

EAT•N**Weatherhead****PORTABLE COLL-O-CRIMP® SYSTEM T-480****Set up and operating instructions****COLL-O-CRIMP®**

**Make factory-type hose assemblies
anywhere – anytime!**

- **Fast**
- **Versatile**
- **Simple**
- **Portable**

CAUTION: It is recommended this booklet be read prior to set-up, then used as a guide during actual assembly. Retain for reference purposes.

WEATHERHEAD®

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EAT•N**Weatherhead****WEATHERHEAD®**

WEATHERHEAD WARRANTY

WEATHERHEAD WARRANTY

For one year after date of purchase, Dana Corporation warrants its products to be free from defects in materials and workmanship when properly installed and maintained. Products covered include those items contained in this catalog.

If during the warranty period, a product is discovered to be defective, Dana will, at its option replace the warranted product or grant the purchaser a credit for the product claimed to be defective. Dana will have the sole discretion to determine whether the product was defective.

This warranty is null and void if the product has been used in the wrong application or has been damaged from an accident or willfully destroyed. In addition, this warranty will not apply to Weatherhead assembly equipment, Weatherhead end fittings, and Weatherhead hose if the claimed defective product has been used in an assembly made from other than Weatherhead parts.

NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, NOR ANY OTHER WARRANTY, EXPRESS OR IMPLIED, IS MADE BY DANA CORPORATION. THE FOREGOING STATES DANA CORPORATION'S ENTIRE AND EXCLUSIVE LIABILITY AND BUYER'S EXCLUSIVE REMEDY FOR ANY CLAIM OR DAMAGES IN CONNECTION WITH THE SALE OF THE PRODUCTS HEREUNDER. IN NO EVENT SHALL DANA CORPORATION BE LIABLE FOR ANY SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES WHATSOEVER.

SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS AND YOU MAY ALSO HAVE OTHER LEGAL RIGHTS WHICH VARY FROM STATE TO STATE.

CLAIM INFORMATION

To make a claim under this warranty:

1. Return the defective product along with the purchase receipt and a copy of this certificate to your local distributor or Dana sales representative or to the attention: Engineering Lab, at the following addresses:




Hose & Fittings
Dana Corporation
Boston Weatherhead Division
5228 U.S. Route 24, East
Antwerp, OH 45813

Tooling
Dana Corporation
Boston Weatherhead Division
1380 South Williams Drive
Columbia City, IN 46725
(219) 248-5889

2. In the event of a question or difficulty, contact your local distributor or Dana sales representative or Weatherhead Quality Assurance Department at the above address.

