



General Technical

Instructions

Safety

Warranties

Table of Contents

Hose Assembly & Crimping

Using Crimpsource G-3

Permanent Crimp G-4
Series 56, CG, 92, CY, MS, SF

Field Attachable.....G-8
Series 51, 51R, BU, MS

PTFE Permanent Crimp G-9
Series 91, 91N, 93N

PTFE Permanent Crimp G-11
Series PAGE

PTFE Field Attachable G-13
Series 90

Sewer Hose Swaged G-15
Series SQ

Hose Handling

Twin/Multi-Line Separation..... G-17

Safety/Warranties

Parker Safety Guide G-19

Enerpac Warranty G-23

Offer of sale..... G-24

Index

By part number G-25

By keyword..... G-29



Parflex[®]
Partner. Innovator. Leader.

A Hose

B Tubing Thermoplastic

C Coiled Air Hose & Fittings

D Transportation

E Fittings

F Tooling, Equipment & Accessories

G General Technical

Hose Assembly and Crimping

How To Use Crimpsource

1

Data



The most up-to-date information for crimping is located at www.parker.com/crimpsource. Not only is it accurate, but it is easy.

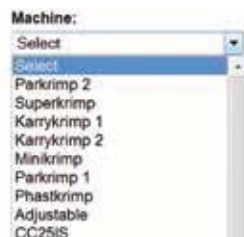
Note

- ✓ If the hose does not come up, then you cannot crimp that hose on the machine you selected.
- ✓ If the fitting/size you choose doesn't come up, then that series is not available for that hose.

www.parker.com/crimpsource

2

Make Your Selections

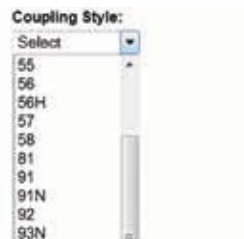


Choose the correction machine.



Choose the hose you are crimping.

Note - If the hose does not come up, then the crimper chosen does not work with the selected hose.



Choose the fitting style.



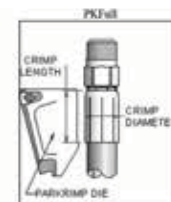
Choose the fittings size. Once you have selected values from each field, hit the search button.

Note - If the fitting/size does not come up, the series and or size is not available for the selected hose.

3

Review the Results

#	80C-P08	82C-R01	0.850	FULL	1-1/8	PKFull
Comments						
PFD: Crimp diameter is measured four places, 45 degrees apart, at the top, then middle and bottom of the crimp.						
PFD: Crimp diameter tolerance on all Parkrimp Crimpers is $\pm 0.010"$ ($\pm 0.25\text{mm}$) unless otherwise specified. Crimp length tolerance is $\pm 0.030"$ ($\pm 0.76\text{mm}$).						
PFD: Align measurement caliper or micrometer on the center of crimp impressions avoiding the crimp ribs.						
PFD: Crimp diameter tolerance on all Adjustable Crimpers is $\pm 0.005"$ ($\pm 0.13\text{mm}$). Crimp length tolerance is $\pm 0.030"$ ($\pm 0.76\text{mm}$).						



A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

E Fittings

F Tooling, Equipment & Accessories

G General Technical

Hose Assembly and Crimping

Permanent Crimp - Series 56, CG, 92, CY, MS, SF

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Inspection



Hose – Visually inspect both ends of hose for square cut. Remove any burrs, loose fibers or wires.



Fittings – Verify fitting series corresponds to the selected hose. Visually inspect fitting(s) for a through-hole, threads and damage.

2

Assembly Prep



Insertion Depth – Mark hose end with proper insertion depth line. Shown is a 56 Series fitting. See Hose Fitting Insertion Values, pg. E-10 for insertion depths of fitting series that do not incorporate an insertion depth.



Lubrication (as required) – Using an SAE 20 weight lubricating oil, lightly lubricate inside of hose end.

Warning Do not use lubricating oil when installing fittings on hose used in breathing air systems.

