

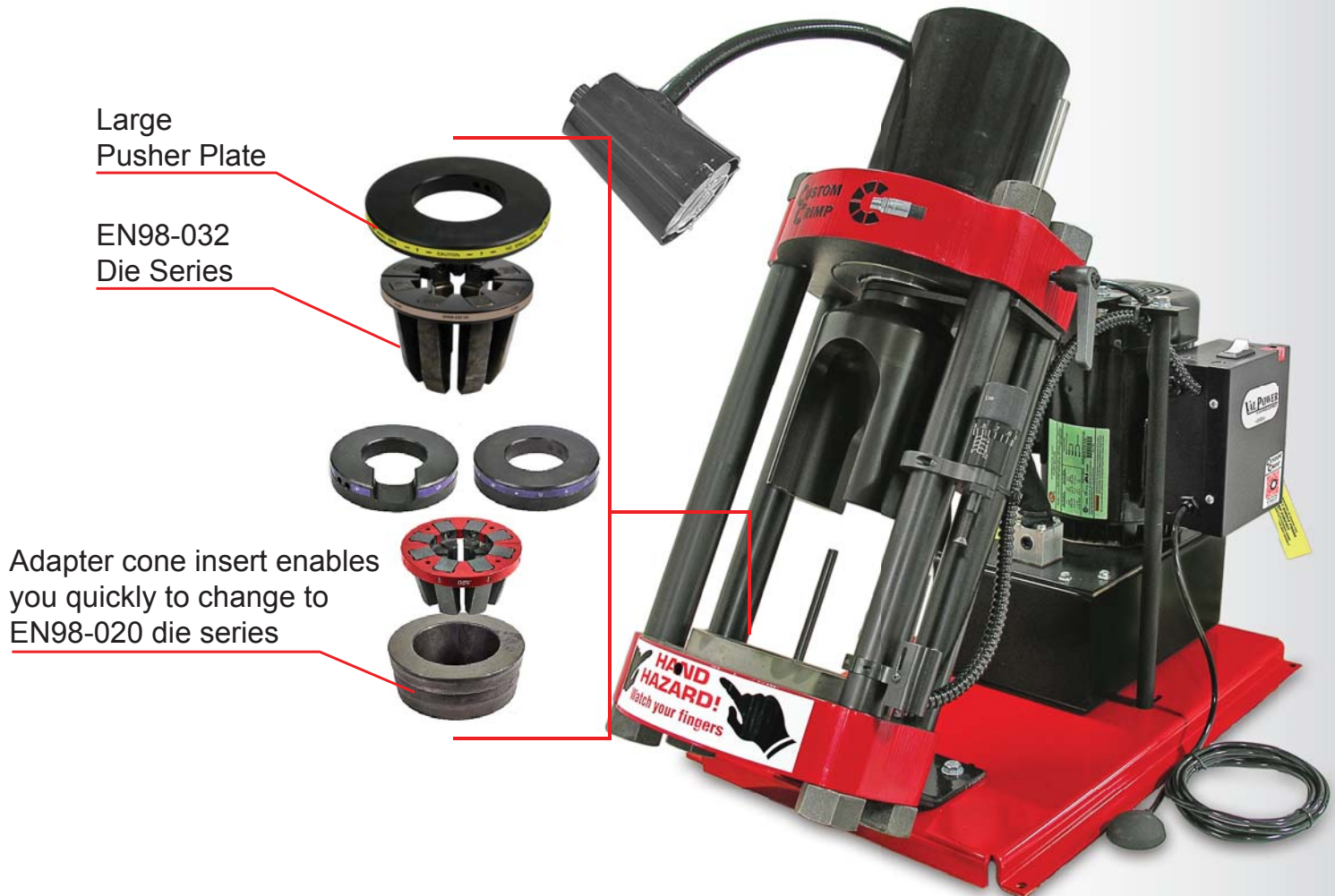
D205WB / D206WB Service Hose Crimper



The D206-WB hose crimper with the Micrometer Style Adjustment and 80 ton cylinder has the capacity to crimp hoses up to: 1-1/4" 4SP (with standard EN98-020 dies) and up to 2" 4SP (with optional EN98-032 dies).