T-480 SYSTEM HOSE END & TOOL SELECTOR CHART

| Hose Type | Hose I.D. | Skive Tool | Hose End Prefix | Collet Number | Spacer Ring | | Nominal Crimp Dia. |
|-----------|-----------|--------------------|-----------------|---------------|-------------|-----------|--------------------|
| | | | | | Color | Flat Side | |
| H24303 | 3/16 | N/R | 22910P | T-400-83C | Black | Dn | .875 |
| H24303 | 3/16 | N/R | 03E | T-400-113C | Tan | Up | .355 |
| H24304 | 1/4 | N/R | 04E | T-400-31C | Green | Up | .405 |
| H24305 | 5/16 | N/R | 05E | T-400-32C | Red | Up | .475 |
| H24306 | 3/8 | N/R | 06E | T-400-33C | Red | Up | .545 |
| H24308 | 1/2 | N/R | 08E | T-400-34C | Red | Up | .695 |
| H24312 | 3/4 | N/R | 12E | T-400-35C | Red | Up | .978 |
| H24316 | 1 | N/R | 16E | T-400-36C | Red | Up | 1.225 |
| H24504 | 1/4 | N/R | 04U | T-400-2C | Yellow | Dn | .560 |
| H24506 | 3/8 | N/R | 06U | T-400-3C | Yellow | Dn | .740 |
| H24508 | 1/2 | N/R | 08U | T-400-4C | Yellow | Dn | .865 |
| H24510 | 5/8 | N/R | 10U | T-400-64C | Yellow | Up | 1.010 |
| H24512 | 3/4 | N/R | 12U | T-400-6C | Yellow | Dn | 1.160 |
| H24516 | 1 | N/R | 16U | T-400-6C | Yellow | Up | 1.465 |
| H24520 | 1-1/4 | N/R | 20U | T-400-12 | Yellow | Dn | 1.795 |
| H24504 | 1/4 | N/R | 04S | T-400-2C | Yellow | Dn | .560 |
| H24506 | 3/8 | N/R | 06S | T-400-3C | Yellow | Dn | .740 |
| H24508 | 1/2 | N/R | 08S | T-400-4C | Yellow | Dn | .865 |
| H24512 | 3/4 | N/R | 12S | T-400-5C | Yellow | Dn | 1.160 |
| H24516 | 1 | N/R | 16S | T-400-6C | Yellow | Up | 1.465 |
| H24520 | 1-1/4 | N/R | 20S | T-400-12 | Yellow | Dn | 1.795 |
| H26506 | 3/8 | N/R | 06E | T-400-33C | Black | Up | .660 |
| H26508 | 1/2 | N/R | 08E | T-400-34C | Black | Up | .810 |
| H26512 | 3/4 | N/R | 12E | T-400-35C | Black | Up | 1.080 |
| H26516 | 1 | N/R | 16E | T-400-36C | Black | Up | 1.340 |
| H26504 | 1/4 | N/R | 26504P | T-400-2C | Green | Up | .520 |
| H26506 | 3/8 | N/R | 26506P | T-400-2C | Silver | Up | .640 |
| H26508 | 1/2 | N/R | 26508P | T-400-3C | Black | Up | .788 |
| H26512 | 3/4 | N/R | 26512P | T-400-64C | Silver | Up | 1.070 |
| H27506 | 3/8 | N/R | 06E | T-400-33C | Black | Up | .660 |
| H27508 | 1/2 | N/R | 08E | T-400-34C | Black | Up | .810 |
| H27512 | 3/4 | N/R | 12E | T-400-35C | Black | Up | 1.090 |
| H27516 | 1 | N/R | 16E | T-400-36C | Black | Up | 1.340 |
| H27504 | 1/4 | N/R | 26504P | T-400-2C | Green | Up | .520 |
| H27506 | 3/8 | N/R | 26506P | T-400-2C | Silver | Up | .640 |
| H27508 | 1/2 | N/R | 26508P | T-400-3C | Black | Up | .788 |
| H27512 | 3/4 | N/R | 26512P | T-400-64C | Silver | Up | 1.070 |
| H28504 | 1/4 | N/R | 04E | T-400-31C | Black | Up | .500 |
| H28505 | 5/16 | N/R | 05E | T-400-32C | Black | Up | .595 |
| H28506 | 3/8 | N/R | 06E | T-400-33C | Black | Up | .660 |
| H28508 | 1/2 | N/R | 08E | T-400-34C | Black | Up | .810 |
| H28512 | 3/4 | N/R | 12E | T-400-35C | Black | Up | 1.090 |
| H28516 | 1 | N/R | 16E | T-400-36C | Black | Up | 1.340 |
| H28504 | 1/4 | N/R | 26504P | T-400-2C | Green | Up | .520 |
| H28506 | 3/8 | N/R | 26506P | T-400-2C | Silver | Up | .640 |
| H28508 | 1/2 | N/R | 26508P | T-400-3C | Black | Up | .788 |
| H28512 | 3/4 | N/R | 26512P | T-400-64C | Silver | Up | 1.070 |
| H30004 | 1/4 | N/R | 04U | T-400-2C | Black | Dn | .560 |
| H30006 | 3/8 | N/R | 06U | T-400-3C | Black | Dn | .740 |
| H30008 | 1/2 | N/R | 08U | T-400-4C | Black | Up | .925 |
| H30010 | 5/8 | N/R | 10U | T-400-64C | Black | Up | 1.050 |
| H30012 | 3/4 | N/R | 12U | T-400-5C | Black | Up | 1.215 |
| H32406 | 3/8 | N/R | 06U | T-400-3C | Black | Up | .785 |
| H33806 | 3/8 | N/R | 33806P | T-400-102C | Black | Dn | .700 |
| H33808 | 1/2 | N/R | 33808P | T-400-103C | Black | Dn | .795 |
| H34504 | 1/4 | N/R | 04M | T-400-109C | Yellow | Up | .630 |
| H34506 | 3/8 | N/R | 06M | T-400-110C | Yellow | Up | .765 |
| H34508 | 1/2 | N/R | 08M | T-400-111C | Yellow | Dn | .915 |
| H35006 | 3/8 | N/R | 06U | T-400-3C | Yellow | Dn | .740 |
| H35008 | 1/2 | N/R | 08U | T-400-4C | Yellow | Dn | .865 |
| H35006 | 3/8 | N/R | 06M | T-400-110C | Black | Up | .805 |
| H35008 | 1/2 | N/R | 08M | T-400-111C | Yellow | Up | .945 |
| H35010 | 5/8 | N/R | 10M | T-420-30C | N/R | N/R | 1.120 |
| H35012 | 3/4 | N/R | 43012U | T-420-5CN | T-480-68 | | 1.413 |
| H35016 | 1 | N/R | 43016U | T-420-6CN | T-480-68 | | 1.705 |
| H36606 | 5/16 | N/R | 06906E | T-400-56C | Black | Up | .680 |
| H36608 | 13/32 | N/R | 06908E | T-400-57C | Yellow | Up | .765 |
| H36904 | 3/16 | N/R | 06904E | T-400-54C | Yellow | Up | .525 |
| H36906 | 5/16 | N/R | 06906E | T-400-56C | Yellow | Up | .650 |
| H36908 | 13/32 | N/R | 06908E | T-400-57C | Black | Dn | .735 |
| H36910 | 1/2 | N/R | 06910E | T-400-58C | Black | Dn | .865 |
| H36912 | 5/8 | N/R | 06912E | T-400-59C | Black | Up | 1.045 |
| H36916 | 7/8 | N/R | 06916E | T-400-60C | Black | Up | 1.220 |
| H36920 | 1-1/8 | N/R | 06920E | T-400-61C | Black | Up | 1.500 |
| H36924 | 1-3/8 | N/R | 06924E | T-400-70 | Black | Up | 1.690 |
| H42504 | 1/4 | N/R | 04S | T-400-2C | Black | Up | .610 |
| H42506 | 3/8 | N/R | 06S | T-400-3C | Black | Up | .795 |
| H42508 | 1/2 | N/R | 08S | T-400-4C | Black | Up | .920 |
| H42512 | 3/4 | N/R | 012S | T-400-5C | Black | Up | 1.210 |
| H42516 | 1-1/4 | N/R | 016S | T-400-6C | Silver | Up | 1.525 |
| H42520 | 1-1/4 | N/R | 020S | T-400-12 | Silver | Up | 1.885 |
| H42504 | 1/4 | N/R | 04U | T-400-2C | Black | Up | .610 |
| H42506 | 3/8 | N/R | 06U | T-400-3C | Black | Up | .795 |
| H42508 | 1/2 | N/R | 08U | T-400-4C | Black | Up | .925 |
| H42510 | 5/8 | N/R | 10U | T-400-64C | Black | Up | 1.050 |
| H42512 | 3/4 | N/R | 12U | T-400-5C | Black | Up | 1.215 |
| H42516 | 1 | N/R | 16U | T-400-6C | Silver | Up | 1.525 |
| H42520 | 1-1/4 | N/R | 20U | T-400-12 | Black | Up | 1.850 |
| H42512 | 3/4 | Brush ¹ | 43012E | T-420-5C | T-480-68 | | 1.255 |
| H42516 | 1 | Brush ¹ | 43016E | T-420-6C | T-480-68 | | 1.545 |
| H42520 | 1-1/4 | Brush ¹ | 43020E | T-420-7C | T-480-68 | | 1.860 |
| H43008 | 1/2 | T-410-30 | 43008E | T-420-4C | T-480-68 | | .950 |
| H43012 | 3/4 | T-410-31 | 43012E | T-420-5C | T-480-68 | | 1.255 |
| H43016 | 1 | T-410-32 | 43016E | T-420-6C | T-480-68 | | 1.545 |
| H43020 | 1-1/4 | T-410-33 | 43020E | T-420-7C | T-480-68 | | 1.860 |
| H43008 | 1/2 | N/R | 43008U | T-420-4CN | T-480-68 | | 1.150 |
| H43012 | 3/4 | N/R | 43012U | T-420-5CN | T-480-68 | | 1.406 |
| H43016 | 1 | N/R | 43016U | T-420-6CN | T-480-68 | | 1.705 |
| H43020 | 1-1/4 | N/R | 43020U | T-420-7CN | T-480-68 | | 2.035 |
| H43504 | 1/4 | N/R | 04E | T-400-31C | Black | Dn | .455 |
| H43505 | 5/16 | N/R | 05E | T-400-32C | Black | Dn | .555 |
| H43506 | 3/8 | N/R | 06E | T-400-33C | Black | Dn | .615 |
| H43508 | 1/2 | N/R | 08E | T-400-34C | Black | Dn | .765 |
| H43512 | 3/4 | N/R | 12E | T-400-35C | Black | Dn | 1.035 |
| H43516 | 1 | N/R | 16E | T-400-36C | Black | Dn | 1.295 |
| H43604 | 1/4 | N/R | 04E | T-400-31C | Black | Dn | .455 |
| H43605 | 5/16 | N/R | 05E | T-400-32C | Black | Dn | .555 |
| H43606 | 3/8 | N/R | 06E | T-400-33C | Black | Dn | .615 |
| H43608 | 1/2 | N/R | 08E | T-400-34C | Black | Dn | .765 |
| H43612 | 3/4 | N/R | 12E | T-400-35C | Black | Dn | 1.035 |
| H43616 | 1 | N/R | 16E | T-400-36C | Black | Dn | 1.295 |
| H43908 | 1/2 | T-410-30 | 43008E | T-420-4C | T-480-68 | | .950 |
| H43912 | 3/4 | T-410-31 | 43012E | T-420-5C | T-480-68 | | 1.255 |
| H43916 | 1 | T-410-32 | 43016E | T-420-6C | T-480-68 | | 1.545 |
| H43920 | 1-1/4 | T-410-33 | 43020E | T-420-7C | T-480-68 | | 1.860 |
| H43908 | 1/2 | N/R | 43008U | T-420-4CN | T-480-68 | | 1.150 |
| H43912 | 3/4 | N/R | 43012U | T-420-5CN | T-480-68 | | 1.406 |
| H43916 | 1 | N/R | 43016U | T-420-6CN | T-480-68 | | 1.705 |
| H43920 | 1-1/4 | N/R | 43020U | T-420-7CN | T-480-68 | | 2.035 |
| H47008 | 1/2 | T-410-50 | 47008E | T-420-8C | T-480-68 | | .980 |
| H47012 | 3/4 | T-410-52 | 47012E | T-420-9C | T-480-68 | | 1.250 |
| H47016 | 1 | T-410-53 | 47016E | T-420-10C | T-480-68 | | 1.560 |
| H47020 | 1-1/4 | T-410-54 | 47020E | T-420-11 | T-480-68 | | 2.025 |
| H47012 | 3/4 | T-410-52 | 57012S | T-420-9C | T-480-68 | | 1.250 |
| H47016 | 1 | T-410-53 | 57016S | T-420-10C | T-480-68 | | 1.560 |
| H47020 | 1-1/4 | T-410-54 | 57020S | T-420-11 | T-480-68 | | 2.025 |
| H54504 | 1/4 | N/R | 04U | T-400-2C | Yellow | Dn | .560 |
| H54506 | 3/8 | N/R | 06U | T-400-3C | Green | Up | .695 |
| H54508 | 1/2 | N/R | 08U | T-400-4C | Yellow | Up | .865 |
| H54510 | 5/8 | N/R | 10U | T-400-64C | Yellow | Up | 1.010 |
| H54512 | 3/4 | N/R | 12U | T-400-5C | Yellow | Dn | 1.155 |
| H54516 | 1 | N/R | 43016U | T-420-6CN | T-480-68 | | 1.705 |
| H54504 | 1/4 | N/R | 04S | T-400-2C | Yellow | Dn | .560 |
| H54506 | 3/8 | N/R | 06S | T-400-3C | Green | Up | .695 |
| H54508 | 1/2 | N/R | 08S | T-400-4C | Black | Dn | .865 |
| H54512 | 3/4 | N/R | 12S | T-400-5C | Yellow | Dn | 1.155 |
| H75706 | 5/16 | N/R | 75706E | T-400-105C | Black | Dn | .495 |
| H75708 | 13/32 | N/R | 75708E | T-400-106C | Black | Dn | .595 |
| H75710 | 1/2 | N/R | 75710E | T-400-107C | Black | Dn | .695 |
| H75712 | 5/8 | N/R | 75712E | T-400-108C | Black | Dn | .850 |

