Hydraulic Hose Crimpers

PC100SH-RCD and PC100SP-RCD Quick Start Guide

Use your smartphone to scan the Continental QR Code to get full access to the operators manuals and training videos.

PC100SH-RCD Technical Data
SAP # 21063169
Crimping force: 35 Ton
Hydraulic hose capacity: -16 B2 and -08 SG fittings
Micrometer Style Adjustment: T420
Crimper size: L: 12-½" x W: 12-½" x H: 21-½"
Crimper weight: 48 lbs
Die series: PC125RCD
Power source: ValPower® Hand Pump 10,000 PSi

PC100SP-RCD Technical Data
SAP # 21063190
Crimping force: 35 Ton
Hydraulic hose capacity: -16 B2 and -08 SG fittings
Micrometer Style Adjustment: T420
Crimper size: L: 12-½" x W: 12-½" x H: 21-½"
Crimper weight: 48 lbs
Die series: PC125RCD
Power source: ValPower® Pneumatic Pump 10,000 PSi

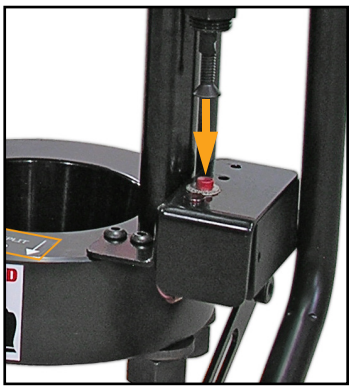
SAFETYPRECAUTIONS

- Read instructions and identify all component parts before using the crimper.
- Crimper can produce 35 tons of crimping force, keep both hands away from pinch points.
- Consult the Continental Hydraulic Crimp Specifications Manual or via our mobile app - C-IQ for correct crimper settings and crimp measurements.
- Always wear eye protection.

Initial Setup

Check Point #1

Check Point #2



Check Point #3

Check Point #4

#1. Crimper position can be adjusted for optimum crimping position. Loosen the knob on each side and adjust the cone base to desire position then tighten each knob.

#2. You can dropped to vertical position for better balance when the crimper is being carried.

#3. Push the red button to verify that the LED light turns on.

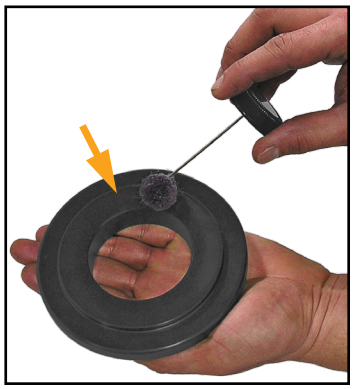
Note: If the LED Indicator Light becomes faint, replace the (2) AA batteries as needed.

#4. If the crimper is mounted on a workbench, the workbench should be able to support the crimper weight of 48 lbs and the components.

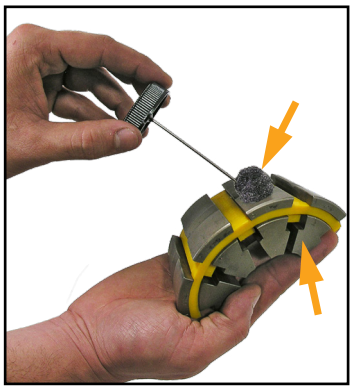
Note: The crimper should be mounted close enough to the edge of the work surface so that hose will not contact the bench or work surface while crimping. There must be enough clearance for the hose to align perpendicular with the cone base, or the dies will not seat properly and the crimps will not be accurate.

PC100SH-RCD / PC100SP-RCD Lubrication Procedure

Grease Point #1



Grease Point #2



Grease Point #3

#1. Apply a thin layer of CrimpX oil (supplied with the crimper), or a molybdenum disulfide high pressure grease on the surface of the cone base.

#2. Before sliding the pressure plate over the correct die set, apply a thin layer of CrimpX oil (supplied with crimper) or a molybdenum disulfide high pressure grease on the entire area that dies come in contact with.

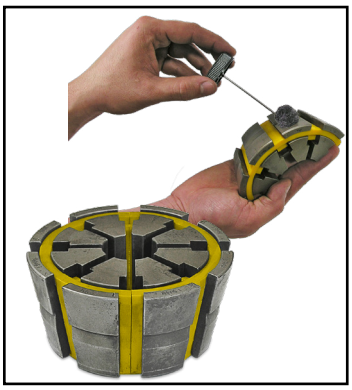
#3. **If the dies are sticking in the surface of the cone base:** Continue to lubricate / grease as explained above in addition to lubricating each die finger individually.

Note: Follow lubrication procedure prior to calibration check.
Lubrication is not required before each crimp, typical lubrication is after 100 crimp cycles.

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

PC100SH-RCD / PC100SP-RCD Crimping Procedure

Step #1



Step #2

Step #3

Step #4

Caution: Follow the lubrication procedure prior to crimping, failure to lubricate the die set and pressure plate, could result in the die seizing in the cone base.

#1. Make certain that the cone base is clean and lubricated prior to inserting the die set.

#2. Select the correct die set for the combination of hose and fitting being crimped. Lubricate the contact surfaces, both the top and the outside edges of the die fingers, with CrimpX oil (supplied with the crimper), or a molybdenum disulfide high pressure grease.