When installing fittings on hose used in breathing air systems, lubricate with a non-oil based soap solution as failure to do so may result in personal injury.

3

Assembly



Assemble Hose – Push hose into fitting all the way to depth insertion mark.

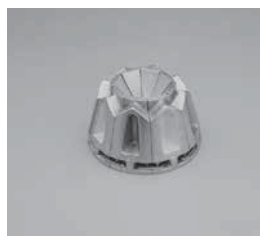
If fitting does not readily slide onto hose, perform the next step.



Using Parker VBS or VBL (vise blocks) and a rubber mallet, tap fitting onto hose until bottom of fitting shell is aligned with depth insertion mark.

4

Die Selection



Select proper Parkrimp die set.

Reference Crimp Die Selection at Crimpsource online.

www.parker.com/crimpsource

5

Lubricate Bowl



Grease frequently using a premium, quality, lithium-based grease. Apply a thin layer of grease on bowl of crimper base plate.

Hose Assembly and Crimping

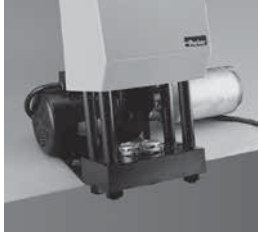
Permanent Crimp - Series 56, CG, 92, CY, MS, SF

CAUTION

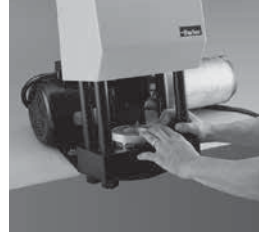
There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

6

Die and Spacer Ring



Crimp Die – Place die set into bowl.



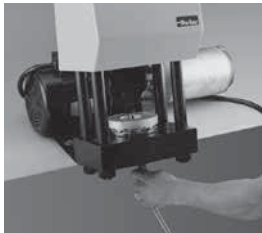
Die Ring – Place applicable die ring on top of crimp die. Position die ring so it is centered on the crimp die. Parflex utilizes the Silver die ring (8XC-R01) with limited exception.

Reference proper tooling (crimp die and die ring) at Crimpsource on-line.

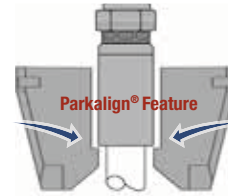
www.parker.com/crimpsource

7

Crimp



Assemble Hose – Insert hose and fitting from bottom of crimper and up through die set. Position fitting so bottom of fitting skirt rests on die step (PARKALIGN® feature).



While holding hose and fitting in position on die step, crimp fitting onto hose until die ring contacts base plate.

Note – Pump on crimper must not exceed the rated pressure of the crimper being used. Parker Hannifin will not accept responsibility for the operation of or provide warranty coverage for a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating.

Warning Keep fingers and hands away from die-pusher area. Failure to do so may result in personal injury.

8

Measure & Inspect



Measure and verify hose assembly length.

Inspect insertion depth mark at fitting ends. Insertion mark must be visible but not exceed 1/8" from end of crimped fitting shell.



Measure crimp diameter of each fitting at the top, middle and bottom of the crimp shell. Take measurements at a minimum of three (3) places around the shell circumference.

Crimp acceptance is based on the middle measurement average with a maximum taper of 0.010" between the top and bottom crimp averages. No single measurement outside the specification is permissible.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

F Fittings

T Tooling, Equipment & Accessories

G General Technical

Minikrimp Fitting Assembly

Permanent Crimp - Series 56, CG, 92, CY, MS, SF

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Inspection



Hose – Visually inspect both ends of hose for square cut. Remove any burrs, loose fibers or wires.



Fittings – Verify fitting series corresponds to the selected hose. Visually inspect fitting(s) for a through-hole, threads and damage.

2

Assembly Prep



Insertion Depth – Mark hose end with proper insertion depth line. Shown is a 56 Series fitting. See Hose Fitting Insertion Values, pg. E-10 for insertion depths of fitting series that do not incorporate an insertion depth.



Lubrication (as required) – Using an SAE 20 weight lubricating oil, lightly lubricate inside of hose end.