-  Designates Hose End and Tooling Change (T-400)
-  Designates Hose End and Tooling Change (Alternate)
-  Designates Hose End and Tooling Change (T-420 and T-480)

NOTE: Lubricate the tapered cone seat with Lubriplate grease (Weatherhead Part No. T-400-G) or equivalent.

¹Wire Brush — Method of hose cover removal. See Weatherhead Master Hose Assembly Catalog for instruction

N/R — Not required. **Dn** — Down

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IMPORTANT SAFETY INFORMATION



WARNING

Selection of Hose

Selection of the proper Weatherhead hose for the application is essential to the proper operation and safe use of the hose and related equipment. Inadequate attention to selection of the hose for your application can result in hose leakage, bursting, or other failure which can cause serious bodily injury or property damage from spraying fluids or flying projectiles. In order to avoid serious bodily injury or property damage resulting from selection of the wrong hose, you should carefully review the information in this catalog. Some of the factors which are involved in the selection of the proper hose are:

- hose size
- hose length
- hose ends
- fluid conveyed
- bends
- temperature
- hose pressure
- static head pressure
- installation design

These factors and the other information in this catalog should be considered by you in selecting the proper hose for your application. Further information on proper hose selection is found in the Weatherhead Master Hose Assembly Catalog.

If you have any questions regarding the proper hose for your application, please contact the Boston Weatherhead® Division of Dana Corporation.

Proper Selection of Hose Ends

Selection of the proper Weatherhead end fittings for the hose end application is essential to the proper operation and safe use of the hose and related equipment. Inadequate attention to the selection of the end fittings for your application can result in hose leakage, bursting, or other failure which can cause serious bodily injury or property damage from spraying fluids or flying projectiles. In order to avoid serious bodily injury or property damage resulting from selection of the wrong end fitting, you should carefully review the information in this catalog. Some of the factors which are involved in the selection of the proper hose ends are:

- fluid compatibility
- temperature
- installation design
- hose size
- corrosion requirements
- fluids conveyed

These factors and the other information in this catalog should be considered by you in selecting the proper hose end fitting for your application.

If you have any questions regarding the proper hose for your application, please contact the Boston Weatherhead® Division of Dana Corporation.

T-480 SYSTEM HOSE END & TOOL SELECTOR CHART

Spacer Ring Information when Crimping H54516, H430, H439 AND H470 Hose with the T-480 System.

NOTE: Always wear safety glasses when crimping the Weatherhead hoses shown above with a T-420-4C/4CN, T-420-5C/5CN, T-420-6C/6CN, T-420-7C/7CN, T-420-8C, T-420-9C, T-420-10C, or a T-420-11 collet, a T-480-68 spacer ring MUST BE USED to prevent damage to the T-480 pusher.

When crimping 430 'U' and 43016 'U' Series No Skive hose ends to H14516 hose, the orange T-420-29 Spacer Ring MUST BE USED. For all other hose types, use the proper standard spacer ring as shown in the Weatherhead Master Hose Assembly Catalog and chart below.

