



D165-BCT-T420

B C T Controller
Basic Crimp Technology

Quick Start



SAFETY PRECAUTIONS



READ INSTRUCTIONS AND IDENTIFY ALL COMPONENT PARTS BEFORE USING CRIMPER

CRIMPER CAN PRODUCE 60 TONS OF FORCE. KEEP BOTH HANDS AWAY FROM PINCH POINTS

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

ALWAYS WEAR EYE PROTECTION

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Taking a quick glance at the navigations buttons

Press  to go back to the Main Menu.

Press  to go back to the previous screen.

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Quick Start

HOW TO SELECT A CRIMP

- From the **NRP Jones** screen, press the **START** button.

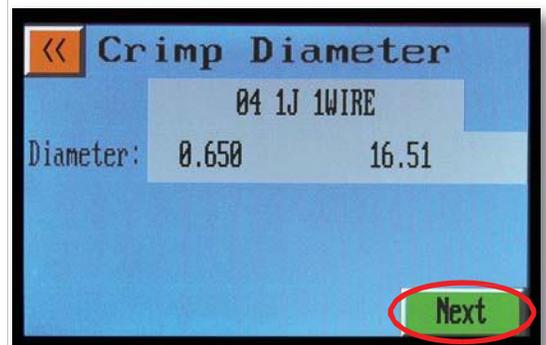
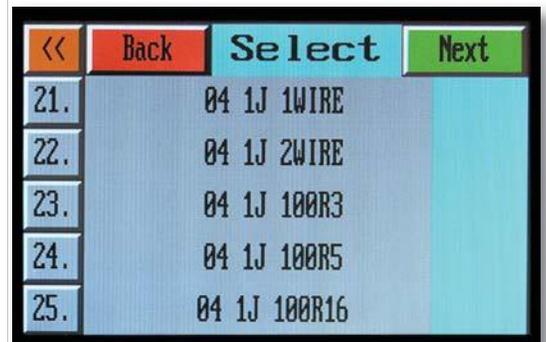
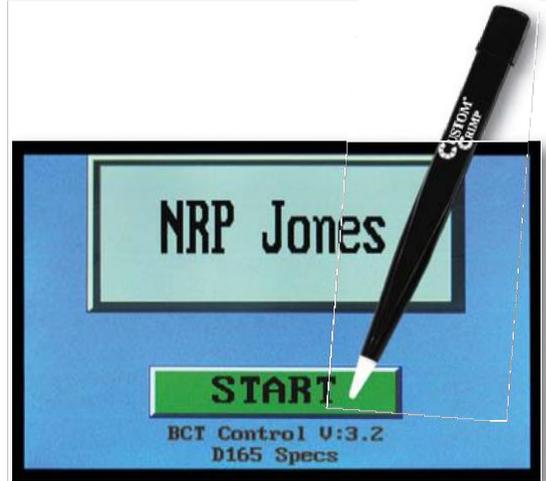
- It will bring up the **Select Crimp** screen, choose your Hose Size.

Note: For this example we are going to choose 1/4"

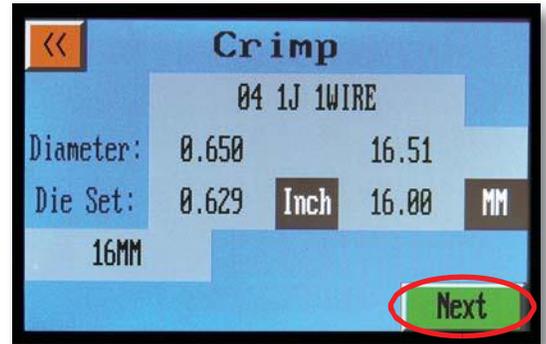
- After you have chosen your Hose Size, it will bring up the **Select** screen, choose your Hose and Fittings series.

Note: For this example we are going to choose 04 1J 1WIRE

- Then, it will bring up the **Crimp Diameter** screen, where shows the recommended Crimp Diameter and then press the **Next** button.



- It will bring up the **Crimp** screen, the controller will automatically select the correct Die Set.



- Insert the correct Die Set.
- Insert the Compression Cone and attach the Pusher (As shown on photo 1), and then press the **Next** button from the **Crimp** screen.



