



Make better connections!

Spiral hose connection (INTERLOCK) – for SAE100 R13 and R15 (EN 856 4SH, 6SP and 6SH) - internal & external skive



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



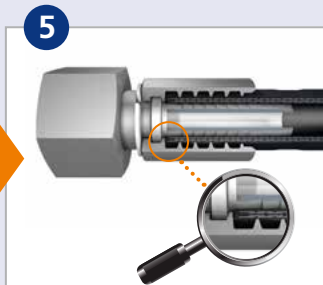
- Select the appropriate hosetail and ferrule with reference to the Volz catalogue.
- Check identification, ferrules are marked with dimension, trace number as well as V71 Logo.
- Ensure that all selected components match.



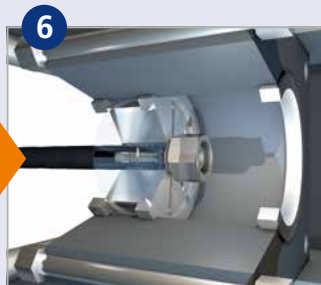
- Use dimensions from the Volz Crimp Chart. (Check validity with Volz).



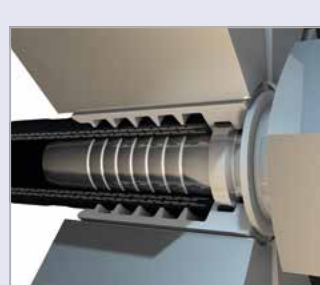
- Pay attention to internal and external skive lengths and remove all visible rubber to the correct marks. Ensure wires are not damaged. After skiving ensure **ALL** surfaces are clean.



- 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.