

Procedure 2304	Installation of Brass Stems and Ferrules Using 5111A & 1765A Tools	Revision 4-04
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Preparation:

1. Prepare the hose using Procedure 1100 (General Preparation Instructions).
2. For Information concerning selection of the proper ferrule and die, as well as setting-up 5111A / 1765A Crimping Machines use Procedure 1103 (Set-up 5111A / 1765A Crimping Machine).

Note:

1. Dixon recommends the 5111A tool be mounted on a table leg, storage rack leg or wall at waist height for maximum leverage.
2. BFL and BFM style ferrules are for Air or Water service. BF, BFW, and BFMW style ferrules are for Water service ONLY.

Procedure

1. Slide the ferrule over the hose.
2. Insert the coupling.
3. For 5111A tool:
 - a. Lift the handle to open the dies.
 - b. Slide hose with stem and ferrule through dies to its proper position. Use Procedure 1103.
 - c. Push down on the tool handle so that the dies fully close then open up. **Note:** It is important for the tool to complete its "cycle" of open-closed-open in one downward stroke of the handle to ensure proper crimping.
 - d. Remove the assembly from the tool.
4. For 1765A tool, use as follows:
 - a. Insert the hose with the stem and ferrule through the dies until the stem contacts the stop.
 - b. Depress the foot pedal to crimp the ferrule.
 - c. Release the foot pedal.
 - d. Remove the assembly from the tool.
5. Test the assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

Assembled By: _____ Tested By: _____ Reference No. _____
 Assembled Date: _____ Test Date: _____