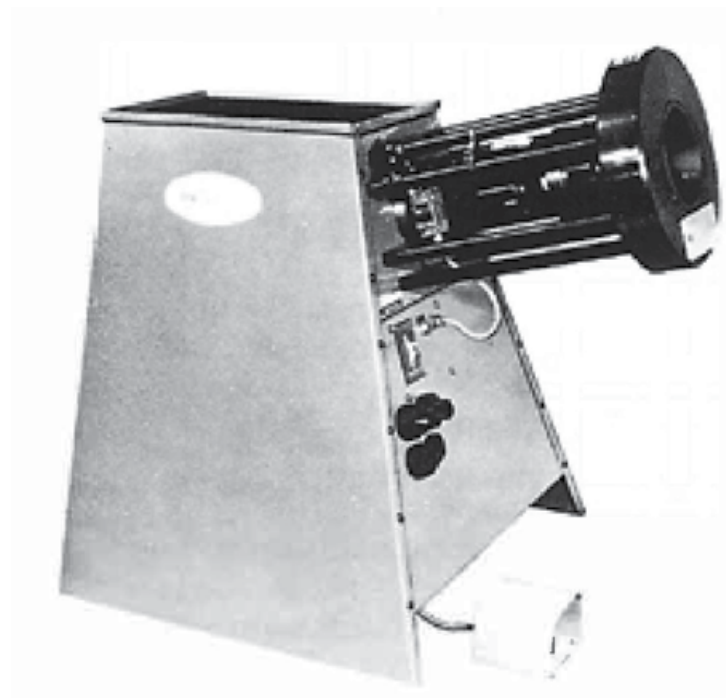


Operating Instructions

Aeroquip® FT1307 Crimp Machine

Maintenance and Repair Instructions



The new Aeroquip FT1307 crimped hose assembly machine is designed for quick, accurate crimping of high quality hose assemblies by distributors and manufacturers. Simple to set up and operate, the FT1307 crimp machine provides fast, efficient hose assembly production.

The Aeroquip FT1307 crimp machine will attach straight and elbow fittings on textile and wire reinforced hoses, through 6-spiral wire, up through 2" I.D. It will also crimp fittings on Aeroquip teflon and thermoplastic hoses.

Features

- Front-end loading design
- Limit switch control of crimp diameter
- Power return stroke, return limit control.
- Drop-in tooling (crimp die cages)
- Optional backstop fitting locator and elbow holders.

The machine crimps fittings to preset dimensions and automatically stops and returns when the crimping operation is completed. Crimping die cages can be quickly changed, with some dies capable of crimping several styles of hoses.

Benefits

- Offers greater visibility and ease of operation than top-loading or bottom-loading crimp machines.
- Provides exact and consistent crimp, time after time.
- Permit faster, more efficient production.
- Simplified crimping operation eliminates handling of rings and dies, and eliminates incorrect die insertion.
- Complete range of tooling options permits "custom design" of machine to suit individual requirements.

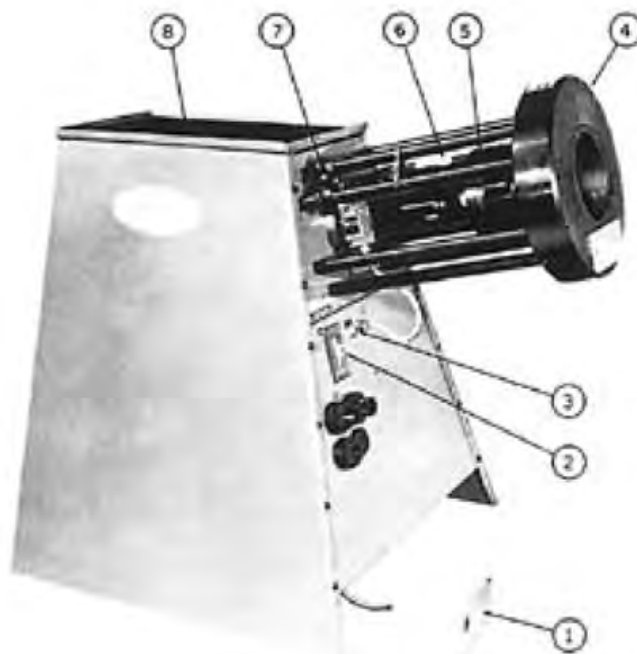
Aeroquip® FT1307 Crimp Machine Maintenance and Repair Instructions