| Nominal crimp diameters are for Weatherhead hose and end fittings when crimped with Weatherhead Coil-O-Crimp tooling. | | | | | | | | | | | | | Spacer Ring | | | | |
|---|-----------|------------|-----------------|---------------|-------------|-----------|-------|--------------------|-----------|-----------|------------|-----------------|---------------|-------------|-----------|-------|--------------------|
| Hose Type | Hose I.D. | Skive Tool | Hose End Prefix | Collet Number | Spacer Ring | | | Nominal Crimp Dia. | Hose Type | Hose I.D. | Skive Tool | Hose End Prefix | Collet Number | Spacer Ring | | | Nominal Crimp Dia. |
| | | | | | Color | Flat Side | | | | | | | | Color | Flat Side | | |
| H00905 | 5/16 | N/R | 05E | T-400-32C | Black | Up | .585 | | H11504 | 1/4 | N/R | 04U | T-400-2C | Black | Up | .610 | |
| H00906 | 3/8 | N/R | 06E | T-400-33C | Black | Up | .655 | | H11506 | 3/8 | N/R | 06U | T-400-3C | Black | Up | .790 | |
| H00908 | 1/2 | N/R | 08E | T-400-34C | Black | Up | .805 | | H11508 | 1/2 | N/R | 08U | T-400-4C | Silver | Up | .940 | |
| H01704 | 1/4 | N/R | 04U | T-400-2C | Yellow | Up | .580 | | H11512 | 3/4 | N/R | 12U | T-400-5C | Silver | Up | 1.230 | |
| H01706 | 3/8 | N/R | 06U | T-400-3C | Black | Up | .785 | | H11516 | 1 | N/R | 16U | T-400-6C | Silver | Up | 1.520 | |
| H01708 | 1/2 | N/R | 08U | T-400-4C | Silver | Up | .940 | | H11520 | 1-1/4 | N/R | 20U | T-400-12 | Silver | Up | 1.860 | |
| H01712 | 3/4 | N/R | 12U | T-400-5C | Silver | Up | 1.235 | | H11504 | 1/4 | N/R | 11504H | T-400-2C | Silver | Up | .645 | |
| H01716 | 1 | N/R | 16U | T-400-6C | Silver | Up | 1.525 | | H11506 | 3/8 | N/R | 11506H | T-400-3C | Black | Dn | .740 | |
| H01720 | 1-1/4 | N/R | 20U | T-400-12 | Black | Dn | 1.785 | | H11508 | 1/2 | N/R | 11508H | T-400-4C | Black | Dn | .865 | |
| H03912 | 3/4 | N/R | 12U | T-400-5C | Silver | Up | 1.230 | | H11512 | 3/4 | N/R | 11512H | T-400-5C | Silver | Up | 1.240 | |
| H03916 | 1 | N/R | 16U | T-400-6C | Silver | Up | 1.520 | | H14504 | 1/4 | N/R | 04S | T400-2C | Green | Up | .520 | |
| H03920 | 1-1/4 | N/R | 20U | T-400-12 | Black | Dn | 1.790 | | H14506 | 3/8 | N/R | 06S | T400-3C | Green | Up | .695 | |
| H03912 | 3/4 | N/R | 12S | T-400-5C | Silver | Up | 1.230 | | H14508 | 1/2 | N/R | 08S | T400-4C | Yellow | Dn | .870 | |
| H03916 | 1 | N/R | 16S | T-400-6C | Silver | Up | 1.520 | | H14510 | 5/8 | N/R | 10S | T400-64C | Yellow | Dn | 1.010 | |
| H03920 | 1-1/4 | N/R | 20S | T-400-12 | Black | Dn | 1.790 | | H14512 | 3/4 | N/R | 12S | T400-5C | Yellow | Dn | 1.160 | |
| H06904 | 3/16 | N/R | 06904E | T-400-54C | Yellow | Up | .525 | | H14516 | 1 | N/R | 16S | T-400-6C | Yellow | Dn | 1.445 | |
| H06905 | 1/4 | N/R | 06905E | T-400-55C | Black | Up | .585 | | H14504 | 1/4 | N/R | 04U | T-400-2C | Green | Up | .520 | |
| H06906 | 5/16 | N/R | 06906E | T-400-56C | Black | Up | .680 | | H14506 | 3/8 | N/R | 06U | T-400-3C | Green | Up | .695 | |
| H06908 | 13/32 | N/R | 06908E | T-400-57C | Yellow | Up | .765 | | H14508 | 1/2 | N/R | 08U | T-400-4C | Yellow | Dn | .870 | |
| H06910 | 1/2 | N/R | 06910E | T-400-58C | Black | Up | .910 | | H14510 | 5/8 | N/R | 10U | T-400-64C | Yellow | Dn | 1.010 | |
| H06912 | 5/8 | N/R | 06912E | T-400-59C | Silver | Up | 1.080 | | H14512 | 3/4 | N/R | 12U | T-400-5C | Yellow | Dn | 1.160 | |
| H06916 | 7/8 | N/R | 06916E | T-400-60C | Black | Up | 1.275 | | H14516 | 1 | N/R | 43016U | T-420-6CN | Orange | Up | 1.655 | |
| H06920 | 1-1/8 | N/R | 06920E | T-400-61C | Yellow | Up | 1.520 | | H14604 | 1/4 | N/R | 04U | T-400-2C | Green | Up | .520 | |
| H06924 | 1-3/8 | N/R | 06924E | T-400-70 | Black | Up | 1.730 | | H14606 | 3/8 | N/R | 06U | T-400-3C | Green | Up | .695 | |
| H10404 | 1/4 | N/R | 04U | T-400-2C | Black | Dn | .560 | | H14608 | 1/2 | N/R | 08U | T-400-4C | Green | Up | .830 | |
| H10406 | 3/8 | N/R | 06U | T-400-3C | Black | Dn | .740 | | H16604 | 3/16 | N/R | 06904E | T-400-54C | Yellow | Up | .525 | |
| H10408 | 1/2 | N/R | 08U | T-400-4C | Black | Dn | .870 | | H16605 | 1/4 | N/R | 06905E | T-400-55C | Black | Up | .585 | |
| H10410 | 5/8 | N/R | 10U | T-400-64C | Black | Dn | 1.000 | | H16606 | 5/16 | N/R | 06906E | T-400-56C | Black | Up | .680 | |
| H10412 | 3/4 | N/R | 12U | T-400-5C | Black | Dn | 1.160 | | H16608 | 13/32 | N/R | 06908E | T-400-57C | Yellow | Up | .765 | |
| H10416 | 1 | N/R | 16U | T-400-6C | Black | Dn | 1.450 | | H16610 | 1/2 | N/R | 06910E | T-400-58C | Black | Up | .910 | |
| H10420 | 1-1/4 | N/R | 20U | T-400-12 | Black | Dn | 1.785 | | H16612 | 5/8 | N/R | 06912E | T-400-59C | Silver | Up | 1.080 | |
| H10404 | 1/4 | N/R | 04S | T-400-2C | Black | Dn | .580 | | H16616 | 7/8 | N/R | 06916E | T-400-60C | Black | Up | 1.275 | |
| H10406 | 3/8 | N/R | 06S | T-400-3C | Black | Dn | .738 | | H16620 | 1-1/8 | N/R | 06920E | T-400-61C | Yellow | Up | 1.660 | |
| H10408 | 1/2 | N/R | 08S | T-400-4C | Black | Dn | .863 | | H16904 | 3/16 | N/R | 06904E | T-400-54C | Yellow | Up | .525 | |
| H10412 | 3/4 | N/R | 12S | T-400-5C | Yellow | Up | 1.175 | | H16905 | 1/4 | N/R | 06905E | T-400-55C | Black | Up | .585 | |
| H10416 | 1 | N/R | 16S | T-400-6C | Yellow | Up | 1.465 | | H16906 | 5/16 | N/R | 06906E | T-400-56C | Black | Up | .680 | |
| H10420 | 1-1/4 | N/R | 20S | T-400-12 | Black | Dn | 1.790 | | H16908 | 13/32 | N/R | 06908E | T-400-57C | Yellow | Up | .765 | |
| H10504 | 1/4 | N/R | 04U | T-400-2C | Black | Up | .610 | | H16910 | 1/2 | N/R | 06910E | T-400-58C | Black | Up | .910 | |
| H10506 | 3/8 | N/R | 06U | T-400-3C | Black | Up | .790 | | H16912 | 5/8 | N/R | 06912E | T-400-59C | Silver | Up | 1.080 | |
| H10508 | 1/2 | N/R | 08U | T-400-4C | Silver | Up | .940 | | H16916 | 7/8 | N/R | 06916E | T-400-60C | Black | Up | 1.275 | |
| H10512 | 3/4 | N/R | 12U | T-400-5C | Silver | Up | 1.230 | | H16920 | 1-1/8 | N/R | 06920E | T-400-61C | Yellow | Up | 1.520 | |
| H10516 | 1 | N/R | 16U | T-400-6C | Silver | Up | 1.520 | | H16924 | 1-3/8 | N/R | 06924E | T-400-70 | Black | Up | 1.730 | |
| H10504 | 1/4 | N/R | 11504H | T-400-2C | Black | Up | .612 | | H20904 | 1/4 | N/R | 04E | T-400-31C | Black | Dn | .455 | |
| H10506 | 3/8 | N/R | 11506H | T-400-3C | Green | Up | .698 | | H20905 | 5/16 | N/R | 05E | T-400-32C | Black | Dn | .555 | |
| H10508 | 1/2 | N/R | 11508H | T-400-4C | Green | Up | .825 | | H20906 | 3/8 | N/R | 06E | T-400-33C | Black | Dn | .615 | |
| H10512 | 3/4 | N/R | 11512H | T-400-5C | Black | Up | 1.210 | | H20908 | 1/2 | N/R | 08E | T-400-34C | Black | Dn | .765 | |
| H11404 | 1/4 | N/R | 04U | T-400-2C | Green | Up | .520 | | H22904 | 3/16 | N/R | 06904E | T-400-54C | Yellow | Up | .525 | |
| H11406 | 3/8 | N/R | 06U | T-400-3C | Green | Up | .695 | | H22906 | 5/16 | N/R | 06906E | T-400-56C | Black | Up | .680 | |
| H11408 | 1/2 | N/R | 08U | T-400-4C | Green | Up | .830 | | H22908 | 13/32 | N/R | 06908E | T-400-57C | Yellow | Up | .765 | |
| H11404 | 1/4 | N/R | 04S | T400-2C | Green | Up | .520 | | H22910 | 1/2 | N/R | 06910E | T-400-58C | Black | Up | .910 | |
| H11406 | 3/8 | N/R | 06S | T400-3C | Green | Up | .695 | | H22912 | 5/8 | N/R | 06912E | T-400-59C | Silver | Up | 1.080 | |
| H11408 | 1/2 | N/R | 08S | T400-4C | Black | Down | .860 | | H22904 | 3/16 | N/R | 22904P | T-400-80C | Yellow | Up | .505 | |
| | | | | | | | | | H22906 | 5/16 | N/R | 22906P | T-400-81C | Black | Dn | .650 | |
| | | | | | | | | | H22908 | 13/32 | N/R | 22908P | T-400-82C | Black | Dn | .775 | |

Designates Hose End and Tooling Change (T-400)

