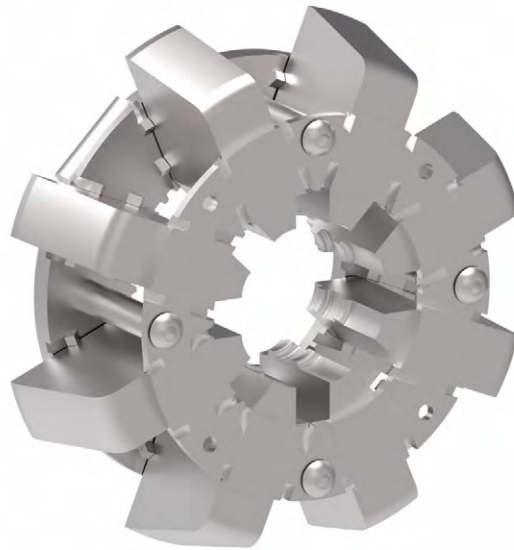


Owner's Manual

# Danfoss FT1307-2-9

## Crimp Die Cage Assembly



### Warning

Danfoss fitting tolerances are engineered to match Danfoss hose tolerances. The use of Danfoss fittings on hose supplied by other manufacturers and/or the use of Danfoss hose with fittings supplied by other manufacturers may result in the production of unreliable and unsafe hose assemblies and is neither recommended nor authorized by Danfoss.

Failure to follow Danfoss process and product instructions and limitations could lead to premature hose assembly failures resulting in property damage, serious injury or death.

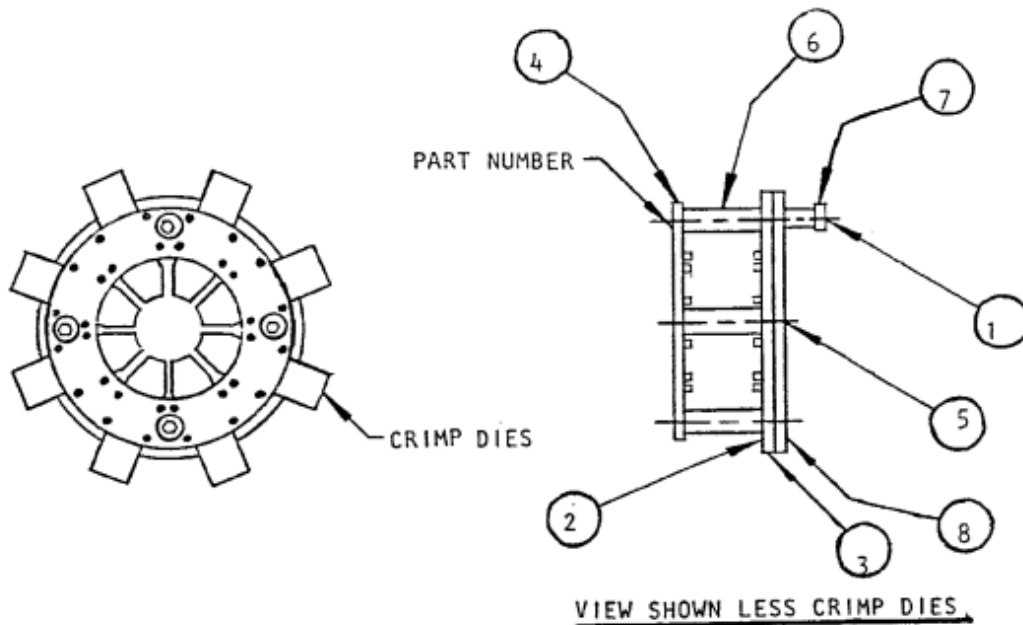
The user must exercise extreme care when operating any Danfoss assembly equipment with powered moving components. Safety glasses must be worn at all times when using any Danfoss assembly equipment.

