



CRIMPING CHART

CRIMP REFERENCE

CSP-0023-04-2020-06

FlexIT 1T

EN 853 1SN - EXCEEDS SAE 100 R1AT

ASSEMBLING PARAMETERS FOR ONE PIECE J NO SKIVE FERRULE FOR BRAID HOSE

| BORE DIAMETER | | | INSERT TYPE | FERRULE CODE | Crimping Diameter | | Internal Skive Length | | External Skive Length | | Crimping Type |
|---------------|------|------|-------------|--------------|-------------------|--------|-----------------------|--------|-----------------------|--------|---------------|
| | | | | | mm | inch | mm | inch | mm | inch | |
| DN | inch | size | | | 0 | 0 | ± 0,5 | ± 0,02 | ± 0,5 | ± 0,02 | |
| | | | | | -0,2 | -0,008 | | | | | |

| | | | | | | | | | | |
|----|--------|----|----|------|-------|----|----|----|----|------|
| 10 | 3/8" | 06 | 2J | 21,7 | 0,854 | NO | -- | NO | -- | FLAT |
| 12 | 1/2" | 08 | | 24,4 | 0,961 | NO | -- | NO | -- | FLAT |
| 16 | 5/8" | 10 | | 28,3 | 1,114 | NO | -- | NO | -- | FLAT |
| 19 | 3/4" | 12 | | 33,0 | 1,299 | NO | -- | NO | -- | FLAT |
| 25 | 1" | 16 | | 41,3 | 1,626 | NO | -- | NO | -- | FLAT |
| 31 | 1.1/4" | 20 | J | 49,5 | 1,949 | NO | -- | NO | -- | FLAT |
| 38 | 1.1/2" | 24 | | 60,0 | 2,362 | NO | -- | NO | -- | FLAT |
| 51 | 2" | 32 | | 70,6 | 2,780 | NO | -- | NO | -- | FLAT |
| 63 | 2.1/2" | 40 | | 81,8 | 3,220 | NO | -- | NO | -- | FLAT |
| 76 | 3" | 48 | | 93,8 | 3,693 | NO | -- | NO | -- | FLAT |

| DATE | REV |
|-----------|-----|
| 12/6/2020 | 04 |

DISCLAIMER: The above crimping diameters and assembling instructions are strictly related to the nominated Intertraco hydraulic hoses and fittings