

## Procedure 2400: King Crimp™ with Sleeves

effective 06/16

### Selection

- 1. Measure the OD (Outside Diameter) of each end of the hose with a Dixon® diameter tape.  
*Tip: Mark hose OD on the hose after measuring to avoid mistakes on crimp dimensions/sleeve selection.*
- 2. From the current Dixon® Product List (DPL), select the correct sleeve for the hose OD just measured.

### Preparation

- 1. Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

### Notes

- 1. Each end of the hose to be assembled must be measured accurately.
- 2. Crimp diameters can be located in the current DPL, on the sleeve or by calling Dixon® at 877-963-4966.
- 3. Hold the finished crimp diameter for 3 to 5 seconds. This allows the metal to retain its new diameter.
- 4. Finished crimp diameter must be measured for each fitting. Tolerance is  $\pm 0.010$ " from published crimp diameter.
- 5. If the finished crimp diameter is larger than tolerance, re-crimp. If the crimp diameter is smaller than tolerance, consult Dixon®.
- 6. Consult Dixon® for coupling working pressures and for working pressures above **70°F (21°C)**.  
*Tip: Use the crimp die closest to crimp diameter without going over for the best results (ex. crimp diameter 31mm, use 30mm die).*

### Process

- 1. Slide the sleeve over the hose.
- 2. Insert the fitting into locking groove shoulder of the couplers and adapters. For King™ Combination nipples, insert to flat before the locking groove. Do not over insert.
- 3. Set the crimp diameter on the crimper.
- 4. Bring the hose with fitting and sleeve through the back of the crimper so that it is facing the operator.
- 5. Slowly jog dies closed. Make sure the dies clear the coupler head, adapter hose stop or King™ Combination nipple body.
- 6. Position the sleeve even with the dies.
- 7. Slowly close the dies until they just contact the sleeve. Make positioning adjustments if necessary.
- 8. Push the coupler head or adapter hose stop against the dies. For King™ Combination nipples, line up the back edge of the locking groove (the edge closest to body) with the end of the sleeve. Make sure the fitting clears the dies.
- 9. Close the dies until the machine has reached the set crimp diameter and hold for 3 to 5 seconds.
- 10. Open the dies, pull the assembly forward and measure the crimp diameter.

*Tip: Crimp all hose ends having the same OD to speed up the crimping process by not having to continually change crimper specifications.*