



Stainless Steel

***Two Piece Fittings
for No-Skive Compact Hose***

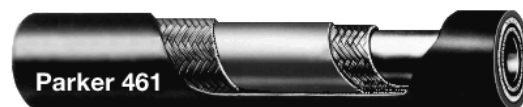
*Bulletin 4480-B23/UK
June 2003*





461 - *No-Skive* Hose

Compact 2-braid exceeds EN 857 2SC



Hose construction:

Synthetic rubber tube; two braids of high tensile steel wire reinforcement separated by a synthetic rubber layer; oil, weather and abrasion resistant synthetic black rubber cover.

Temperature range: -40 C to +100 C
 Exceptions: Air max. +70 C
 Water* max. +85 C

Applications:

High pressure service with petroleum based hydraulic fluids, water*-glycol and water*-oil emulsion hydraulic fluids, grease, lubricants, crude and fuel oils, air and water. Pin prick cover for air or gas applications above 17 bar (250psi)

Crimped fittings: 46 series, two piece

Part Number	Hose-I.D.				Hose O.D. mm	Pressure rating				Min. bend radius mm	Weight kg/m
	DN	Inch	Size	mm		max. dynamic working pressure	Min. burst pressure				
						MPa	psi	MPa	psi		
461-4	6	1/4	-4	6,3	13,4	42,5	6 160	170,0	24 640	75	0,30
461-5	8	5/16	-5	7,9	15,0	40,0	5 800	160,0	23 200	85	0,35
461-6	10	3/8	-6	9,5	17,2	35,0	5 075	140,0	20 300	90	0,42
461-8	12	1/2	-8	12,7	20,4	31,0	4 495	124,0	17 980	130	0,52
461-10	16	5/8	-10	15,9	23,9	28,0	4 060	112,0	16 240	160	0,66
461-12	20	3/4	-12	19,0	27,7	28,0	4 060	112,0	16 240	195	0,86
461-16	25	1	-16	25,4	35,4	21,0	3 045	84,0	12 180	250	1,17

462 - *No-Skive* Hose

Compact 2-braid exceeds EN 857 2SC



Hose construction:

Nitrile rubber tube; two braids of high tensile steel wire reinforcement separated by a synthetic rubber layer; oil, weather and abrasion resistant synthetic black rubber cover.

Temperature range: -40 C to +100 C
 Exceptions: Air max. +70 C
 Water* max. +85 C

Applications:

High pressure service with petroleum based hydraulic fluids, **biologically degradable oils** (see chemical resistance table in catalogue 4400), water*-glycol and water*-oil emulsion hydraulic fluids, grease, lubricants, crude and fuel oils, air, water. Pin prick cover for air or gas applications above 17 bar (250 psi).

Crimped fittings: 46 series, two piece

Part Number	Hose-I.D.				Hose O.D. mm	Pressure rating				Min. bend radius mm	Weight kg/m
	DN	Inch	Size	mm		max. dynamic working pressure	Min. burst pressure				
						MPa	psi	MPa	psi		
462-4	6	1/4	-4	6,3	13,4	42,5	6 160	170,0	24 640	75	0,30
462-5	8	5/16	-5	7,9	15,0	40,0	5 800	160,0	23 200	85	0,35
462-6	10	3/8	-6	9,5	17,2	35,0	5 075	140,0	20 300	90	0,42
462-8	12	1/2	-8	12,7	20,4	31,0	4 495	124,0	17 980	130	0,52
462-10	16	5/8	-10	15,9	23,9	28,0	4 060	112,0	16 240	160	0,66
462-12	20	3/4	-12	19,0	27,7	28,0	4 060	112,0	16 240	195	0,86
462-16	25	1	-16	25,4	35,4	21,0	3 045	84,0	12 180	250	1,17

Stainless Steel – Two Piece Fittings for *No-Skive* Compact Hose

Hose 491, 492

491 - *No-Skive* Compact Hose

1-Layer, exceeds EN 857 1SC



Hose construction:

Synthetic rubber tube; one braid of high tensile steel wire reinforcement; oil, weather and abrasion resistant black synthetic rubber cover.

