CRIMPING SPECIFICATIONS

POWERING GLOBAL INDUSTRY

ASSEMBLY PROCEDURE RECOMMENDATIONS

The following six pages will list the crimp OD's for 1-1/2" to 6" ID hoses. These crimp OD's are guides only. We recommend that you accurately measure the dimensions of each hose, test each assembly and document everything.

It is difficult to establish ironclad standards because of the many variables in hose construction. Hardwall versus softwall construction, corrugated versus smooth cover and differing compounds all play a part in the difficulty of establishing crimp-specific OD's.

Once again, do not mix other manufacturer's products (hose, ferrule, sleeve or coupling) with Jason Industrial products.

Before doing any assembly work, please do the following steps:

1. Make sure each hose end is cut square. Clean any debris from the tube interior.
2. Before the coupling is installed, check for any burrs or sharp edges. This will make the coupling insertion easier and prevent inner tube damage.
3. **This next step is vital!** Measure the Hose O.D. in at least three different locations on each end. This will ensure that the proper sized ferrule/sleeve is used.
    a. Never try to enlarge the tube to make it easier to insert the coupling - this could result in tearing the tube. Lubrication should only be used if necessary.
    b. There is no need to buff the cover of the hose.
4. The fitting shank should be inserted into the hose to where the last serration is covered. Inserting past this point does not help hose/coupling retention. Do not insert hose against the stop on cam & groove parts C & E. The hose will extrude during the crimping process and will fill in that space.
5. Check the charts on the next six pages for the hose ID and find the correct crimp OD.
6. If a static charge needs to be maintained, then bend the helical wires inside the hose tube. Slide the sleeve or ferrule onto the hose. Insert the shank and complete the assembly.
7. In petroleum tank truck applications, it is recommended that the ends be sealed. After crimping, the ends will be exposed and will require a chloroprene cement to accomplish the seal.
8. Jason Industrial recommends that ferrules **ONLY** be used when crimping a hose with a natural rubber tube. These hoses have a tendency to squeeze out of the fitting during the crimping process.
9. Each assembly should be hydrostatically tested to two times the working pressure, unless otherwise specified by the customer. Otherwise, please refer to the NAHAD Assembly Guidelines industry-accepted guidelines for hose assembly practices.
10. Non-sparking materials like brass or aluminum should be used if the assembly is conveying flammable liquids.

Please do not mix Jason Industrial couplings with other products. We cannot recommend working pressures or crimp specifications for non-Jason parts. Please follow the safety recommendations as published in the NAHAD Industrial Hose Assembly Specification Guidelines.

All sizes may not be stocked in all locations. Check with customer service for availability.

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