

Procedure 2304: Installation of Brass Stems and Ferrules using 5111A and 1765A Tools

effective 02/08

Preparation

- 1. Prepare the hose using Procedure 1100: General Preparation Instructions.
- 2. For Information concerning selection of the proper ferrule and die, as well as setting-up 5111A/1765A Crimping Machines use Procedure 1103: Set-up 5111A/1765A Crimping Machine.

Notes

- 1. Dixon recommends the 5111A tool be mounted on a table leg, storage rack leg or wall at waist height for maximum leverage.
- 2. BFL and BFM style ferrules are for air or water service. BF, BFW, and BFMW style ferrules are for water service ONLY.

Procedure

- 1. Slide the ferrule over the hose.
- 2. Insert the coupling. Refer to step 9 of Procedure 1100: General Preparation Instructions.
- 3. *For 5111A tool:*
 - a. Lift the handle to open the dies.
 - b. Slide hose with stem and ferrule through dies to its proper position.
Use Procedure 1103: Set-up 5111A/1765A Crimping Machine.
 - c. Push down on the tool handle so that the dies fully close then open up.
Note: It is important for the tool to complete its 'cycle' of open-closed-open in one downward stroke of the handle to ensure proper crimping.
 - d. Remove the assembly from the tool.
- 4. *For 1765A tool:*
 - a. Insert the hose with the stem and ferrule through the dies until the stem contacts the stop.
 - b. Depress the foot pedal to crimp the ferrule.
 - c. Release the foot pedal.
 - d. Remove the assembly from the tool.
- 5. Test the assembly using Procedure 4000: General Hydrostatic Testing Information and 4001: Hydrostatic Testing.