

Adjustable Crimper

V4/V6 Series

Hose I.D.				Hose type	Fitting series	Skiving length		Crimping diameter ± 0.2 mm	Shell ovalization	Shell conicity	Die set	Length min.
DN	Inch	Size	mm			internal ± 1 mm	external ± 1 mm					
16	5/8	-10	15.9	H31 - H31ST - H31TC	V4	14.5	50.0	30.40	0.2	0.6	PB239-28	70
16	5/8	-10	15.9	R42 - R42ST - R42TC	V4	14.5	50.0	30.40 *)	0.2	0.6	PB239-28	70
20	3/4	-12	19.1	H29 - H29RH - H29ST - H29TC	V4	15.0	52.0	33.90 *)	0.2	0.6	PB239-32	70
20	3/4	-12	19.1	H31 - H31ST - H31TC - R35 - R35TC	V4	15.0	52.0	33.90	0.2	0.6	PB239-32	70
20	3/4	-12	19.1	R42 - R42ST - R42TC	V4	15.0	52.0	33.90 *)	0.2	0.6	PB239-32	70
25	1	-16	25.4	H29 - H29RH - H29ST - H29TC R42 - R42ST - R42TC	V4	17.0	65.0	42.50 *)	0.2	0.6	PB239L-40	85
25	1	-16	25.4	H31 - H31ST - H31TC	V4	17.0	65.0	41.60	0.2	0.6	PB239L-40	85
25	1	-16	25.4	R35 - R35TC	V4	17.0	65.0	42.50	0.2	0.6	PB239L-40	85
32	1.1/4	-20	31.8	H29 - H29RH - H29ST - H29TC	V4	21.5	74.0	50.20 *)	0.3	1.0	PB239L-50	100
32	1.1/4	-20	31.8	H31 - H31ST - H31TC	V4	21.5	74.0	51.00	0.3	1.0	PB239L-50	100
32	1.1/4	-20	31.8	R35 - R35TC	V4	21.5	74.0	50.20	0.3	1.0	PB239L-50	100
32	1.1/4	-20	31.8	R42	V6	22.0	58.0	55.50 *)	0.3	1.0	PB232L-54	100
40	1.1/2	-24	38.1	H29 - H29RH - H29ST - H29TC	V4	22.0	81.0	57.30 *)	0.3	1.0	PB232L-57	110
40	1.1/2	-24	38.1	H31 - H31ST - H31TC	V4	22.0	81.0	57.20	0.3	1.0	PB232L-57	110
40	1.1/2	-24	38.1	R35 - R35TC	V6	22.0	65.0	63.20	0.3	1.0	PB232L-62	110
40	1.1/2	-24	38.1	R42	V6	22.0	65.0	63.20 *)	0.3	1.0	PB232L-62	110
50	2	-32	50.8	H29 - H29RH - H29ST - H29TC - H31 - H31ST - H31TC	V4	29.0	85.0	73.50	0.3	1.0	PB232L-71	110
50	2	-32	50.8	R35 - R35TC	V6	22.0	75.0	77.30	0.3	1.0	PB232L-74	118
50	2	-32	50.8	R42	V6	22.0	75.0	78.00 *)	0.3	1.0	PB232L-78	118

*) Stainless Steel

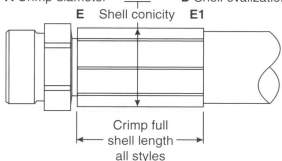
Double swaging of shells should be avoided as it detrimentally influences the functionality and reduces the service life of the hose assembly.

It must be ensured that the crimper has enough crimping force to crimp the fitting and that the swage-dies are of sufficient length to cover the entire length of the shell.

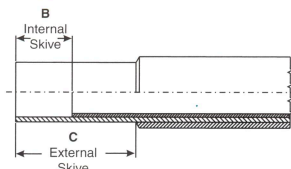
Only for use with adjustable crimpers – Minimum of 340 tons crimping force required for size -32

Crimp Information

A Crimp diameter E Shell conicity E1



Skive Information



1. Use a vernier calliper to carry out two measurements at 90° in the middle of the shell (D). The ovaling is the difference between the min and the max measured diameters.
2. Use a vernier calliper to carry out two 90° opposed measurements on the shell surfaces as indicated (E - E1). The conicity is the difference between the medium diameter value E minus the medium diameter value E1, (E1 should not be greater than E)

Dimensions shown may be changed at any time without prior notice. These crimping tables are intended as a guide. Before crimping hoses and fittings it must be ensured that you have the most recent crimping dimensions. Please contact your local Parker sales office or HPDE_Helpdesk@parker.com

Crimp Charts Status: 2010-03-23