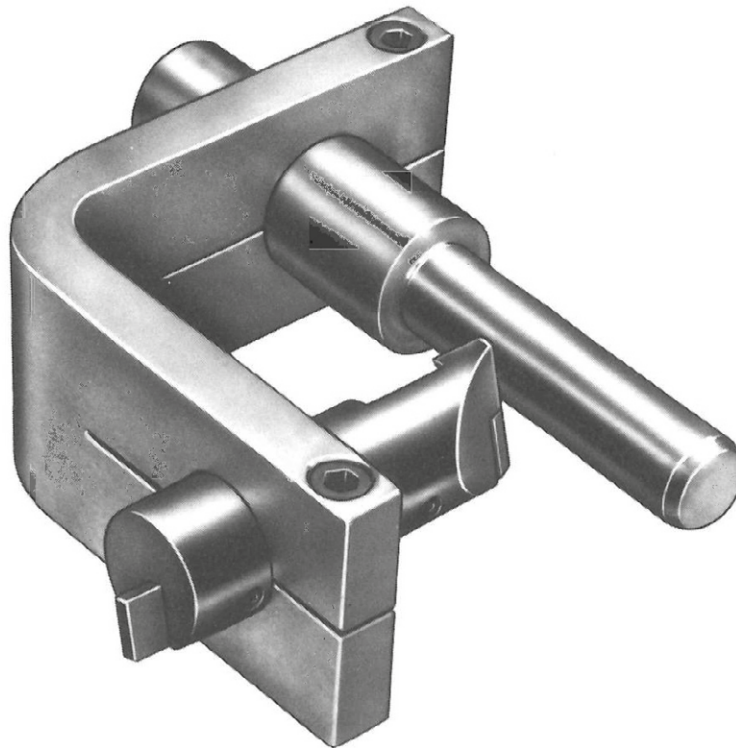


Operating Instructions

Aeroquip® by Danfoss Skiving Tool Instructions



FT1229-Size
Silver Chromate Mandrel
(for reusable fittings)

FT1230-Size
Yellow Chromate Mandrel
(for crimp fittings)

FT1231-Size
Black Oxide Mandrel
(for crimp internal skive fittings)

The Aeroquip FT1229, FT1230 and FT1231 hose cover skiving tools are designed to remove the rubber cover from wire reinforced hose prior to attaching crimped or reusable fittings. The tools are designed for use either in a standard shop vise, lathe chuck, drill press, Aeroquip assembly machine or by hand.

Stripping or skiving the rubber cover is necessary when assembling two-piece fittings on Aeroquip wire reinforced hose. Although the rubber cover can be removed by hand with a knife, the FT1229, FT1230 and FT1231

skiving tools will speed up and greatly facilitate the operation, especially when quantities of hose assemblies are needed.

A separate tool is available for each of the eleven hose sizes, from -3 through -32. These tools are ruggedly constructed with a steel frame and mandrel and a specially hardened steel blade holder. The mandrels are color-coded for easy identification. Each tool is assembled and preset for the particular size hose (see part number list). If desired, components may also be ordered separately.

Operation Instructions

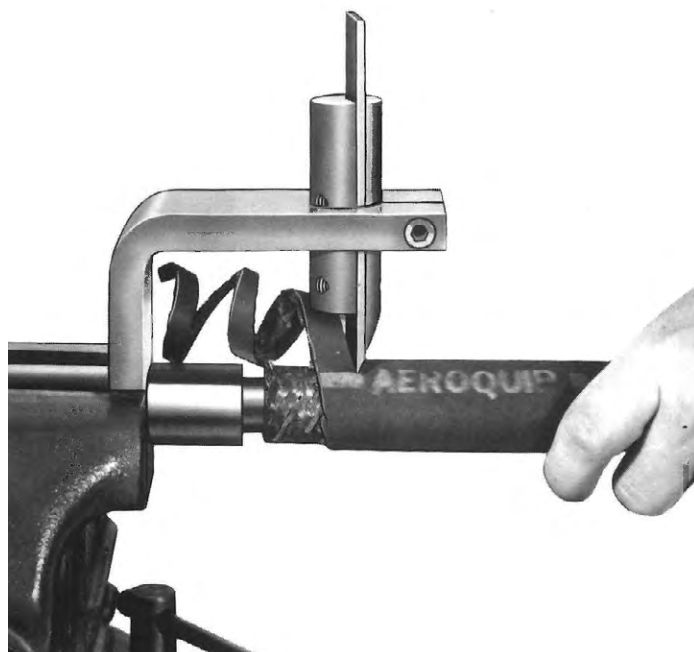


Figure 1

AS A HAND TOOL

Tighten the FT1229, FT1230 or FT1231 tool bracket in a vise as shown in Figure 1. Lubricate the mandrel with oil for hose that will convey fluids other than phosphate-ester based. For phosphate-ester based fluid, lubricate the mandrel with liquid soap. Push the hose over the mandrel until it engages the cutting blade. Rotate the hose clockwise while pushing it into the cutting blade. The tool will neatly cut and lift the rubber cover from the hose. When the hose bottoms on the mandrel shoulder, it may be removed by pulling it off the mandrel with a twisting motion. Repeat the operation on the opposite end of the hose.

