

Hydraulic hose 52428- Bridgestone R2K with MF ferrule and inserts

Hose dim.	Part no. hose	Part no. ferrule	Ferrule marking	Diam x length before crimping	Ferrule/insert serie	Crimping measure mm
1/4	52428-04	65125-04	M03400-04	23,0 X 30,1	MF	18,6
3/8	52428-06	65125-06	M03400-06	26,0 X 31,1	MF	20,6
1/2	52428-08	65125-08	M03400-08	29,0 X 33,4	MF	24,0
5/8	52428-10	65125-10	M03400-10	33,0 X 37,0	MF	27,9
3/4	52428-12	65125-12	M03400-12	37,0 X 42,0	MF	31,5
1	52428-16	65125-16	M03400-16	46,0 X 51,0	MF	39,0

References and explanations for the crimping chart:

Please see <http://intranett.tessdata.no> for updated version of crimping chart.

Contact your nearest TESS Service centre if you have questions. Reservations for typing error and changes.

Crimping control steps

- Step 1. Inspect the crimping dimension in the die-set area as indicated in the picture. Take four measurements across the crimped ferrule at 45° to each other using a vernier calipers in the middle section of the crimped length of the ferrule. Verify that all four measurements are according to the designated crimping diameter. Tolerance 0/-0,2 mm.
- Step 2. Inspect the crimp taper values
Measure the diameter at the top of the ferrule and at the bottom of the ferrule (see picture)
Verify that the ferrule taper satisfies the following limits:
Taper ≤ 0,3 mm. for hose size up to and including 5/8 inch
Taper ≤ 0,6 mm. for hose size from 3/4 inch up to and including 3 inch