Machine Components

1. Foot switch
2. Electric On-Off Switch
3. Jog Return Switch
4. Crimp Ring
5. Crimp Die Cage (must be ordered separately)
6. Digital Crimp Diameter Control for Crimp Die Setting
7. Return Stop Adjustment
8. Padded Tool/Parts Tray

Machine Specification

Dimension	35" wide, 48" deep, 44" high
Weight	850lbs. (without tooling)
Pump	2 stage, 7 gpm to 400 psi 1 gpm to 3000 psi
Reservoir Capacity	5 gallons (SAE 10W hydraulic oil) Machine supplied with oil
Electrical	120 volt, single phase, 60 hertz, 1 hp motor. Requires 30 amp service



Aeroquip FT1307 Models

FT1307-1-1 Aeroquip crimp machine, 120 volt, single phase, 60 hertz, 1 hp motor

FT1307-1-3 Aeroquip crimp machine, 220 volt, single phase, 60 hertz, 1 hp motor

Both crimp machines have a digital micrometer for setting crimp diameters.

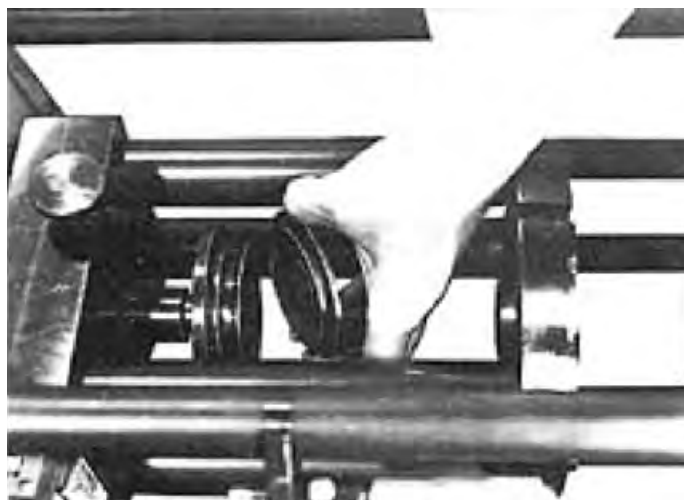
Operating Instructions



1. Hose and Fitting Preparation

Select the proper hose, nipple, and socket combination. Cut to length and skive, if necessary. Install the socket on the hose, then, insert the nipple into the hose until the nipple shoulder bottoms against the hose.

CAUTION: This equipment has powered moving parts. Read all operating and safety instructions in the owner's manual before attempting to operate.



2. Optional Straight Fitting Locators

The optional straight fitting location kit has four different individual locators which "lock-on" to the holder assembly.

This optional location kit is not required when crimping most standard hose assemblies but aids in correct fitting location when assembling several identical fittings.

Aeroquip® FT1307 Crimp Machine Maintenance and Repair Instructions



3. Optional Elbow Fitting Location Kit

The optional elbow fitting location kit contains a yoke holder and yokes up to -16 size. The yokes simply rotate into the yoke holder which interlocks with the holder assembly.



6. Straight Fitting Position (w/o Locator Kit)

Without the optional locator kit, align the fitting in the correct position. Refer to the owner's manual for correct fitting location.