Photo 1

- It will bring up the **Crimp Mode** screen, confirm that the Die and finished Crimp Diameters are correct.
- Make a crimp, press and hold the green **CLOSE** button until the crimper stops closing.



- Measure the final crimp diameter (As shown on photo 2).

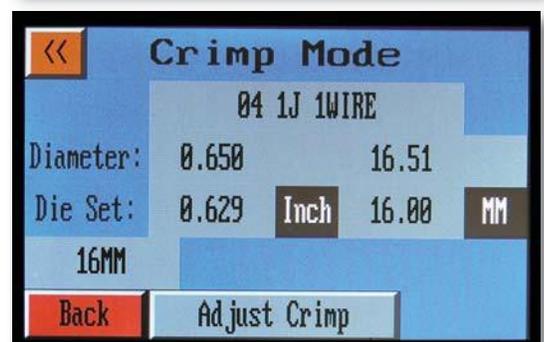
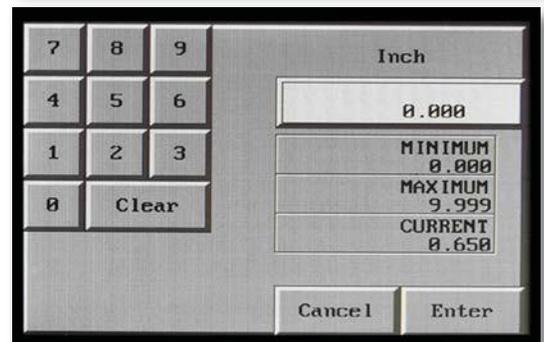
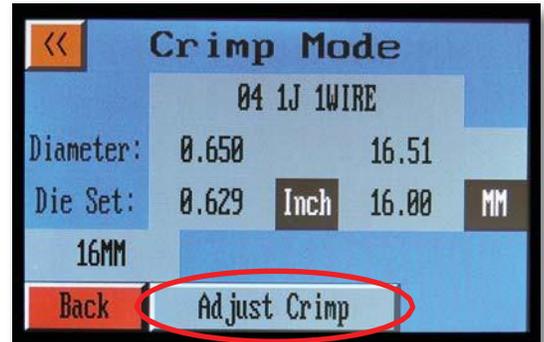


Photo 2

Note: If the finished crimp diameter is not within the required specifications press the **Adjust Crimp** button.

- It will bring up the **Adjust Crimp** screen, press the **Diameter** button.
- A keypad will pop up, and then enter **what your measured crimp diameter was**, (Do not enter the amount of correction) and press **Enter**.
- It will bring up the **Adjust Crimp** screen, and press the **Store** button.
- It will bring up the **Crimp Mode** screen.
- Make another crimp, press and hold the green **CLOSE** button until the crimper stops closing.

Note: Measure the final crimp diameter to be certain that it is within the required specifications.



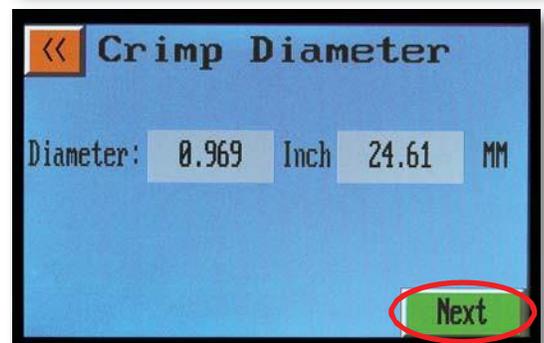
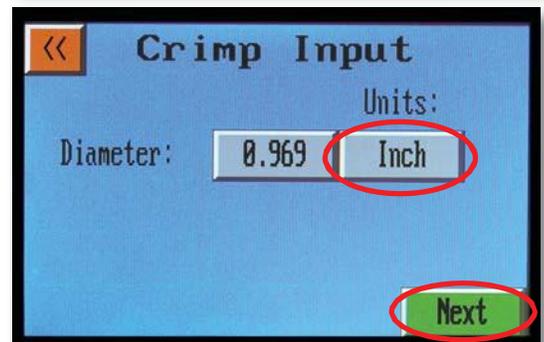
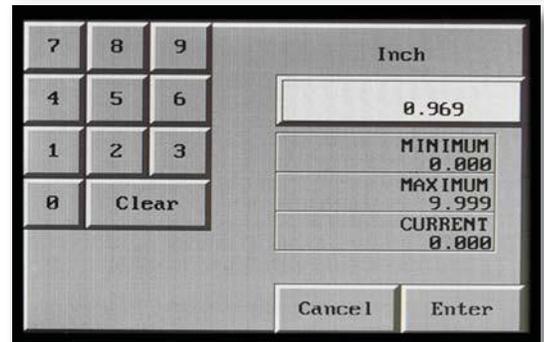
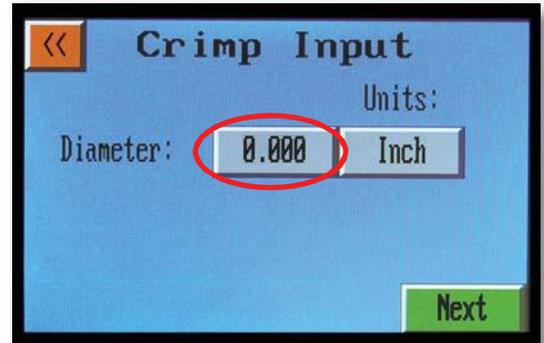
HOW TO MAKE A CUSTOM SIZE CRIMP