Temperature range: -40 C to +100 C

Exceptions: Air max. +70 C

Water* max. +85 C

Applications:

High pressure service with petroleum based hydraulic fluids, water*-glycol and water*-oil emulsion hydraulic fluids, grease, lubricants, crude and fuel oils, air and water. Pin prick cover for air or gas applications above 17 bar (250 psi).

Crimped fittings: 46 series, two piece

XXXXX-VV-VV Part Number	 Hose-I.D.				 Hose O.D. mm	Pressure rating				 Min. bend radius mm	 Weight kg/m
	DN	Inch	Size	mm	 max. dynamic working pressure	 Min. burst pressure		MPa	psi	MPa	psi
						MPa	psi				
491-4	6	1/4	-4	6,3	11,5	28,0	4060	112,0	16240	75	0,18
491-5	8	5/16	-5	7,9	13,6	25,0	3625	100,0	14500	85	0,21
491-6	10	3/8	-6	9,5	15,5	22,5	3260	90,0	13050	90	0,25
491-8	12	1/2	-8	12,7	18,9	19,0	2755	76,0	11020	130	0,33
491-10	16	5/8	-10	15,9	22,2	15,0	2175	60,0	8700	150	0,41
491-12	20	3/4	-12	19,0	26,0	15,0	2175	60,0	8700	180	0,56
491-16	25	1	-16	25,4	33,3	11,0	1595	44,0	6380	230	0,75

492 - *No-Skive* Compact Hose

1-Layer, exceeds EN 857 1SC



Hose construction:

Nitrile rubber tube; one braid of high tensile steel wire reinforcement; oil, weather and abrasion resistant black synthetic rubber cover.

Temperature range: -40 C to +100 C

Exceptions: Air max. +70 C

Water* max. +85 C

Applications:

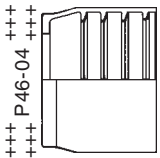
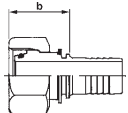
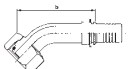
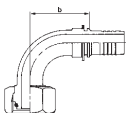
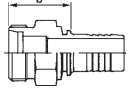
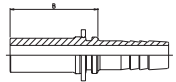
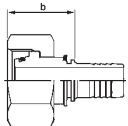
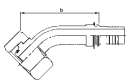
High pressure service with petroleum based hydraulic fluids, **biologically degradable oils** (see chemical resistance table in catalogue 4400), water*-glycol and water*-oil emulsion hydraulic fluids, grease, lubricants, crude and fuel oils, air, water. Pin prick cover for air or gas applications above 17 bar (250 psi).

Crimped fittings: 46 series, two piece

Part Number	 Hose-I.D.				 Hose O.D. mm	Pressure rating				 Min. bend radius mm	 Weight kg/m
	DN	Inch	Size	mm		 max. dynamic working pressure		 Min. burst pressure			
						MPa	psi	MPa	psi		
492-4	6	1/4	-4	6,3	11,5	28,0	4060	112,0	16240	75	0,18
492-5	8	5/16	-5	7,9	13,6	25,0	3625	100,0	14500	85	0,21
492-6	10	3/8	-6	9,5	15,5	22,5	3260	90,0	13050	90	0,25
492-8	12	1/2	-8	12,7	18,9	19,0	2755	76,0	11020	130	0,33
492-10	16	5/8	-10	15,9	22,2	15,0	2175	60,0	8700	150	0,41
492-12	20	3/4	-12	19,0	26,0	15,0	2175	60,0	8700	180	0,56
492-16	25	1	-16	25.4	33.3	11.0	1595	44.0	6380	230	0.75

Stainless Steel – Two Piece Fittings for *No-Skive* Compact Hose

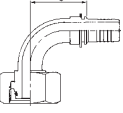
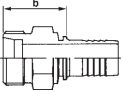
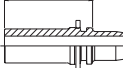
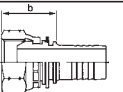
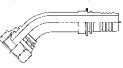
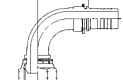
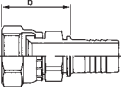
Fitting Chart

