Procedure 2400: King Crimp™ with Sleeves

Selection
☐ 1. Measure the OD of each end of the hose with a diameter tape.
   
   Tip: Mark hose OD on hose after measuring to avoid mistakes on crimp dimensions / sleeve selection.

☐ 2. From the current Dixon® catalog, select the correct sleeve for the hose OD just measured.

Preparation
☐ 1. Prepare the hose using Procedure 1100: General Preparation Instructions.

Notes
☐ 1. Each end of the hose to be assembled must be measured accurately.
☐ 2. Crimp diameters can be located in the current DPL, on the sleeve or by calling 800-355-1991.
☐ 3. Dwell, or hold, the finished crimp diameter for 3 to 5 seconds. This allows the metal to retain its new diameter.
☐ 4. Finished crimp diameter must be measured for each fitting. Tolerance is ±0.010" from published crimp diameter.
☐ 5. If finished crimp diameter is larger than tolerance re-crimp. If crimp diameter is smaller than tolerance consult Dixon®.
☐ 6. Consult Dixon® for coupling working pressures and for working pressures above 70°F.
   
   Tip: Use crimp die closest to crimp diameter without going over for best results. (ex. crimp diameter 31mm, use 30mm die)

Process
☐ 1. Slide sleeve over hose.
☐ 2. Insert fitting to locking groove shoulder of couplers and adapters. For KC nipples, insert to flat before locking groove. Do not over insert.
☐ 3. Set the crimp diameter on the crimper.
☐ 4. Bring hose with fitting and sleeve through the back of the crimper so that it is facing the operator.
☐ 5. Slowly jog dies closed. Make sure dies clear coupler head or adapter hose stop or KC nipple body.
☐ 6. Position sleeve even with dies.
☐ 7. Slowly close dies until they just contact sleeve. Make positioning adjustments if necessary.
☐ 8. Push coupler head or adapter hose stop against dies. For KC nipples, line up the back edge of the locking groove (edge closest to body) with end of sleeve. Make sure fitting clears dies.
☐ 9. Close the dies until the machine has reached the set crimp diameter and hold / dwell for 3 - 5 seconds.
☐ 10. Open dies, pull assembly forward and measure crimp diameter.
   
   Tip: Crimp all hose ends having the same OD to speed up crimping process by not having to continually change crimper specifications.