

Aeroquip Crimping Machine Crimping Procedure

Facility:	Written By:	Approved By:	Date Created:	Date of Last Revision

Hazards Present:	PPE or Devices Required:	Additional Training Required:
Mechanical Energy	Safety Glasses	Certification/ training in house
Pinch Point	Steel Toed Boots	by individuals, experienced
	Hand Protection	and knowledgeable with the tool
		Operators Manual

Safe Work Procedure:

- 1) Refer to the current Aeroquip Crimp Specifications bulletin for complete and detailed crimp specification information for each hose and fitting style
- 2) Retract the crimp ring by depressing the retract switch until the crimp ring is fully retracted. Select the proper die cage from the current Aeroquip Crimp Specifications bulletin. Slide the die cage into the cage holder slots
- 3) Press the proper PRESENT button or key in a value to DISPLAY. MatchMate Plus and MatchMate Blue target setting charts are available from Aeroquip.
- 4) Position the fitting within the crimp cage according to the corresponding figure in the current Aeroquip Crimp Specifications bulletin
- 5) To crimp the fitting, depress the CRIMP switch. The crimp ring will rise until the fitting is fully crimped. It will then stop and begin to retract, signifying that the crimp is complete. Remove your finger from the CRIMP switch. The crimp ring will automatically retract and stop at the *soft retract* position (about ½ inch short of being fully retracted)
- 6) **Verify correct crimp diameter**

NOTE

- A) Retraction can be halted at any point by momentarily depressing the RETRACT switch, and then resumed by depressing and hold the RETRACT switch
- B) Full Retraction is required for changing die cages.

If an emergency situation occurs while conducting this task, or there is an equipment malfunction, engage the emergency stop and follow the lock out procedure
REPORT ANY HAZARDOUS SITUATIONS TO YOUR SUPERVISOR

<p>Guidance Documents/Standards: MB Workplace Safety & Health Act & Regulations: Part 2.1 Safe Work Procedures Section 5 Duties of Workers Part 6 Personal Protective Equipment</p>	<p>This Safe Work Procedure will be reviewed any time the task, equipment or materials change and at a minimum of every three years</p> <hr/> <p>Reviewed By WSH Committee:</p> <p>Date:</p>
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