	DN	6	8	10	12	16	20	25
	inch	1/4	5/16	3/8	1/2	5/8	3/4	1
	-size	-4	-5	-6	-8	-10	-12	-16
	mm	6,3	7,9	9,5	12,7	15,9	19,1	25,4
	10046 Crimp shell for hoses 461 / 462 / 491 / 492	10046-4C	10046-5C	10046-6C	10046-8C	10046-10C	10046-12C	10046-16C
	CA DIN 20 078 N Light Series Metric Swivel Female	M12x1,5 ø6 b=23 KCA47-6-4C		M16x1,5 ø10 b=24 KCA47-10-6C				M36x2 ø28 b=33 KCA47-28-16C
		M14x1,5 ø8 b=22 KCA47-8-4C	M16x1,5 ø10 b=22 KCA47-10-5C	M18x1,5 ø12 b=23 KCA47-12-6C	M22x1,5 ø15 b=50 KCA47-15-8C	M26x1,5 ø18 b=26 KCA47-18-10C	M30x2 ø22 b=30 KCA47-22-12C	
	CE DIN 20 078 N Light Series Metric Swivel Female 45° Elbow	M12x1,5 ø6 b=54 KCE47-6-4C		M16x1,5 ø10 b=54 KCE47-10-6C				M36x2 ø28 b=76 KCE47-28-16C
		M14x1,5 ø8 b=44 KCE47-8-4C	M16x1,5 ø10 b=44 KCE47-10-5C	M18x1,5 ø12 b=57 KCE47-12-6C	M22x1,5 ø15 b=62 KCE47-15-8C	M26x1,5 ø18 b=68 KCE47-18-10C	M30x2 ø22 b=58 KCE47-22-12C	
	CF DIN 20 078 N Light Series Metric Swivel Female 90° Elbow	M12x1,5 ø6 b=33 KCF47-6-4C		M16x1,5 ø10 b=32 KCF47-10-6C				M36x2 ø28 b=70 KCF47-28-16C
		M14x1,5 ø8 b=26 KCF47-8-4C	M16x1,5 ø10 b=37 KCF47-10-5C	M18x1,5 ø12 b=35 KCF47-12-6C	M22x1,5 ø18 b=37 KCF47-15-8C	M26x1,5 ø18 b=41 KCF47-18-10C	M30x2 ø22 b=54 KCF47-22-12C	
	DO DIN 20 078 D Light Series Male Stud	M12x1,5 ø6 b=20 KD047-6-4C		M16x1,5 ø10 b=24 KD047-10-6C				M36x2 ø28 b=35 KD047-28-16C
		M14x1,5 ø8 b=22 KD047-8-4C	M16x1,5 ø10 b=24 KD047-10-5C	M18x1,5 ø12 b=24 KD047-12-6C	M22x1,5 ø15 b=26 KD047-15-8C	M26x1,5 ø18 b=30 KD047-18-10C	M30x2 ø22 b=33 KD047-22-12C	
	1D Metric Standpipe Light Series	ø6 b=30 K1D47-6-4C		ø10 b=31 K1D47-10-6C				ø28 b=39 K1D47-28-16C
		ø8 b=30 K1D47-8-4C	ø10 b=31 K1D47-10-5C	ø12 b=31 K1D47-12-6C	ø15 b=33 K1D47-15-8C	ø18 b=34 K1D47-18-10C	ø22 b=36 K1D47-22-12C	
	C9 DIN 20 078 P Heavy Series Metric Swivel Female	M14x1,5 ø6 b=26 KC947-6-4C					M30x2 ø20 b=30 KC947-20-12C	
		M16x1,5 ø8 b=23 KC947-8-4C	M18x1,5 ø10 b=22 KC947-10-5C	M20x1,5 ø12 b=25 KC947-12-6C	M24x1,5 ø16 b=28 KC947-16-8C	M30x2 ø20 b=28 KC947-20-10C	M36x2 ø25 b=35 KC947-25-12C	M42x2 ø30 b=38 KC947-30-16C
		M18x1,5 ø10 b=22 KC947-10-4C	M20x1,5 ø12 b=24 KC947-12-5C	M22x1,5 ø14 b=24 KCE47-14-6C				
	OC DIN 20 078 P Heavy Series Metric Swivel Female 45° Elbow	M14x1,5 ø6 b=37 K0C47-6-4C					M30x2 ø20 b=60 K0C47-20-12C	
		M16x1,5 ø8 b=35 K0C47-8-4C	M18x1,5 ø10 b=38 K0C47-10-5C	M20x1,5 ø12 b=58 K0C47-12-6C	M24x1,5 ø16 b=65 K0C47-16-8C	M30x2 ø20 b=69 K0C47-20-10C	M36x2 ø25 b=60 K0C47-25-12C	M42x2 ø30 b=79 K0C47-30-16C
		M18x1,5 ø10 b=44 K0C47-10-4C	M20x1,5 ø12 b=47 K0C47-12-5C	M22x1,5 ø14 b=58 K0C47-14-6C				