UNIQUE USER FRIENDLY MICROMETER STYLE ADJUSTMENT

- Easy to use and read.
- Ideal for repetitive crimps.
- Fully adjustable micrometer for a precise crimp.
- Simple to calibrate and minimum maintenance.
- Micrometer style adjustment permits crimping a wide variety of hose and fittings.
- Utilizes existing NP60 and DE60 die sets.



D205WB / D206WB SERIES HYDRAULIC CRIMPER OPERATORS MANUAL

D205WB / D206WB Service Hose Crimper



SAFETY PRECAUTIONS

MODELS COVERED:

This manual is applicable to a number of variations of the D205WB Series Crimpers.

A "Standard", "Metric" and "DC" Micrometer is available on different models.

A 1HP-110Volt and a 2 HP-220 Volt ValPower pump are used on different models.

Crimping, calibration and repair procedures are similar.

See detailed parts breakdown at the back of the manual for parts applicable to specific models



SAFETY PRECAUTIONS



- READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER.
- CRIMPER D205WB / D206WB SERIES CAN PRODUCE 80 TONS OF CRIMPING FORCE.
- KEEP BOTH HANDS AWAY FROM PINCH POINTS.
- CONSULT HOSE AND FITTING MANUFACTURER FOR CORRECT MACHINE SETTINGS AND CRIMP MEASUREMENTS.
- ALWAYS WEAR EYE PROTECTION.

D205WB / D206WB Service Hose Crimper



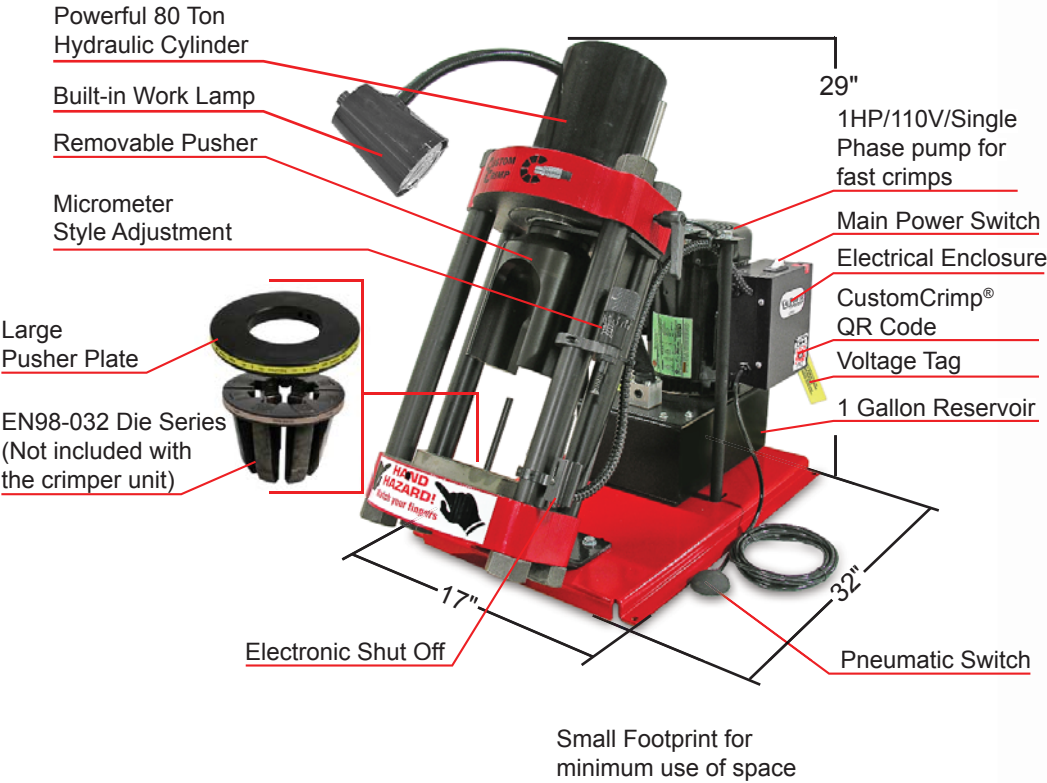
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D205WB / D206WB Service Hose Crimper



COMPONENT PARTS & TECHNICAL DATA



Technical Data	
80 Ton EN98-020 Dies	80 Ton EN98-032 Dies
1-1/4" - 1 - 2 Wire	2" - 1 - 2 Wire
1-1/4" - 4SP	2" - 4SP
L: 32" x W: 17" x H: 29"	
Weight: 305 lbs	
Power: 2HP / 220V / 1Phase (Standard) 1HP / 110V / 1Phase (Optional)	
Die series: EN98-020 / EN98-032	
Micrometer Style Adjustment: Standard	
Reservoir capacity: 1 US Gallon	
Oil type: ISO 46 Hydraulic Oil	

*Crimper capacity is estimated based on typical 1-piece fitting. Actual results may vary depending on the fitting and hose manufacturer.

