



## Make better connections!

### Braided hose connection – for SAE100 R1A and R2A (EN 853 ST-hoses) - external skive



- Select the correct hose.
  - Cut square and ensure the cut is free from contamination.



- Select the appropriate hosietail and ferrule with reference to the Volz catalogue.
  - Check identification, ferrules are marked with dimension, trace number as well as V71 Logo.
  - Ensure that all selected components match.



- Use dimensions from the Volz Crimp Chart. (Check validity with Volz)
  - Check whether the Volz crimp spec require external and / or internal skiving.
  - Pay attention to skive length and remove **ALL** visible rubber to the correct mark. Ensure wires are not damaged and **ALL** surfaces are clean.



- Place ferrule fully on hose and then insert hose tail.
  - Ensure the hose tail is fully engaged inside hose.

**Attention!** During the crimping process the ferrule has to create a positive lock with the hose tail.

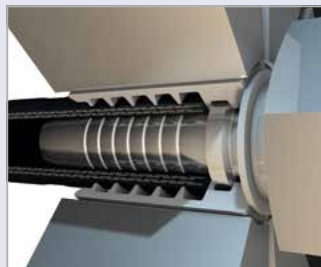


- Setting of the crimp machine should be in compliance with the manufacturer's handbook.
  - Follow the instructions.

**Attention!** Only use machines with 8 dies for crimping. Dies must be smooth and defect free. The dies must be longer than the length of the ferrule. Multiple crimping needs to be avoided.

  - For even crimp results, ensure the dies overlap ferrule at both ends when inserting into machine. Keep the final crimp force for at least 30 seconds before releasing.

**Attention!** Stainless steel has a spring back tendency when releasing the crimp force too early.



- Check the crimp results at multiple points. If necessary, adjust the machine setting to reach the required crimp diameter value.