

## Procedure 2304: Installation of Brass Stems and Ferrules using 5111A and 1765A Tools

*effective 02/08*

### **Preparation**

- 1. Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. For Information concerning selection of the proper ferrule and die, as well as setting up 5111A/1765A Crimping Machines using Procedure 1103: Set-up 5111A /1765A Crimping Machine (page 14).

### **Notes**

- 1. Dixon® recommends the 5111A tool be mounted on a table leg, storage rack leg or wall at waist height for maximum leverage.
- 2. BFL and BFM style ferrules are for air or water service. BF, BFW, and BFMW style ferrules are for water service ONLY.

### **Procedure**

- 1. Slide the ferrule over the hose.
- 2. Insert the coupling. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
- 3. *For the 5111A tool:*
  - a. Lift the handle to open the dies.
  - b. Slide the hose with the stem and ferrule through dies to its proper position.  
Use Procedure 1103: Set-up 5111A /1765A Crimping Machine (page 14).
  - c. Push down on the tool handle so that the dies fully close then open up.  
*Note:* It is important for the tool to complete its 'cycle' of open-closed-open in one downward stroke of the handle to ensure proper crimping.
  - d. Remove the assembly from the tool.
- 4. *For the 1765A tool:*
  - a. Insert the hose with the stem and ferrule through the dies until the stem contacts the stop.
  - b. Depress the foot pedal to crimp the ferrule.
  - c. Release the foot pedal.
  - d. Remove the assembly from the tool.
- 5. Test the assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).