DIXON

The Right Connection®

5111A
Brass Ferrule Crimper Operating Manual

Hand Operated
Positive Stroke - High Speed

INSTRUCTIONS FOR USE OF 5111A FERRULE CRIMPER

DESCRIPTION:

The 5111A Ferrule crimper is hand operated. It is used in a fixed location for small production runs, or mounted on a carrier as a mobile hose repair unit.

The 5111A crimper is designed for the production or repair of hoses using light or medium weight ferrules and stems for air or water hose.

INSTALLATION:

The 5111A ferrule crimper is shipped fully assembled, (except for installing handle), less crimping dies. It should be secured to a bench or carrier.

MAINTENANCE:

The 5111A ferrule crimper is greased at time of assembly. Periodic inspection, cleaning and greasing of all moving parts is necessary (use a WD40 type spray).

OPERATION:

1. Install proper stem and ferrule onto hose.

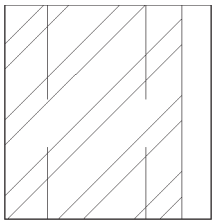
2. Place assembly into opening between the crimping dies and pull handle No. 8 until crimping dies contact ferrule. A steady pull on the handle will bring the dies through center completing the crimping operation.

DIE CHANGE:

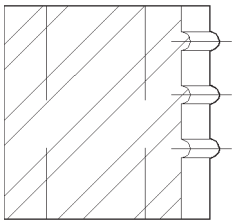
1. Remove wing nuts No. 6 and lock washers No. 7. Die holder plate No. 3 can now be removed exposing the crimping dies as well as the die holders No.10, links No. 11 and their pins No's 12 and 13.

2. Crimping dies will slide in and out of the mating dovetails freely.

3. All crimping dies are stamped with their part number. When the die holder plate is removed, this number is visible on each die. When changing dies, be sure to install each die with the numbered side facing the die holder plate. This is very important when using ribbed dies for proper rib orientation.



5111A CRIMPING DIE CHART



Plain Dies

Die #	Bore	Die #	Bore
P1	1.450	**P26**	.825
P2	1.425	**P27**	.800
P3	1.400	**P28**	.775
P4	1.375	**P29**	.750
P5	1.350	**P30**	.725
P6	1.325	**P31**	.700
P7	1.300	**P32**	.675
P8	1.275	**P33**	.650
P9	1.250	**P34**	.625
P10	1.225	**P35**	.600
P11	1.200	**P36**	.575
P12	1.175	**P37**	.550
P13	1.150	**P38**	.525
P14	1.125	**P39**	.500
P15	1.100	**P40**	.475
P16	1.075	**P41**	.450
P17	1.050	**P42**	.425
P18	1.025	**P43**	.400
P19	1.000	**P44**	.375
P20	.975	**P45**	.350
P21	.950	**P46**	.325
P22	.925	**P47**	.300
P23	.900	**P48**	.275
P24	.875	**P49**	.250
P25	.850	**P50**	.225