- From the **Main Menu** screen, press the **Custom Size** button.
- It will bring up the **Crimp Input** screen, and press the **Diameter** button.

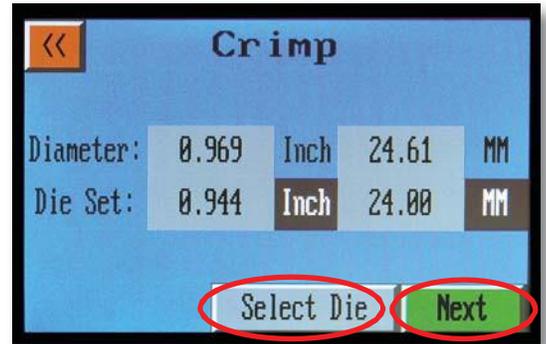
- A keypad will pop up, enter your diameter and press **Enter**.

Note: For this example we are going to enter (0.969 in) for Diameter.

- After you have entered your Diameter and pressed **Enter**, it will bring up the **Crimp Input** screen.
- Press the **Units** button, to change the units in either inches or mm and press the **Next** button.
- It will bring up the **Crimp Diameter** screen, where shows the Diameter and the conversion in either inches or mm, and press the **Next** button.



- It will bring up the **Crimp** screen, the controller will automatically select the correct Die Set.



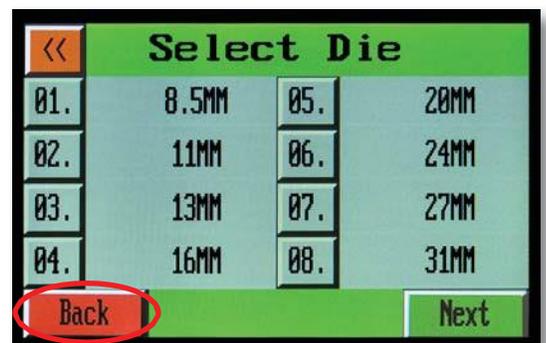
- Insert the correct Die Set.
- Insert the Compression Cone and attach the Pusher (As shown on photo 3), and then press the **Next** button from the **Crimp** screen.



Photo 3

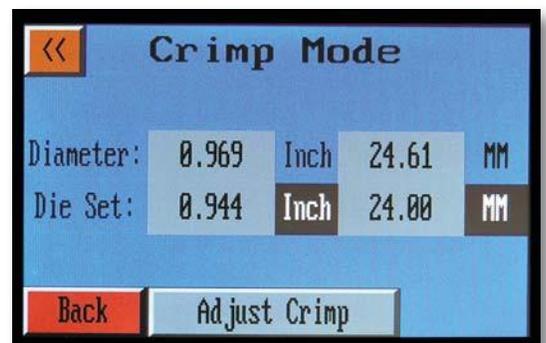
Note: If you need to select a die press the **Select Die** button from the **Crimp** screen.

- It will bring up the **Select Die** screen, where you can select a die from the ones that are already pre-loaded in the memory.