Warning Do not use lubricating oil when installing fittings on hose used in breathing air systems.

When installing fittings on hose used in breathing air systems, lubricate with a non-oil based soap solution as failure to do so may result in personal injury.

3

Assembly



Assemble Hose – Push hose into fitting all the way to depth insertion mark.

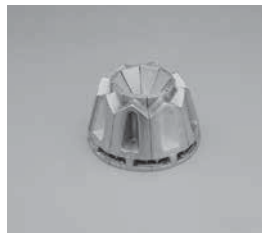
If fitting does not readily slide onto hose, perform the next step.



Using Parker VBS or VBL (vise blocks) and a rubber mallet, tap fitting onto hose until bottom of fitting shell is aligned with depth insertion mark.

4

Die Selection



Select proper Parkrimp die set.

Reference Crimp Die Selection at CrimpSource online.

www.parker.com/crimpsource

5

Lubricate Bowl



Remove pusher from shoulder bolt.

Using a premium, quality, lithium-based grease, apply a thin layer of grease on bowl of crimper baseplate.

Minikrimp Fitting Assembly

Permanent Crimp - Series 56, CG, 92, CY, MS, SF

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

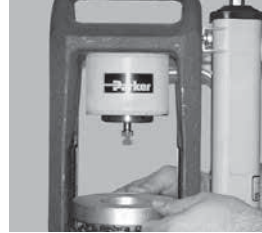
6

Die and Spacer Ring



Crimp Die – Place die set into bowl.

Replace pusher onto shoulder bolt.



Die Ring – Place applicable die ring on top of crimp die. Position die ring so it is centered on the crimp die. Parflex utilizes the Silver die ring (8XC-R01) with limited exception.

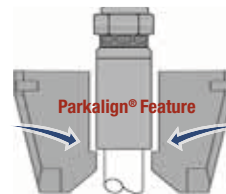
Reference proper tooling (crimp die and die ring) at Crimpsource on-line. www.parker.com/crimpsource

7

Crimp



Assemble Hose – Insert hose and fitting from bottom of crimper and up through die set. Position fitting so bottom of fitting skirt rests on die step (PARKALIGN® feature).



While holding hose and fitting in position on die step, crimp fitting onto hose until die ring contacts base plate.

Note – Pump on crimper must not exceed the rated pressure of the crimper being used. Parker Hannifin will not accept responsibility for the operation of or provide warranty coverage for a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating

Warning Keep fingers and hands away from die-pusher area. Failure to do so may result in personal injury.

8

Measure & Inspect



Measure and verify hose assembly length.

Inspect insertion depth mark at fitting ends. Insertion mark must be visible but not exceed 1/8" from end of crimped fitting shell.



Measure crimp diameter of each fitting at the top, middle and bottom of the crimp shell. Take measurements at a minimum of three (3) places around the shell circumference.

Crimp acceptance is based on the middle measurement average with a maximum taper of 0.010" between the top and bottom crimp averages. No single measurement outside the specification is permissible.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

F Fittings

T Tooling, Equipment & Accessories

General Technical

Field Attachable Assembly

Series 51, 51R, BU, MS

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Inspection



Hose – Visually inspect both ends of hose for square cut. Remove any burrs, loose fibers or wires.



Fittings – Inspect nipple for a through-hole, damaged or missing threads and improperly crimped nut (if applicable). Do not use if these conditions exist. Inspect socket for damaged or missing threads. Do not use if conditions exist.

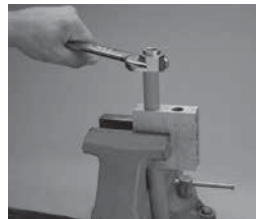
2

Assembly



Using the Parker VBS or VBL vise block, place hose in proper hole of the vise block and then clamp in a bench vise. Ensure enough hose extends from the vise block to install socket.

CAUTION Ensure hose is installed in correct size hole of vise block. Clamping hose in a smaller hole will crush hose.