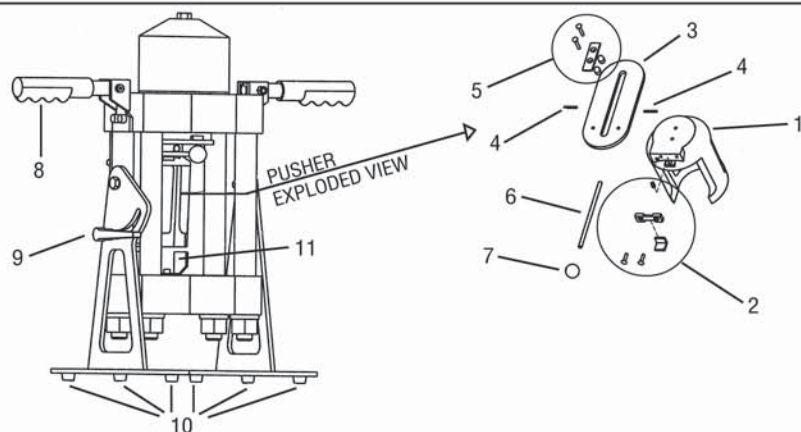
Designates Hose End and Tooling Change (T-420 and T-480)

Designates Hose End and Tooling Change (Alternate)

N/R — Not required. Dn — Down

WEATHERHEAD®

REPAIR & REPLACEMENT ITEMS



| Item Number | Qty. | Part Number | Description | Remarks |
|-------------|------|---------------|--------------------------|---|
| 1 | 1 | T-480-P | Pusher | |
| 2 | 1 | T-480-PSK | Pusher Stop Repair Kit | Includes pusher clip, 2 machine screws, pusher stop & spring |
| 3 | 1 | T-480-SP | Slider Plate | |
| 4 | 2 | 140-05485-01* | Roll Pin | |
| 5 | 1 | T-480-SFK | Slide Flange Kit | Includes slide flange, 2 bushings & 2 machine screws |
| 6 | 1 | T-480-SPR | Slide Pull Rod | |
| 7 | 1 | T-480-SPK | Slide Pull Knob | |
| 8 | 2 | 140-06601* | Vinyl Grip | |
| 9 | 1 | T-480-TBK | Tilt Bracket Knob | |
| 10 | 6 | 140-06894* | Foot Pad | |
| 11 | 1 | T-480-69 | Tool Locator Bracket | |
| # | 1 | T-480-70 | Hose Assembly | 10,000 PSI replacement hose assembly for T-480-HP and T-480-AH System |
| # | 1 | T-480-71 | Hose Assembly | 10,000 PSI replacement hose assembly for T-480-EP and T-480-TA System |
| # | 1 | 140-06906* | Hydraulic Quick Coupler | Used with the T-480-TA and T-480-EP System |
| # | 1 | T-480-3 | Turbo Air/Hydraulic Pump | Replacement pump for T-480-TA System |
| # | 1 | T-481-110 | Electric Pump | Replacement pump for T-480-EP System |
| # | 1 | T-480-2 | Hand Pump | Replacement pump for T-480-HP System |
| # | 1 | T-482-2 | Air/Hydraulic Pump | Replacement pump for T-480-AH System |
| # | 1 | T-480-M | Set-up & Operating Guide | For T-480 System |

Item not illustrated in parts breakdown.

* Please contact the Boston Weatherhead Division Tool Plant at (219) 248-5889 for price and availability on these items.

IMPORTANT SAFETY INFORMATION



WARNING

Hose Installation

Proper installation of the hose is essential to the proper operation and safe use of the hose and related equipment. Improper installation of the hose can result in serious injury or property damage caused by spraying fluids or flying projectiles. In order to avoid serious bodily injury or property damage resulting from improper installation of the hose, you should carefully review the information in this set-up guide and in the Weatherhead Master Hose Assembly Catalog. Some of the factors you must consider in installing the hose properly are:

- changes in length
- protection from high temperature sources
- twisting
- proper bend radius
- elbows and adapters to relieve strain
- rubbing or abrasion
- improper hose movement

These factors and the other information in this catalog regarding hose installation should be considered by you before installing the hose. Refer to the Weatherhead Master Hose Assembly Catalog for further information on proper hose selection.

If you have any questions regarding the proper hose installation, please contact the Boston Weatherhead® Division of Dana Corporation.

Hose Maintenance

Proper maintenance of the hose is essential to the safe use of the hose and related equipment. Hose should be stored in a dry place. Hose should also be visually inspected. Any hose that has a cut or gouge in the cover that exposes the reinforcement should be retired from service. Hoses should also be inspected for kinking or broken reinforcement. If the outside diameter of the hose is reduced by 20% at the spot where it is kinked then the hose should be retired from service. Inadequate attention to maintenance of the hose can result in hose leakage, bursting, or other failure which can cause serious bodily injury or property damage from spraying fluids, flying projectiles, or other substances. Refer to the Weatherhead Master Hose Assembly Catalog for information on proper hose maintenance.

If you have any questions regarding the proper hose installation, please contact the Boston Weatherhead® Division of Dana Corporation.

Hose and Field Attachable Hose Ends

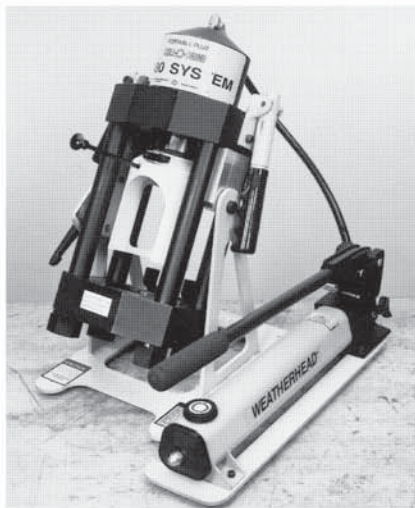
Weatherhead® Hose and Field Attachable Hose Ends have been engineered and designed as a complete hose assembly system. Component compatibility along with the use of quality components insures the production of reliable hose assemblies when assembled properly. The use or intermixing of ends and hose not specifically engineered and designed for use with each other may result in the production of unsafe or unreliable hose assemblies. This can result in hose assembly leakage, hose separation or other failures which can cause serious bodily injury or property damage from spraying fluids, flying projectiles, or other substances. The Weatherhead warranty is limited to apply only when Weatherhead Field Attachable Hose Ends are used on the compatible Weatherhead hose.

Coll-O-Crimp® Hose, Hose Ends and Assembly Equipment Compatibility

The Coll-O-Crimp® Equipment Package, Coll-O-Crimp® Hose Ends and Coll-O-Crimp Hose have been engineered and designed as a complete hose assembly system. Each component of the Coll-O-Crimp hose assembly system is compatible with other Coll-O-Crimp components to which it relates. Component compatibility, along with the use of quality components, insures the production of reliable hose assemblies when assembled properly. The use or intermixing of fittings and hose not specifically engineered and designed for use with each other and Coll-O-Crimp equipment is not recommended and may result in the production of unsafe or unreliable hose assemblies. This can result in hose assembly leakage, hose separation or other failures which can cause serious bodily injury or property damage from spraying fluids, flying projectiles, or other substances. The Weatherhead warranty is limited to apply only when Coll-O-Crimp Hose Ends and compatible Coll-O-Crimp Hose are used with Coll-O-Crimp assembly equipment.

WEATHERHEAD®

T-480 SYSTEM SPECIFICATIONS & EQUIPMENT



T-480-HP

T-480 System with hand pump

Press Specifications:

Crimping Capacity 3/16" I.D. one fiber braid through 1-1/4" I.D. six spiral hose
Size 22-1/2" high, 14" long, 10-1/2" wide
Weight Approx. 102 lbs.
Mounting Free-standing base

Pump Specifications:

Dimensions 12-1/8" long, 4-5/8" wide, 7-3/16" high
Weight 10 lbs.
Pressure 0-10,000 PSI
Outlet Port Size 3/8" NPT
Hydraulic Oil Enerpac
Reservoir Capacity 55 in³



T-480-AH

T-480 System with air/hydraulic pump

Press Specifications:

Crimping Capacity 3/16" I.D. one fiber braid through 1-1/4" I.D. six spiral hose
Size 22-1/2" high, 14" long, 10-1/2" wide
Weight Approx. 102 lbs.
Mounting Free-standing base

Pump Specifications:

Dimensions 14-11/16" long, 5-5/8" wide, 5" high
Weight 12 lbs.
Pressure 0-10,000 PSI
Outlet Port Size 3/8" NPT
Inlet Port Size 1/4" NPT
Air Pressure 60-100 PSI
Hydraulic Oil Enerpac
Reservoir Capacity 36 in³

NOTE: It is recommended that a filter, regulator, lubricator and air pressure gauge be installed upstream from the pump. Filter, Regulator and Lubricator units are not included.

