

Improper Die Warning

Improper die set may have the effect similar to the picture show. The die set protrudes outward, and the rear part of the master die is off the cone track. You can observe this phenomenon quite easy when crimping if this happen. Please check these pictures carefully, when you encounter the same phenomenon, please stop crimping immediately. You need a proper die for your fitting.

This machine require a balanced crimping, if there is any phenomena similar to the pictures showing, then you need to stop crimping immediately and change a die set or contact us for a proper die set you require.

Possible cause

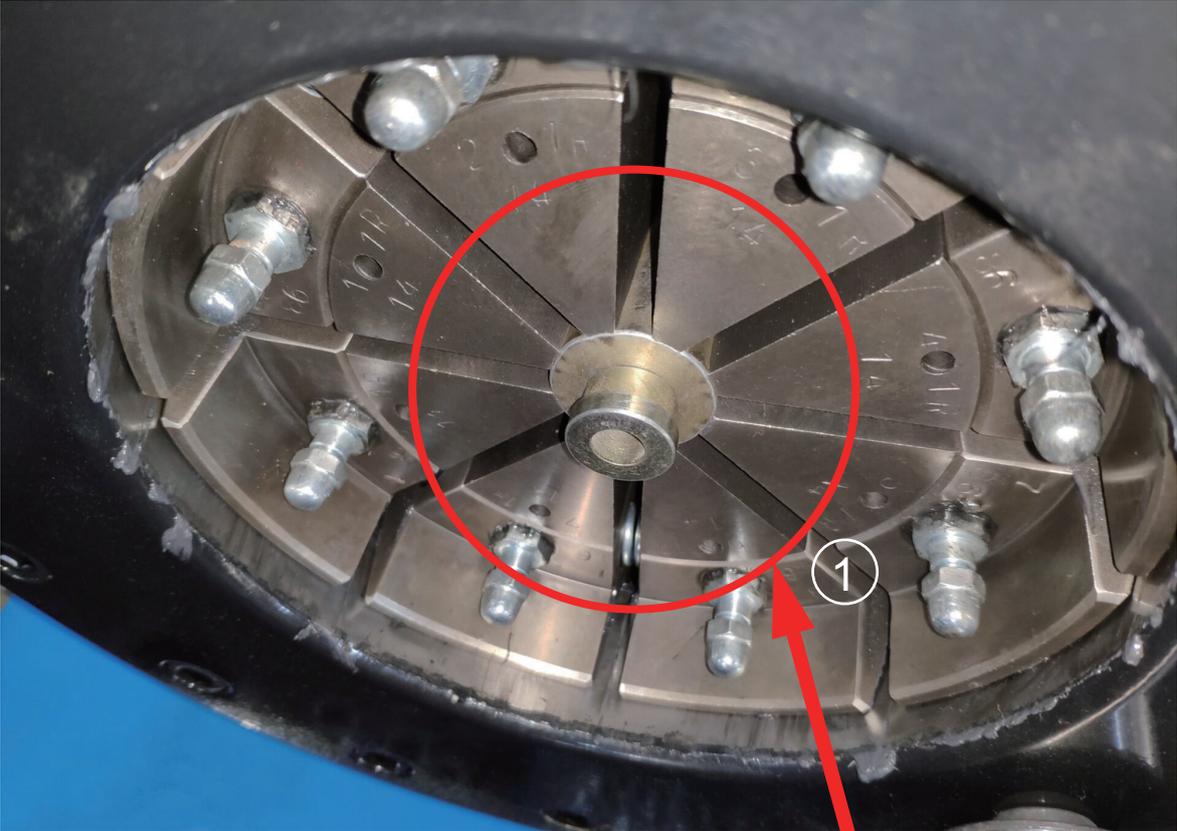
1: The die diameter is not correct, you choose a smaller die (if the difference between the die diameter and coupler diameter usually shall be less than 10mm), if exceeding 10mm before crimping, you shall check the die sets and change the one closest.

2: The die set is too long compared to the length of the ferule need to be crimped, this makes the crimping part too front to be able to crimp evenly or balanced, this will cause the problems shown in the picture, normally more often caused by **one piece fitting**, as one piece fitting is very short compared to the normal fittings. Our standard die set is designed to crimp the most fittings, thus it is usual longer. But when you encounter these phenomena, please stop crimping and request proper die sets from us.

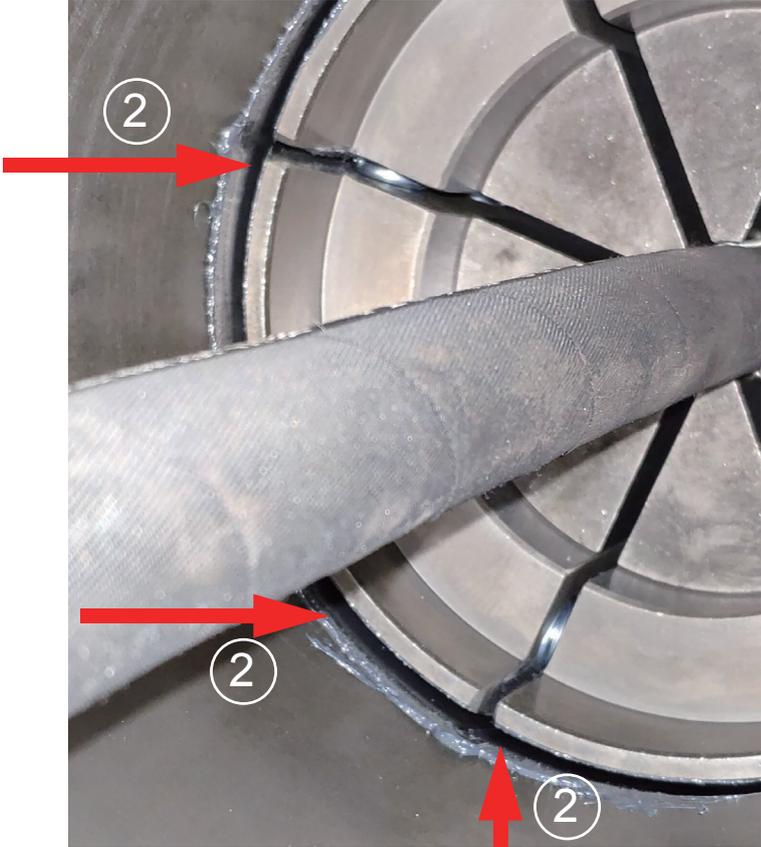
Please stop crimping when you encounter these phenomena, if you proceed you will have serious consequences like but not limited to: break the jaw of the master die and also damage the front and back cone surface, which will eventually make the machine useless.

Improper Die Phenomena

Stop Crimping If You Encouter these Phenomena !



1 The die set protrudes outward



2 The rear part of the master die is off the cone track