Bent Tube Pusher Plate Standard Pusher Plate



EN98-020 Die Series (Not included)



Cone Insert

Die Stack with EN98-032 Series Dies

EN98-032 Die Series (Not included)

Large Pusher Plate



Die Stack with EN98-032 Series Dies

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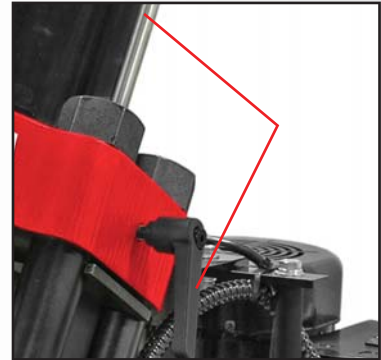
D205WB / D206WB FEATURES

- The D205WB / D206WBVVV Series Crimper comes with standard features which increase accuracy and improve productivity for jobs which require repeat crimps of similar or identical assemblies. (Optional accessories available).

- Fully adjustable micrometer for a precise crimp and electric shutoff switch makes crimping process fast.



- The Adjustable Retraction Stop allows the operator to limit the retraction of the hydraulic ram at the point where the die set is open only enough to remove the hose and fitting. This feature can greatly speed up crimping on production jobs since the ram does not have to fully advance and retract on every cycle.



- With the EN98-032 series dies can crimp up to 1-1/4" 4 spiral hose.



- With the EN98-032 series dies can crimp up to 2" 4 spiral hose.



D205WB / D206WB Service Hose Crimper



INITIAL SET UP & MAINTENANCE

FOLLOW THESE STEPS BEFORE YOU USE THE CRIMPER FOR THE FIRST TIME.

- Mount the crimper on a sturdy workbench in a well-lit area. Workbench should be able to support the crimper and components weight.
 - The crimper should be mounted close enough to the edge of the work surface so that hose will not contact the bench or work surface while crimping. There must be enough clearance for the hose to align perpendicular with the cone base, or the dies will not seat properly and the crimps will not be accurate.
 - Always check oil level in the D205WB pump, should be 1-1/2 to 2 inches below the vent plug when the cylinder is in the retracted position and should be visible in the sight glass window of the pump reservoir.
 - If oil needs to be added use ISO 46 weight hydraulic oil.
 - Oil can be drained from the rear oil port of the reservoir.
 - Check to be certain that the shipping plug in the pump reservoir has been replaced with the vent plug shipped with the D205WB crimper.
 - Check electrical circuit to be certain that it matches the crimper requirements shown on the voltage tag attached to the crimper cord.
 - Plug the D206WB crimper directly into a 110 volt, 15 amp wall outlet.
- Note:** The optional 220 volts / 2HP unit must be connected to a 220 volts 20 amp wall outlet.



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EN98-032 LUBRICATION PROCEDURE

Grease Point # 1

Place a thin layer of CrimpX grease (supplied with crimper) or a high pressure molybdenum high pressure grease on the surface of the bottom flange. (as shown in photo # 1).



Photo # 1

Grease Point # 2

Before sliding the large pressure plate over the correct dies, place a thin layer of CrimpX grease (supplied with crimper) or a high pressure molybdenum high pressure grease on the entire area that dies come in contact with (as shown in photo # 2).



Photo # 2

If Dies are sticking in the surface of the bottom flange:

Continue to lubricate / grease as explained above in addition to lubricating each die finger individually. (as shown in photo # 3).

Note: The die fingers must be lubricated at the positions that come in contact with the pressure plate and the bottom flange.

Note: Lubrication is not required before each crimp. Typical lubrication is after 100 crimps.