AS A POWER TOOL

Any Aeroquip hose assembly machine may be used as the power unit. Other shop machines such as a lathe or drill press can be also used. Maximum recommended operating speed is 150 rpm. In the illustration, an Aeroquip FT1012 machine is used. To operate, tightly grip the skiving tool in the revolving chuck. Lubricate the mandrel with oil for hose that will convey fluids other than phosphate-ester based. Use liquid soap for hose that will convey phosphate-ester based hydraulic fluid. Rotate the tool counterclockwise. Push the hose onto the mandrel until it engages the cutting blade. Hold the hose to prevent it from turning. The blade will pull the hose onto the mandrel to finish the skiving operation. When the hose bottoms on the mandrel shoulder, pull the hose off the mandrel. Repeat the operation on the opposite end of the hose.

CAUTION: Machines with moving parts should only be operated after carefully reading operating manual.

For Skiving Rubber Covered Wire Reinforced Hoses

When selecting skive tools refer to the Aeroquip crimp specification bulletin for proper skive length of hose styles. Any tool with 2 or more skive lengths shown is adjustable.

FT1229-Reusable Type Fittings			FT1230-Crimp Type Fittings		FT1231-Crimp Internal Skivee Fittings	
Hose Size	Part No. Suffix	Part No. Length	Part No. Suffix	Skive Length	Part No. Suffix	Skive Length
-3			-3	.55 ⁶ .45		
-4	-4	91	-4	.64 ⁶ .76		
-5			-5	.76 ⁶ .76		
-6	-6	1.15 1.23 1.30	-6	.65 ⁶ .90		
-8	-8	1.25	-8	.79 ⁶ 1.04	-8	1.34
-10	-10	1.25	-10	.83 ⁶ 1.11		
-12	-12 -12B ²	1.40 2.40	-12	.85 ⁶ 1.21 1.31	-12	1.40
-16	-16 -16B ²	1.65 2.30	-16	1.02 ⁶ 1.30	-16	1.85
-20	-20 -20A ³ -20B ²	2.09 2.60 2.75	-20	1.21 ⁶ 1.66 1.52 1.88	-20	2.05
-24	-24 -24B ⁴	1.95 2.60	-24	1.29 ⁶ 1.74 1.64 2.18	-24	2.05
-32	-32 ⁵	2.05 1.30			-32 -32B	2.30 1.15

1 Adjustable tool, see Figure 2.

2 For FC606

3 For FC136 and FC250A

4 For FC136, FC250A and FC254

5 FT1229-32 tool is used for reusable and crimp fittings.

6 For global fittings.

All dimensions in inches.

Instructions for FT1229-100-6 (Reusable Skiving only)

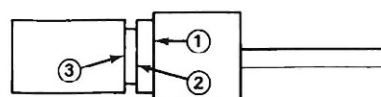


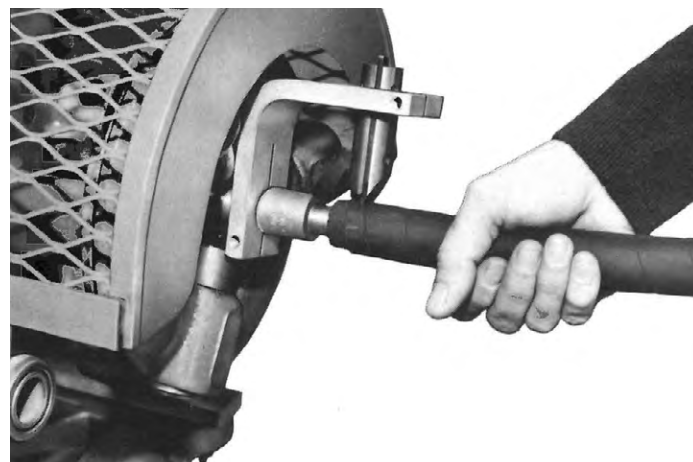
Figure 2

Hose Styles FC136

1. Insert all the way into bracket
1508, 1549, 2756

2. Insert to hose side of groove
All other hose styles

3. Insert to drive side of groove



Service Instructions

The FT1229, FT1230 and FT1231 tools have a replaceable steel cutting blade (no. FT1229-3-4). This blade may be removed and sharpened when it becomes dull. DO NOT ATTEMPT TO SHARPEN HOLDER.

