

Thermoplastic and teflon hoses

Hose dim.	Ferrule type	Marking	Diam x lenght before crimping	Ferrule/insert	Hose Procedure	5710		5720	5730	5740	57120	57210		57220	57230	532180	5344	5380		12500	49200
						5715	5720					57215	57220					53180	12500		
3/16"	65235-03	M00820-03	14,0 x 26,4	MF/MF		11,6								8.2.21				8.2.1			8.2.1
1/4"	65236-04	M00830-04	18,0 x 29,6	MF/MF		14,1															
5/16"	-05	M00830-05	19,0 x 31,9	MF/MF		15,5	15,2														
3/8"	65235-06	M00820-06	22,0 x 32,0	MF/MF		17,8	18,0														
1/2"	-08	M00820-08	26,0 x 33,9	MF/MF		22,8	21,7														
3/16"	654240-03	BP316R7	15,0 x 26,0	ST/MF		12,9															
3/8"	-06	BP38R7V	22,0 x 32,0	ST/MF				18,7	18,4		18,4										
1/4"	65344-04		19,5 x 29,0	ST/MF														16,5			
3/8"	-06		25,0 x 35,0	ST/MF														22,1			
1/2"	-08		28,6 x 36,7	ST/MF														25,0			
3/16"	654240-03	BP316R7	15,0 x 26,0	ST/ST		13,0	13,0														
1/4"	-04	BP14R7	17,0 x 29,0	ST/ST		14,4		14,4	14,4		14,4										
5/16"	-05	BP516R7V	20,0 x 30,0	ST/ST		17,0	16,8														
3/8"	-06	BP38R7V	22,0 x 32,0	ST/ST		18,5	19,0	18,5	18,9	19,0	18,5										
1/2"	-08	BP12R7V	27,0 x 34,0	ST/ST		23,3	22,2	22,6													
3/4"	-12	BP34R7V	33,0 x 40,8	ST/ST				31,0													
1"	-16	BP1R11TV	44,0 x 50,0	ST/ST				38,2													
3/16"	66524240-03	PF-R7-DN 05	14,0 x 26,5	ST/ST		11,8	12,1	12,0													
1/4"	-04	PF-R7-DN 06	18,0 x 34,5	ST/ST		15,0	15,0	15,0													
5/16"	-05	PF-R7-DN 08	19,0 x 34,5	ST/ST		15,9	16,2	15,7													
3/8"	-06	PF-R7-DN 10	22,0 x 35,0	ST/ST		18,9	19,0	18,9													
1/2"	-08	PF-R7-DN 12	25,0 x 37,0	ST/ST		22,0	21,6	22,0													
3/4"	-12	PF-R7-DN 19	33,0 x 45,0	ST/ST		29,5		29,1													
1"	-16	PF-R7-DN 25	40,0 x 45,0	ST/ST		36,7															
1/2"	654241-08	BP12R9R	26,0 x 43,0	ST/ST					25,1												
1/4"	654242-04	BP14MT1	18,0 x 29,0	ST/ST			14,7														
1/4"	665700-04	BP114R7	17,0 x 29,0	ST/ST					14,6												
3/8"	-06	BP138R7	22,0 x 32,0	ST/ST				18,6	18,6												
1/2"	-08	BP112R9R	30,0 x 45,0	ST/ST				25,4													
3/8"	665344-06		24,7 x 35,2	ST/MF														21,0			
3/8"	6581-06		19,2 x 28,5	ST/MF																	
1/2"	-08		22,7 x 30,0	ST/MF																	
3/4"	-12		30,8 x 38,0	ST/MF																	
1"	-16		37,7 x 41,0	ST/MF																	
1.1/4"	-20		49,0 x 54,0	ST/MF																	
1.1/2"	-24		54,2 x 57,2	ST/MF																	
2"	-32		68,0 x 70,0	ST/MF																	
1/4"	65124-04	M00910-04	22,0 x 30,0	MF/MF								5) 18,0 / 16,5	5) 18,0 / 16,6	5) 18,0 / 16,5				18,6			
3/8"	-06	M00910-06	26,0 x 33,0	MF/MF								5) 23,5 / 21,3	5) 23,5 / 21,3	5) 23,5 / 21,3							
1/2"	-08	M00910-08	30,0 x 34,0	MF/MF								5) 25,8 / 24,9	5) 25,8 / 24,9	5) 25,8 / 24,9							
3/4"	65224-12	M00920-12	38,0 x 40,0	MF/MF								5) 34,5 / 32,6	5) 34,5 / 32,6	5) 34,5 / 32,6							
1"	-16	M00920-16	46,0 x 54,0	MF/MF								5) 42,5 / 39,9	5) 42,5 / 39,9	5) 42,5 / 39,9							
3/16"	65133-03	M00310-03	17,5 x 27,0	MF/MF							5) 15,0 / 13,0	5) 14,4 / 12,9									
1/4"	-04	M00310-04	19,3 x 30,0	MF/MF								5) 16,0 / 15,0									
3/8"	-06	M00310-06	24,0 x 32,0	MF/MF																	
1/2"	-08	M00310-08	28,4 x 34,0	MF/MF															20,4		
3/4"	-12	M00310-12	37,0 x 43,0	MF/MF															24,3		
1/4"	65200-04		15,8 x 26,5	ST/ST																	13,5
3/8"	-06		19,0 x 29,9	ST/ST																	16,3
1/2"	-08		24,0 x 32,1	ST/ST																	21,6
5/8"	-10		26,7 x 35,0	ST/ST																	24,4
3/4"	-12		30,6 x 40,0	ST/ST																	28,1
1"	-16		37,0 x 47,0	ST/ST																	35,8
1/8"	49222-02		7,7 x 14,0	ST/ST																	7,1
1/4"	65113-04	M00120-04	19,50 x 28,0	MF																	
5/16"	-05	M00120-05	20,0 x 28,6	MF/MF									17,5								
3/8"	-06	M00120-06	23,0 x 30,0	MF/MF									20,3	20,1							
1/2"	-08	M00120-08	26,7 x 32,0	MF/MF									23,6	23,4							
3/4"	-12	M00120-12	35,8 x 41,7	MF																	
1"	-16	M00120-16	43,0 x 47,0	MF																	

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.

- Conical crimping necessary. First step is to crimp complete ferrule down to the measurement that is mentionen first, then pull the sleeve with latch area out of the crimping head and then press the rest of the ferrule down to the second measurement. How far the sleeve/insert shall be pulled out of the crimping head need to be measured before crimping.
- Requires special die set.

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.
- Ovalisation tolerance ≤ 1/2" ± 0,1 mm.
 - Ovalisation tolerance > 1/2" ± 0,2 mm.

- Step 2.
- Tolerance crimping parameter ± 0,1 mm for all dimensions.
 - Taper crimping to be avoided.

