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SAFE OPERATING PROCEDURES

Hose Crimp Machine

SOP 11A-10

Hazard Review		
Cuts, Bruises and Blisters	Pinching and Crushing Injuries	Eye Injury
High Pressure Fluid	Electrical Shock Hazard	Material Under Stress
Required Personal Protective Equipment (PPE) (Based on job specific hazard review)		
Safety Shoes	Safety Glasses/Goggles/Face Shield	Gloves

1. Make sure work area is clean and clear of all hazards.
2. Ensure machine is oiled and that regular preventative maintenance is performed.
3. Keep hands out from under ram at all times.
4. Wear leather gloves when using skiving tools.
5. Keep bottom of die-cage clean.
6. Never re-use any component. Use new components (i.e., hoses, ferrules and stems).
7. Use a magnet to insert proper die halves, one at a time, into base ring.
8. Ensure proper setting of Digital Readout Pressure.
9. Use proper die and hose assembly components.
10. Be sure you have the latest crimping pressure chart for your machine.

Related SOP's	
General SOP's.....Chapter 10	Hydraulic System Repairs.....11A-11
Metal Punching, Forming and Seaming.....11A-25	High Pressure Hoses 11E-6
Lockout-Tagout..... 11E-8	Maintenance and Repair Shops (General)11A-21
Roadside Equipment Repair..... 11B-68	Hand Tools (Power and Manual).....12B-13