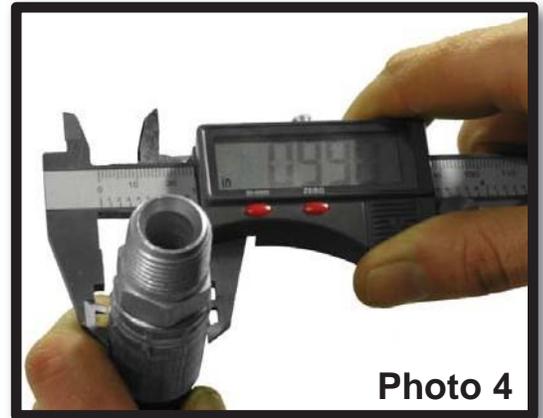
Note: If you don't need to select a die, press the **Back** button to return to the **Crimp** screen, and press the **Next** button.

- It will bring up the **Crimp Mode** screen, confirm that the Die and finished Crimp Diameters are correct.

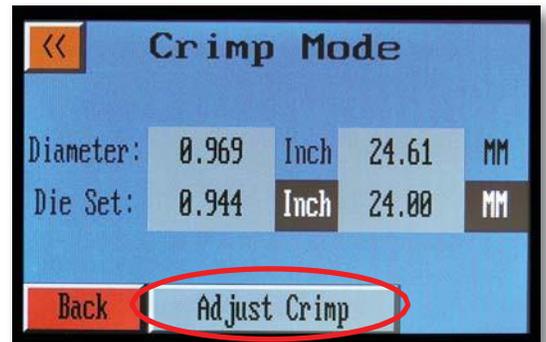


- Make a crimp, press and hold the green **CLOSE** button until the crimper stops closing.

- Measure the final crimp diameter (As shown on photo 4).



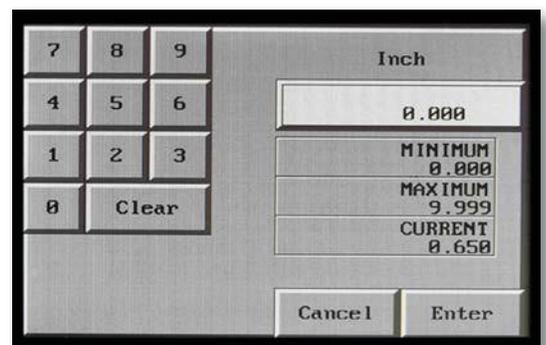
Note: If the finished crimp diameter is not within the required specifications press the **Adjust Crimp** button.



- It will bring up the **Adjust Crimp** screen, press the **Diameter** button.



- A keypad will pop up, and then enter **what your measured crimp diameter was**, (Do not enter the amount of correction) and press **Enter**.

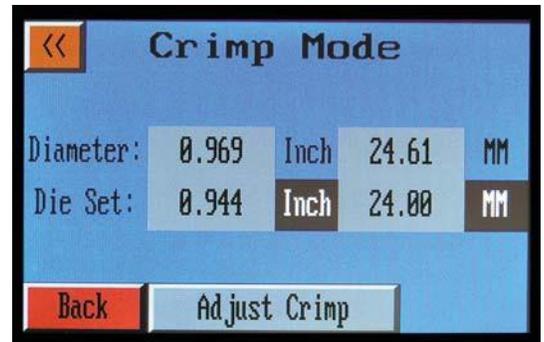


- It will bring up the **Adjust Crimp** screen and press the **Store** button.

- It will bring up the **Crimp Mode** screen.

- Make another crimp, press and hold the green **CLOSE** button until the crimper stops closing.

Note: Measure the final crimp diameter to be certain that it is within the required specifications.



D165 CRIMPER CALIBRATION

- From the **Main Menu** screen, press the **Options** button.
- It will bring up the **Options** screen, and press the **Machine Calibration** button.
- Follow the instructions on how to calibrate the crimper.

- Once you have calibrated the crimper, make a crimp and measure the final crimp diameter to be certain that it is within the required specifications.

Note: Due to variations in hose and fitting tolerances, some “offset” may require to achieve the correct crimp diameter for specific hose and fitting combinations across the range of hose and fittings being crimped.

If crimp diameters are consistently too large or consistently too small, the crimper should be recalibrated.

