped with the machine or equivalent.
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D205WB/D206WB Crimper Assembly (102265)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	101585	Crimper Base	1
2	101624	Support Rod	2
3	90126A031	3/8 Flat Washer	10
4	92865A622	3/8-16 X 3/4 Hex Bolt	4
5	101621	Support Rod Brace	1
6	92865A624	3/8-16 X 1 Hex Bolt	4
7	91102A031	3/8 Lock Washer	4
8	95462A031	3/8-16 Nut	4
9	101987	Crimper Head Assembly	1
10	101633	1HP Pump Assembly	1
10	102264	2HP Pump Assembly	1
11	90126A029	1/4 Flat Washer	4
12	91102A029	1/4 Lock Washer	4
13	92865A540	1/4-20 x 3/4 Hex Bolt	4
14	60TA06X08	45 Deg. Hydraulic Fitting	1
15	101645	Hydraulic Hose	1
16	101349	Pendant Switch & Plug	1



D205WB/D206WB Crimper Head Assembly (102263)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	100679	80-Ton Cone Base	1
2	100642	Strain Rod	4
3	90500A040	Heavy Hex Nut 1 1/4-12 Gd.8	8
4	100661	Limit Switch Bracket	1
5	91251A146	6-32 X 3/8 SHCS	2
6	903 Switch	Limit Switch	1
7	100692	Limit Switch Guard	1
8	91255A190	8-32 X 1/4 BHCS	2
9	101995	3/8 Dia. X 5 1/2 Pin	2
10	100643	Compression Cone	1
11	100641	Micrometer Mount Assembly	1
12	100628	Standard Micrometer Assembly	1
13	100727	Micrometer Nut	1
14	100640	80-Ton Top Flange	1
15	100663	80-Ton Cylinder Assembly	1
16	100648	Pusher Suspension Pin	1
17	100711	Stop Rod	1
18	100710	Stop Rod Locking Handle	1
19	100818	Pusher	1
20	100964	Cone Reducer	1
21	100915	NP Pusher Plate	1
22	100961	WB Pusher Plate	1
23	100960	NP Bent Tube Pusher Plate	1
24	100954	Coupling Stop Assembly	1
25	100680	Mounting Bracket	2
26	90126A031	3/8 Flat Washer	4
27	91102A031	3/8 Lock Washer	2
28	92865A622	3/8-16 X 3/4 Hex Bolt	4

CRIMP SPECIFICATIONS

Rev. 513



Crimp Data for Couplamatic Systems inc. <u>Vari-Crimp Couplings</u> using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)			
HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
3/16" 100R1AT	.520	95	0.530
3/16" 100R2AT	.520	87	0.575
1/4" 100R1AT & 100R16/2SC	.520	90	0.560
1/4" 100R2AT/2SN	.520	80	0.610
3/8" 100R1AT & 100R16/2SC	.670	84	0.740
3/8" 100R2AT/2SN	.670	74	0.790
1/2" 100R1AT & 100R16/2SC	.830	92	0.865
1/2" 100R2AT/2SN	.830	79	0.915
5/8" 100R16/2SC	.950	83	1.010
5/8" 100R2AT/2SN	.950	76	1.050
3/4" 100R1AT	1.100	84	1.160
3/4" 100R16 (R16CS)	1.100	88	1.135
3/4" 100R2AT	1.100	76	1.200
1" 100R1AT & R16CS	1.320	74	1.455
1" 100R2AT	1.500	92	1.520
1-1/4" 100R1AT	1.730	90	1.785
1-1/4" 100R2AT	1.730	73	1.850
1/4" HY-PLUS I & 1/4" R17R (1SN OD)	.520	90	0.560
3/8" HY-PLUS I & 3/8" R17R (1SN OD)	.670	84	0.740
1/2" HY-PLUS I & 1/2" R17R (1SN OD)	.830	92	0.865
3/4" HY-PLUS I	1.100	87	1.160
1" HY-PLUS I	1.320	74	1.455
1/4" HY-PLUS III	.520	90	0.560
3/8" HY-PLUS III	.670	84	0.740
1/2" HY-PLUS III	.830	92	0.865
5/8" HY-PLUS III	.950	83	1.010
3/4" HY-PLUS III	1.100	87	1.160
1" HY-PLUS III	1.320	74	1.455
1/4" 100R17 (REDUCED O.D.)	.520	95	0.520
3/8" 100R17 (REDUCED O.D.)	.670	90	0.695
1/2" 100R17 (REDUCED O.D.)	.830	95	0.835
5/8" 100R17 (REDUCED O.D.)	.950	83	1.010
3/4" 100R17 (REDUCED O.D.)	1.100	88	1.135
1" 100R17 (REDUCED O.D.)	1.320	77	1.425
1/4" DURA-HYD (DH17)	.520	90	0.560
3/8" DURA-HYD (DH16,DHEX16,DH17)	.670	84	0.740
1/2" DURA-HYD (DH16,,DHEX16 DH17).	.830	92	0.865
5/8" DURA-HYD (DH16,,DHEX16 DH17).	.950	83	1.010
3/4" DURA-HYD (DH16,DHEX16)	1.100	88	1.135
3/4" DURA-HYD (DH17)	1.100	87	1.160
1" DURA-HYD (DH16,DHEX16)	1.320	74	1.455

