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Crimp Specification

Polyflex Europe Division

Tuesday, June 25, 2019

*All units in inches

Hose Style: **550H** Coupling Style: **56** Crimper: **Karrykrimp 1** Hose Description: **Polyflex Thermoplastic Hose**

Size	Crimper Die		Die Ring	Crimp Diameter	Crimp Length	Hose Insertion	Drawing
Parker Parflex Crimp Dies							
-3	80C-P03		82C-R01	0.490	FULL	5/8	PKFull
-4	80C-P04		82C-R01	0.570	FULL	15/16	PKFull
-5	80C-P05		82C-R01	0.630	FULL	1	PKFull
-6	80C-P06		82C-R01	0.685	FULL	1	PKFull
-8	80C-P08		82C-R01	0.850	FULL	1-1/8	PKFull
-10	80C-P10H		82C-R01	1.010	FULL	1-1/8	PKFull
-12	80C-P12		82C-R01	1.110	FULL	1-3/8	PKFull
-16	80C-P16		82C-R01	1.355	FULL	1-7/8	PKFull

Comments

PFDE: Pertains to steel & stainless steel fittings. Refer to Polyflex Catalog 4460 for hose assembly instructions.

PFDE: Reference Parker Fluid Connector Group (FCG) Safety Bulletin 4400-B.1 (www.parker.com/safety).

PFDE: Crimp diameter is measured minimum of three places, 45 degrees apart, at the top, then middle and bottom of the crimp.

PFDE: Crimp acceptance is based on the center measurement average with a maximum taper of 0,25mm (0.010") between the top and bottom crimp averages.

PFDE: Crimp diameter tolerance on all Crimpers is 0,25mm (± 0.010 ”).

PFDE: Align measurement caliper or micrometer on the center of crimp impressions avoiding the crimp ribs.

PKFull