Photo # 3

D205WB / D206WB Service Hose Crimper



EN98-020 LUBRICATION PROCEDURE

Grease Point # 1

Place a thin layer of CrimpX grease (supplied with crimper) or a high pressure molybdenum high pressure grease on the surface of the adapter cone inert. (as shown in photo # 1).



Photo # 1

Grease Point # 2

Before sliding the standard pusher plate or the bent tube pusher plate (as shown in photo # 2 and # 3) over the correct dies, place a thin layer of CrimpX grease (supplied with crimper) or a high pressure molybdenum high pressure grease on the entire area that dies come in contact with



Photo # 2

If Dies are sticking in the surface of the bottom flange:

Continue to lubricate / grease as explained above in addition to lubricating each die finger individually. (as shown in photo # 4).



Photo # 3

Note: The die fingers must be lubricated at the positions that come in contact with the pressure plate and the bottom flange.

Note: Lubrication is not required before each crimp. Typical lubrication is after 100 crimps.

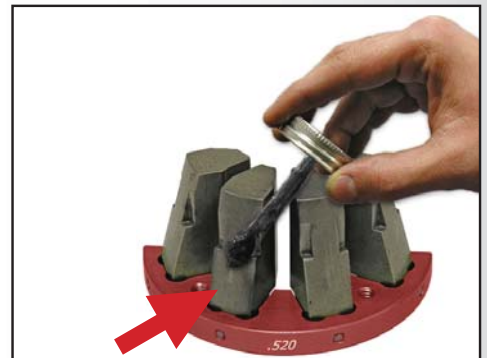


Photo # 4

D205WB / D206WB Service Hose Crimper



CRIMPING WITH EN98-020 DIE SERIES



Lubricate all contact surfaces of the cone insert and place it squarely in the base of the crimper.



Lubricate die fingers, all contact surfaces and die cones.

WARNING: Failure to lubricate will cause damage to die sets and crimper.



Alignment of the hose and fitting in the die set is shown. Reference hose and fitting manufacturers specifications for correct locations



Use care to be certain that the die halves do not overlap.



Place the die set and hose and fitting loosely in the cone insert.



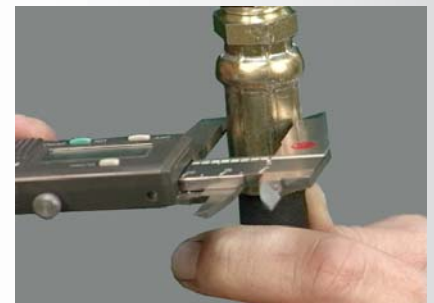
Place the Pusher Plate on top of the die set.



Slide the Pusher onto the stud on the hydraulic ram.



Press and hold the start switch until the motor shuts off.



Check the finished crimp diameter to be certain that it is within the hose and fitting manufacturers crimp specification limits.

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CRIMPING WITH EN98-030 DIE SERIES

Crimping with CC032 series dies is essentially identical to crimping with the CC020 series dies except that the Cone Insert is removed from the crimper base



Remove the Cone Insert from the crimper base and lubricate all contact surfaces of the die set.

WARNING: Failure to lubricate will cause damage to die sets and crimper



Insert the die set and Pusher Plate in the order illustrated.



Align the hose and coupling as recommended. Load the Pusher Plate and Pusher and press and hold the start/stop switch until the crimper shuts off. Check the final crimp diameter to be certain that it is within specifications.

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INCLUDED ACCESSORIES



Removable Pusher
(Included) P/N:100818



Large Pusher Plate (Included)
P/N:EN94-030



Standard Pusher Plate
P/N:EN97-058



Bent Tube Pusher Plate
P/N:EN96-027



Adapter cone
P/N:EN94-027-C



Pneumatic Pendent Switch
(Included) P/N:101349



Work Lamp Installed
P/N:668-02



D205WB/D206WB Coupling
Stop P/N:101631



CRIMPX Lubricant Grease
4 oz can with brush (Included)
P/N:104162



(5) Screws for die series EN98-020
P/N:EN84-115
(5) Springs for die series EN98-020
№:LC 022D 01



Vent Plug
P/N:104007

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AVAILABLE ACCESSORIES



D205/D206 Die Storage Shelf
(Optional) P/N:101625



Mobile Cart
(Optional) P/N:101956



Screws for die series EN98-032
P/N:EN00-061
Springs for die series EN98-032
P/N:LC 032E 04 M



