

HERCULES/HT

CRIMP VERSION:

Standard 1

Release number: 2.0

PART. NO.	HOSE SIZE			Insert Type	Ferrule	Crimping Type	Internal Skive Length		External Skive Length		Crimp. Diam.		DIE N.
	DN	Dash	Inch				mm	inch	mm	inch	mm	inch	
H10125031*	31	- 20	1.1/4"	Interlock-Plus	M01850-20	Double Skive	22,0	0,87	71,0	2,80	58,3	2,295	57
H10125038*	38	- 24	1.1/2"	Interlock-Super	M02700-24	Double Skive	26,0	1,02	82,0	3,23	66,5	2,618	66
H10125051*	51	- 32	2"	Interlock-Super	M02700-32	Double Skive	30,0	1,18	92,0	3,62	80,0	3,150	76

- It is recommended to follow the instructions and training information present on the Manuli website "Assembling information and instructions".
- The present crimp chart document is related to the Manuli Hydraulics integrated package of hoses, fittings and hose-assembling equipment and is valid under the condition of use of original components from the Manuli Manufacturing Integrated Program, coherently with the recommendations of international norms of the sector, ref. ISO/TR 17165-2 "Recommended practices for hydraulic hose assemblies".
- For optimum performance use the recommended machines and tools of the Manuli Hydraulics integrated catalogue.

Skive length tolerance: ± 0.5 mm / ± 0.02 inches

Crimping diameter tolerance: 0 /-0.2 mm (0 /-0.008 inch)

REMARK:

DN51 and DN38 references must be crimped with one of the following machines:

- MS400
- MS480
- MS800
- GOLDENCRIMP420
- GOLDENCRIMP450

DN51 & DN38 require the usage of a special die set with increased length (code: ESA3540N135-76 & ESA3440NL125D066L4) and please verify the pins codes when ordering this special die set according to machine model.

HEAT-SHRINKABLE SLEEVE length around 15 (± 1) cm positioned half length on the ferrule and half on the hose side.