NOTE: Gauge settings are approximate and may vary due to machining tolerances of the dies.
After crimping verify the crimp O.D. with a caliper to ensure proper crimp dimensions.

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Crimp Data for Couplamatic Systems inc. GW Series Couplings using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)

HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
1/2" 100R12*	1.100	90	1.150
3/4" 100R12*	1.320	84	1.406
1" 100R12*	1.620	79	1.705
1 1/4" 100R12*	1.920	74	2.035
1 1/2" 100R12*	2.140	25	2.285
2" 100R12*	2.800	43	2.895
1" Dura-Hyd R17	1.500	74	1.655
1-1/2" 100R2AT (56MB-2)	2.140	31	2.270
2" 100R2AT (56MB-2)	2.800	45	2.890

NOTE: THE GW SERIES COUPLINGS REQUIRE NO SKIVE!

* CSI 100R12 SERIES SP580, RC12B, DHEXR12

Crimp Data for Couplamatic Systems inc. 4H Series Couplings using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)

HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER	SKIVE LENGTH
1/2" 100R12	.950	96	0.950	1-3/8"
3/4" 100R12	1.100	70	1.255	1-11/16"
1" 100R12	1.320	59	1.550	1-15/16"
1-1/4" 100R12	1.730	76	1.860	2-1/8"
1-1/2" 100R12	2.050	52	2.120	2-1/4"
2" 100R12	2.620	52	2.690	2-9/16"

NOTE: SKIVING THE COVER IS REQUIRED WITH 4H SERIES COUPLINGS

NOTE: CSI 100R12 SERIES SP580, RC12B, DHEXR12

Crimp Data for Couplamatic Systems inc. SX Series Couplings using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)

HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER	SKIVE LENGTH
3/4" 100R13	1.100	70	1.250	1-13/16"
1" 100R13	1.500	88	1.560	2-1/8"
1-1/4" 100R13	1.920*	40	2.025	2-7/8"
1-1/2" 100R13	2.300	54	2.365	3-1/8"
2" 100R13	2.800	15	2.975	3-3/8"

* Requires wide body 1.920 Die, Part Number EN98-032-04

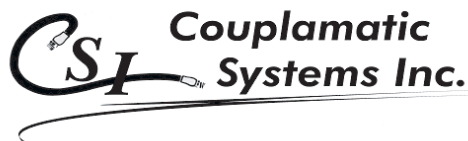
NOTE: SKIVING THE COVER IS REQUIRED WITH SX SERIES COUPLINGS.

NOTE: CSI 100R13 SERIES RC13, DHEXR13

NOTE: Gauge settings are approximate and may vary due to machining tolerances of the dies. After crimping verify the crimp O.D. with a caliper to ensure proper crimp dimensions.