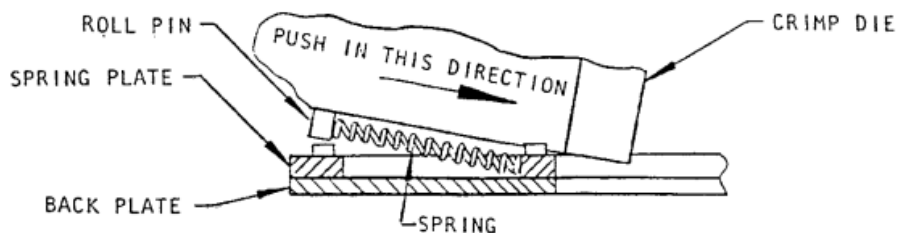
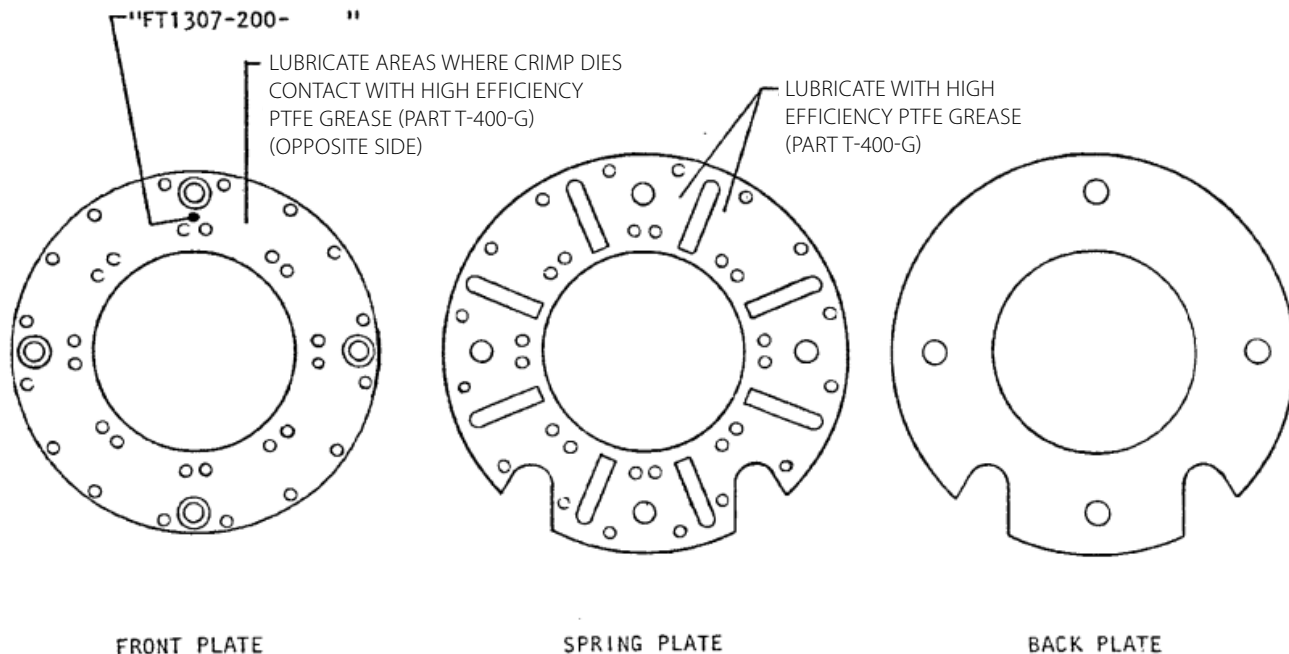
Read and understand the owners and operators manual before attempting to operate any equipment.

Danfoss hereby disclaims any obligation or liability (including incidental and consequential damages) arising from breach of contract, warranty, or tort (under negligence or strict liability theories) should Danfoss hose, fittings or assembly equipment be used with the hose, fittings or assembly equipment supplied by another manufacturer or in the event that product instructions for each specified hose assembly are not followed.

### Crimp die cage assembly

1. Assure all components are free from dirt and other contaminants prior to assembly.
2. Position back plate on a table with the slots toward the assembler
3. Lightly lubricate the spring plate with high efficiency PTFE grease (part T-400-G). See illustrations for location of the lubricant.
4. Position spring plate on top of the back plate with the lubricated side up. Orientation must be the same as the back plate.
5. Install all eight springs into the slots of the spring plate. Allow the excess of the spring to overhang the outside diameter of the spring plate.
6. Install all eight roll pins into the backside of the die. Allow .20" of roll pin to protrude.
7. Install all eight crimp dies within the slots of the spring plate. See illustration for insertion.
8. Lightly lubricate the front plate with high efficiency PTFE grease (part T-400-G). See illustration for location of lubricant.
9. Position the front plate on top of the crimp dies. The part number must be to the topside of the cage.
10. Install all four spacers in-line with the tapped and clearance holes.
11. Install three 2 5/8" long button head screws. Tighten securely.
12. Install one 3" long button head screw. Tighten into position with "T" nut.
13. Stamp the same number, following the FT1204-100- located in the cavity of the crimp die, on the front plate after the Fri 307-200.
14. Rub white paint into the stamped numbers.





**INSTALLING THE CRIMP DIE**

**Crimp die cage**

DETAIL NUMBER	PART NUMBER	DESCRIPTION	NUMBER REQUIRED
1	FT1307-2-9-10	5/16-18 x 3.00 lg. Bucs	1
2	FT1209-2-9-7	Spring	8
3	Fri 307-2-9-3	Spring Plate	1
4	FT1307-2-9-4	Front Plate	1
5	FT1307-2-9-5	Screw	3
6	FT1307-2-9-6	Spacer	4
7	FT1307-2-9-7	Nut	1
8	FT1307-2-9-8	Back Plate	1

## About Danfoss Power Solutions FC

Danfoss hoses, fittings, and tooling provide the ultimate fluid conveyance solutions for a variety of equipment and applications around the world. We proudly engineer to support a sustainable future for tomorrow.

To learn more please visit: <http://www.danfoss.com/en/about-danfoss/our-businesses/power-solutions>

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