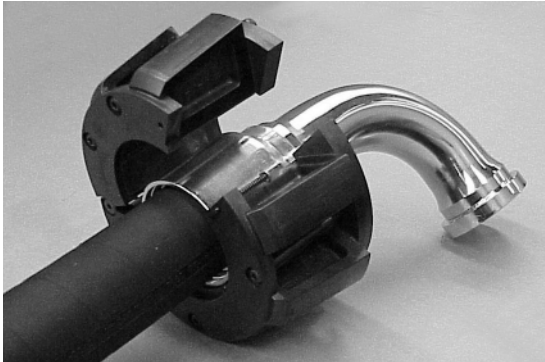
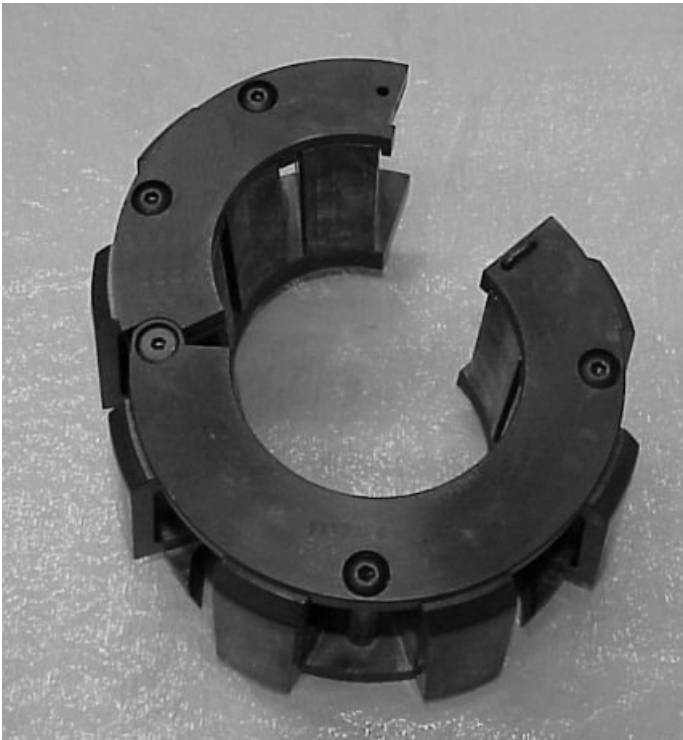
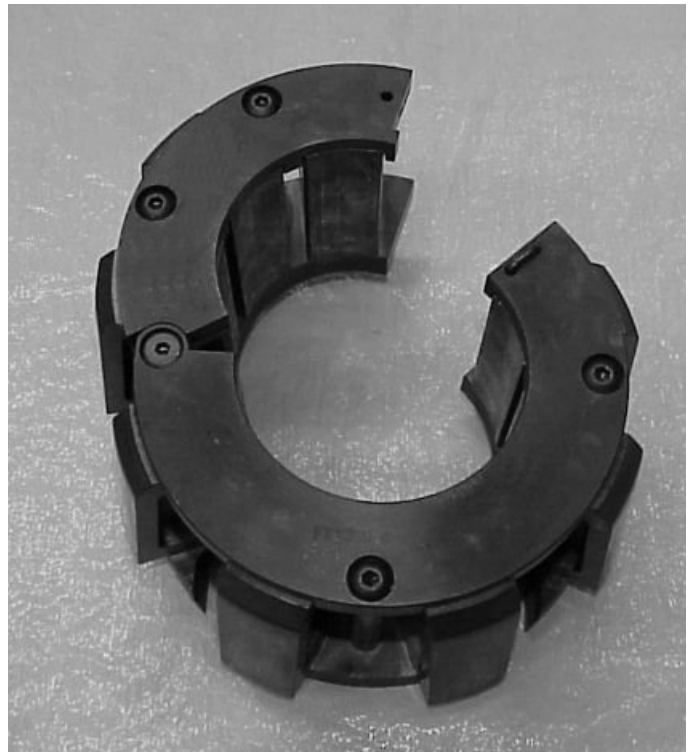
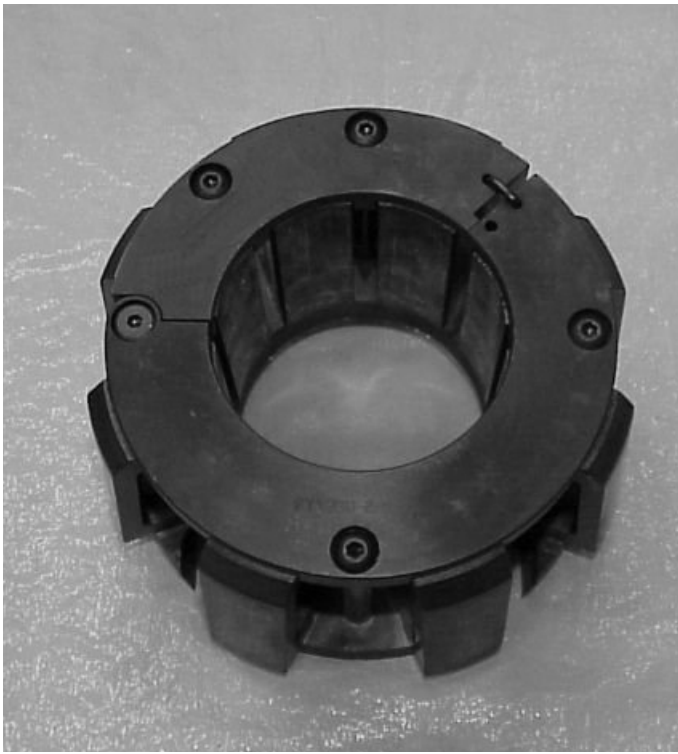


