

Hydraulic Hose Crimpers

PSW-100 and PSW-101 Conversion Kits

Operators Manual

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SAFETY PRECAUTIONS



- READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER.
- CRIMPER CAN PRODUCE EXTREME FORCE. KEEP BOTH HANDS AWAY FROM PINCH POINTS.
- CONSULT THE CONTINENTAL CONTITECH CRIMP SPECIFICATION MANUAL FOR CORRECT CRIMPER SETTINGS AND CRIMP MEASUREMENTS.
- ALWAYS WEAR EYE PROTECTION.

PSW-100 and PSW-101 Conversion Kits

Continental Products has developed two conversion kits which enable users of the Weatherhead T400 and T420 crimpers to easily convert these crimpers to accurately crimp Continental Products hose and fittings.

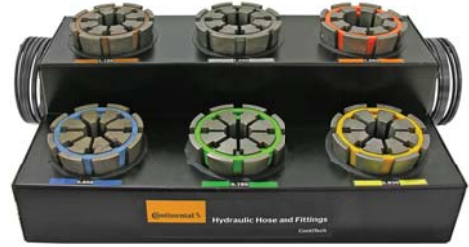
With the PSW-100 Conversion Kit, only the hydraulic power unit from the Weatherhead crimpers is utilized. A new crimp head, dies, spacers and die lubricant are furnished with the kit. The correct flex cage die and spacer can easily be determined from the crimp specification chart on page 8 of this manual.



The PSW-101 kit utilizes the both Weatherhead T420 crimp head and power unit. The spacer shoes on the bottom of the pusher must be replaced with spacer shoes furnished in the PSW-101 kit. With the new spacer shoes in place, it is simply a matter of determining the correct flex cage die and spacer from the chart on page 8, and the T420 crimper can be used the normal manner.

The PSW-100 Conversion Kit enables users of the Weatherhead T400 Crimpers to quickly and accurately crimp Continental Products Hose and fittings

The items shown should be included in the PSW-100 Conversion Kit



6 Flex Cage Die Sets
(Die Holder Stand available but not included in kit)



Crimp Head



11 Spacer Rings



Use the pump and reservoir unit from the existing Weatherhead T400 crimper. (Pump is not included with the kit.)



Pusher



Pusher Plate



1 Container of die lubricant

The PSW-100 Conversion Kit utilizes only the hydraulic unit from the Weatherhead T400 unit. The pump must be in good working order and capable of generating 4300 psi maximum.



Disconnect and discard the existing T400 head unit. It is recommended that the hose be replaced with a new 4300 psi working



Connect the T400 Power unit to the new Continental Products crimp head. Do not readjust the hydraulic unit to exceed 4300 psi.



Lubricate the cone base with the grease furnished with the kit.



Select the correct spacer ring and place it on top of the cone base. A zero indicates no holes, 1 indicates 1 hole etc.



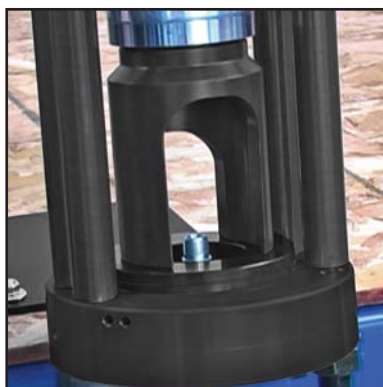
Select the correct flex cage die from the chart and insert it in the cone base.



Install the pusher on the stud on the bottom of the hydraulic ram



Install the pusher plate on top of the die set. Note the "This Side Up" notation.



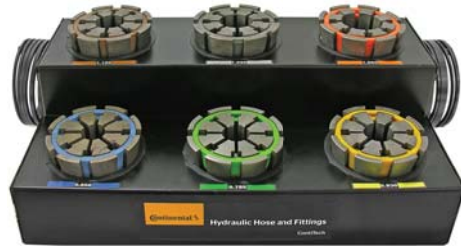
Actuate the hydraulic pump and allow the pusher to fully contact the spacer ring.



Release the hydraulic pressure and withdraw the hose. Always measure the completed fitting.

The PSW-101 Conversion Kit enables users of the Weatherhead T420 Crimpers to quickly and accurately crimp Continental Products Hose and fittings.

With only minor modifications to the existing T420 Crimper, Continental Products hose and fittings can be quickly and accurately crimped with the flex cage dies and spacer rings furnished with the PSW-101 Conversion Kit.



6 Flex Cage Die Sets
(Die Holder Stand available but not included in kit)



Use the existing Weatherhead T420 Crimper
(The crimper is not part of the conversion kit)



11 Spacer Rings



Replacement Spacer Shoes



1 Container of die lubricant

The PSW-101 Conversion Kit enables users to accurately crimp Continental Products hose and fittings in their existing Weatherhead T420 crimper with only minor modifications.