Using a wrench or deep well socket with 51R, screw the socket onto the hose counterclockwise until it bottoms. Ensure end of hose is against inside shoulder. Back off socket 1/4 turn clockwise.

Socket should be firm when tightened but not difficult to install. If socket is difficult to install, apply lubricant that is compatible with the hose material.

The 51R Series Field-attachable fitting features an optional deep-well socket assembly procedure with either ratchet or power drill at low speed allowing for quick, power assist assembly giving you more control on the turn and rate.

Note

- ✓ MS Series - Do not use a lubricant.
- ✓ 51R Series - Lubrication, using a SAE 20 weight lubricating oil, must be used for assembly.

3

Assembly



Place hex portion of socket into vise and tighten vise. Ensure socket extends past vise jaws enough to allow for installation of nipple

CAUTION When tightening socket in vise, do not over tighten vise jaws. Over tightening vise jaws will distort internal threads of socket and hamper installation of nipple.

Using an SAE 20 weight lubricating oil, generously lubricate nipple and socket, threads and hose I.D.



Using using a wrench on the nipple hex, screw nipple into socket clockwise until nipple bottoms against socket shoulder.

CAUTION Nipple should be firm when tightened but not difficult to turn. If nipple is difficult to install, check hose for proper lubrication. Re-apply lubricating oil as necessary. Installation of nipple without proper lubrication will damage core tube.

Note - For 51R-series fittings, the nipple will thread directly into the hose and socket.

4

Measure and Inspect



Measure and verify hose assembly length.

PTFE Assembly

Permanent Crimp - Series 91, 91N, 93N

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Cut



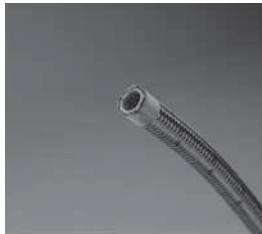
Using a power hose cut-off saw, cut hose squarely.



Fittings – Inspect nipple for a through-hole, damaged or missing threads and improperly crimped nut (if applicable). Do not use if these conditions exist. Inspect socket for damaged or missing threads. Do not use if conditions exist.

Note

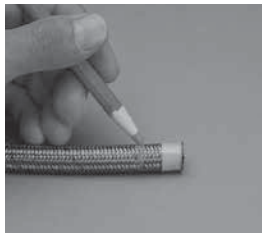
✓ 93N Series -Make certain crimp shell is screwed tight to the nipple.



Visually inspect both ends of hose for square cut. Remove any burrs, loose fibers or wires.

2

Assembly



Insertion Depth – Mark hose end with proper insertion depth line. See Hose Fitting Insertion Values, E-10 for insertion depths of fitting series that do not incorporate an insertion depth. For jacketed PTFE hoses, use a sharp knife and light pressure to cut back the cover at least the length of the insertion depth of the fitting.



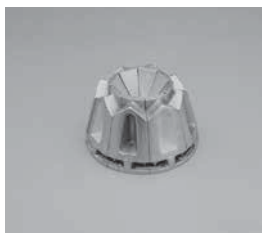
Assemble Hose – Push fitting onto hose slightly and then remove tape. Continue pushing fitting onto hose until fitting reaches depth insertion mark.

Warning Do not use lubricating oil when installing fittings on hose used in breathing air systems.

When installing fittings on hose used in breathing air systems, lubricate with a non-oil based soap solution as failure to do so may result in personal injury. personal injury when hose is used.

3

Die Selection



Select proper Parkrimp die set.

Reference Crimp Die Selection at Crimpsource online.

www.parker.com/crimpsource

4

Lubricate Bowl



Using a premium, quality, lithium-based grease. Apply a thin layer of grease on bowl of crimper base plate.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

F Fittings

Tooling, Equipment & Accessories

General Technical

PTFE Assembly

Permanent Crimp - Series 91, 91N, 93N

CAUTION

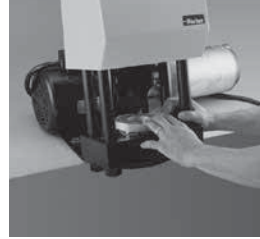
There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

5

Die and Spacer Ring



Crimp Die – Place die set into bowl.



