PART 1 - PREPARATION

SELECTION
1) Select proper hose for the application, see hose section of the FLEXTRAL catalog for proper hose identification.
2) Select proper coupling that matches the Flextral hose series.

NOTE - For more information on hose selection please consult your FLEXTRAL representative.

MEASURE
1) Insure proper measurement of Overall Length (OAL) of sample hose.
2) Measure and mark new hose at proper cut point.

CUT
1) Insure square cut on new hose.

DEPTH MARK
1) Mark coupling depth using proper depth gauges.

SKIVE - IF NEEDED
For hoses that need to be skived reference FLEXTRAL crimp chart.
1) Use proper skive key to mark skive depth and coupling insertion depth. If you do not have skive key use calipers.
2) Insert and rotate skive head in clockwise direction. Make sure lubrication is used to prevent lock-up.
3) Make sure skive area is clean of any cover material.

CLEAN
1) Select projectile and air nozzle according to hose size.
2) Insure projectile travels the full length of the hose and exits the other end.

PART 2 - ASSEMBLY

LUBRICATE
1) Lubricate coupling stem by spraying the tip with lubricating oil.

INSERT COUPLINGS
1) Push coupling on hose, insure depth mark aligns with ferrule bottom.

TOOL SELECTION
1) Refer to FLEXTRAL crimp chart for proper die and spacer ring selection.
2) Place die in die bowl. Note – apply high pressure lubricant to die bowl prior to use.
3) Place correct spacer ring on top of die flat side up.

CAUTION - make sure spacer ring is FLAT SIDE UP and centered over die.

DIE INSERTION
1) Insert hose assembly from below between the die halves.
2) Align the coupling with the top of the die in the proper location as indicated in the location diagram.

CRIMP
1) Slide entire die assembly back against rear locating stops when using the FX21 or FX41 crimpers. For other Flextral vertical crimpers skip to step two.

CAUTION - insure die bowl assembly is vertically aligned with push tube.
2) Activate pump to crimp coupling to hose.
3) When spacer ring contacts die bowl crimping is complete.
4) Release electric switch to retract the push tube.
5) Slide die bowl assembly forward and remove spacer ring.

PART 3 - INSPECTION

CHECK CRIMP DIAMETER
1) To insure proper crimp has been completed, measure the nominal crimp diameter across flats. Refer to FLEXTRAL crimp chart.

CHECK CRIMP LOCATION
1) Visually inspect the crimped coupling, verify the proper crimp location.

COUPLING INSPECTION
1) Insure depth mark is visible after crimp is complete.

Hose Assembly Guidelines
Remember for your safety!
You must be trained before using Flextral equipment.