The T420 crimper must be in good working condition and the pump capable of generating 4300 psi maximum pressure.



Remove the existing spacer shoes if present. If there are no spacer shoes, the pusher should already be drilled and tapped to accept them.



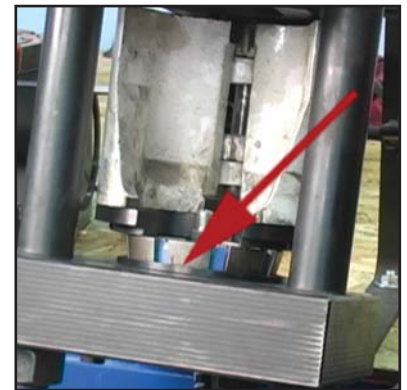
Replace the existing spacer shoes with the spacer shoes furnished with the PSW-101 Conversion Kit.



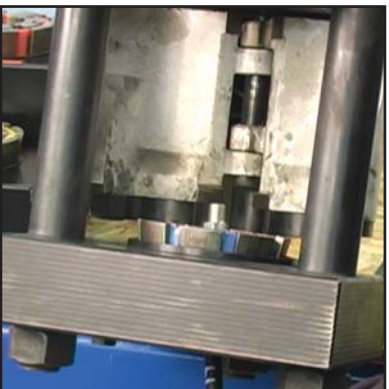
The replacement shoes are clearly marked for left and right and top and bottom.



Select the correct spacer ring from the chart. A "0" indicates no holes, a "1" one hole etc.



Install the correct flex cage die and spacer ring in the cone base.



Position the hose and fitting in the die set.



Operate the T420 crimper in the normal manner.



Release the hydraulic pressure and withdraw the hose. Always measure the completed fitting.



ContiTech

PSW-100,PSW-101 & PC125PS Crimp

Hose Part #	Hose I.D. (INCH)	Fitting Family	Insertion Length (INCH)	Crimp Length (INCH, tol ± 1/32")	Crimp Diameter (tol. ± 0.005" or ±0.127mm)		Die Set		# of Holes in Spacer
					INCH	MM	INCH	MM	
SR1SN-04	1/4	B2-***-04**	.875	Full	0.665	16.90	0.650	16.51	1
SR1SN-6	3/8	B2-***-06**	.906	Full	0.811	20.60	0.785	19.40	2
SR1SN-08	1/2	B2-***-08**	1.096	Full	0.933	23.70	0.930	23.62	No Spacer
SR1SN-10	5/8	B2-***-10**	1.250	Full	1.122	28.50	1.120	28.45	No Spacer
SR1SN-12	3/4	B2-***-12**	1.305	Full	1.272	32.30	1.260	32.00	0
SR1SN-16	1	B2-***-16**	1.535	Full	1.701	43.20	1.680	42.67	0
SR2SN-04	1/4	B2-***-04**	.875	Full	0.697	17.70	0.650	16.51	4
SR2SN-06	3/8	B2-***-06**	.906	Full	0.846	21.50	0.785	19.40	5
SR2SN-08	1/2	B2-***-08**	1.096	Full	0.969	24.60	0.930	23.62	3
SR2SN-10	5/8	B2-***-10**	1.250	Full	1.138	28.90	1.120	28.45	0
SR2SN-12	3/4	B2-***-12**	1.305	Full	1.307	33.20	1.260	32.00	3
SR2SN-16	1	B2-***-16**	1.535	Full	1.736	44.10	1.680	42.67	3
SR16SC/XR16SC/A RC16SC-04	1/4	B2-***-04**	.875	Full	0.677	17.20	0.650	16.51	2
SR16SC/XR16SC/A RC16SC-06	3/8	B2-***-06**	.906	Full	0.811	20.60	0.785	19.40	2
SR16SC/XR16SC/A RC16SC-08	1/2	B2-***-08**	1.096	Full	0.945	24.00	0.930	23.62	0
SR16SC/XR16SC/A RC16SC-10	5/8	B2-***-10**	1.250	Full	1.122	28.50	1.120	28.45	No Spacer
SR16SC/XR16SC/A RC16SC-12	3/4	B2-***-12**	1.305	Full	1.272	32.30	1.260	32.00	0
SR16SC/XR16SC/A RC16SC-16	1	B2-***-16**	1.535	Full	1.705	43.30	1.680	42.67	0
LR16SC-04	1/4	B2-***-04**	.875	Full	0.677	17.20	0.650	16.51	2
LR16SC-06	3/8	B2-***-06**	.906	Full	0.811	20.60	0.785	19.40	2
LR16SC-08	1/2	B2-***-08**	1.096	Full	0.945	24.00	0.930	23.62	0
DR16SC-04	1/4	B2-***-04**	.875	Full	0.677	17.20	0.650	16.51	2
DR16SC-06	3/8	B2-***-06**	.906	Full	0.811	20.60	0.785	19.40	2
DR16SC-08	1/2	B2-***-08**	1.096	Full	0.945	24.00	0.930	23.62	0
DR16SC-10	5/8	B2-***-10**	1.250	Full	1.150	29.20	1.120	28.45	2
DR16SC-12	3/4	B2-***-12**	1.305	Full	1.272	32.30	1.260	32.00	0
DR16SC-16	1	B2-***-16**	1.535	Full	1.705	43.30	1.680	42.67	0
SCP3/XCP3-04	1/4	B2-***-04**	.875	Full	0.650	16.51	0.650	16.51	No Spacer
SCP3/XCP3-06	3/8	B2-***-06**	.906	Full	0.783	19.94	0.785	19.40	No Spacer
SCP3/XCP3-08	1/2	B2-***-08**	1.096	Full	0.933	23.70	0.930	23.62	No Spacer
SCP3/XCP3-10	5/8	B2-***-10**	1.250	Full	1.122	28.50	1.120	28.45	No Spacer
SCP3/XCP3-12	3/4	B2-***-12**	1.305	Full	1.272	32.30	1.260	32.00	0
SCP3/XCP3-16	1	B2-***-16**	1.535	Full	1.701	43.20	1.680	42.67	0
XCP4, ACP4	1/4	B2-***-04**	.875	Full	0.677	17.20	0.650	16.51	2
XCP4, ACP4	3/8	B2-***-06**	.906	Full	0.811	20.60	0.785	19.40	2
XCP4, ACP4	1/2	B2-***-08**	1.096	Full	0.945	24.00	0.930	23.62	0
XCP4, ACP4	5/8	B2-***-10**	1.250	Full	1.122	28.50	1.120	28.45	No Spacer
XCP4, ACP4	3/4	B2-***-12**	1.305	Full	1.299	33.00	1.260	32.00	3
FPII-04	1/4	B2-***-04**	.875	Full	0.665	16.900	0.650	16.51	1
FPII-06	3/8	B2-***-06**	.906	Full	0.799	20.30	0.785	19.40	1
FPII-08	1/2	B2-***-08**	1.096	Full	0.929	23.60	0.930	23.62	No Spacer
FPII-10	5/8	B2-***-10**	1.250	Full	1.118	28.40	1.120	28.45	No Spacer
FPII-12	3/4	B2-***-12**	1.305	Full	1.272	32.30	1.260	32.00	0
FPII-16	1	B2-***-16**	1.535	Full	1.689	42.90	1.610	40.89	6