To remove the blade, loosen screw "A" (in the exploded view Figure 3) and pull the blade holder out of the frame. If the blade holder is still tightly in the frame after removing screw "A", insert a screwdriver in slot "B" and tap lightly to spread the bracket. Loosen the set screws in the blade holder and remove the blade. The blade then can be sharpened on a grinding wheel to a 30° angle from the face. Reinsert the blade into the blade holder and tighten the set screws. When reassembling the blade holder into the bracket, it is important to adjust the blade holder so that the proper clearance is maintained between the mandrel and the blade. See clearance chart below. Rotate the blade holder so that the blade enters the hose at approximately a 7° angle (see Figure 4). An alignment mark is provided on the bracket for positioning. This angle may be varied to suit individual requirements. To complete the adjustment, tighten screw "A" to a snug fit.

Clearance Chart

Hose Size	Clearance "C" Inches *
-4	.134
-6	.142
-8	.142
-10	.142
-12	.160
-16	.183
-20	.221
-24	.221
-20A & -20B	.240
-24	.245
-32	.221

* For most hose styles, minor adjustments in this figure may be necessary.

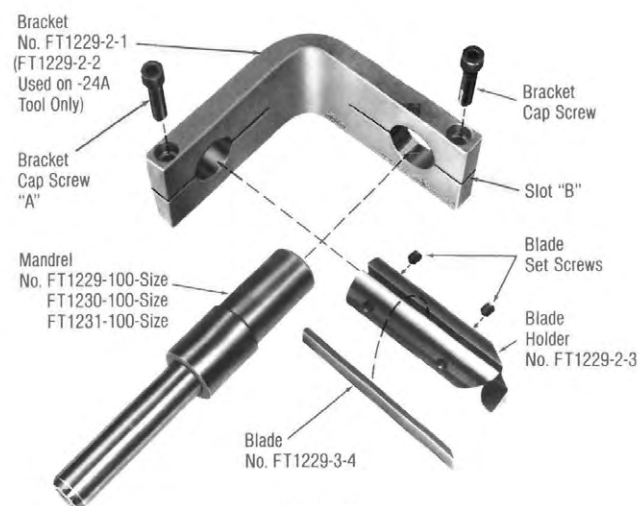


Figure 3

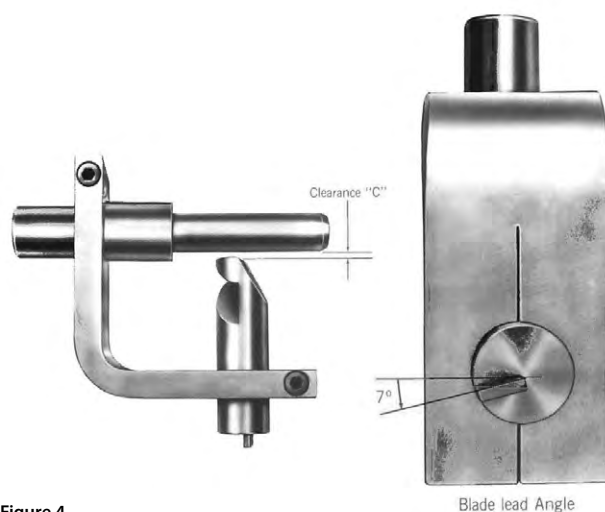
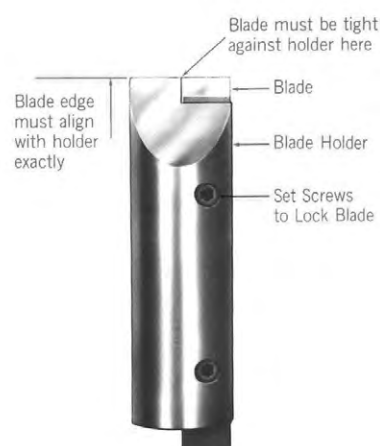


Figure 4

Internal Skive Tooling Chart

Internal Skive Tool	FC136 FC250A FC336	FC254	FC273	FC323 FC324 FC325	FC606
FT1240-150-8	-	-8	-	-	-
FT1240-100-12	-12	-	-12	-12	-
FT1240-150-12	-	-12	-	-	-
FT1240-150-16	-16	-16	-16	-16	-16
FT1240-100-20	-20	-	-20	-20	-
FT1240-150-20	-	-20	-	-	-20
FT1240-100-24	-24	-	-24	-24	-
FT1240-150-24	-	-24	-	-	-
FT1240-100-32	-32	-	-32	-32	-
FT1240-150-32	-	-32	-	-	-

All dimensions in inches.



FT1240-100-Size



FT1240-150-Size

FT1240 Internal Skive Tools

FT1279 Auger Attachment

The FT1279 auger attachment permits efficient skiving of rubber covered wire reinforced hose.

Designed for use with FT1229, FT1230 and FT1231 skiving tools, the FT1279 auger attachment promotes quick completion of hand skiving operations.



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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.

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