Only items set in bold in the current price list can be supplied ex stock. All soft seal end-configurations are supplied with FKM O-rings.

Stainless Steel – Two Piece Fittings for *No-Skive* Compact Hose

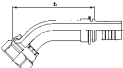
Fitting Chart

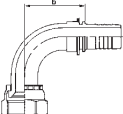
		DN inch -size mm	6 1/4 -4 6,3	8 5/16 -5 7,9	10 3/8 -6 9,5	12 1/2 -8 12,7	16 5/8 -10 15,9	20 3/4 -12 19,1	25 1 -16 25,4
	1C DIN 20 078 P Heavy Series Metric Swivel Female 90° Elbow	M14x1,5 ø6 b=38 K1C47-6-4C						M30x2 ø20 b=54 K1C47-20-12C	
		M16x1,5 ø8 b=26 K1C47-8-4C	M18x1,5 ø10 b=37 K1C47-10-5C	M20x1,5 ø12 b=35 K1C47-12-6C	M24x1,5 ø16 b=37 K1C47-16-8C	M30x2 ø20 b=40 K1C47-20-10C	M36x2 ø25 b=54 K1C47-25-12C	M42x2 ø30 b=68 K1C47-30-16C	
		M18x1,5 ø10 b=26 K1C47-10-4C	M20x1,5 ø12 b=36 K1C47-12-5C	M22x1,5 ø14 b=35 K1C47-14-6C					
	D2 DIN 20 078 E Heavy Series Metric Male Stud	M14x1,5 ø6 b=24 KD247-6-4C						M30x2 ø20 b=35 KD247-20-12C	ø25 b=39 KD247-25-16C
		M16x1,5 ø8 b=24 KD247-8-4C			M24x1,5 ø16 b=29 KD247-16-8C	M30x2 ø20 b=32 KD247-20-10C	M36x2 ø25 b=38 KD247-25-12C	M42x2 ø30 b=42 KD247-30-16C	
		M18x1,5 ø10 b=26 KD247-10-4C	M20x1,5 ø12 b=26 KD247-12-5C	M22x1,5 ø14 b=28 KD247-14-6C					
	3D Heavy Series Metric Standpipe				ø16 b=38 K3D47-16-8C	ø20 b=44 K3D47-20-10C	ø25 b=48 K3D47-25-12C	ø30 b=53 K3D47-30-16C	
		ø10 b=34 K3D47-10-4C	ø12 b=34 K3D47-12-5C	ø14 b=37 K3D47-14-6C					
	92 BSP Swivel Female	1/4x19 b=19 K9247-4-4C	3/8x19 b=20 K9247-6-5C	3/8x19 b=21 K9247-6-6C	1/2x14 b=22 K9247-8-8C	5/8x14 b=21 K9247-10-10C	3/4x14 b=23 K9247-12-12C	1x11 b=25 K9247-16-16C	
	B1 BSP Swivel Female 45° Elbow	1/4x19 b=44 KB147-4-4C	3/8x19 b=36 KB147-6-5C	3/8x19 b=58 KB147-6-6C	1/2x14 b=64 KB147-8-8C	5/8x14 b=53 KB147-10-10C	3/4x14 b=57 KB147-12-12C	1x11 b=76 KB147-16-16C	
	B2 BSP Swivel Female 90° Elbow	1/4x19 b=26 KB247-4-4C	3/8x19 b=28 KB247-6-5C	3/8x19 b=38 KB247-6-6C	1/2x14 b=40 KB247-8-8C	5/8x14 b=45 KB247-10-10C	3/4x14 b=54 KB247-12-12C	1x11 b=75 KB247-16-16C	
	D9 BSP Male Stud (DIN 3852 - Form A)	1/4x19 b=27 KD947-4-4C	3/8x19 b=31 KD947-6-5C	3/8x19 b=31 KD947-6-6C	1/2x14 b=33 KD947-8-8C		3/4x14 b=33 KD947-12-12C	1x11 b=42 KD947-16-16C	
				1/2x14 b=33 KD947-8-6C		3/4x14 b=37 KD947-12-10C			
	01 NPTF Male Pipe	1/4x18 b=29 K0147-4-4C	3/8x18 b=31 K0147-6-5C	3/8x18 b=31 K0147-6-6C	1/2x14 b=38 K0147-8-8C		3/4x14 b=34 K0147-12-12C	1x11-1/2 b=45 K0147-16-16C	
	03 JIC 37° Male	7/16x20 b=29 K0347-4-4C	9/16x18 b=31 K0347-6-5C	9/16x18 b=31 K0347-6-6C	3/4x16 b=34 K0347-8-8C	7/8x14 b=38 K0347-10-10C	1-1/16x12 b=42 K0347-12-12C	1-5/16x12 b=46 K0347-16-16C	
	06/68 Swivel Female 06 JIC - 37° 68 JIC - 37° and SAE - 45°	7/16x20 b=29 K6847-4-4C		9/16x18 b=30 K0647-6-6C	3/4x16 b=32 K6847-8-8C	7/8x14 b=35 K6847-10-10C	1-1/16x12 b=41 K0647-12-12C	1-5/16x12 b=46 K0647-16-16C	
			9/16x18 b=31 K0647-6-5C	3/4x16 b=34 K6847-8-6C	7/8x14 b=38 K6847-10-8C	1-1/16x12 b=39 K0647-12-10C			
		9/16x18 b=31 K0647-6-4C							

