

# PIRANHA FLEX<sup>TM</sup>

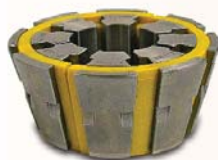
HYDRAULICS

## P400



## P400 Portable Hose Crimper/PF402 Kit

### Quick Start Guide





## **SAFETY PRECAUTIONS**



**READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER.**

**P400 CRIMPER CAN PRODUCE 35 TONS OF FORCE.**

**KEEP HANDS AWAY FROM PINCH POINTS.**

**CONSULT HOSE AND FITTING MANUFACTURER'S SPECIFICATIONS FOR CORRECT MACHINE SETTINGS AND CRIMP MEASUREMENTS.**

**ALWAYS WEAR EYE PROTECTION WHEN USING CRIMPER.**

**USE ONLY MANUFACTURER'S RECOMMENDED PARTS.**

## **MAINTENANCE:**

Periodic inspection, cleaning and lubrication of all moving parts is necessary for proper operation of the crimper.

# COMPONENT PART IDENTIFICATION



Adapter Die Bowl  
Used only in P400 Crimper



PF402 Die Set Series



Pusher Plate w/  
Nose up or Nose Down



T400 Spacer # 1



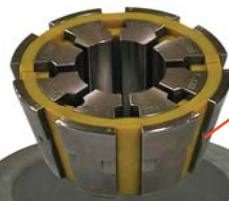
T400 Spacer # 2



Pusher Plate With  
Nose Down



Spacer



PF402 Die Set



Adapter Die Bowl

Example Set Up. (Refer to Piranhaflex Tool Selector Chart for more information).

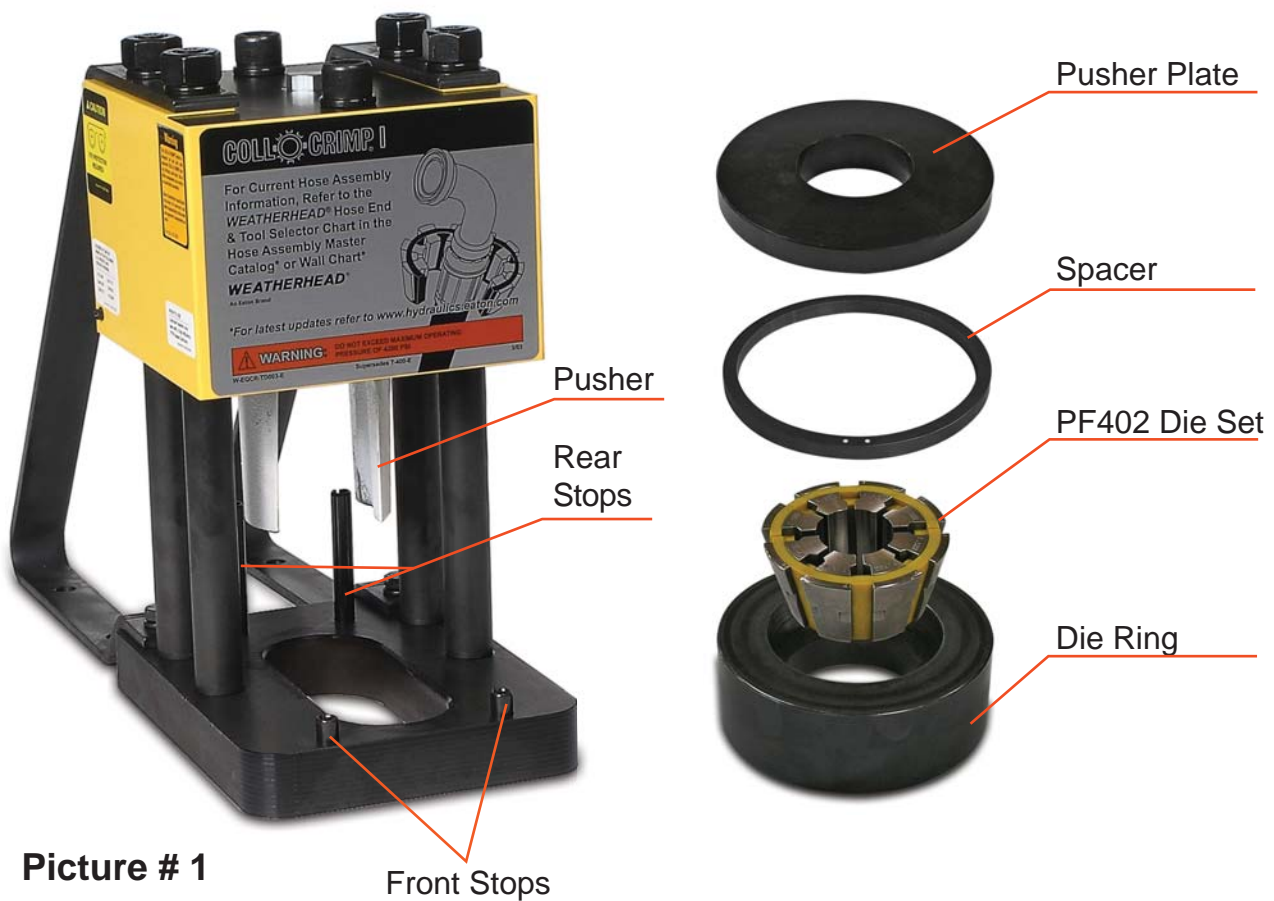
# PF402 DIE INSTRUCTIONS FOR USE IN A WEATHERHEAD T-400

- Inspect Weatherhead T-400 crimper and ensure it is functioning to the manufacturer's specifications.
- **WARNING:** Adhere and follow all Warning & Safety instructions from the Manufacture and beware of pinch points.

