

# Assembly Instructions

## StartLite® and AQP Racing Hose with Lightweight Crimp Fittings

### StartLite® Racing Hose and AQP® Racing Hose (with Lightweight Crimp Fittings)



#### ProCrimp® 1380 Crimp Machine

The ProCrimp 1380 machine is designed to assemble StartLite and AQP® Racing Hose assemblies. It is electronically controlled to give fast, accurate crimps and incorporates programmable crimp settings and a simple die cage insertion to reduce setup time and errors.

#### ProCrimp® 1380 Target Settings

The target settings for Eaton's Aeroquip Performance Products crimp machines are provided to aid in establishing actual settings. While the settings on this chart will give crimp diameters close to, or at, specified value, the machine operator must check to verify the actual diameter. Before using these target settings, the crimp machine must be within proper calibration. If needed, consult your Eaton Aeroquip Performance Products equipment manual for calibration procedures.

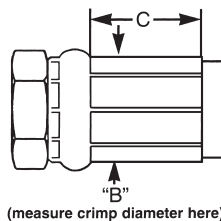
#### 1380 Crimp Machine Target Settings

Hose Dash Size	Die Cage	Crimp Diameter (±.005 Inches)	Target Setting
-04	-M120	.493	088
-06	-M150	.614	078
-08	-M150	.719	187
-10	-M210	.896	142
-12	-M240	1.020	116
-16	-M280	1.205	155
-20	-M370	1.465	040

**Note:** To ensure a proper crimp, the StartLite and AQP Racing Hose (FBU & FBA) must have a clean cut with no frayed ends and must be fully inserted into the fitting. Position your scribe line level with the top of the die. Follow target setting for the size of hose to be crimped. Check your crimp diameter with a dial caliper.

#### Crimp Diameter Measurement Locations

Diameter measurements are to be taken at the center (top to bottom, side to side) of the specified fitting selection.



#### Determining Crimp Diameter

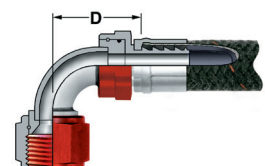
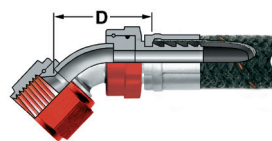
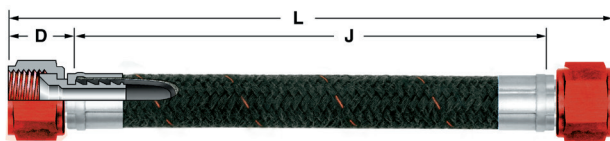
The crimp diameter is the average of the four diameter measurements around the fitting. These measurements are to be taken at the same relative locations indicated in the illustration above right.

$$\frac{\text{Measurement 1} + \text{Measurement 2} + \text{Measurement 3} + \text{Measurement 4}}{4} = \text{Crimp Diameter}$$

#### How To Determine Hose Assembly Lengths

To determine the "J" length (cut length of hose) from "L" length (overall length), deduct "D" dimensions of both end fittings. Consult fitting information tables for "D" dimensions.

L = Overall Length  
J = Cut Length of Hose  
D = Fitting Length



Compliments of Aeroquip Performance Product team. For more technical information please visit [Aeroquipperformance.com](http://Aeroquipperformance.com)