

ASSEMBLY INSTRUCTIONS

TECHNICAL SECTION

ULTRA-FLEX™ HOSE ENDS WITH ULTRA-FLEX 650™ HOSE



1. Prepare to cut UltraFlex 650 hose. Wrap hose tightly with thin packing tape to prevent Kevlar braid from fraying during cutting.



2. Use the Earl's UltraFlex Hand Hose Cutter to cut hose. Use a sharp blade as to not crush the PTFE hose during the cutting process.



3. Cut hose square or perpendicular to centerline of hose. No loose or fraying Kevlar braids are to be present.



4. Insert crimp collar onto UltraFlex hose. Do not remove thin tape as adhesive from tape might unravel Kevlar braid.



5. Push UltraFlex hose into crimp collar and verify that hose end bottoms inside of collar.



6. Insert UltraFlex fitting nipple into collar and hose assembly as shown.



7. Prepare the UltraFlex Crimper for operation.



8. Verify correct size crimp die. When inserting die into crimper insure that the bottom of die (shown) mates correctly with die bowl and diamond shaped features in die bowl.



9. Top of crimp die shown in die bowl. Verify die sets correctly in die bowl!

ASSEMBLY INSTRUCTIONS

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ULTRA-FLEX™ HOSE ENDS WITH ULTRA-FLEX 650™ HOSE - (CONT'D)



10. Gently push down onto crimp die to insert and center die ring on top of crimp die below pusher. Verify that bottom of crimp die is seated correctly in die bowl. Prepare to install pusher onto crimper.



11. Insert and position the hose and fitting assembly into crimp from below. Verify that crimp collar seats correctly in crimp die.



12. While holding hose and fitting into position, begin pumping hand pump until die ring contacts crimper base plate. Release pressure by turning triangular knob on valve.



13. Remove hose and fitting assembly through bottom of die ring and inspect crimp on hose assembly.



14. Measure crimp diameter to ensure proper crimp diameter has been achieved. Refer to crimp chart dimension chart.

ULTRA-FLEX 650™ CRIMP DIMENSIONS

The target settings for the Earl's Ultra-Flex 650™ Kevlar & Stainless Steel covered hose, to be applied when using the Earl's Ultra-Flex Crimper and dies, are provided to aid in establishing actual diameters. While the Earl's Ultra-Flex crimper and dies for our Ultra-Flex hose will give crimp diameters close to, or at, specified diameters, the machine operator must check to verify actual dimensions.

SIZE	Dia. after Crimp (in.)	Dia. After Crimp (mm)
-4	Ø 0.465 +/- .005	Ø11.81mm +/- .12mm
-6	Ø 0.606 +/- .005	Ø15.39mm +/- .12mm
-8	Ø 0.800 +/- .005	Ø20.32mm +/- .12mm
-10	Ø 0.930 +/- .005	Ø23.6mm +/- .12mm
-12	Ø 1.151 +/- .005	Ø29.23mm +/- .12mm
-16	Ø 1.345 +/- .005	Ø34.16mm +/- .12mm

Failure to follow these instructions could result in serious injury or property damage during crimping. Improperly crimped fittings can be dangerous to the user of the hose assembly.

- Do not crimp Earl's hose or fittings with another manufacturer's hose or fitting.
 - These dimensions are for Earl's Ultra-Flex Kevlar & Stainless covered hose and Ultra-Flex hose ends only.
 - Wear safety glasses and keep hands away from moving objects.
 - Always check for proper crimping dimensions
- Always test assemblies for leakage prior to installation.