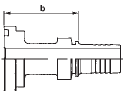
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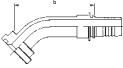
Fitting Chart

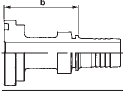
		6	8	10	12	16	20	25
DN		1/4	5/16	3/8	1/2	5/8	3/4	1
inch		1/4	5/16	3/8	1/2	5/8	3/4	1
-size		-4	-5	-6	-8	-10	-12	-16
mm		6,3	7,9	9,5	12,7	15,9	19,1	25,4

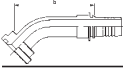
	37/3V Swivel Female - 45° Elbow 37 JIC - 37° 3V JIC - 37° and SAE - 45°	7/16x20 b=29 K3V47-4-4C	1/2x20 b=29 K3V47-5-5C	9/16x18 b=39 K3747-6-6C	3/4x16 b=38 K3V47-8-8C	7/8x14 b=44 K3V47-10-10C	1-1/16x12 b=57 K3747-12-12C	1-5/16x12 b=64 K3747-16-16C
			9/16x18 b=34 K3747-6-5C	3/4x16 b=44 K3V47-8-6C	7/8x14 b=46 K3V47-10-8C	1-1/16x12 b=76 K3747-12-10C		
		9/16x18 b=39 K3747-6-4C						

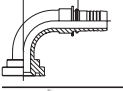
	39/3W Swivel Female 90° Elbow (Short) 39 JIC - 37° 3W JIC - 37° and SAE 45°	7/16x20 b=24 K3W47-4-4C	1/2x20 b=25 K3W47-5-5C	9/16x18 b=25 K3947-6-6C	3/4x16 b=30 K3W47-8-8C	7/8x14 b=39 K3W47-10-10C	1-1/16x12 b=48 K3947-12-12C	1-5/16x12 b=58 K3947-16-16C
			9/16x18 b=28 K3947-6-5C	3/4x16 b=36 K3W47-8-6C	7/8x14 b=39 K3W47-10-8C	1-1/16x12 b=45 K3947-12-10C		
		9/16x18 b=27 K3947-6-4C						

	15 SAE Code 61 Flange Standard Series DIN 20 078 R				1/2 b=51 K1547-8-8C	3/4 b=30 K1547-12-10C	3/4 b=56 K1547-12-12C	1 b=54 K1547-16-16C
							1 b=51 K1547-16-12C	1-1/4 b=74 K1547-20-16C