Aeroquip FT1390 Die Cage

Operator's Manual

Designed specifically for Global Spiral TTC™ Fittings





Designed specifically for Aeroquip's Global Spiral TTC™ fittings, the FT1390 Die Cage simplifies the crimping process. The hinged design allows for clearance of large elbow fittings, while the latchable one-piece construction makes for easy handling.

Features

- Hinges open
- Uses FT1209 dies
- Chrome moly alloy steel
- Simple latch mechanism
- Ion nitrided wear surfaces

Benefits

- Allows clearance of Global Spiral TTC™ elbows
- Ability to convert FT1209 die cage
- Maximum durability/high strength
- Easy handling
- Maximum service life

Ordering Instructions

Complete Die Cage Assemblies

FT1390-200-14

FT1390-200-15

FT1390-200-16

FT1390-200-20

FT1390-200-21

FT1390-200-23

Die Cage Repair Kit

(Complete cage, less dies)

FT1390-2-9

Note: For individual die cage components, please refer to page 7 of this bulletin.

The FT1390 Die Cage can be used with the following Aeroquip Crimp Machines.

ProCrimp 1390



FT1340



FT1360



FT1307



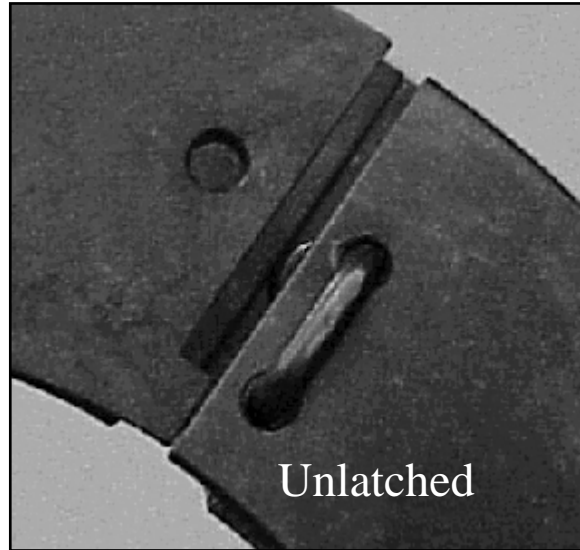
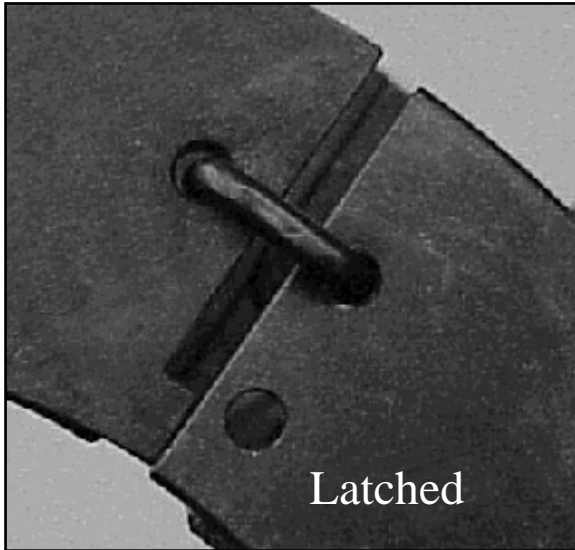
FT1209