Refer to picture # 1 & # 2 for all Instructions.

- To start: Begin by sliding the Die Ring to the Front Stops.

**Note:** Make sure to lubricate the inner Die Ring, and PF402 Die Set with grease supplied with crimper.



Picture # 1

Front Stops

- Remove the Space Ring and Caged Collet halves.

- Refer to the **Piranhaflex Tool Selector Chart** to choose the correct Die Size, Spacer along with the Main Pusher Plate for the correct size Piranhaflex hose you are going to crimp.

## **Piranhaflex Tool Selector Chart**

### **PF354 / PF354 / PF354NC / PFP354 / PFP354NC / PF367 / PF367NC / PF267 / PF267NC / PFAN388NC / PFLT364 - 2 PIECE**

	PFR-03	PFR-04	PFR-05	PFR-06	PFR-08
Crimp Spec	12.07	14.22	15.75	17.78	22.23
Die Size	<b>12</b>	<b>14.2</b>	<b>14.2</b>	<b>17.4</b>	<b>22.2</b>
Die Color	Purple	Yellow	Yellow	Orange	Blue
Spacer	None	None	#2	#1	None
Pusher Plate	Nose Up	Nose Up	Nose Down	Nose Down	Nose Up

### **PF628 / PF628NC - 2 PIECE**

	PFR-03	PFR-04	PFR-06	PFR-08
Crimp Spec	12.01	13.84	17.4	22.48
Die Size	<b>12</b>	<b>12</b>	<b>17.4</b>	<b>22.2</b>
Die Color	Purple	Purple	Orange	Blue
Spacer	None	#2	None	#1
Pusher Plate	Nose Up	Nose Down	Nose Up	Nose Down

### **PF427 / PF427NC - 2 PIECE**

	PFR-04	PFR-06	PFR-08
Crimp Spec	14.22	17.78	22.48
Die Size	<b>14.2</b>	<b>17.4</b>	<b>22.2</b>
Die Color	Yellow	Orange	Blue
Spacer	None	#1	#1
Pusher Plate	Nose Up	Nose Down	Nose Down

- Insert the Die halves into the Die Ring.
- Select the correct Spacer, in accordance with the Piranhaflex Tool Selector Chart.
- Then place the Pusher Plate on top of the Die halves.  
**Note:** Orient the Pusher Plate (Nose Up or Nose Down) in accordance with the Piranhaflex Tool Selector Chart.
- Install the Pusher.
- Slide the Die Ring (with Die halves, Spacer & Pusher Plate properly installed) fully to the Rear Stops to assure all tooling is in proper alignment.
- (Adhering to Warning & Safety Instructions) Cycle the machine to assure tooling is properly aligned. Follow all Manufactures crimping instructions and crimp Piranhaflex hose & fitting. Assure the finish crimp dimensions are within tolerance.

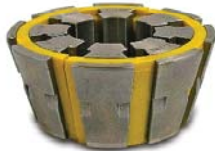


Picture # 2



# P400 Portable Hose Crimper

**NOTE:** When using PF402 Die Series insert the Adapter Die Bowl.



PF402 Die Series



Adapter Die Bowl

**NOTE:** When using T420 Die Series remove the Adapter Die Bowl.



T420 Die Series



# KuriKrimp™ Tool Selection Guide

## Glossary of Terms:

Skive — Removal of the hose cover by way of knife hand tool, brush wheel or other method, exposing the uppermost layer of reinforcement prior to crimping.

Skive Length — Area to be skived prior to crimping.

Crimp Diameter — The measured outside diameter of the ferrule or shell - measuring the **FLAT SURFACES** of the crimped ferrule or shell. Acceptable range of tolerance for Alfagomma and Pirahnaflex is **+/- .005 inches**.



Crimping specifications for this unit and these instructions were developed using ALFAGOMMA® hydraulic hose and couplings. Kuriyama of America and ALFAGOMMA® recommend using only the hose and coupling combinations specified in the current Kuriyama of America ALFAGOMMA® catalog and the crimp specifications for these KuriKrimp™ units. Be sure to read and follow the instructions in the KuriKrimp™ Operations Guide, the instructions beneath the

word "Important" below, and the specifications in the KuriKrimp™ Tool Selection Guide which appear on the following pages. Failure to act consistent with any of the above can result in serious bodily injury or damage.

## Important!

The Micro Crimp adjuster setting values shown on this chart are APPROXIMATE SETTINGS only and should be used only as a starting point. Due to differences in calibration and metal surface machining tolerances, the Micro Crimp setting may require adjustment. It is highly recommended that the finished crimp diameter of each assembly made be measured with calipers to determine if adjustment is necessary. To determine actual setting, measure the crimp diameter of the crimped assembly end. To tighten the crimp diameter, adjust the setting to a higher value. To increase (enlarge) the finished crimp diameter, adjust the setting to a lower value.

The column labeled "Actual" adjacent to the "Approx" column in the tables has been provided to give the user a place to record his own ideal Micro Crimp setting.



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Disclaimer: Always check your crimp results. Kuriyama of America, Inc. is not responsible for failure of the power unit. Always check the power unit is putting out the proper pressure recommended by the crimper manufacturer. Extension cords could also cause low voltage affecting the hydraulic pump performance.