

Always inspect crimps visually and dimensionally.

## Visual Inspection

Visually inspect the first crimp to make sure that the correct dies were used, crimp location is correct, crimp is uniform, and there is no internal deformation of the fitting. A good crimp will be properly centered on the ferrule, meet the target depth dimension, and be symmetrical in shape.

### What to look for:

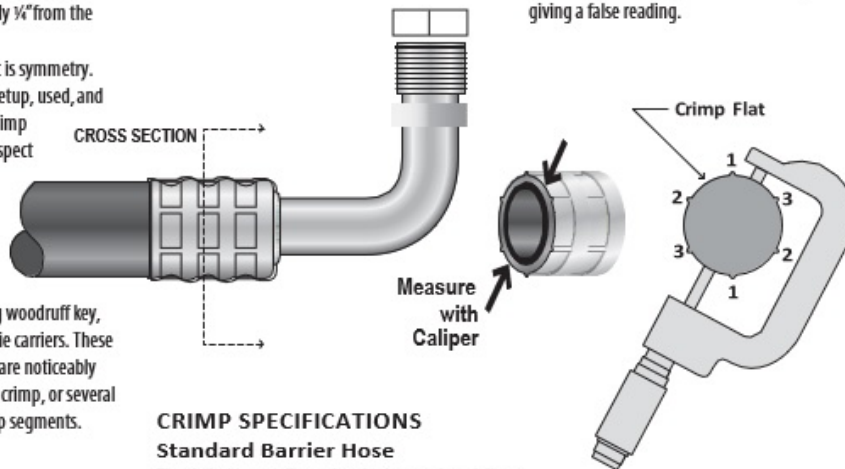
- 1) The first visual criteria for a good crimp is the location of the crimp rings on the ferrule. The instructions provided should produce a crimp that is well centered on the ferrule. The first crimp ring will be approximately 1/4" from the open end of the ferrule.
- 2) The second visual characteristic is symmetry. When the Crimper is properly setup, used, and maintained, it will produce a crimp which is evenly shaped with respect to the crimp depths and the pinched ears in between. Many conditions in the process could cause an irregular crimp including: worn guide blocks, dies not seated, missing woodruff key, or deterioration in the plastic die carriers. These faults will produce crimps that are noticeably irregular with varying depth of crimp, or several prominent "ears" between crimp segments.

## Dimensional Inspection

If the crimp is properly centered and regular, the crimp depth is the only remaining characteristic to check. The target dimensions can be measured with a set of blade or pin micrometers. The dimensional gauging should be used to verify the proper setup or when the tool is disassembled for maintenance. Gauges also should be used periodically during operation to verify continued acceptable crimps.

## What to Measure

With the use of a micrometer measure across the diameter at the center of the crimp. The tooling manufacturer recommends checking in three locations: one reading on each of the three crimp bands, rotating the part to the next facet each time to assure checking each opposing die segment. In this manner each band and facet are checked. NOTE: Using a Vernier Caliper may be an acceptable alternate gauge for the larger size fittings but not the smaller ones. Depending on ferrule size, the crimped "ears" may extend higher than the crimp diameter giving a false reading.



## CRIMP SPECIFICATIONS

### Standard Barrier Hose

The critical target dimensional tolerance is as follows:

Die Size	Target Diameter	Tolerance Range
#6	.660"	.650" to .675"
#8	.830"	.820" to .845"
#10	.936"	.926" to .951"
#12	1.035"	1.025" to 1.050"

### Reduced Barrier Hose

The critical target dimensional tolerance is as follows:

Die Size	Target Diameter	Tolerance Range
#6	.556"	.551" to .571"
#8	.640"	.635" to .655"
#10	.742"	.737" to .757"
#12	.897"	.892" to .912"