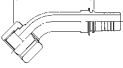
	17 SAE Code 61 Flange 45° Elbow DIN 20 078 R				1/2 b=48 K1747-8-8C	3/4 b=50 K1747-12-10C	3/4 b=62 K1747-12-12C	1 b=74 K1747-16-16C
							1 b=57 K1747-16-12C	1-1/4 b=63 K1747-20-16C

	6A SAE Flange DIN 20 078 S Heavy Series				1/2 b=52 K6A47-8-8C		3/4 b=70 K6A47-12-12C	1 b=82 K6A47-16-16C

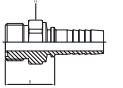
	6F SAE Flange 45° Elbow Heavy Series DIN 20 078 S				1/2 b=48 K6F47-8-8C		3/4 b=62 K6F47-12-12C	1 b=72 K6F47-16-16C

	6N SAE Flange 90° Elbow Heavy Series DIN 20 078 S				1/2 b=43 K6N47-8-8C	3/4 b=49 K6N47-12-10C	3/4 b=50 K6N47-12-12C	1 b=68 K6N47-16-16C

	JC ORFS Swivel Female (Short)	9/16x18 b=22 KJC47-4-4C	11/16x16 b=23 KJC47-6-5C	11/16x16 b=21 KJC47-6-6C	13/16x16 b=22 KJC47-8-8C	1x14 b=26 KJC47-10-10C	1-3/16x12 b=29 KJC47-12-12C	1-7/16x12 b=36 KJC47-16-16C

	J7 ORFS Swivel Female 45° Elbow	9/16x18 b=39 KJ747-4-4C	11/16x16 b=32 KJ747-6-5C	11/16x16 b=31 KJ747-6-6C	13/16x16 b=38 KJ747-8-8C	1x14 b=42 KJ747-10-10C	1-3/16x12 b=53 KJ747-12-12C	1-7/16x12 b=70 KJ747-16-16C

	J9 ORFS Swivel Female 90° Elbow	9/16x18 b=24 KJ947-4-4C	11/16x16 b=28 KJ947-6-5C	11/16x16 b=29 KJ947-6-6C	13/16x16 b=31 KJ947-8-8C	1x14 b=40 KJ947-10-10C	1-3/16x12 b=51 KJ947-12-12C	1-7/16x12 b=62 KJ947-16-16C

	JM ORFS Male	9/16x18 b=22 KJM47-4-4C	11/16x16 b=26 KJM47-6-5C	11/16x16 b=24 KJM47-6-6C	13/16x16 b=27 KJM47-8-8C	1x14 b=32 KJM47-10-10C	1-3/16x12 b=35 KJM47-12-12C	1-7/16x12 b=37 KJM47-16-16C

Only items set in bold in the current price list can be supplied ex stock. All soft seal end-configurations are supplied with FKM O-rings.

Polykrimp® 2 Crimping Press

– TH8-520 - Basic model with manual control

– TH8-520.E - Machine with electronic control „UNIMATICONTROL E“

This powerful adjustable crimper is ideal for small and middle sized serial production. Model TH 8-520.E is more suitable for large serial production.



Technical Details:

Electrical power:	400 V / 50 Hz / 3 Ph / 3,0 kW
Dimensions:	W = 750 mm D = 530 mm H = 670 mm
Weight:	180 kg (without oil) 220 kg (incl. oil)
Tank capacity:	40 l Hydraulic oil HLP46
Pressing force:	max. 2400 kN (240t)
Pressing area:	max. 110 mm Durchmesser
Die Set Length:	l = 110 mm
Control system:	manual TH8-520 electronical TH8-520E
Sound Pressure Level:	65 dB (A)

Part-No.:	TH8-520 TH8-520E
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For the use of die sets PB 239 diameter 14 until PB 239/50 please add the special intermediate die set 232.904. Please order this die set separately. Please use the die set series PB 232 without special intermediate die set.