PSW-100,PSW-101 & PC125PS Crimp

SR12/ARC12-06	3/8	SG-***-06**	.926	Full	1.047	26.60	0.930	23.62	10
SR12-08	1/2	S4-***-08**	1.140	Full	1.118	28.40	1.120	28.45	No Spacer
SR12/ARC12-08	1/2	SG-***-08**	1.140	Full	1.150	29.20	1.120	28.45	11
SR12-10	5/8	S4-***-10**	1.226	Full	1.276	32.40	1.260	32.00	0
SR12	5/8	SG-***-10**	1.226	Full	1.323	33.60	1.260	32.00	4
SR12/ARC12	3/4	SG-***-12**	1.563	Full	1.425	36.20	1.410	35.81	9
SR12-16	1	S4-***-16**	1.605	Full	1.728	43.9	1.680	42.67	8

XCP4S	3/8	SG-***-06**	.926	Full	1.047	26.6	0.930	23.62	10
XCP4S	1/2	SG-***-08**	1.140	Full	1.150	29.20	1.120	28.45	11
XCP4S	5/8	SG-***-10**	1.226	Full	1.323	33.6	1.260	32.00	4
XCP4S	3/4	SG-***-12**	1.563	Full	1.425	36.20	1.410	35.81	9

HR4-12 *OD: 1.093-1.123	3/4	UCF6-12	1.240	Full	1.270	32.30	1.260	32.00	1
HR4-12 *OD: 1.123-1.152	3/4	UCF6-12	1.240	Full	1.290	32.80	1.260	32.00	3
HR4-12 *OD: 1.152-1.182	3/4	UCF6-12	1.240	Full	1.310	33.30	1.260	32.00	5
HR4-16 *OD: 1.406-1.437	1	UCF6-16	1.464	Full	1.630	41.40	1.610	40.89	0
HR4-16 *OD: 1.437-1.469	1	UCF6-16	1.464	Full	1.655	42.00	1.610	40.89	3
HR4-16 *OD: 1.469-1.500	1	UCF6-16	1.464	Full	1.675	42.50	1.610	40.89	5

* Measure hose OD before crimping. Match OD with range in crimp chart to select correct crimp OD.

Note: All fittings are non-skive