OPERATING INSTRUCTIONS

Figure A - Insertion Depth

Place hose ends on hose until hose is bottomed in collar.

To insure that hose is bottomed in collar, mark the insertion depth on the hose before inserting it into the hose end.



| Hose I.D. | 'U' Series Rubber | 'E' Series Nylon/Teflon | 069 'E' Series Truck Hose | 757 'E' Series Refrigerant Hose |
|-----------|-------------------|-------------------------|---------------------------|---------------------------------|
| 3/16 | — | 7/8 | 1 | — |
| 1/4 | 1-1/2 | 7/8 | 1 | — |
| 5/16 | — | 15/16 | 1-3/32 | 1 |
| 3/8 | 1-7/16 | 15/16 | — | — |
| 13/32 | — | — | 1-3/32 | 1-1/8 |
| 1/2 | 1-7/16 | 1-1/16 | 1-3/32 | 1-3/32 |
| 5/8 | 1-15/16 | — | 1-5/16 | 1-3/32 |
| 3/4 | 2-1/8 | 1-1/4 | — | — |
| 7/8 | — | — | 1-5/16 | — |
| 1 | 2-3/16 | 1-11/32 | — | — |
| 1-1/8 | — | — | 1-3/8 | — |
| 1-1/4 | 2-5/16 | — | — | — |

Figure B - COLL-O-CRIMP® Spacer Ring

Typical spacer ring illustrating both sides of ring.

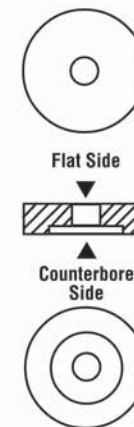


Figure C - Nominal Crimp Diameter Measurement

Measuring crimp diameters should be a part of the normal hose assembly procedure. To insure a proper crimp diameter reading, follow these steps:

1. Measure the diameter in the middle of crimped portion of the hose end.
2. Place the caliper in a position to allow a measurement across the pressed (flat) portion of the crimp.
3. Refer to page 15 Hose End and Tool Selector Chart for nominal crimp diameter.

NOTE: In the larger sizes, calipers may be used; however, in the smaller sizes, and in the 'E' Series, 430U Series and thermoplastic hose ends, a point micrometer will provide an accurate reading.

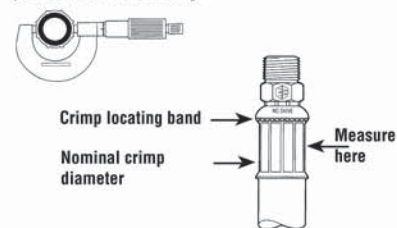
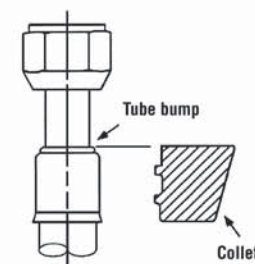


Figure D - 757 'E' Series Hose End

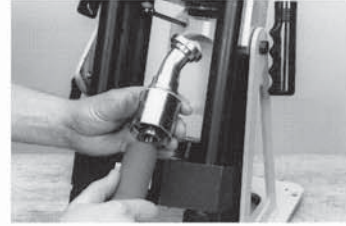
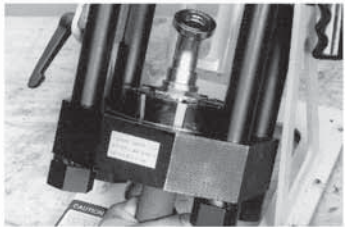
757 'E' Series hose ends must be positioned with tube bump level with top of collet.



T-480 EP SET-UP & OPERATING INSTRUCTIONS



1. Open vent plug on reservoir. Release the pusher clip and slide pusher back. NOTE: Periodically lubricate the die ring with Weatherhead T-400-G lubricant. When crimping with Coll-O-Crimp® I tooling, insert the T-420-25 adapter die ring into the base plate. Insert the proper sized collet.



3. Loosen knob and tilt press as necessary. Insert hose assembly from below the base plate and between the collet halves. Align dimples or knurl band on end fitting with top of collet, making sure that collet halves are evenly matched. When crimping H757 hose, position end fitting as shown in figure D, page 13.



5. Press pump switch to the top detent "ON" position. Press pendant switch and hold until the spacer ring contacts the base ring, indicating that the crimp is complete.



6. Release pendant switch to retract pusher and move pump switch to the middle "OFF" position. Release the pusher clip and slide the pusher back to access tooling. Remove the spacer ring and the crimped hose assembly from below the base plate and between the collet halves. NOTE: Visually inspect the crimped end. Check nominal crimp diameter and verify that the crimp is within 1/16" from the locating dimples on the collar, see figure C, page 13.

T-480 SYSTEM SPECIFICATIONS & EQUIPMENT

T-480-TA

T-480 System with turbo air/hydraulic pump

Press Specifications:

| | |
|-------------------------|--|
| Crimping Capacity | 3/16" I.D. one fiber braid through 1-1/4" I.D. six spiral hose |
| Size | 22-1/2" high, 14" long, 10-1/2" wide |
| Weight | Approx. 102 lbs. |
| Mounting | Free-standing base |

Pump Specifications:

| | |
|--------------------------|------------------------------------|
| Weight | 14 lbs. |
| Pressure | 0-10,000 PSI |
| Outlet Port Size | 3/8" NPT |
| Inlet Port Size | 1/4" NPT |
| Dimensions | 12-3/8" long, 8" wide, 8-1/4" high |
| Air Pressure | 40-150 PSI |
| Hydraulic Oil | Enerpac |
| Reservoir Capacity | 150 in ³ |

NOTE: It is recommended that a filter, regulator, lubricator and air pressure gauge be installed upstream from the pump. Filter, Regulator and Lubricator units are not included.



T-480-EP

T-480 System with 120V electric pump

Press Specifications:

| | |
|-------------------------|--|
| Crimping Capacity | 3/16" I.D. one fiber braid through 1-1/4" I.D. six spiral hose |
| Size | 22-1/2" high, 14" long, 10-1/2" wide |
| Weight | Approx. 102 lbs. |
| Mounting | Free-standing base |

Pump Specifications:

| | |
|----------------------------|--|
| Electrical Power Source .. | 15 Amp, 120V grounded 1 Ph 50/60 HZ |
| Dimensions | 9-5/8" long, 9-5/8" wide, 14-1/4" high |
| Weight | 32 lbs. |
| Pressure | 0-10,000 PSI |
| Outlet Port Size | 3/8" NPT |
| Hydraulic Oil | Enerpac |
| Reservoir Capacity | 115.5 in ³ |
| Flow | .5-1.0 GPM |
| Motor Rating | 1/2 HP Universal, 9 Amps at 10,000 PSI |



OPTIONAL TOOLING & KITS

⚠ Refer to safety information regarding Coll-O-Crimp® hose, hose fittings and assembly equipment compatibility on pages 2 and 3.

430 'E' Series Collets

For 4 Spiral Hose H430

| | |
|-----------------|-----------------|
| T-420-4C | Collet – 1/2" |
| T-420-5C | Collet – 3/4" |
| T-420-6C | Collet – 1" |
| T-420-7C | Collet – 1-1/4" |

NOTE: Above collets to be used on Coll-O-Crimp® Super 1 Press and T-480 system only.

