

Technical Bulletin

FT1380-XL Fitting Locators

For use with Eaton FT1380 “M” Series Die Cages

- Simplifies crimping of 4S series fittings
- Easy to install
- Perfectly positions the fitting within the crimp cage every time

Consistent crimping of 4S series fittings is greatly simplified when using Eaton fitting locators. The locators are designed for easy installation and use on the Eaton FT1380 “M” series die cages noted below.

When using the locators, a crimp machine operator no longer needs to “eyeball” the crimp location on the fitting. The locators allow the operator to position the fittings for consistent crimping and optimal performance of assemblies.

The locator kits can be ordered as part number FT1380-XL.

Locator Kit includes—

- Locators (one each): 4S6P, 4S8P, 4S10P, 4S12P, 4S16P, 4S6, 4S12, 4S16
- Installation instructions



Locator Suffix	Die Cage	GH493/H430	EC415	FC500/H471	EC420	EC600
4S6P	FT1380-200-M210	-6	-6			
4S8P	FT1381-200-M280	-8	-8			
4S10P	FT1381-200-M280	-10	-10			
4S12P	FT1380-200-M320	-12	-12	-12	-12	-12
4S16P	FT1380-200-M420	-16	-16	-16	-16	-16
None Required	FT1382-200-M465	-20	-20	-20		
4S6	FT1380-275-M210	-6	-6			
4S12	FT1380-275-M320	-12	-12	-12	-12	-12
4S16	FT1380-275-M420	-16	-16	-16	-16	-16

Selecting the Proper Locator and Die Cage Combination

Using the chart on the front of this bulletin, match the proper locator and die cage. When examining the dies, place the front of the die cage down. The individual dies must be examined to determine if the “standard” (example: 4S6) or “P” style (example: 4S6P) should be used, as shown in Figures 1 and 2.



Figure 1.
Dies with NO CHAMFER use the “standard” locators.



Figure 2.
Dies with a CHAMFER use the “P” locators.

Installation Instructions

1. Using a 5/32-inch allen wrench, remove the bottom bolt and sleeve from the die cage.
2. Slide the locator over the 3/8-inch diameter sleeve, and re-install as shown in figure 1.

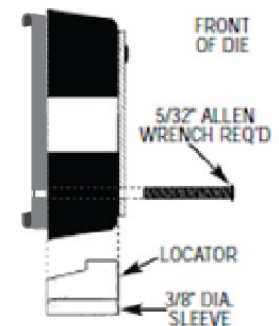


Figure 1.

Crimping Procedure Using the Locator

1. Establish the setting on the crimp machine.
2. Assemble the fitting onto the end of the hose, making certain that the fitting has “bottomed-out” against the squarely cut hose.
3. Insert the fitting into the crimp cage, then locate the back edge of the socket against the locator as shown in figure 2.
4. Complete the crimping cycle in the usual manner.

*Assembler to ensure the proper crimp diameter and correct crimp location to the scribe line per Eaton’s specs for the hose and fitting combination.

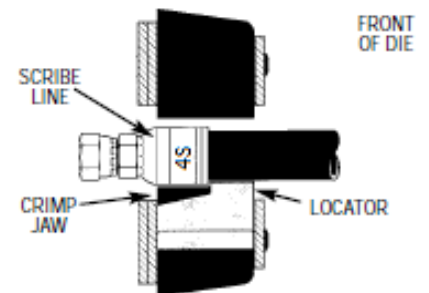


Figure 2.