Additional Options:

(please find in our operational instruction 4480-T13-UK)	
– Mirror Set	SHS 220/290
– Depth Stop (manual)	TA 290
– Depth Stop (automatically)	TA 290 A
– Foot Pedal	FU-HMX

* select the appropriate die sets from the crimping chart on page 8

Procedures for Crimping

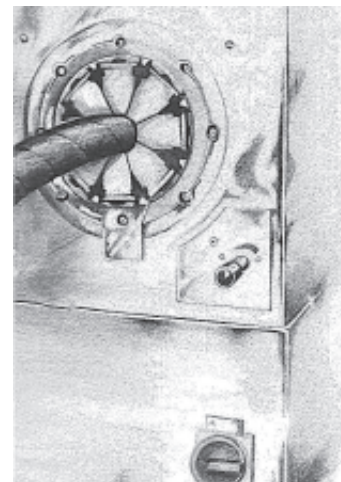
The connection of hydraulic components (hose and fitting) is determined by the fitting type: crimp fitting or reusable fitting.

Crimping is the safest, fastest and most common method of producing a hose assembly. The Parker crimping systems ensure a precise, leak-free and tear-resistant connection of hose and fitting. Due to the accurate adjustment of the crimping diameter, it is possible to crimp two-piece fittings with freely adjustable crimping tools.

In the crimping process it is essential that the hose, the fitting and the crimping tool (crimping dies) match precisely.

With the Polycrimp machine, the shell, nipple and hose are crimped in one smooth procedure.

A depth stop with automatic function ensures the safe positioning of the fitting. This guarantees a perfect crimping result for hydraulic hose assemblies.



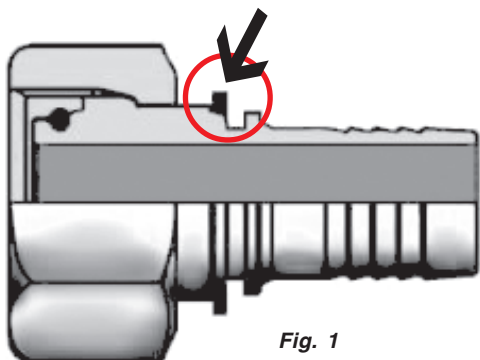


Fig. 1

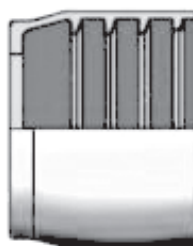


Fig. 2



Fig. 3

Select the matching components:

e.g. nipple KCA47-15-8C
shell 10046-8C
hose 461-8

Make sure that the hose ends are cut perpendicularly.



Fig. 4

Push the shell on the hose. The cut end of the hose must be clearly visible (Fig. 2 - 4).

Check the correct position of the plastic ring in the groove located in the middle of the nipple. Push the nipple down into the hose until it reaches the stop on the lower groove (Fig. 5) (Use Hoze-Oil, if required).

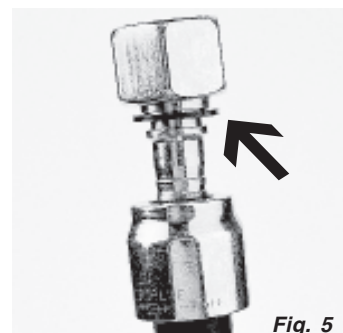


Fig. 5

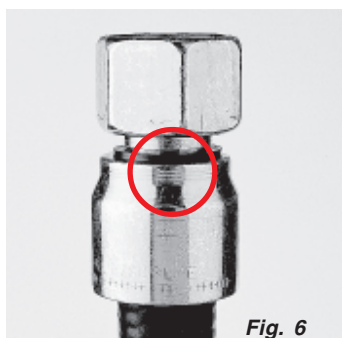


Fig. 6

The plastic ring must be placed directly on the shell. (Fig. 6, 7).

After crimping, the shell must be located precisely in the lower groove of the nipple. (Fig. 7)

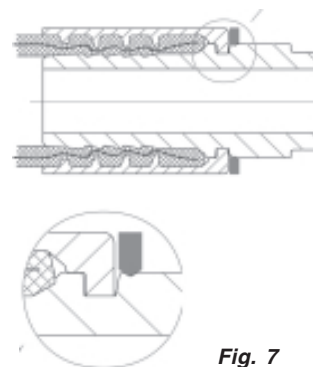


Fig. 7

Attention:

Two-piece fittings must not be crimped on Parkrimp crimpers but only with freely adjustable crimpers.

- Select the appropriate crimping dies using the crimping diameter chart (see page 8).
- Insert the dies into the crimping press and adjust the crimping diameter.
- Place the pre-assembled hose assembly into the crimper and perform the crimping procedure.
- Please take note of the operating instructions of the hose press.

