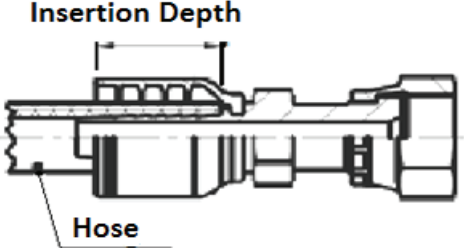


Water Cleaning Hose

Hose dim.	Item no. hose	Insert type	Marking	Crimping dia.	Insertion Depth	
5/16"	53400-05	Serie K	K-05	19,0	23,5	
3/8"	53400-06	Serie K	K-06	21,0	25,5	
1/2"	53400-08	Serie K	K-08	24,8	29,0	

Insertion Depth:

The insertion dept are stated in the crimping chart. Mark the hose with a line at stated depth. Push the insert all the way, so the edge of the ferrule gets parallel with the marking.

Crimping control steps:

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.

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 $\leq 0,3$ mm for hose size upto and including 5/8 inch.

