



Parker Hannifin Corporation
Fluid Connectors Group
Parflex Division
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PARFLEX PRODUCT BULLETIN

To: FC/*
Subj: CHECKING CRIMP & SWAGE DIMENSIONS

Section: HH
Num: 27
Date: April 4, 2005

TECHNICAL ALERT

We continue to receive many field returns where the crimp or swage dimensions were not held to specified tolerances. It is the responsibility of the assembler to accurately measure crimp and swage dimensions to ensure that they conform to Parflex published standards. Failure to do so can result in poor assembly performance, which is potentially dangerous. Improper crimp or swage dimensions may be the result of using the wrong die, a worn die, the wrong die ring, a worn out assembly machine or (die) bowl, or a machine that is not operating properly. Checking crimp or swage dimensions will greatly minimize the possibility of fitting leakage, fitting blow-off and other assembly-related problems.

Carefully check crimp and swage dimensions each time you set up to fabricate hose assemblies:

- Tolerances are published in the Parflex 4660 Catalog. To check a crimp or swage diameter, refer to the Parflex 4660 Catalog. If a catalog is not available, request one from your local Parker salesperson, or call Catalog Services @ 440-205-7799; they will be able to provide one.
- You can also access the crimp diameters on-line through the Crimp Source program at <http://www.parker.com/dayco/csonline/crimpsource.asp>.
- The Parflex Division also publishes a crimp and swage specification chart for each piece of assembly equipment that is used to fabricate Parflex hose assemblies. If you need a crimp or swage dimensional chart for your given assembly machine, contact the Parflex Division.

Remember . . . checking dimensions will reduce the risk of injury, eliminate downtime and maximize the reliability of any hose assembly. Be sure that the dimensions are correct – check them frequently!

Additional crimp/swage procedures and practices to apply (refer to Parflex Catalog 4660, “Technical & Design Information/Hose Assembly & Crimping” section):

- Always use proper hose insertion depth (also available via Crimp Source)
- Always ensure that the hose is pushed into the fitting all the way to the proper depth
- Always ensure that crimp and swage dies are properly lubricated
- When seating the fitting onto the step/ledge of the Parkalign die, do not pull down too hard; this may cause the fitting to slip. Always check prior to crimping that the fitting has not slipped.

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Product Sales Manager

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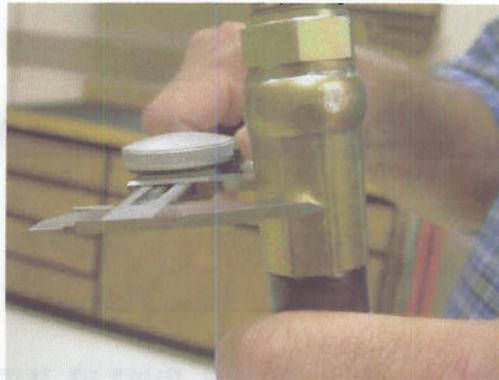
Steve Johns
Product Sales Manager

REMEMBER

MEASURE FOUR SEPARATE CRIMP FLATS IN EACH SECTION OF THE COMPLETED CRIMP:
TOP – MIDDLE - BOTTOM



TOP of crimped area



MIDDLE of crimped area



BOTTOM of crimped area

CRIMP ACCEPTANCE RULES PER PARFLEX STANDARDS

- The recorded crimp diameters are the min / max of any readings taken on the fitting
- The difference between the averages of the top crimp and bottom crimp cannot exceed .010"
- No single measurement outside the specification is permissible

It is the responsibility of the person attaching the fittings to verify that each and every crimp falls within the specifications published in the Parflex 4660 catalog and/or CrimpSource OnLine