CRIMP SPECIFICATIONS

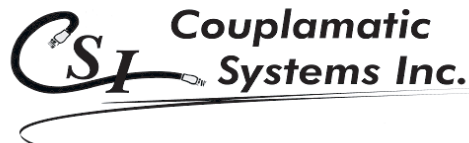
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Crimp Data for Couplamatic Systems inc. <u>T Series Couplings</u> using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)			
HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
3/16" 100R14 PTFE (TR14)	.350	90	0.395
1/4" 100R14 PTFE (TR14)	.350	83	0.430
5/16" 100R14 PTFE (TR14)	.450	91	0.490
3/8" 100R14 (TR14)	.520	89	0.565
1/2" 100R14 (TR14)	.670	93	0.695
3/4" 100R14 PTFE (TR14)	.950	87	0.995
1" 100R14 PTFE (TR14)	1.100	76	1.225
1/4" REDUCED OD 100R7 (RD7 & RD7NC)	.450	92	0.485
5/16" REDUCED OD 100R7 (RD7 & RD7NC)	.520	86	0.585
3/8" REDUCED OD 100R7 (RD7 & RD7NC)	.520	74	0.645
1/2" 100R7 (H7 & H7NC)	.830	96	0.840
3/4" 100R7 (H7 & H7NC)	1.100	92	1.125
1" 100R7 (H7 & H7NC)	1.320	86	1.385
Crimp Data for Couplamatic Systems inc. <u>R5 Series Couplings</u> using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)			
HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
3/16" 100R5 (58MBA & HTR5)	.520	89	0.565
1/4" 100R5 (58MBA & HTR5)	.520	80	0.620
5/16" 100R5 (58MBA & HTR5)	.670	92	0.710
13/32" 100R5 (58MBA & HTR5)	.670	76	0.795
1/2" 100R5 (58MBA & HTR5)	.830	85	0.910
5/8" 100R5 (58MBA & HTR5)	1.100	99	1.100
7/8" 100R5 (58MBA & HTR5)	1.100	71	1.265
1-1/8" 100R5 (58MBA & HTR5)	1.500	92	1.535
1-3/8" 100R5 (58MBA & HTR5)	1.730*	70	1.750
1-13/16" 100R5 (58MBA & HTR5)	2.140	56	2.200
*Requires wide-body 1.730 die, part number: EN98-032-08			
NOTE: Gauge settings are approximate and may vary due to machining tolerances of the dies. After crimping verify the crimp O.D. with a caliper to ensure proper crimp dimensions.			

CRIMP SPECIFICATIONS

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Crimp Data for Couplamatic Systems inc. <u>GRIP CRIMP "Bite to the Wire" Couplings</u> using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)			
HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
1/4"100R1AT & 100R16/2SC & 1/4" 2SK	.520	72	0.655
1/4"100R2AT/2SN & 1/4" Jackhose	.670	91	0.695
3/8"100R1AT & 100R16/2SC & 3/8" 2SK	.830	94	0.835
3/8"100R2AT/2SN & 3/8" Jackhose	.830	88	0.875
1/2"100R1AT & 100R16/2SC & 1/2" 2SK	.950	94	0.955
1/2"100R2AT/2SN	.950	87	0.995
5/8" 100R16/2SC & 5/8" 2SK	.950	73	1.070
5/8"100R2AT 2SN	1.100	95	1.110
3/4"100R1AT & 100R16/2SC & 3/4" 2SK	1.100	69	1.255
3/4"100R2AT/2SN	1.100	63	1.295
1"100R1AT & 100R16/2SC	1.500	79	1.600
1"100R2AT/2SN & 1" 2SK	1.500	72	1.640
1-1/4" 100R1AT	1.920	84	1.980
1-1/4" 100R2AT/2SN	1.920	80	2.020
1-1/2" 100R1AT	2.300	77	2.300
1-1/2" 100R2AT/2SN	2.300	63	2.340
2" 100R1AT	2.620	34	2.745
2" 100R2AT/2SN	2.620	18	2.785
1/4" HY-PLUS I & 1/4" R17R (1SN OD)	.520	72	0.655
3/8" HY-PLUS I & 3/8" R17R (1SN OD)	.830	94	0.835
1/2" HY-PLUS I & 1/2" R17R (1SN OD)	.950	94	0.955
3/4" HY-PLUS I	1.100	69	1.255
1" HY-PLUS I	1.500	79	1.600
1/4" HY-PLUS III	.520	72	0.655
3/8" HY-PLUS III	.830	94	0.835
1/2" HY-PLUS III	.950	94	0.955
5/8" HY-PLUS III	.950	73	1.070
3/4" HY-PLUS III	1.100	69	1.255
1" HY-PLUS III	1.500	79	1.600
1/4"100R17 (REDUCED O.D.)	.520	78	0.630
3/8"100R17 (REDUCED O.D.)	.670	73	0.800
1/2"100R17 (REDUCED O.D.)	.830	80	0.925
5/8"100R17 (REDUCED O.D.)	.950	73	1.070
3/4"100R17 (REDUCED O.D.)	1.100	70	1.255
1"100R17 (REDUCED O.D.)	1.500	79	1.600
1/4" DURA-HYD (DH16, DH17)	.520	72	0.655
3/8" DURA-HYD (DH16, DH17)	.830	94	0.835
1/2" DURA-HYD (DH16, DH17)	.950	94	0.955
5/8" DURA-HYD (DH16, DH17)	.950	73	1.070
3/4" DURA-HYD (DH16, DH17)	1.100	69	1.255
1" DURA-HYD (DH16, DH17)	1.500	79	1.600

NOTE: Gauge settings are approximate and may vary due to machining tolerances of the dies.
After crimping verify the crimp O.D. with a caliper to ensure proper crimp dimensions.