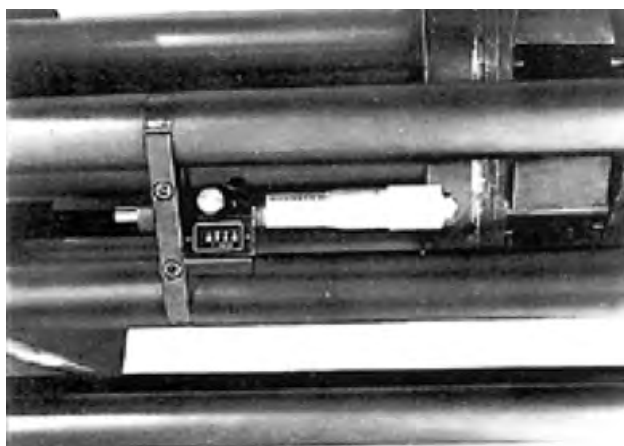
4. Insert Crimp Die Cage

With the piston retracted, the crimp die cage is installed and locked into position with three alignment slots.



7. Straight Fitting Position (w/ Locator Kit)

When using the optional straight fitting locator kit, positioning of the locator is accomplished by loosening the hand knob, sliding the assembly into the correct position, followed by tightening of the hand knob. Refer to the owner's manual for correct fitting location.



5. Setting the Crimp Diameter Control

Refer to the owner's manual for information on how obtain the correct micrometer setting. Set the micrometer accordingly.



8. Elbow Fitting Position (w/o Locator Kit)

Most standard elbow assemblies may be crimped by visually locating the fitting. Refer to the owner's manual for proper fitting location.

Aeroquip® FT1307 Crimp Machine Maintenance and Repair Instructions



9. Elbow Fitting Position (w/Locator Kit)

The correct position adjustment for the elbow fitting locator is accomplished by loosening the hand knob, sliding the assembly into the correct position and tightening the hand knob. Refer to the owner's manual for correct fitting location.



10. Crimping Operation

Turn the machine on and depress the foot switch. The dies will automatically crimp the fitting to the preset dimension. Once the foot switch is released, after the full crimping stroke, the crimp dies will return. If the foot switch is released before the full crimp stroke is completed, the dies can be returned by pushing the jog return switch.



11. Checking the Crimp (Flat Crimp)

The crimp diameter must be checked after the first of each hose style and size is crimped. When checking factory style crimped fittings, use a micrometer or caliper and measure across the middle of each opposing set of flat formed on the socket.



12. Checking the Crimp (Field Crimp)

The crimp diameter must be checked after the first of each hose style and size is crimped. When checking field crimp fittings, use a micrometer or altered blade micrometer and measure within the center of opposing indentations on the socket.

Optional Tooling



Straight Fitting Location Kit

The optional straight fitting location kit contains 4 individual locators and a holder which install into the push block of the machine. This locator kit is used to locate all standard straight fittings.

Order by part number FT1209-130.



Elbow Fitting Location Kit

The optional elbow fitting location kit contains a yoke holder and yokes for all size elbow fittings.

Order by part number FT1209-150.

NOTE: The straight fitting locator kit is required when using the elbow fitting locator kit.

Internal Skive Die Cages

Basic Hose Style and Dash Size	Die Cage Part Number (Ored one only)
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(These hose styles require Aeroquip internal skive type fitting.)

FC254-08	FT1307-200-83
FC254-12, FC273-12,	FT1209-200-82
FC323-12	FT209-200-96
FC250A16, FC254-16,	FT209-200-14
FC273-16, FC323-16	FT209-200-15
FC250A20, FC254-20,	FT209-200-16
FC323-20	FT209-200-23
FC250A24, FC254-24,	FT209-200-18
FC273-20, FC323-24, FC:273-24	
FC250A32, FC254-32,	
FC273-32	



The FT1307-2-13 "drop-in" reusable die cage shown above allows use of individual FT1204 dies.

Crimp Die Cages



Aeroquip crimp die cages provide simple "drop-in" tooling for the FT1307 hose machines.

Refer to the charts in the end of this bulletin for correct die cage selection.