Ribbed Dies

Die #	Bore	Die #	Bore
R1	1.450	**R26**	.825
R2	1.425	**R27**	.800
R3	1.400	**R28**	.775
R4	1.375	**R29**	.750
R5	1.350	**R30**	.725
R6	1.325	**R31**	.700
R7	1.300	**R32**	.675
R8	1.275	**R33**	.650
R9	1.250	**R34**	.625
R10	1.225	**R35**	.600
R11	1.200	**R36**	.575
R12	1.175	**R37**	.550
R13	1.150	**R38**	.525
R14	1.125	**R39**	.500
R15	1.100	**R40**	.475
R16	1.075	**R41**	.450
R17	1.050	**R42**	.425
R18	1.025	**R43**	.400
R19	1.000	**R44**	.375
R20	.975	**R45**	.350
R21	.950	**R46**	.325
R22	.925	**R47**	.300
R23	.900	**R48**	.275
R24	.875	**R49**	.250
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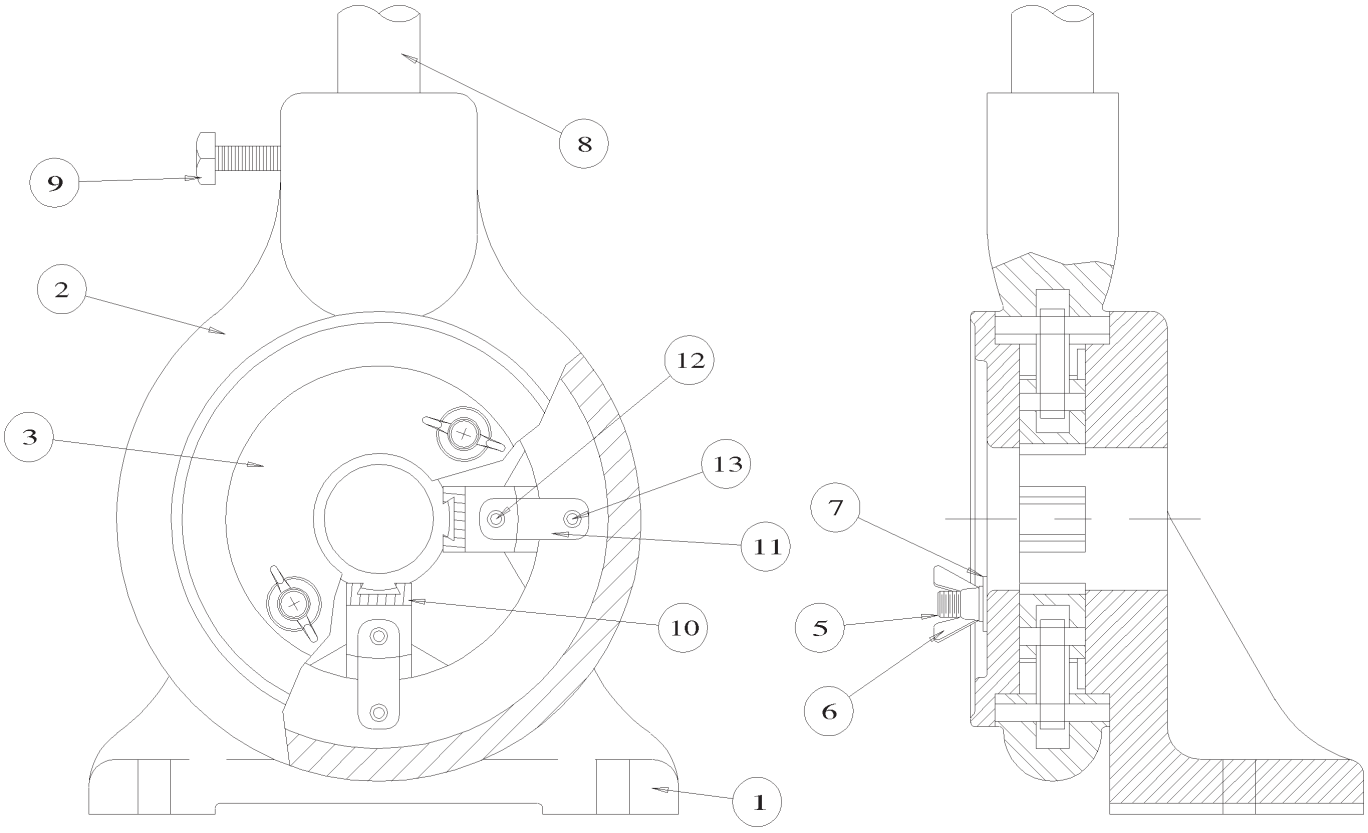
5111A Crimper



Parts List

Item #	Part Name	Part #
1	Die Holder Base	**2551110001**
2	Die Link Ring	**2551110002**
3	Die Holder Plate	**2551110003**
5	Stud (2)	**2551110005**
6	Wing Nut (2)	**2551110006**
7	Lock Washer (2)	**2551110007**
8	Handle	**2551110008**
9	Set Screw	**2551110009**
10	Die Holder (4)	**2551110010**
11	Link (4)	**2551110011**
12	Die Holder Pin (short) (4)	**2551110012**
13	Link Pin (long) (4)	**2551110013**