

How to make a standard Hydraulic Hose Assembly

Step 1: We need to arrange the required tools and materials.

Hydraulic hose
Hydraulic hose fitting and collar
Hose lubricant
Calipers
Safety goggles & gloves
Cutting & Crimping machine
crimping die and collar

Step 2: Measure the required hose and cut

We will measure the length of hose the customer required and cut it to size with a hose saw. For critical hose lengths, we will make sure to account for the cut off factor when determining final length of hose. After cutting the hose, there should be a clean edge and if not, we will use a file to clean the ends.



Step 3: Clean inner tube hose

We will remove contaminants within the hose, by air compressor air gun and water gun to ensure equipment safety

Step 4: Put the fitting and collar on the hose

We will check all of the fitting and collar qualified carefully, by the way, the fitting and collar we recommend to our customers, we will consider the working pressure, style, type, orientation, attachment methods and material for its corrosion resistance.



Step 5: Verify crimper capabilities and adjust the crimper setting

Considering crimpers are specifically made to crimp specific hose diameters. Therefore, we will confirm the capabilities of the machine and adjust settings as necessary. Make sure to choose the correct crimp diameter for each hose assembly.



Step 6: Crimp hose diameter

We strictly matches the Table of the crimp technical parameters.

扣管机扣压量技术参数 (仅供参考)

| 胶管内径 Φ | 外套外径Φmm (扣压前) | | | | 外套外径Φmm (扣压后) | | | |
|-----------|---------------|------|-------|------|---------------|------|-------|------|
| | (I) | (II) | (III) | (IV) | (I) | (II) | (III) | (IV) |
| 6 | 19 | 21 | 23 | 25 | 17 | 18.8 | 20.5 | 22 |
| 8 | 21 | 23 | 25 | 27.5 | 19 | 20.8 | 22.5 | 24.5 |
| 10 | 23 | 25 | 27 | 29.5 | 21 | 22.8 | 24.5 | 26.5 |
| 13 | 28 | 31 | 33 | 35 | 26 | 28.8 | 30.5 | 32 |
| 16 | 31 | 34 | 36 | 38 | 29 | 31.8 | 33.5 | 35 |
| 19 | 34 | 37 | 39 | 41 | 32 | 34.8 | 36.5 | 38 |
| 22 | 37 | 40 | 42 | 44 | 35 | 37.8 | 39.5 | 41 |
| 25 | 41 | 43 | 45 | 47 | 39 | 40.8 | 42.5 | 44 |
| 32 | 49 | 51 | 53 | 55 | 47 | 48.8 | 50.5 | 52.5 |
| 38 | 55 | 57 | 59 | 61 | 53 | 54.8 | 56.5 | 58 |
| 51 | 68 | 70 | 72 | 74 | 66 | 67.8 | 69.5 | 71 |

Step 9: To prevent dust before use, we will cap the assembly on both ends.