430 'U' Series No Skive Collets

For Hose H14516 and H54516 and 4 Spiral Hoses H430 and H439

| | |
|------------------|-----------------|
| T-420-4CN | Collet – 1/2" |
| T-420-5CN | Collet – 3/4" |
| T-420-6CN | Collet – 1" |
| T-420-7CN | Collet – 1-1/4" |

NOTE: Above collets to be used on Coll-O-Crimp Super 1 Press and T-480 system only.

470 'E' Series Collet

For 6 Spiral Hose H470

| | |
|------------------|-----------------|
| T-420-8C | Collet – 1/2" |
| T-420-9C | Collet – 3/4" |
| T-420-10C | Collet – 1" |
| T-420-11 | Collet – 1-1/4" |

NOTE: Above collets to be used on Coll-O-Crimp Super 1 Press and T-480 system only.

Spacer Ring

For crimping H54516, H430, H439 and H470 Hose with the T-480 System

⚠ **NOTE:** when crimping the Weatherhead hoses shown above with a T-420-4C/4CN, T-420-5C/5CN, T-420-6C/6CN, T-420-7C/7CN, T-420-8C, T-420-9C, T-420-10C, or a T-420-11 collet, a T-480-68 spacer ring **MUST BE USED** to prevent damage to the T-480 pusher.

When crimping 430 'U' and 43016 'U' Series No Skive hose ends to H14516 hose, the orange T-420-29 Spacer Ring **MUST BE USED**. For all other hose types, use the proper standard spacer ring shown to the right in "Conversion Tooling."

Conversion Tooling

If you desire to crimp hose other than four or six spiral hose with the T-480 system, you will need the T-420-25 Adapter Die Ring. This ring allows the use of standard Coll-O-Crimp® I tooling, listed below. Also listed are the proper Spacer Rings to use when converting your T-480. Order items individually by catalog number.

Note: See Hose End and Tool Selector Chart for proper spacer ring selection/position for hose type and size desired.

| | |
|------------------|------------------------------------|
| T-420-25 | Adapter Die Ring for T-400 Collets |
| T-400-10 | Spacer Ring - Black |
| T-400-11 | Spacer Ring - Silver |
| T-400-37 | Spacer Ring - Green |
| T-400-38 | Spacer Ring - Red |
| T-400-62 | Spacer Ring - Yellow |
| T-400-112 | Spacer Ring - Tan |

Additional Tooling Sets

See Weatherhead Master Hose Assembly Catalog for contents of tooling sets and for additional tooling not available in sets.

| | |
|------------------|---|
| T-400-30 | 'E' Series Collets - Nylon and Teflon® Hose. Requires T-400-10 (black), T-400-37 (green) or T-400-38 (red) Spacer Ring. Spacer Rings not included in T-400-30 Kit. |
| T-400-66 | 069 'E' Series Collets - Truck Hose. Requires T-400-10 (black), T-400-11 (silver) or T-400-62 (yellow) Spacer Ring. Spacer Rings not included in T-400-66 Kit. |
| T-420-30C | 10M Collet - Collet for -10 size 'M' Series ends. |
| T-400-67 | 'U' Series Collets - Rubber Hose. Requires T-400-10 (black), or T-400-11 (silver) Spacer Ring. Spacer Rings not included in T-400-67 Kit. |
| T-400-104 | 338 'P' Series Collets - Air Brake Hose. Requires T-400-10 (black) Spacer Ring. Spacer Rings not included in T-400-104 Kit. |
| T-400-114 | 757 'E' Series Collets - Air Conditioning Hose. Requires T-400-10 (black) Spacer Ring. Spacer Rings not included in T-400-114 Kit. |

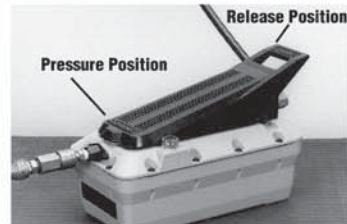
T-480 TA SET-UP & OPERATING INSTRUCTIONS



1. Open vent screw on pump reservoir before operation. Release the pusher clip and slide pusher back. **NOTE:** Periodically lubricate the die ring with Weatherhead T-400-G lubricant. When crimping with Coll-O-Crimp® I tooling, insert the T-420-25 adapter die ring into the base plate. Insert the proper sized collet.



3. Loosen knob and tilt press as necessary. Insert hose assembly from below the base plate and between the collet halves. Align dimples or knurl band on end fitting with top of collet, making sure that collet halves are evenly matched. When crimping H757 hose, position end fitting as shown in figure D, page 13.



5. Attach air supply and depress pressure end of treadle and hold until spacer ring contacts the base ring, indicating that the crimp is complete.



2. Select the proper Weatherhead hose and end fitting. Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting. For insertion depth information, reference figure A, page 13.



4. Holding uncrimped hose assembly in place, reference Hose End and Tool Selector Chart found on page 16 for correct spacer ring. **Note:** when crimping spiral-reinforced hose (H430, H439, H470), a T-480-68 spacer ring must be used to prevent damage to the pusher. Position spacer ring on top of collet with proper side of spacer ring facing up as shown in figure B, page 13 and slide pusher forward, making sure pusher clip has locked.



6. Depress the release end of treadle to retract pusher. Release the pusher clip and slide the pusher back to access tooling. Remove the spacer ring and the crimped hose assembly from below the base plate and between the collet halves. **NOTE:** Visually inspect the crimped end. Check the nominal crimp diameter and verify that the crimp is within 1/16" from the locating dimples on the collar, see figure C, page 13.

WEATHERHEAD®

T-480 AH SET-UP & OPERATING INSTRUCTIONS



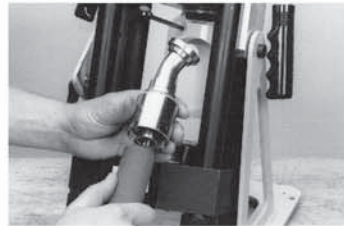
1. Pump reservoir must be properly vented before operation. Release the pusher clip and slide pusher back. NOTE: Periodically lubricate the die ring with Weatherhead T-400-G lubricant. When crimping with Coll-O-Crimp® I tooling, insert the T-420-25 adapter die ring into the base plate. Insert the proper sized collet.



3. Loosen knob and tilt press as necessary. Insert hose assembly from below the base plate and between the collet halves. Align dimples or knurl band on end fitting with top of collet, making sure that collet halves are evenly matched. When crimping H757 hose, position end fitting as shown in figure D, page 13.



5. Attach air supply and depress pressure valve and hold until spacer ring contacts the base ring, indicating that the crimp is complete.



2. Select the proper Weatherhead hose and end fitting. Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting. For insertion depth information, reference figure A, page 13.



4. Holding uncrimped hose assembly in place, reference Hose End and Tool Selector Chart found on page 16 for correct spacer ring. Note: when crimping spiral-reinforced hose (H430, H439, H470), a T-480-68 spacer ring must be used to prevent damage to the pusher. Position spacer ring on top of collet with proper side of spacer ring facing up as shown in figure B, page 13 and slide pusher forward, making sure pusher clip has locked.



6. Release pressure valve to retract pusher. Release the pusher clip and slide the pusher back to access tooling. Remove the spacer ring and the crimped hose assembly from below the base plate and between the collet halves. NOTE: Visually inspect the crimped end. Check nominal crimp diameter and verify that the crimp is within 1/16" from the locating dimples on the collar, see figure C, page 13.

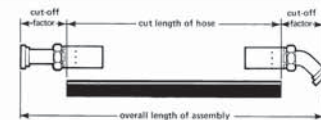
SKIVING PROCEDURE



Failure to completely remove the cover may result in serious personal injury or property damage due to hose ends blowing off, hose leakage, and other failures.

HOSE CUT-OFF FACTOR

Select the proper hose and ends and cut hose to length. The cut length of the hose is determined by subtracting the cut-off factor for each end from the overall length of the assembly. See individual catalog listings for hose cut-off factors.