Die Ring – Place applicable die ring on top of crimp die. Position die ring so it is centered on the crimp die. Parflex utilizes the Silver die ring [8XC-R01] with limited exception.

Reference proper tooling (crimp die and die ring) at Crimpsource on-line.

www.parker.com/crimpsource

6

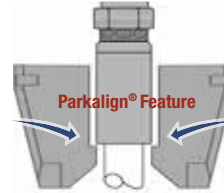
Crimp



Assemble Hose – Insert hose and fitting from bottom of crimper and up through die set. Position fitting so bottom of fitting skirt rests on die step (PARKALIGN® feature).

Warning Keep fingers and hands away from die-pusher area. Failure to do so may result in personal injury.

Note - Pump on crimper must not exceed the rated pressure of the crimper being used. Parker Hannifin will not accept responsibility for the operation of or provide warranty coverage for a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating .



While holding hose and fitting in position on die step, crimp fitting onto hose until die ring contacts base plate.

Note - Pump on crimper must not exceed the rated pressure of the crimper being used. Parker Hannifin will not accept responsibility for the operation of or provide warranty coverage for a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating

Warning Keep fingers and hands away from die-pusher area. Failure to do so may result in personal injury.

7

Measure & Inspect



Measure and verify hose assembly length.

Inspect insertion depth mark at fitting ends. Insertion mark must be visible but not exceed 1/8" from end of crimped fitting shell.



Measure crimp diameter of each fitting at the top, middle and bottom of the crimp shell. Take measurements at a minimum of three (3) places around the shell circumference.

Crimp acceptance is based on the middle measurement average with a maximum taper of 0.010" between the top and bottom crimp averages. No single measurement outside the specification is permissible.

PTFE Assembly

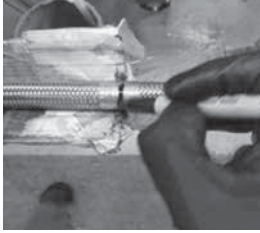
Permanent Crimp - Series PAGE

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Inspection/Marking



Obtain correct hose, fittings and collars per customer order. Inspect to make certain no defects are present on fittings, collars or hose.

Using 1" wide filament tape, apply 1 to 1½ wraps of tape tightly around hose at location to be cut. Mark tape in the middle where cut will be made. Tape will be left on during crimping so only ½" width of tape should remain.



Fittings – Inspect each component for possible damage. In addition, inspect socket and nipple for a through-hole and threads.

2

Assembly



Cut hose.



Blow ends of hose off / out to remove any debris left from cutting operation. Cut off wires or fabric extending past the end of the hose.

3

Assembly



PAGE series fittings are not one piece but two pieces (insert plus collar) and must be properly installed to assure leak free long life assemblies.



Orient and place collar on hose end fully.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

F Fittings

T Tooling, Equipment & Accessories

G General Technical

PTFE Assembly

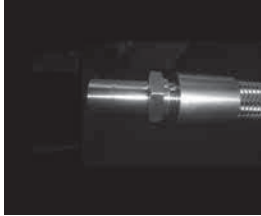
Permanent Crimp - Series PAGE

CAUTION

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4

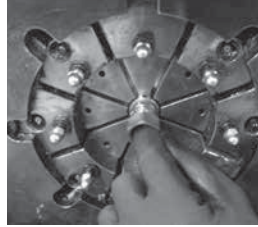
Assembly



Using a taper punch, push punch into tube to enlarge bore of hose so insert just slides into hose.

Push insert into hose until lock groove of insert is just at end of collar.

Pull collar out towards end of insert until at correct crimp position on insert of collar.



Pull collar out towards end of insert until at Crimp assembly only in Parker Approved adjustable crimper. Select correct die and crimp spec from Parker Crimp Source.

www.parker.com/crimpsource

a. Place assembly into crimp dies so full collar length crimp is obtained.

b. Check crimp dimensions in four places around the middle of the crimp circumference. Verify the average of those readings is within crimp specification tolerances.

