

Hydraulic hoses with PH ferrule and insert A316

Hose dim.	Ferrule type	Diam x length before crimping	Note	533	5166	5256	528	5528	547	Skiving length	
										Ext.	
1/4"	6651225-04	23,0 x 31,7	ST		17,9	18,6	18,2				-
5/16"	-05	24,0 x 31,5	ST		18,7	19,7	19,0				-
3/8"	-06	26,0 x 33,3	ST		20,6	21,4	20,6				-
1/2"	-08	29,0 x 34,5	ST		23,5	24,3	23,5				-
5/8"	-10	33,0 x 39,0	ST		27,5	28,1	27,7				-
3/4"	-12	37,0 x 44,0	ST		30,9	31,9	31,1				-
1"	-16	46,0 x 45,7	ST		38,5	40,0	39,1				-
1.1/4"	-20	59,0 x 66,5	ST			50,0	48,7				-
1.1/2"	-24	67,0 x 67,0	ST			59,0	56,2				-
2"	-32	80,0 x 75,0	ST			72,3	69,0				-
1/4"	6651228-04	20,0 x 34,5	ST					17,2			-
3/8"	-06	25,0 x 35,0	ST					22,0			-
1/2"	-08	28,0 x 37,0	ST					24,6			-
5/8"	-10	32,0 x 40,0	ST					28,5			-
3/4"	-12	36,0 x 45,0	ST					1) 31,9			35,0
1"	-16	45,0 x 50,0	ST					1) 39,3			39,0
1.1/4"	-20	55,0 x 70,0	ST		49,7						-
1.1/2"	-24	60,0 x 70,0	ST		54,5						-
2"	-32	76,0 x 80,0	ST		70,5						-
1/4"	6651224-04	22,0 x 34,5	ST						1) 19,5		25,0
3/8"	-06	26,0 x 35,0	ST						1) 23,2		25,0
1/2"	-08	30,0 x 37,0	ST						1) 26,5		27,0
5/8"	-10	33,0 x 40,0	ST						1) 29,5		28,0
3/4"	-12	38,0 x 45,0	ST						1) 34,0		33,5
1"	-16	46,0 x 50,0	ST						1) 42,0		38,0
1.1/4"	-20	58,0 x 70,0	ST						1) 52,6		55,0
1.1/2"	-24	64,0 x 70,0	ST						1) 58,0		56,0
2"	-32	76,0 x 80,0	ST						1) 71,0		66,0
1/4"	6651323-04	22,0 x 34,5	ST	18,0							-
5/16"	-05	24,0 x 34,5	ST	20,5							-
3/8"	-06	26,0 x 35,0	ST	22,3							-
1/2"	-08	30,0 x 37,0	ST	26,0							-
5/8"	-10	33,0 x 40,0	ST	29,0							-
3/4"	-12	38,0 x 45,0	ST	33,5							-
1"	-16	46,0 x 50,0	ST	39,5							-

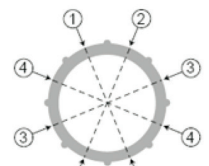
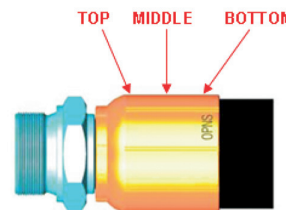
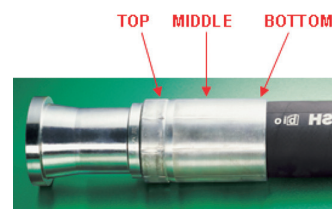
References and explanations for the crimping chart:

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.

- 1) External rubber must be removed before the ferrule is fitted.
(See skive length ext)

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