FT1390 Die Cage Operation

Latch Operation

The FT1390 die cage uses a simple spring mechanism to keep the latch in place. To latch or unlatch the cage, simply push the backside of the latch to compress the spring. Adjust the latch to the appropriate position. (See below)



Fitting Assembly

Please refer to the JA55 Crimp Specifications Manual or the appropriate bulletin for the proper hose/fitting combinations, skive preparation, crimp diameters, crimp ovality, crimp length and proper die selection.

Assembly of Straight Fittings

Straight fittings do not require the hinged feature of the FT1390 Die Cage and should be assembled as follows:

1. Prior to handling, verify that the cage is latched.
2. Install the die cage into the crimp machine by placing the "T-nut" into the slot on the pressure plate.
3. Insert the fitting.
4. Position the fitting and crimp.

Assembly of Elbow Fittings

1. Prior to handling, verify that the cage is latched.
2. Install the die cage into the crimp machine by placing the t-nut into the slot on the pressure plate.
3. Unlatch the die cage.
4. Open the die cage by pulling up on the top (2) dies. Rest the t-nut on top of the pressure plate. (see Figure A and B)



Figure A

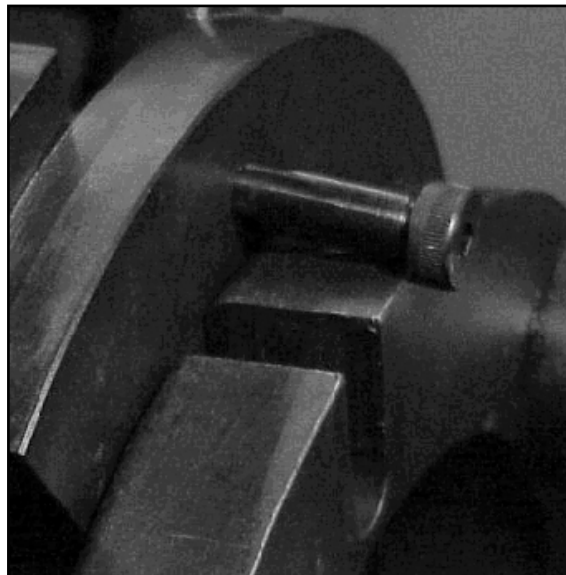


Figure B

5. Insert the fitting. If the fitting is successfully inserted, proceed to step 8. If the fitting will not clear the opening, close the die cage and advance the machine approximately 1/2". (see Figure C and D)

