Bulletin JA247B

Supersedes Bulletin JA247A

FT1320 Crimp Machine Decal

w/Sleeve FT1320-550

Aeroquip

MATCHMATE Plus®

Crimp System

1. Select desired hose and fitting.
2. Insert fitting fully onto hose.
3. Select proper crimp die cage (preferred dies are indicated with bold print on the table below) and insert into machine.
4. Select proper display setting.
5. Insert assembly into the cage and align the socket scribe mark with the edge of the dies.
6. Activate power source until the adjustable stop bottoms.
7. Remove crimped assembly.

Hose Style	Hose Size Die Color	Die Cage Part No.	Socket Marking	Crimp Diameter[1]	Sleeve Setting
GH663	–4 White	**–M150** –2	TTC-4	**15.75 mm .620 in**	
	–6 White	**–M180** –3	TTC-6	**19.94 mm .785 in**	
	–8 White	**–M240** –M210 –4	TTC-8	**23.88 mm .940 in**	
	–12 White	**–M320** –M280 –6	TTC-12	**31.75 mm 1.250 in**	
	–16 White	**–M370** –8	TTC-16	**40.39 mm 1.590 in**	
GH793	–4 Red	**–M150** –2	TTC-4	**17.27 mm .680 in**	
	–6 Red	**–M210** –M180 –3	TTC-6	**21.21 mm .835 in**	
	–8 Red	**–M240** –M210 –4	TTC-8	**25.15 mm .990 in**	
	–10 Red	**–M280** –M240 –5	TTC-10	**28.70 mm 1.130 in**	
	–12 Red	**–M320** –M280 –6	TTC-12	**32.51 mm 1.280 in**	
	–16 Red	**–M370** –8	TTC-16	**41.40 mm 1.630 in**	

Hose Style	Hose Size Die Color	Die Cage Part No.	Socket Marking	Crimp Diameter[1]	Sleeve Setting
GH781	–4 Green	**–M150** –2	TTC-4	**16.89 mm .665 in**	
	–6 Green	**–M210** –M180 –3	TTC-6	**20.70 mm .815 in**	
	–8 Green	**–M240** –M210 –4	TTC-8	**24.77 mm .975 in**	
	–10 Green	**–M280** –M240 –5	TTC-10	**28.32 mm 1.115 in**	
	–12 Green	**–M320** –M280 –6	TTC-12	**31.62 mm 1.245 in**	
	–16 Green	**–M370** –8	TTC-16	**39.75 mm 1.565 in**	
GH493	–6 Yellow	**–M210** –4	TTC12-6	**22.76 mm .896 in**	
	–8 Yellow	**–M280** –M240 –6	TTC12-8	**27.81 mm 1.095 in**	
	–10 Yellow	**–M280** –6	TTC12-10	**30.48 mm 1.200 in**	
	–12 Yellow	**–M320** –M280 –6	TTC12-12	**34.42 mm 1.355 in**	

MATCHMATE BLUE®

Hose Style	Hose Size Die Color	Die Cage Part No.	Socket Marking	Crimp Diameter[1]	Sleeve Setting
GH194	–4 Silver/Blue	**–M150** –2	TTC-4	**15.75 mm .620 in**	
	–6 Silver/Blue	**–M180** –3	TTC-6	**19.56 mm .770 in**	
	–8 Silver/Blue	**–M240** –4	TTC-8	**23.88 mm .940 in**	
	–10 Silver/Blue	**–M240** –5	TTC-10	**26.80 mm 1.055 in**	
	–12 Silver/Blue	**–M320** –6	TTC-12	**31.75 mm 1.250 in**	
	–16 Silver/Blue	**–M370** –8	TTC-16	**40.39 mm 1.590 in**	
GH195	–4 Gold/Blue	**–M150** –2	TTC-4	**16.89 mm .665 in**	
	–6 Gold/Blue	**–M210** –3	TTC-6	**21.21 mm .835 in**	
	–8 Gold/Blue	**–M240** –4	TTC-8	**25.15 mm .990 in**	
	–10 Gold/Blue				
	–12 Gold/Blue	**–M320** –6	TTC-12	**32.51 mm 1.280 in**	
	–16 Gold/Blue	**–M370** –8	TTC-16	**41.66 mm 1.640 in**	

Note: Sleeve settings are not provided. The operator must verify that the machine is crimping to the crimp diameter listed. Contact your Aeroquip representative or refer to the operators manual for instructions to establish sleeve settings.

[1]Tolerance ±0.15 mm/.006 in.
Maximum crimp ovality .20 mm/.008 in.

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