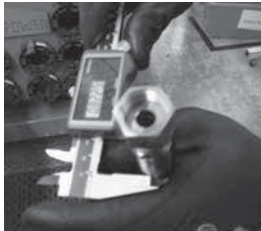
Adjust crimper up or down if needed to obtain proper dimension.

c. Crimp opposite end following the same procedures.

Warning Keep fingers and hands away from die-pusher area. Failure to do so may result in personal injury.

5

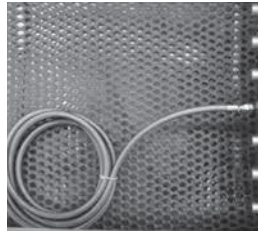
Inspect



Inspect assembly, noting the length.

Test to correct test pressures to assure no leaks are observed using hydrostatic pressure unit (recommended).

Air or nitrogen under water can be used with caution utilizing the proper pressure and procedures for that equipment.



Blow out all water from the assembly and recheck length.

Note

✓ Note any movement of length and make compensations as needed on next assembly.

✓ Package assembly appropriately for customer requirements.

PTFE Assembly

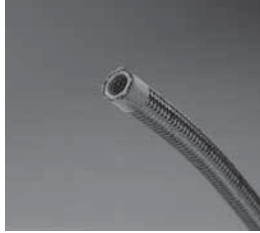
Field Attachable - Series 90

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Inspection



Hose – Visually inspect both ends of hose for square cut. Remove any burrs, loose fibers or wires.

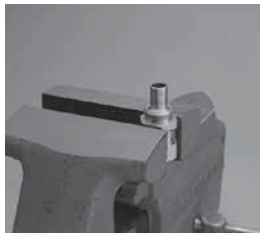


Fittings – Inspect each component for possible damage.

Inspect socket and nipple for a through-hole and threads.

2

Assembly



Mount nipple hex in vise. Ensure nipple end extends beyond vise jaws sufficiently to allow installation of hose.



Push hose bore onto nipple to size tube and to aid in separating braid before assembling ferrule onto hose.

Once completed, remove hose from nipple.

3

Assembly



By hand, push sleeve over end of PTFE core tube and under wire braid.



To complete positioning of sleeve, push hose end with sleeve against a solid flat surface.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

E Fittings

F Tooling, Equipment & Accessories

G General Technical

PTFE Assembly

Field Attachable - Series 90

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

5

Assembly



Verify tube butts against inside shoulder of ferrule.



Using a tapered punch, push punch into end of sleeve and tube to set sleeve barbs into tube.

6

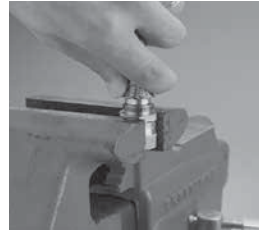
Assembly



Using SAE 20 weight oil, lubricate nipple and socket threads. For stainless steel fittings use Parker Thread-Mate® or a molybdenum type lubricant.

Warning Do not use lubricating oil when installing fittings on hose use in breathing air systems.

When installing fittings on hose used in breathing air systems, lubricate with a non-oil based soap solution as failure to do so may result in personal injury.



Assemble Hose – Using a twisting motion, push hose over nipple until hose is seated against nipple chamfer.

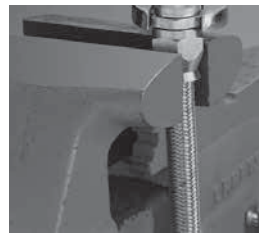
7

Assembly



Push socket forward and hand-start threading of socket to nipple.

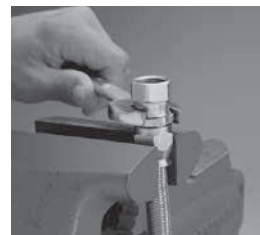
CAUTION When tightening socket in vise, do not over tighten vise jaws. Over tightening vise jaws will distort internal threads of socket.



Remove assembly from vise and reposition with socket in vise jaws. Ensure socket extends beyond vise jaws far enough to allow nipple to be completely tightened.

