CRIMP-ON

HOSE ASSEMBLY **INSTRUCTIONS**

***K, L, N, J & C** SERIES HOSE TAILS*

***STEP 1:** HOSE ASSEMBLY REQUEST FORM*

Complete a 'Hose Assembly Request' form
Scan the QR code, head to *taipan.com.au/charts-and-tools* or go to the Resource Centre on our website.

***STEP 2:** HOSE TAIL PAIRING*

Find qualified hose tail pairing for the hose:

SAE	Series	Assembly
100R**1**	K	Crimp-on
	D1	Field Attachable
100R**2**	K	Crimp-on
	D2	Field Attachable
	L	Crimp-on*
	N	Crimp-on -10 only
100R**4**	Low Pressure	Super clamps
	K	Crimp-on
	L	Crimp-on
100R**5**	DF	Field Attachable
	F	Crimp-on
	K	Crimp-on
100R**6**	H	Push-Lock
	J	Crimp-on
100R**7**	J	Crimp-on

SAE	Series	Assembly
100R**8**	J	Crimp-on
100R**12**	L	Crimp-on
100R**13**	N	Crimp-on
100R**14**	C	Crimp-on
100R**15**	L	Crimp-on -06 & -08 only
	N	Crimp-on
	NP	Crimp-on -32 only
100R**16**	K	Crimp-on
100R**17**	K	Crimp-on
	D17	Field Attachable
100R**18**	J	Crimp-on
100R**19**	K	Crimp-on
GH8.3	GH	Field Attachable
	J	Crimp-on
PSH1	J	Crimp-on

**L: Not all sizes.*

Further hose and hose tail pairings are available, see our catalogue, crimp chart, or call us for help.
For **Field Attachable** hose tails, please see Field Attachable Hose Assembly Instructions.
For **Push-On** hose tails, please see Push Lock Hose Assembly Instructions.

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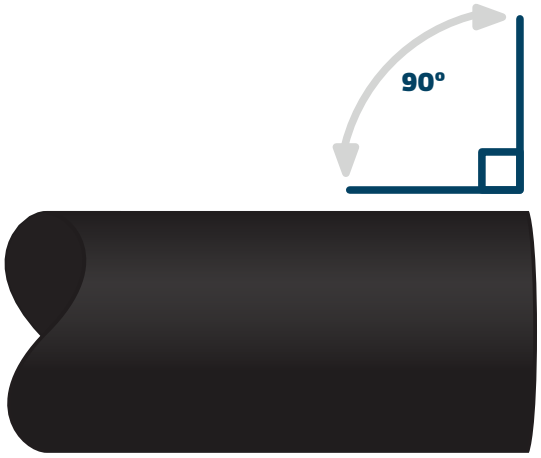
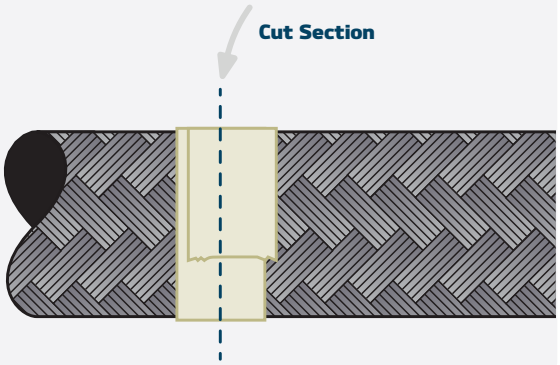
STEP 3: CUT HOSE

Cut hose to the length required, ensuring the cut is square



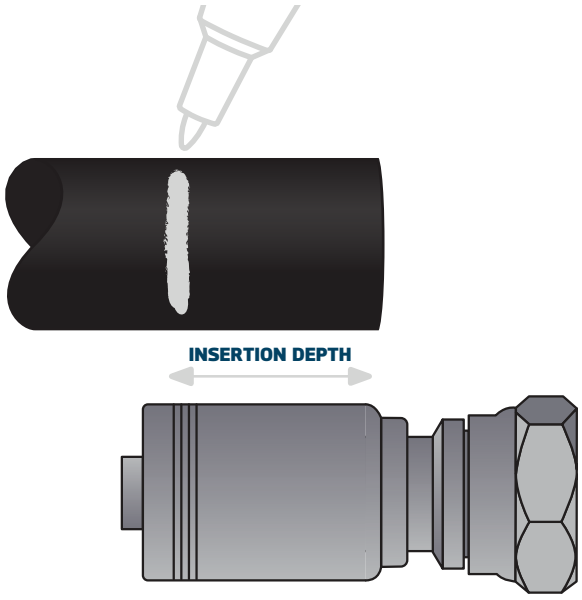
PTFE hose requires the use of multi-filament tape on the cut section to prevent flaring



STEP 4: INSERTION DEPTH

Use a permanent paint pen to mark hose tail insertion depths as advised in the chart below

Hose Dash Size	Insertion Depth (mm)				
	J	C	K	L	N
-2	14				
-3	21.5	16			
-4	27.5	16	20		
-5	28.1		23		
-6	23.8	18	24.8	28.5	
-8	32	18.3	30.8	34.3	
-10		17.9	39		29.4
-12		17.6	38	38.5	56.5
-16		22.2	38	47	58.9
-20			45	47.5	71
-24			37.7	59.5	79.5
-32			48.1	64.5	99