FT1307 Crimp Machine Die Cage Selection Chart

Note: These Die Cages also work with the FT1209 Crimp Machine.

Internal Skive Die Cages

Basic Hose Style and Dash Size	Die Cage Part Number (Order one only)
FC120-03	FT1307-200-64
FC120, FC172-04	FT1307-200-49
FC120-05	FT1307-200-57
FC120, FC172-06	FT1307-200-58
FC120, FC172-06	FT1307-200-50
FC120-10	FT1307-200-60
FC121-03	FT1307-200-63
FC121-04	FT1307-200-64
FC121-06	FT1307-200-65
FC121-06	FT1307-200-47
FC121-08	FT1307-200-48
FC121-10	FT1307-200-50
FC160, FC202-06	FT1307-200-68
FC160, FC202-08	FT1307-200-69
FC160, FC202-10	FT1307-200-70
FC160, FC202-12	FT1307-200-71
FC171-06	FT1307-200-42
FC171-08	FT1307-200-43
FC171-10	FT1307-200-44
FC370, FC371, FC372, FC373, FC374, FC375-03	FT1307-200-90
FC370, FC371, FC372, FC373, FC374, FC375-04	FT1307-200-91
FC370, FC371, FC372, FC373-06	FT1307-200-92
FC370, FC371, FC372, FC373, FC374, FC375-06	FT1307-200-93
FC370, FC371, FC372, FC373, FC374, FC375-08	FT1307-200-94
FC370, FC371, FC372, FC373, FC374, FC375-12	FT1307-200-95
FC372, FC374-16	FT1307-200-100
2681-3	FT1307-200-1
2681-4	FT1307-200-2
2681-6	FT1307-200-2
2681-6	FT1307-200-3
2681-8	FT1307-200-4
2681-10	FT1307-200-5
2681-12	FT1307-200-6
2681-16	FT1307-200-8
2681-20	FT1307-200-9
2681-24	FT1307-200-11
2681-32	FT1307-200-23or FT1209-200-17*
FC310, FC610-16**	FT1307-200-55
FC310-20**	FT1307-200-99

* Use FT1307 crimp die cage for one piece precrimped fitting and FT1209 crimp die cage for two piece fitting.

** Requires special dies in -16 and -20 sizes.

Internal Skive Die Cages

Basic Hose Style and Dash Size	Die Cage Part Number (Order one only)
2793-4	FT1307-200-52†
2793-6	FT1307-200-52†
2793-8	FT1307-200-53†
2793-12	FT1307-200-54†
2793-16	FT1307-200-61†
2793-20	FT1307-200-86†
2583-4	FT1307-200-89* or -52†
2583-6	FT1307-200-80* or -52†
2583-8	FT1307-200-87* or -53†
2583-12	FT1307-200-27* or -54†
2661-12	FT1307-200-27* or -54† or -6
2583-16	FT1307-200-28* or -51†
2661-16	FT1307-200-27* or -51† or -8
2583-20	FT1307-200-29* or -88†
2661-20	FT1307-200-30* or -88† or -9
2661-24	FT1307-200-31* or -11‡
2661-32	FT1307-200-32* or -23‡
2661-40	FT1209-200-18†
* Factory FC3023 socket. † Field barrel crimp style fitting. ‡ 1401 style socket	
2807, FC186-04	FT1307-200-39
2807, FC186-06	FT1307-200-40
2807, FC186-06	FT1307-200-41
2807, FC186-08	FT1307-200-26
2807, FC186-10, -12	FT1307-200-37
2807, FC186-16	FT1307-200-05

Selection, assembly installation and operation of Aeroquip products in accordance with Aeroquip recommendation are essential to assure optimum product service life. For detailed information consult current Aeroquip catalogs or contact Aeroquip directly.

About Danfoss Power Solutions FC

Danfoss hoses, fittings, and tooling provide the ultimate fluid conveyance solutions for a variety of equipment and applications around the world. We proudly engineer to support a sustainable future for tomorrow.

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