SKIVING WEATHERHEAD HOSE

When using H425, H430, and H439 hoses with 430 'E' series hose ends and H470 hose with 470 'E' series hose ends

The outer protective covering of wire-wrapped hose must be carefully removed (skived) to the wire to allow proper installation of crimped hose ends and to assure the best possible hose service.

There are two basic methods of skiving a hose: hand-tool and

wire-brush. Each method has specific advantages and should be used as shown below.

With either skiving method, it is advisable to skive a practice piece of hose to determine that covering is properly removed and that the hose wire-wrap reinforcements are not displaced, damaged or cut in the process. The hose should be checked for correct skive length and 100% cover removal.

| HOSE Hose I. D. | H425# | | H430 AND H439 | | H470 | |
|-----------------------|-----------------|-------------------------------------|-----------------|-----------------|---|-----------------|
| | Skive Length | Recommended Skiving Method | Skive Length | Cutting Head | Skive Length | Cutting Head |
| 1/2 | 1-3/8 | Wire-Brush | 1-3/8 | T-410-30 | 1-1/4 | T-410-50 |
| 3/4 | 1-11/16 | | 1-11/16 | T-410-31 | 1-13/16 | T-410-52 |
| 1 | 1-15/16 | | 1-15/16 | T-410-32 | 2-1/8 | T-410-53 |
| 1-1/4 | 2-1/8 | | 2-1/8 | T-410-33 | 2-7/8 | T-410-54 |
| 1-1/2 | 2-1/4 | | 2-1/4 | T-410-34 | 3-1/8 | T-410-55 |
| 2 | 2-9/16 | | 2-9/16 | T-410-35 | 3-3/8 | T-410-56 |
| T-410-36 Handle | | T-410-37 Replacement cutting blades | | | # When used with 430 'E' series hose ends | |

WIRE-BRUSH METHOD

Position the end on a suitable mandrel and rotate the hose against a wire brush to remove the protective covering. See above for correct skive length. In some instances, and with care, the hose may be hand-held while being skived. In either case, it is important that the covering be removed down to the

wire wrap, and that the wire wrap not be disturbed or damaged.



HAND-TOOL METHOD

Skiving heads are shipped preset for proper skive length. Depending on hose cover thickness, the skiving blade may require adjustment. The skiving blade may need periodic adjustment. Directions are packed with the skive tool.

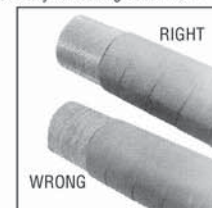
1. Clamp hose in a vise or other suitable holding device. Be sure not to clamp so tight as to damage hose.
2. Lubricate hose I.D. and skiving tool mandrel with oil/soap solution.
3. Carefully align mandrel with hose I.D.; apply steady pressure and start mandrel into hose.
4. When cutting head contacts hose end, slowly rotate skiving tool clockwise. Cutting head will remove hose covering while threading itself to a preset skive length when bottomed against

hose end. Continue to rotate skiving tool clockwise to remove excess rubber from wire wrap while slowly pulling tool from hose. (See illustration below)

5. Wire-brush hose end to remove any remaining cover from wire wrap.

6. Inspect skive for 100% cover removal.

Important: Clean hose I.D. by brushing, blowing compressed air, or by flushing. By doing so, contaminants are kept out of operating systems.



CHECK-OUT PROCEDURE

Check for proper oil level in the power unit. The oil reservoirs in all power units have been filled at the factory; however, if oil is required, refer to the instruction sheet provided with each unit for proper hydraulic oil and filling procedure. It is recommended that you follow the procedure below for your specific model of crimper before making any hose assemblies.

CAUTION: Throughout this procedure, check the power unit and all threaded connections for any leaks and tighten as necessary.

T-480-HP

Note the following steps must be performed without tooling in the press.

1. Turn vent/fill cap to "vent" position to vent reservoir.
2. Open release valve and operate handle until the pusher has fully extended.
3. Release control valve allowing the pusher to retract.
4. Repeat steps 2 and 3 approximately six times which will help purge air from the system.

T-480-AH

1. Connect air supply to the 1/4" NPT port on pump. Recommended air inlet pressure is 60-100 psi. To ensure a long service life, it is recommended that a filter, regulator, lubricator and gauge be installed in the air line.
 2. Turn on air supply and adjust to recommended inlet pressure.
- Note the following steps must be performed without tooling in the press.**
3. Push down pressure valve allowing the pusher to fully extend.
 4. Release pressure valve allowing pusher to retract and purge any air from the system.
 5. Repeat steps 3 and 4 until any air has been purged. When pusher extends fully and retracts without hesitation, the air has been vented from the system.
 6. Turn off air supply.

For models T-480-TA and T-480-EP, the hose assembly will need to be connected. Assemble coupler nipple into street elbow and O-ring adapter and assemble into press.

Assemble female half of coupler to hose assembly and thread adapter into pump and connect hose assembly. Use pipe thread compound on all pipe threads.

T-480-TA

1. Connect air supply to the 1/4" NPT port on pump. Recommended air inlet pressure is 40-150 psi. To ensure a long service life, it is recommended that a filter, regulator, lubricator and gauge be installed in the air line.
2. Turn on air supply and adjust to recommended inlet pressure.
3. Vent pump reservoir by opening vent screw.

Note the following steps must be performed without tooling in the press.

4. Push down pressure valve allowing the pusher to fully extend.
5. Push down on release end of treadle allowing pusher to retract and purge any air from the system.
6. Repeat steps 4 and 5 until any air has been purged. When pusher extends fully and retracts without hesitation, the air has been vented from the system.
7. Turn off air supply.

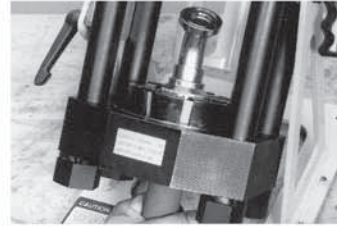
T-480-EP

1. Connect power cord to suitable 15 amp, 120V grounded single phase circuit.
 2. Open vent plug on reservoir.
 3. Turn pump switch located on side of shroud to "on" position.
- Note the following steps must be performed without tooling in the press.**
4. Press pendant switch and hold until pusher fully extends.
 5. Release pendant switch allowing pusher to retract.
 6. Repeat steps 4 and 5 until any air has been purged. When pusher extends fully and retracts without hesitation, the air has been vented from the system.
 7. Turn pump switch to "off" position.

T-480 HP SET-UP & OPERATING INSTRUCTIONS



1. Turn vent/ fill cap to "vent" position to vent pump reservoir. Release the pusher clip and slide pusher back. **NOTE:** Periodically lubricate the die ring with Weatherhead T-400-G lubricant. When crimping with Coll-O-Crimp® I tooling, insert the T-420-25 adapter die ring into the base plate. Insert the proper sized collet.



3. Loosen knob and tilt press as necessary. Insert hose assembly from below the base plate and between the collet halves. Align dimples or knurl band on end fitting with top of collet, making sure that collet halves are evenly matched. When crimping H757 hose, position end fitting as shown in figure D, page 13.



5. Close release valve.



2. Select the proper Weatherhead hose and end fitting. Insert the hose into the end fitting, making sure that the hose is bottomed in end fitting. For insertion depth information, reference figure A, page 13.



4. Holding uncrimped hose assembly in place, reference Hose End and Tool Selector Chart found on page 16 for correct spacer ring. **Note:** when crimping spiral-reinforced hose (H430, H439, H470), a T-480-68 spacer ring must be used to prevent damage to the pusher. Position spacer ring on top of collet with proper side of spacer ring facing up as shown in figure B, page 13 and slide pusher forward, making sure pusher clip has locked.



6. Operate pump handle until spacer ring contacts the base plate indicating that the crimp is complete. Open the release valve to retract pusher. Release the pusher clip and slide the pusher back to access tooling. Remove the spacer ring and the crimped hose assembly from below the base plate and between the collet halves. **NOTE:** Visually inspect the crimped end. Check the nominal crimp diameter and verify that the crimp is within 1/16" from the locating dimples on the collar, see figure C, page 13.

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