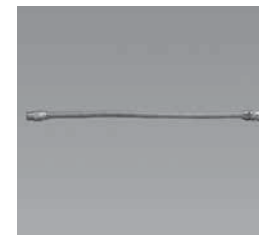
8

Assembly



Wrench tighten nipple hex until clearance between hex and socket hex is 1/32" or less.

Tighten further to align corners of nipple and socket hexes if necessary.



Measure and verify hose assembly length.

Sewer Hose Swaged Assembly

Series SQ

CAUTION

There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

1

Inspection



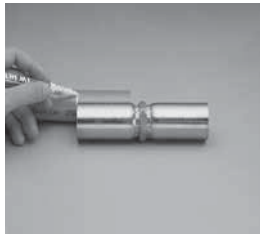
Hose – Visually inspect both ends of hose for square cut. Remove any burrs, loose fibers or wires.



Fittings – Visually inspect fitting for properly crimped shells, internal barbs, a through-hole and damage.

2

Assembly



Insertion Depth – Mark hose end with proper insertion depth line.



Lubricate – Using an SAE 20 weight oil, lightly lubricate inside of both hose ends.

3

Assembly



Assemble Hose – Push each hose end into fitting to the depth insertion mark.



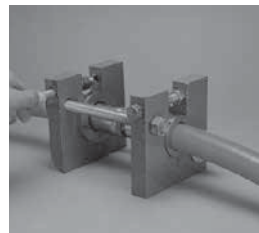
Remove both die securing bolts and nuts.

4

Assembly



Place hose and fitting assembly into position on swager.



Insert both die halves around hose in each end of swager.
Install both die securing bolts with nuts positioned in opening of swager plates. Tighten die securing bolts 1/4 turn past finger tight.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

F Fittings

Tooling, Equipment & Accessories

General Technical

Sewer Hose Swaged Assembly

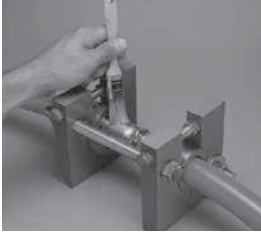
Series SQ

CAUTION

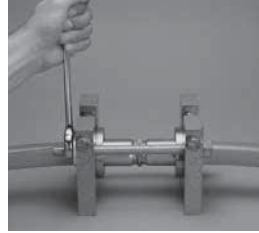
There are several sections for Hose Assembly and Crimping. **Be sure you are in the section that corresponds to the fitting series you are using.** See Table of Contents for listing.

5

Assembly



Lubricate – Using SAE 20 oil, generously lubricate the steel fitting surface and ID of the swage dies.



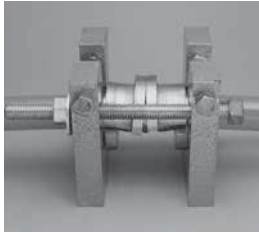
Assemble Hose – Align swager plates in parallel and tighten nuts on swaging bolts uniformly until dies touch.

CAUTION When tightening socket in vise, do not over tighten vise jaws. Over tightening vise jaws will distort internal threads of socket and hamper installation of nipple.

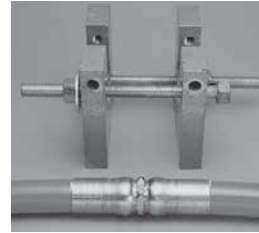
Generously lubricate swaging bolts. Failure to do so may result in an improperly swaged fitting.

6

Assembly



Loosen swaging bolts to release pressure on dies.

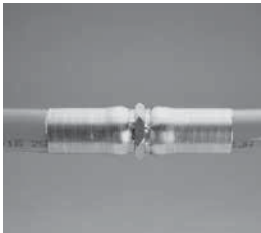


Remove die securing bolts and nuts. Then remove dies.

Push each hose end into fitting to the depth insertion mark.

