



Make better connections!

Spiral hose connection – for SAE100 R9R, R12 (EN 856 4SP) - external skive



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



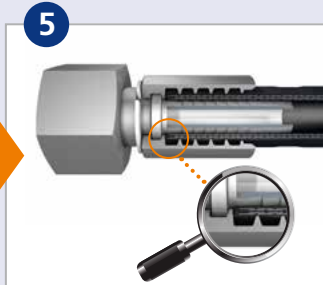
- Select the appropriate hose-tail and ferrule with reference to the Volz catalogue.
 - Check identification, ferrules are marked with dimension, trace number as well as V71 Logo.
 - Ensure that all selected components match.



- Use dimensions from the Volz Crimp Chart. (Check validity with Volz).

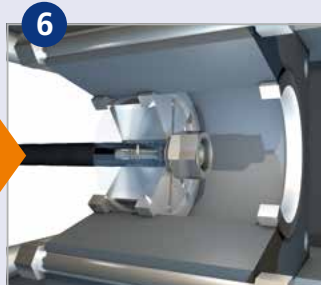


- Pay attention to external skive lengths and remove **ALL** visible rubber to the correct marks. Ensure wires are not damaged. After skiving ensure **ALL** surfaces are clean.



- 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.

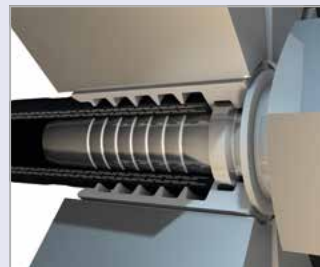


- Setting of the crimp machine should be in compliance with the manufacturer's handbook.
 - Follow the instructions.

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.