Die Removal Magnet
P/N:104679



CustomCrimp® Notched Digital
Caliper IN/MM P/N:CC-Caliper

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TROUBLESHOOTING

PROBLEM: CRIMPER WILL NOT RUN AT ALL

- The white rocker switch is also a circuit breaker. Check to see that the circuit breaker has not been tripped
- Check the wall outlet. The crimper comes from the factory wired for a 220 volt single phase (D205WB) or a 115 volt single phase circuit. (D206WB) Use of extension cords or outlets with inadequate power can damage the motor. Do not run the crimper from a portable power source.
- Check the stop switch mounted to the switch bracket under the Micro-Crimp Adjuster. This is a normally closed switch and if it does not close the crimper will not operate.
CAUTION: Do not operate the crimper with this switch jumpered as the pump will not shut off and the brackets can be damaged.
- Check the pneumatically actuated switch in the electrical box mounted on the motor. This switch controls power to the motor and is actuated with air pressure from the pendant switch bulb.

PROBLEM: CRIMP DIAMETER TOO LARGE

- Incorrect setting of the Micro-Crimp Adjuster. Check crimp specifications.
(NOTE: All published machine settings are approximate. To correct for slight variances, the gauge settings may be adjusted for the specific hose, fitting and size combination.)
- Incorrect die being used. Each die has a range of approximately 3mm (.120 in) above the closed diameter of the die. The closed diameter is the die size stamped on the die ring.
- Check crimper calibration and re-calibrate if required.
- Inadequate pump pressure. Check oil level in the pump. It should be 1-1/2 to 2 inches below the fill plug. Replenish with ISO Viscosity Grade 46 hydraulic oil.
- Inadequate lubrication of the dies and compression ring causing the pump to work harder than normal to reach the required diameter. Use only the grease shipped with the machine or equivalent.
- Inadequate pressure being generated by the pump. This is most likely if the crimper can crimp the smaller size hoses and not the larger hoses. When correctly adjusted, the pump should generate approximately 10,000 psi.
Do Not adjust pump to produce in excess of 10,000 psi as damage to components or personal injury may result.
- No pressure being generated by the pump. There should be a definite change in pitch of the pump as it cycles into high pressure mode and begins to "work" harder.

PROBLEM: CRIMP DIAMETER TOO SMALL

- Incorrect setting of the Micro-Crimp Adjuster. Check crimp specifications.
(NOTE: All published machine settings are approximate. To correct for slight variances, the gauge settings may be adjusted for the specific hose, fitting and size combination.)
- Incorrect die being used (See die range under Crimp Diameter too Large)
- Check crimp diameter and re-calibrate if necessary

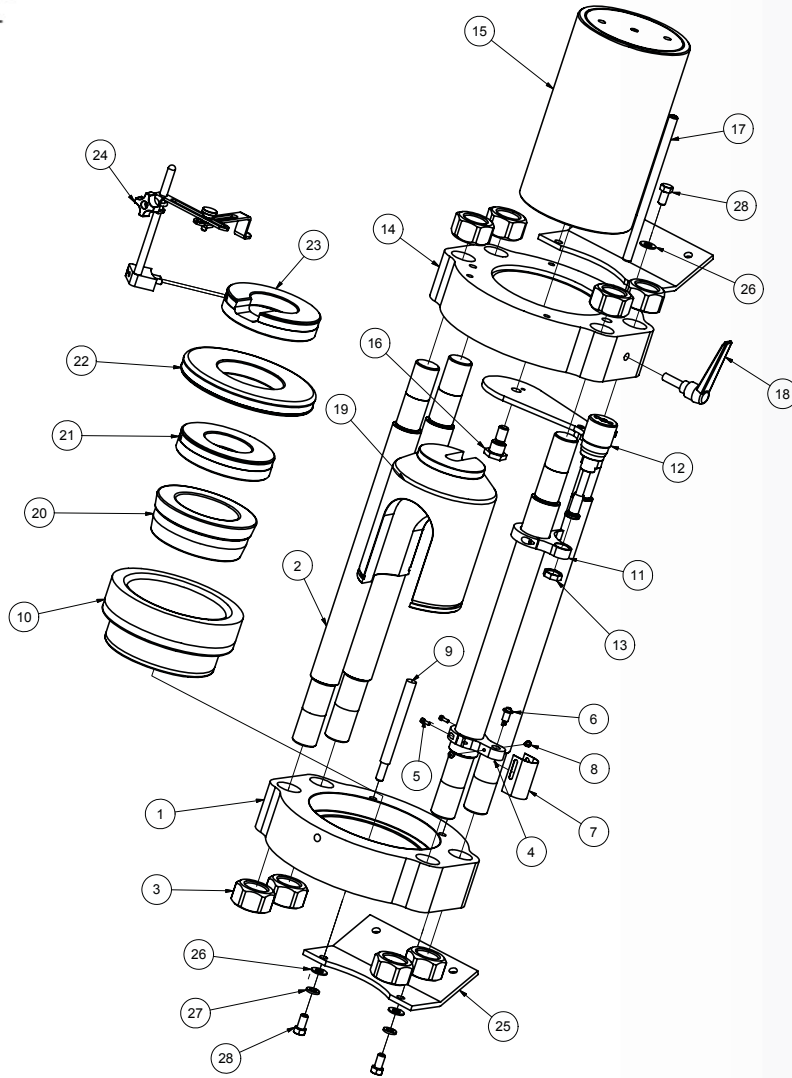
PROBLEM: DIES STICKING IN COMPRESSION CONE