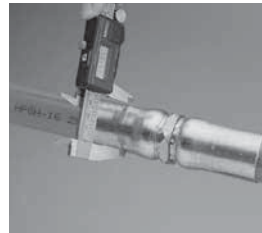
7

Assembly



Measure and verify hose assembly length.

Inspect insertion depth mark at fitting ends, which must be visible, but not exceed 1/8" from end of swage shell.



Measure swage diameter of each fitting at top, middle and bottom of shell. Take measurements at a minimum of three places around shell circumference. Verify swage diameter is within tolerances.

Reference Swage Specification & Tool Selection Chart on pg. F-14 for proper swage diameters.

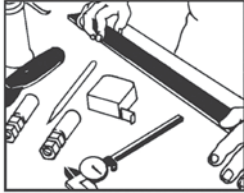
Twin/Multi-Line Separation

Factory-built assemblies are available using twin/multi-line hoses.

When field-built assemblies are preferred, the following steps must be taken.

1

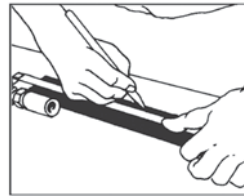
Set-Up



Position twinned or multi-line hose assembly so that it lies flat on work surface without tendency to twist or turn.

2

Measure

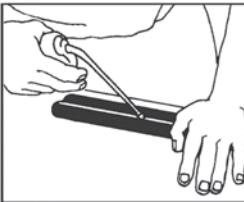


Measure hose to length.

Measure and mark the length that the hoses are to be separated (commonly referred to as Splitback Length).

3

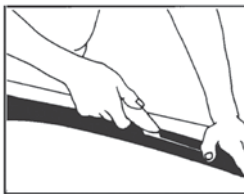
Lubrication



Lightly lubricate the web area between the hoses. Distribute the lubricant uniformly along the web of the assembly to be separated. Any lightweight oil will suffice (SAE 10 or 20). The function of the oil is to reduce the friction of the knife blade so that it naturally seeks the center of the valley formed by the hoses. This eliminates the need for the operator to steer the knife.

4

Cut



Press the multi-line hose assembly firmly and flat against the work surface with your free hand so that it does not move. Using a sharp utility knife, carefully draw the knife toward you with constant light to moderate pressure, and a smooth stroke. Multiple strokes will be necessary to separate the hoses.

Note - It is important that the knife blade be perpendicular to the hose during this procedure so that the blade cuts only the center line of the web. Extreme care must be taken to avoid cutting through the cover of the hoses and thereby exposing the hose reinforcement. If this occurs, the hose assembly must be discarded (See Figure 1). If the separation length is greater than that which can be accomplished with one continuous, smooth stroke, then the procedure should be repeated over shorter distances always cutting toward the free end of the hoses.

A Hose

B Tubing

C Coiled Air Hose & Fittings

D Transportation

E Fittings

F Tooling, Equipment & Accessories

G General Technical

Twin/Multi-Line Separation

A Hose

B Tubing
Thermoplastic

C Coiled Air Hose
& Fittings

D Transportation

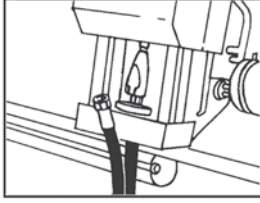
E Fittings

F Tooling,
Equipment
& Accessories

G General
Technical

5

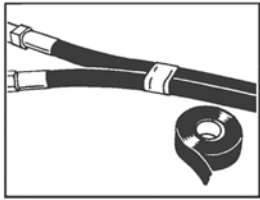
Measure Separation



It is suggested that the separation length be sufficiently long so that the crimping operation can be accomplished without risk of kinking the hoses or tearing the web which could result in exposure of the hose reinforcement

6

Apply Tape



At the option of the assembler, as dictated by the installation, a nylon lashing strap or tape may be applied at the termination of the separated length to provide protection against tearing of the web or hose covers.

Incorrect Handling



Extreme care must be taken to avoid cutting through the cover of the hoses and thereby exposing the hose reinforcement. If this occurs, the hose assembly must be discarded.



The separation length must allow for the crimping operation without damaging the hose.