CRIMP SPECIFICATIONS

Rev. 513



Crimp Data for Couplamatic Systems inc. 4GC Series "Bite to the Wire" Couplings using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)

HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
1/2" 100R12	1.100	98	1.110
3/4" 100R12	1.320	88	1.365
1" 100R12	1.620	79	1.705
1-1/4" 100R12	1.920	76	2.035
1-1/2" 100R12	2.300	77	2.300
2" 100R12	2.620	18	2.785

4GC SERIES COUPLINGS REQUIRES NO SKIVE
CSI 100R12 SERIES RC12B, SP580, DHEXR12

Crimp Data for Couplamatic Systems inc. 6GC Series "Bite to the Wire" Couplings using the CS160 & CS165 (Crimp thru 3/4" 6 Spiral Hose) or the CS205 (Crimps thru 2" hose)

HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
5/8" 4SH	1.181	77	1.270
3/4" 4SH, 100R13, 100R15	1.320	78	1.430
1" 4SH, 100R13, 100R15)	1.730*	73	1.740
1-1/4" 100R13, 100R15	2.140	73	2.150
1-1/2" 100R13, 100R15	2.300	24	2.450
2" 100R13	3.000	65	3.035

*Requires wide-body 1.730 die, part number: EN98-032-08

THE 6GC SERIES COUPLINGS REQUIRES NO SKIVE ON CSI SERIES RC13,
DHEXR13, RC15, 4SH

Crimp Data for Couplamatic Systems inc. 4SH Series "Bite to the Wire" Couplings
using the CS205 (Crimps thru 2" hose)

HOSE I.D. AND BRAID	DIE SET	GAUGE SETTING	CRIMP DIAMETER
1-1/4" 4SH	1.920	76	2.035

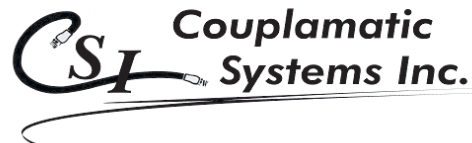
THE 4SH SERIES COUPLINGS ARE USED ON 4SH (1-1/4" thru 2")HOSES WITH
NO SKIVE NECESSARY.

NOTE: Gauge settings are approximate and may vary due to machining tolerances of the dies.
After crimping verify the crimp O.D. with a caliper to ensure proper crimp dimensions.

1 - 1/2" 4SH and 2" 4SH Coming

CRIMP SPECIFICATIONS

Rev. 513



Crimp Data for Couplamatic Systems inc. 3 Series Thermoplastic Couplings using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)				
HOSE I.D. AND BRAID		DIE SET	GAUGE SETTING	CRIMP DIAMETER
1/8" 100R7 (H7 & H7NC)		.350	92	0.365
3/16" 100R7 (H7 & H7NC)		.450	86	0.500
1/4" 100R7 (H7 & H7NC) & 1/4" R18		.520	88	0.555
5/16" 100R7 (H7 & H7NC)		.520	74	0.630
3/8" 100R7 (H7 & H7NC) & 3/8" R18		.670	94	0.675
1/2" 100R7 (H7 & H7NC)		.830	98	0.830
3/4" 100R7 (H7 & H7NC)		.950	71	1.080
1" 100R7 (H7 & H7NC)		1.320	91	1.340
3/16" 100R8 (HS8 & HS8NC)		.450	91	0.475
1/4" 100R8 (HS8 & HS8NC)		.520	88	0.555
3/8" 100R8 (HS8 & HS8NC)		.670	94	0.675
1/2" 100R8 (HS8 & HS8NC)		.830	98	0.830
Crimp Data for Couplamatic Systems inc. PW Series "Bite to the Wire" Pressure Wash Couplings using the CS160 & CS165 (Crimp thru 1-1/4" Hose) or the CS205 (Crimps thru 2" hose)				
HOSE I.D. AND BRAID	Series	DIE SET	GAUGE SETTING	CRIMP DIAMETER
1/4" PW4000	GC	.520	75	0.620
3/8" PW4000	PW	.670	73	0.790
3/8" PW6000	PW	.830	98	0.830
NOTE: Gauge settings are approximate and may vary due to machining tolerances of the dies. After crimping verify the crimp O.D. with a caliper to ensure proper crimp dimensions.				