- Inadequate lubrication of the compression cone and die surfaces. Use only the grease shipped with the machine or equivalent.

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COMPONENT PARTS BREAKDOWN

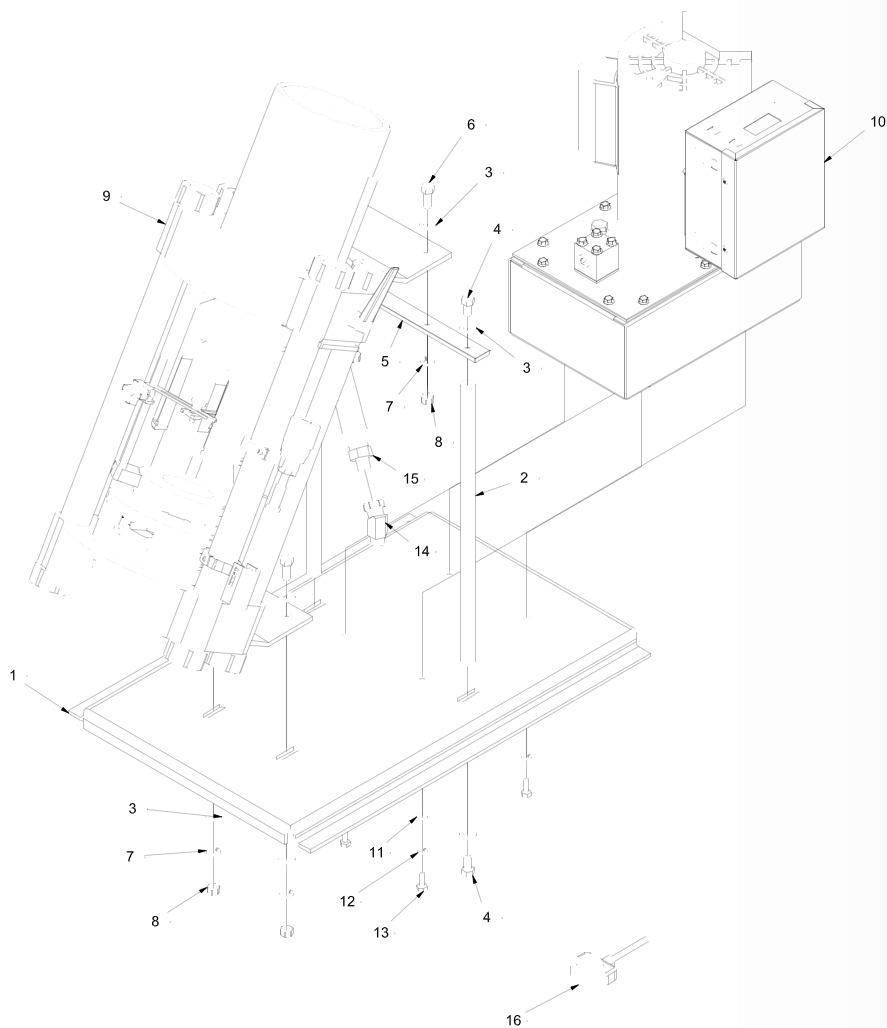


D205WB/D206WB Crimper Head Assembly (102263)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	100679	80-Ton Cone Base	1
2	100642	Strain Rod	4
3	90500A040	Heavy Hex Nut 1 1/4-12 Gd.8	8
4	100661	Limit Switch Bracket	1
5	91251A146	6-32 X 3/8 SHCS	2
6	903 Switch	Limit Switch	1
7	100692	Limit Switch Guard	1
8	91255A190	8-32 X 1/4 BHCS	2
9	101995	3/8 Dia. X 5 1/2 Pin	2
10	100643	Compression Cone	1
11	100641	Micrometer Mount Assembly	1
12	100628	Standard Micrometer Assembly	1
13	100727	Micrometer Nut	1
14	100640	80-Ton Top Flange	1
15	100663	80-Ton Cylinder Assembly	1
16	100648	Pusher Suspension Pin	1
17	100711	Stop Rod	1
18	100710	Stop Rod Locking Handle	1
19	100818	Pusher	1
20	100964	Cone Reducer	1
21	100915	NP Pusher Plate	1
22	100961	WB Pusher Plate	1
23	100960	NP Bent Tube Pusher Plate	1
24	100954	Coupling Stop Assembly	1
25	100680	Mounting Bracket	2
26	90126A031	3/8 Flat Washer	4
27	91102A031	3/8 Lock Washer	2
28	92865A622	3/8-16 X 3/4 Hex Bolt	4

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COMPONENT PARTS BREAKDOWN



D205WB/D206WB Crimper Assembly (102265)			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	101585	Crimper Base	1
2	101624	Support Rod	2
3	90126A031	3/8 Flat Washer	10
4	92865A622	3/8-16 X 3/4 Hex Bolt	4
5	101621	Support Rod Brace	1
6	92865A624	3/8-16 X 1 Hex Bolt	4
7	91102A031	3/8 Lock Washer	4
8	95462A031	3/8-16 Nut	4
9	101987	Crimper Head Assembly	1
10	101633	1HP Pump Assembly	1
10	102264	2HP Pump Assembly	1
11	90126A029	1/4 Flat Washer	4
12	91102A029	1/4 Lock Washer	4
13	92865A540	1/4-20 x 3/4 Hex Bolt	4
14	60TA06X08	45 Deg. Hydraulic Fitting	1
15	101645	Hydraulic Hose	1
16	101349	Pendant Switch & Plug	1