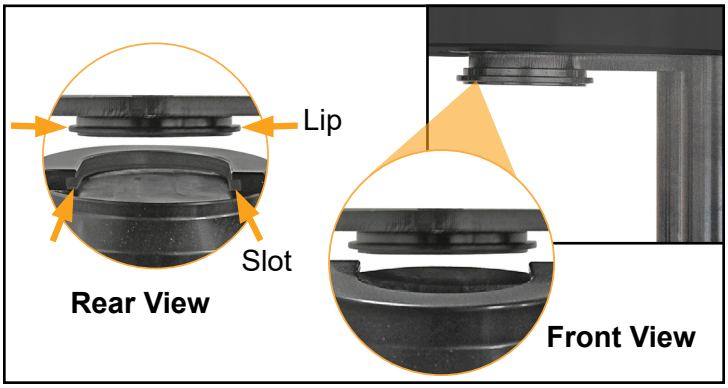
Note: The correct die set can be found in the Continental Hydraulic Crimp Specifications Manual or via our mobile app - C-IQ .

#3. Place the lubricated die set squarely in the cone base, and make sure the split of the die cages is facing the operator.

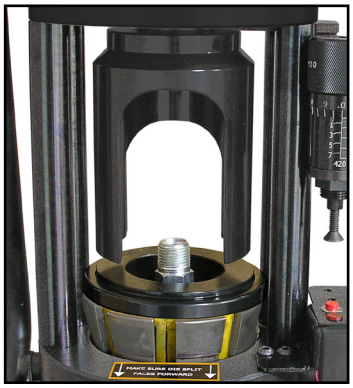
#4. Position the hose and fitting into the die set.

Note: Refer to the Continental Hydraulic Crimp Specifications Manual or via our mobile app - C-IQ for the proper hose assembly procedures.

Step #5



Step #6



Step #7

#5. Place the lubricated pressure plate over the die set.

Note: Compress the die set by hand to hold the hose and fitting in place.

#6. Slide the pusher onto the pusher retaining ring on the hydraulic cylinder.

Note: Make sure the slot in the pusher goes over the lip on the pusher retaining ring.

Caution: Damage to the pusher and retaining ring can occur if they are misaligned.

#7. Make sure the pusher is positioned correctly as shown.

PC100SH-RCD / PC100SP-RCD Crimping Procedure

Step #8

Step #9

Step #10

Step #11

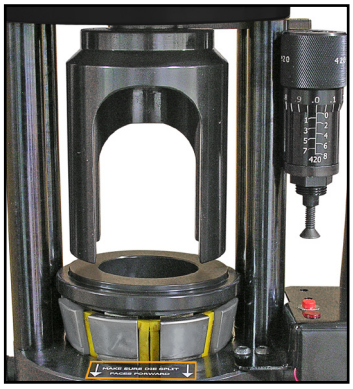
#8. Set the micrometer to the setting as shown in the most current Continental Hydraulic Crimp Specifications Manual or via our mobile app - C-IQ for the combination of hose and fitting being crimped.

#9. Actuate the (Hand or Pneumatic Pump), to bring the pusher in contact with the pressure plate until the hose and fitting are held in position with very light pressure. **Recheck the fitting for correct alignment.**

#10. Continue to apply pressure,until the ram is fully extended compressing the pressure plate onto the die set to crimp the fitting. As the micrometer moves down, it will touch the red button and the LED indicator light will turn on to indicate that the crimp is complete, **release pressure so the pusher will retract**.

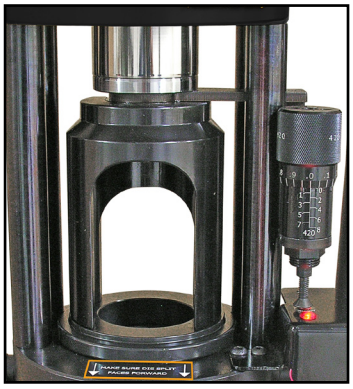
#11. Check the crimp diameter of the finished assembly with calipers or micrometers, to be certain that it is within the specifications as outlined in the Continental Hydraulic Crimp Specifications Manual or via our mobile app - C-IQ.

PC100SH-RCD / PC100SP-RCD Calibration Check



Step #1

Step #2



Step #3

Step #4

Note: All settings are approximate, for minor adjustment adjust the dial as needed.
Due to variations in hose and fitting tolerances, some “offset” may required to achieve the correct crimp diameter for specific hose and fitting combinations across the range of hose and fittings being crimped. If crimp diameters are consistently too large or consistently too small, the crimper should be recalibrated.

#1. Install any die set, the pressure plate, the pusher, and set the micrometer to “0”.

Note: A hose and fitting are not required for a calibration check.

#2. Actuate the (Hand or Pneumatic Pump), to bring the pusher in contact with the pressure plate.

#3. Continue to apply pressure, until the ram is fully extended and the die set is completely closed. At that point the micrometer should touch the red button, and the LED indicator light is turned on. If this happens the crimper is correctly calibrated. **Release pressure so the pusher will retract.**

#4. If the above conditions are not met, the crimper requires recalibration, hold the micrometer barrel with a 5/16 inch open end wrench and rotate the stem either in or out with a 5/32 inch hex key wrench.

Note: 1/4 inch turn of the screw will change crimp diameter approximately 0.008".

• Rotating the stem out of the barrel decreases the ram to retract.

• Recheck calibration.

FHS - Fluid Handling Solution

Market segment
Hydraulic Hose

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