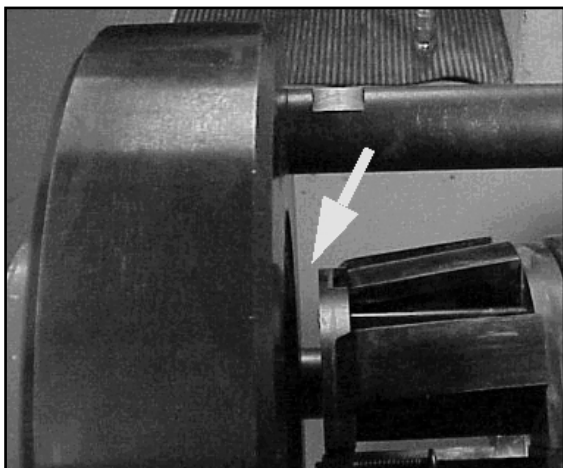


Figure C

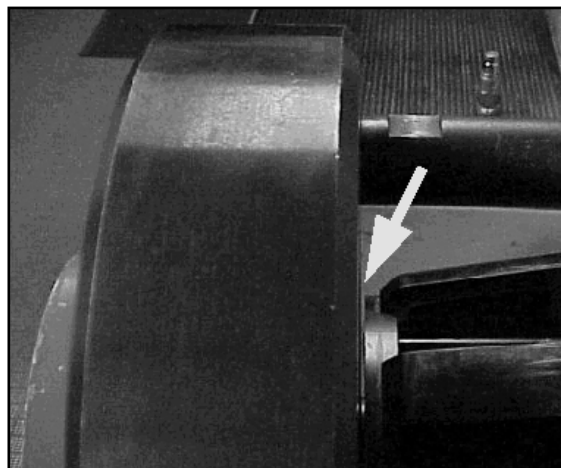


Figure D

6. Re-open the die cage.
7. Insert the fitting.
8. Close the die cage. Latching the die cage is not necessary during the crimping process.
9. Position the fitting and crimp.
10. When removing the fitting, the user may want to open the die cage for additional clearance.

FT1390 Die Cage Maintenance

For maximum service life, die cages need to be lubricated and kept clean from dirt and debris. Sliding surfaces of the individual dies are the areas of most concern. Use NEVER-SEEZ (Aeroquip Part Number FT1092) for all die cage lubrication.

