

## Wire spiral hoses - Manuli IL Plus

Hose dim	Ferrule type	Marking	Diam x length	Note	55280	5530	548	549	55350	55420	5595	Skiving length	
												Ext.	Int.
3/4"	65942-12	M01500-12	40,0 x 51,4	IL Plus		4) 34,8	4) 34,8	4) 35,8	4) 34,0	4) 34,1	4) 34,8	38	13
1"	65942-16	M01500-16	48,0 x 64,5	IL Plus		4) 41,5	4) 41,5	4) 42,4	4) 41,1	4) 41,3	4) 41,5	49	15
1.1/4"	65942-20	M01500-20	57,0 x 84,0	IL Plus			4) 49,5		4) 48,9			66	22
1.1/2"	65942-24	M01500-24	64,3 x 94,0	IL Plus	4) 56,0		4) 56,4					73	25
2"	65942-32	M01500-32	83,5 x 107,0	IL Plus	4) 73,9		4) 73,5					86	29
1.1/4"	655962-20	M01600-20	60,0 x 85,0	IL Plus						4) 52,7		67	22
1.1/4"	655962-20	M01600-20	60,0 x 85,0	IL Plus				4) 6 wire 53,1			4) 52,9	67	22
1.1/2"	655962-24	M01600-24	68,0 x 96,0	IL Plus				4) 61,0	4) 60,2	4) 60,6	4) 61,0	77	25
2"	6595-32	M01800-32	86,5 x 108,0	IL Plus				4) 75,8	4) 75,1			84	29

### References and explanations for the crimping chart:

Abbreviations used under column "note" in the chart describes which insert category the ferrule shall be used with. Combinations of ferrule and inserts from different categories and different manufactures are not permitted.

4) External and internal rubber must be removed before the ferrule is fitted. (See skive length)

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

