



CRIMPING CHART

CRIMP REFERENCE

CSP-0089-00-2015-06

FlexIT HT1

EN 853 1SN - EXCEEDS SAE 100 R1AT
HIGH TEMPERATURE HOSE

ASSEMBLING PARAMETERS FOR PIECE K 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 -0.2 | 0 -0.008 | ± 0.5 | ± 0.02 | ± 0.5 | ± 0.02 | |

| 6 | 1/4" | 04 | K | 16.8 | 0.661 | NO | -- | NO | -- | FLAT |
|----|-------|----|----------|------|-------|----|----|----|----|------|
| 8 | 5/16" | 05 | | 18.5 | 0.728 | NO | -- | NO | -- | FLAT |
| 10 | 3/8" | 06 | | 20.9 | 0.823 | NO | -- | NO | -- | FLAT |
| 12 | 1/2" | 08 | | 24.2 | 0.953 | NO | -- | NO | -- | FLAT |
| 16 | 5/8" | 10 | | 27.9 | 1.098 | NO | -- | NO | -- | FLAT |
| 19 | 3/4" | 12 | | 31.7 | 1.248 | NO | -- | NO | -- | FLAT |
| 25 | 1" | 16 | | 40.4 | 1.591 | NO | -- | NO | -- | FLAT |

| | | | | | | | |
|----------|------------------------------------|----------|------------------------------------|------|-----------|-----|----|
| RELEASED | M. GANDOLFI Design Engineer | APPROVED | U. BONINI Quality Assurance | DATE | 18/6/2015 | REV | 00 |
|----------|------------------------------------|----------|------------------------------------|------|-----------|-----|----|

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