



Weatherhead®

Tool & Die Packages for Core Hydraulic Hose Products

Eaton is taking a new approach to helping you succeed by reducing the complexity of our hose and fitting products. This smarter range of key core products will make it easier for you to master our product portfolio, offer your business greater differentiation and reduce your overhead. But we're not stopping there. Eaton is introducing newly designed tooling sets by machine group that will cover over 80% of your core product crimping needs. This means less issues on your end; from nesting diameters, sticking collets, and other interface problems that we have engineered away. It's as easy as 1-2-3.

Once you've ordered the correct tooling package for your machine simply (refer to back of this sheet):

1. Select your core hose and fitting product combination. (making sure that application and regulatory requirements are met)
2. Based on the hose size, and the corresponding fitting selected, select the correct color coded collet. (using the chart at right)
3. Based on the crimp machine being used, refer to our core product tooling reference to determine if any spacer rings are required for your assembly.

FEATURES & BENEFITS

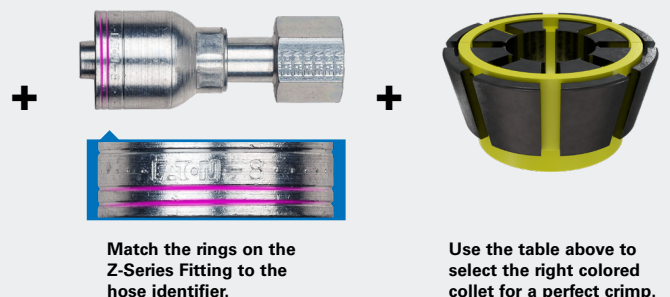
- Fitting locators are built into the collets
- Dies are designed for a specific fitting series
- Collet Cages are color coded by size
- Metal Collets are color coded by fitting series
- Part numbers and fitting series are **CLEARLY** labeled on the collet and spacer rings

Hose Dash Size	Collet Cage Color Code	Z Series Collet	4S Series Collet	6S Series Collet
		Black	Silver	Olive
-04	Red		N/A	N/A
-05	Purple		N/A	N/A
-06	Yellow			N/A
-08	Blue			N/A
-10	Orange			N/A
-12	Green			N/A
-16	Black			N/A
-20	White			
-24	Dark Red			
-32	Dark Green			



T-400 Crimp Example

Hose	H28006
Fitting	Z-Series
Die Collet Color	Black
Die Collet Cage Color	Yellow



Match the rings on the Z-Series Fitting to the hose identifier.

Use the table above to select the right colored collet for a perfect crimp.

Optimized Tooling Conversion Packages

These tooling packages are designed for converting existing crimpers. New crimper placement will require a different tooling package.

Tooling for Crimp Machines: T-400, T-460*, T-462*, T-465*



Package Part Number:

T400TP-1001

Crimps: H180 with Z series sizes -04, -06, -08
H280 with Z series sizes -04, -06, -08, -12, -16

Package Contains:

Part Number	Description	Part Number	Description
ET313DC-4Z	4Z Braided Collet	ET400AR-10	Bowl
ET313DC-6Z	6Z Braided Collet	ET313SR-090A	H180 4-8 Ring
ET313DC-8Z	8Z Braided Collet	ET400SR-280A	H280 12-16 Ring
ET400DC-12Z	12Z Braided Collet		
ET400DC-16Z	16Z Braided Collet		

T-400 machines older than 1980 will not crimp -12 and -16 size due to limited stroke

* Will not crimp -12 and -16 sizes

Tooling for Crimp Machines: ET1000



Package Part Number:

ET1000TP-1001

Crimps: H180/H280 with Z series sizes -04, -06, -08, 12, 16
H430 with 4S/6S sizes -08, 12, 16

Package Contains:

Part Number	Description	Part Number	Description
ET313DC-4Z	4Z Braided Collet	ET313SR-090A	H180 Ring 4,6,8
ET313DC-6Z	6Z Braided Collet	ET425SR-150A	H180 Ring 12,16
ET313DC-8Z	8Z Braided Collet	ET313DC-4S8	4S8 Spiral Collet
ET1000DC-12Z	12Z Braided Collet	ET1000DC-4S12	4S12 Spiral Collet
ET1000DC-16Z	16Z Braided Collet	ET1000DC-4S16	4S16 Spiral Collet

Tooling for Crimp Machines: T-420, T-480



Package Part Number:

T420TP-1001

Crimps: H180/H280 with Z series sizes -04, -06, -08, 12, 16
H430 with 4S/6S sizes -08, 12, 16, 20

Package Contains:

Part Number	Description	Part Number	Description
ET425DC-4Z	4Z Braided Collet	ET425SR-105A	H180 Ring
ET425DC-6Z	6Z Braided Collet	ET425DC-4S8	4S8 Spiral Collet
ET425DC-8Z	8Z Braided Collet	ET425DC-4S12	4S12 Spiral Collet
ET425DC-12Z	12Z Braided Collet	ET425DC-4S16	4S16 Spiral Collet
ET425DC-16Z	16Z Braided Collet	ET425DC-4S20	4S20 Spiral Collet
ET425AR-14	Bowl		

Tooling for Crimp Machines: ET4000, ET4001, T-410*, T-440*



Package Part Number:

ET4001TP-1001

Crimps: H180/H280 with Z series sizes -04, -06, -08, 12, 16
H430 with 4S/6S sizes -08, 12, 16, 20, 24, 32

Package Contains:

Part Number	Description	Part Number	Description
ET525DC-4Z	4Z Braided Collet	ET525DC-4S8	4S8 Spiral Collet
ET525DC-6Z	6Z Braided Collet	ET525DC-4S12	4S12 Spiral Collet
ET525DC-8Z	8Z Braided Collet	ET525DC-4S16	4S16 Spiral Collet
ET525DC-12Z	12Z Braided Collet	ET525DC-4S20	4S20 Spiral Collet
ET525DC-16Z	16Z Braided Collet	ET575DC-4S24	4S24 Spiral Collet
ET525SR-120A	H180 Ring	ET575DC-4S32	4S32 Spiral Collet
ET575SR-135A	H43032 Ring		

* These machines can not crimp 4S24, 4S32, 6S24, or 6S32 fittings



Reference tooling charts in **Eaton Weatherhead Core Hydraulic Hose Products Brochure** for additional capabilities.