CUSTOMCRIMP® “NO-NONSENSE” WARRANTY STATEMENT



CustomCrimp® “No-Nonsense” Warranty Statement

All CustomCrimp® Products are warranted to be free of defects in workmanship and materials for one year from the date of installation. This warranty ends when the product becomes unusable for reasons other than defects in workmanship or material.

Any CustomCrimp® Product proven to be defective in workmanship or material will be repaired or replaced at no charge. To obtain benefits of this warranty, first, contact Warranty Repair Department at Custom Machining Services at **(219) 462-6128** and then deliver via prepaid transportation the complete hydraulic product to:

**ATTN: WARRANTY REPAIR DEPT.
Custom Machining Services, Inc.
326 North Co. Rd 400 East
Valparaiso IN 46383**

If any product or part manufactured by CustomCrimp® is found to be defective by CustomCrimp®, at its option, CustomCrimp® will either repair or replace the defective part or product and return via ground transportation, freight prepaid.

CustomCrimp® will not cover any incoming or outgoing freight charges for machines sold outside The United States.

This warranty does not cover any product or part which is worn out, abused, altered, used for a purpose other than for which it was intended, or used in a manner which was inconsistent with any instructions regarding its use.

Electric motors are separately warranted by their manufacturer under the conditions stated in their separate warranty.

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CONTACT US

CUSTOMCRIMP®, YOUR SINGLE SOURCE FOR HOSE ASSEMBLY PRODUCTS.

Products and services to support industry wide hose assembly needs.

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Fax: (219) 464-2773
www.customcrimp.com



CustomCrimp®

See the complete line of CustomCrimp® Crimpers and Accessories at:

www.customcrimp.com

(219) 462-6128