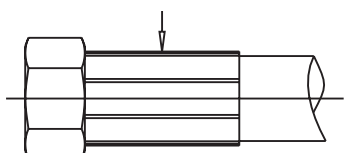


Fig. 8

Checking for the correct crimping diameter:

The crimping diameter is checked in the centre of the shell between the crimping ridges (Fig. 8, 9)

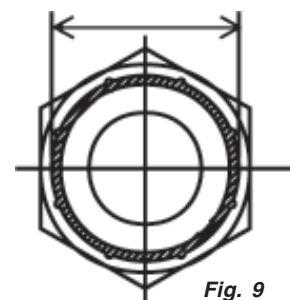


Fig. 9

Stainless Steel – Two Piece Fittings for *No-Skive* Compact Hose

Tooling selection chart

Tools

for 2 piece fittings to be used on adjustable crimpers

 Hose-I.D.				 Hose - type	 shell	Crimp tools				 Crimp diameter	
mm	DN	Size	inch			Parker 86CE-061 87CE-061 UNIFLEX HM270 HM280 HM300 HM310 HM350 HM500	UNIFLEX HM200 HM205 HM250 HM260	Parker TH8-520 TH8-520E UNIFLEX HM290 HM370	FINN-POWER FP110 FP115 FP120 FP160	min. mm	max. mm
6,3	6	-4	1/4	491-492	10046-4C	SpPB204-14	SpPB200-14	PB239-14	32-14,5	14,60	14,80
6,3	6	-4	1/4	461-462	10046-4C	SpPB986-15,5	SpPB987-15,5	PB239-14	32-16	15,60	15,80
7,9	8	-5	5/16	491-492	10046-5C	SpPB986-15,5	SpPB987-15,5	PB239-17	32-16	16,30	16,50
7,9	8	-5	5/16	461-462	10046-5C	SpPB986-17,3	SpPB987-17,3	PB239-17	32-16	17,15	17,35
9,5	10	-6	3/8	491-492	10046-6C	SpPB204-20	PB200-20	PB239-20	32-19	19,30	19,50
9,5	10	-6	3/8	461-462	10046-6C	SpPB204-20	PB200-20	PB239-20	32-19	20,40	20,60
12,7	12	-8	1/2	491-492	10046-8C	SpPB986-21,2	SpPB987-21,2	PB239-20	32-22	22,40	22,60
12,7	12	-8	1/2	461-462	10046-8C	SpPB204-24	PB200-24	PB239-24	32-22	23,40	23,60
15,9	16	-10	5/8	491-492	10046-10C	SpPB204-24	PB200-24	PB239-24	32-26	25,80	26,00
15,9	16	-10	5/8	461-462	10046-10C	SpPB986-27,2	SpPB987-27,2	PB239-24	32-26	26,80	27,00
19,1	20	-12	3/4	491-492	10046-12C	SpPB986-30	SpPB987-30	PB239-28	32-30	29,60	29,80
19,1	20	-12	3/4	461-462	10046-12C	SpPB986-30	SpPB987-30	PB239-28	32-30	30,60	30,80
25,4	25	-16	1	491-492	10046-16C	SPB204-36	SPB200-36	PB239-36	32-37	37,20	37,40
25,4	25	-16	1	461-462	10046-16C	SPB204-36	SPB200-36	PB239-36	32-37	38,20	38,40

Warning! - For your safety

It is important that Parker Hannifin's assembly instructions be strictly adhered to. Regular checking of the crimping diameters achieved must be ensured by specially trained staff. Our Training Centre is constantly at your disposal for information.

For your safety:

Flexible hoses are used to transmit fluids, sometimes at high pressures. The power-grip between the crimp fitting and the hose is the critical zone in all flexible hose connections. Only the use of Parker components (hoses, fittings and tool) designed to be assembled by means of the appropriate Parker tooling, and full compliance with the assembly instructions, can guarantee safety and conformity with standards. Adherence to installation recommendations and suitable maintenance also give a guarantee for long life of the flexible hose. Non-compliance with these elementary rules can lead to the rupture of a flexible hose and cause considerable damage and sometimes bodily injury.

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