Exposed Die Surfaces and Crimp Ring

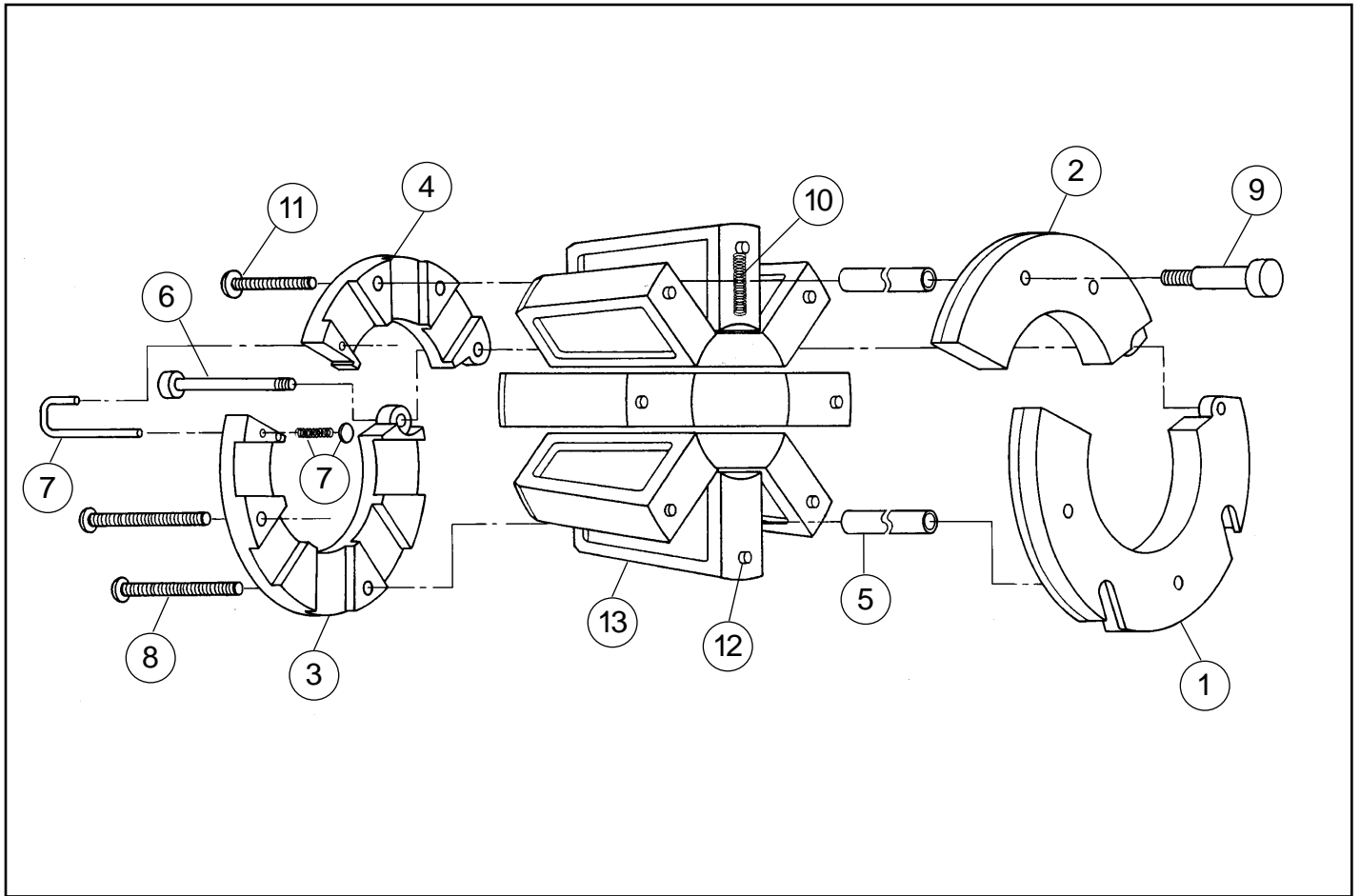
- Lubricate the angled die surfaces every 20 crimps. The style of hose and fittings crimped with the FT1390 die cage produce higher loads on the die cage and crimp machine, which requires lubrication at short intervals.
- Remove old grease and lubricate every 200 crimps. NEVER-SEEZ will build up on the sides of the dies and in the crimp ring during the crimping process. This residue will become contaminated with metal and plating chips and airborne contaminants, which can cause premature wear of the dies and crimp ring.
- The flat surfaces of the dies, that protrude beyond the backplate, should be lubricated every 200 crimps.
- Every 500 crimps, inspect the contact area of the dies and crimp machine. The surfaces should be smooth with no galling. Components with galled surfaces need to be replaced.

Concealed Die Surfaces and Die Cage Components

Every six months or 1000 crimps, whichever occurs first, disassemble the die cages for inspection and lubrication of parts. See page 7 for parts breakdown.

- The sliding surfaces between the dies and front/back plates should appear smooth with no galling. Galled components need to be replaced.
- Replace springs that show signs of damage or collapse, such as those which are shorter than others.
- Inspect remaining components of the die cage and replace those that show significant wear.

FT1390 Die Cage Parts Breakdown



Detail	Qty	Part Number	Description
1	1 pc	FT1390-2-9-1	Back Plate (lower)
2	1 pc	FT1390-2-9-2	Back Plate (upper)
3	1 pc	FT1390-2-9-3	Front Plate (lower)
4	1 pc	FT1390-2-9-4	Front Plate (upper)
5	4 pc	FT1390-2-9-5	Spacer
6	1 pc	FT1390-2-9-6	Shoulder Screw (long)
7	1 pc	FT1390-2-9-7	Latch Assembly
8	3 pc	FT1209-2-9-1	BHCS 5/16-18 x 3.90 long
9	1 pc	FT1209-2-9-5	Shoulder Screw (short)
10	8 pc	FT1209-2-9-7	Spring
11	1 pc	FT1209-2-9-8	BHCS 5/16-18 x 3.50 long
12	8 pc	21057-7	Roll Pin .25 dia. x .62 long
13	8 pc	FT1209-200-SIZE	Dies



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Specifications subject to change without notice