

# Fail-safe Crimping Tools

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Division of S.H. Leggett Company

## Crimp Tool Adjustment Procedures

Crimp tool adjustment is critical for a proper crimp. The tool is factory adjusted to provide crimp, but should be checked before use by testing with caliper gauge (Fig. 2) provided with each new tool. If crimp does not gauge properly, adjust tool by use of following procedures.

1. Loosen set screw two (2) turns.
2. Close tool until jaws touch - see Fig. 1.
3. Turn adjustment screw until handles are approximately  $3/4 - 1$  inch apart - see Fig. 1.

OR

Turn set screw until handles measure  $8-1/2 - 9$  inches inside at bottom of handles - see Fig. 1 - open and close tool three (3) times, then reset handle opening to measure  $7-3/4 - 8-3/4$  inches.

4. Tighten set screw and make test crimp.
5. Gauge crimp with crimp caliper gauge - see Fig. 2 - if crimp fails crimp caliper gauge test, repeat adjusting procedure.

**NOTE: DO NOT GAUGE CRIMP AROUND SERRATED MARKS ON CRIMPED RING, THESE MAY BE LARGER OR SMALLER THEN DIAMETER OF CRIMPED RING.**

## Crimp Gauge Instructions

1. Slip GO side of gauge over band, it should slide over unscarred portion of ring with slight contact.
2. No-Go side of gauge should not slip over unscarred portion of ring.
3. If rings do not gauge properly, then repeat adjustment procedures.

NOTE: THIS TOOL REQUIRES PROPER LUBRICATION FOR MAXIMUM TOOL LIFE, LUBRICATE TOOL EVERY (50) to (75) CRIMPS WITH LIGHT TO MEDIUM OIL (MOTOR OIL OR MACHINE OIL WORKS WELL) THIS IS VERY IMPORTANT TO THE LIFE OF YOUR TOOL.

**WARNING: OVER ADJUSTING TOOL WILL CAUSE DAMAGE AND SHORTEN TOOL LIFE.**