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STEP 5: LUBRICATE & INSERT

a Lubricate hose

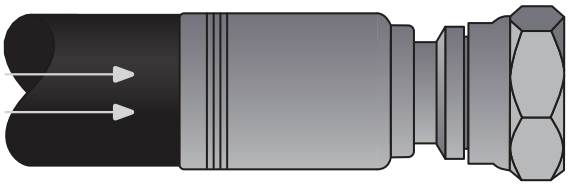
✕ Multispiral Hose

✓ Any other hose

Lubricate inside of hose with a suitable medium for the application

b Insert hose

Push hose into hose tail to the insertion depth mark made in Step 3, so the pen marking is completely hidden inside the end of the ferrule.



Ensure angled hose tails (if any) are aligned correctly with the job requirement and hose memory factors.

STEP 6: SET UP CRIMPER

Set up crimper to the required crimp dimension
Scan the QR code to view Taipan's Crimp Chart, head to *taipan.com.au/crimp-chart* or go to the Resource Centre on our website.

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STEP 7: CRIMP HOSE

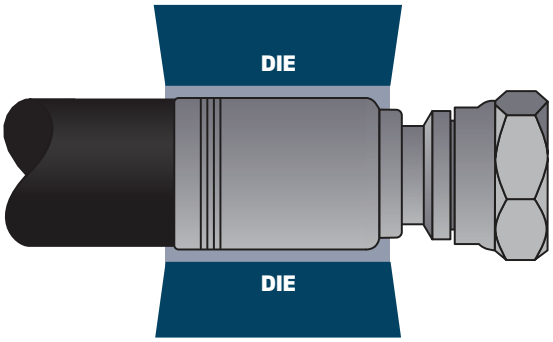
Refer to the Crimp Chart in Step 6 to determine whether your assembly requires a Bubble Crimp or a Full Crimp

Exercise caution when operating a crimper to prevent injury

Crimp End 1 only, then proceed to Step 8 to confirm measurements before returning to Step 7 to crimp End 2

a Full Crimp

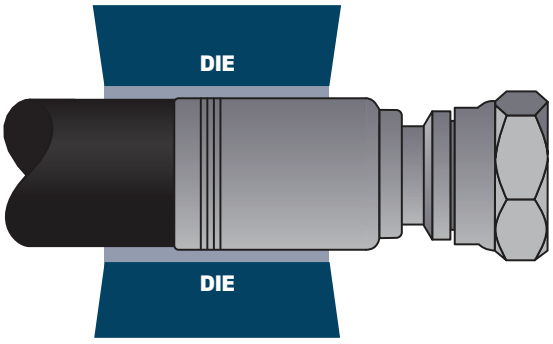
Place hose tail into crimper, ensuring that the hose tail is positioned correctly within the edges of the dies as instructed by the Crimp Chart.



b Bubble Crimp

Position hose tail into crimper, ensuring bubble crimp dimensions are matched as instructed by the Crimp Chart

J Series hose tails feature a line indicator showing exactly where the die jaw should be positioned



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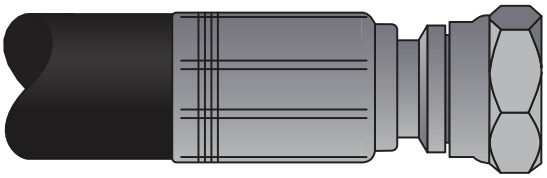
***STEP 8:** CHECK DIMENSIONS*

a

Verify insertion depth
Verify that the marked line is no longer visible at the base of the hose tail, and it has not moved during crimping.

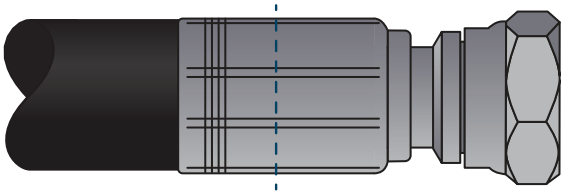


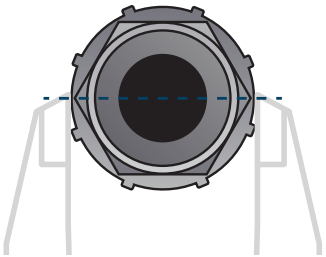
b

Check crimp diameter with a vernier
Confirm you have performed a successful crimp by checking End 1.

If adjustments need to be made to further crimp the ferrule, make these adjustments and re-crimp the hose tail, ensuring you align the foot pattern of the dies with the impressions left in the ferrule.

Once you have obtained the correct crimp dimension on End 1, proceed back to steps 6 and 7 to crimp End 2.





i If a ferrule is over-crimped, you must construct a new assembly.

i A tolerance of ±0.25mm within the published crimp dimension must be maintained

***STEP 9:** CLEAN & CONFIRM*

Check and clean the assembly

- Clean the hose of debris with foam bullets
- Perform a visual inspection to ensure that the hose assembly has been constructed correctly
- Add achieved crimp dimension to the hose assembly requirements form and sign off your completed work