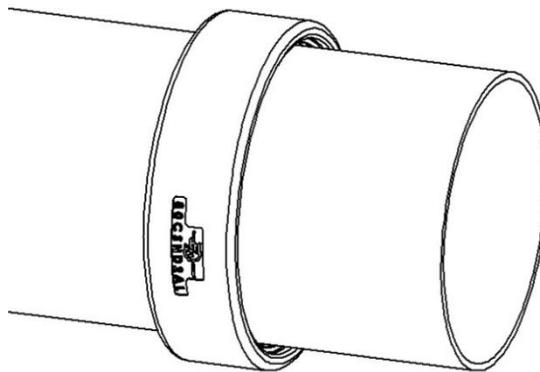


## CSHD2AL CRIMP SLEEVE ASSEMBLY PROCEDURE

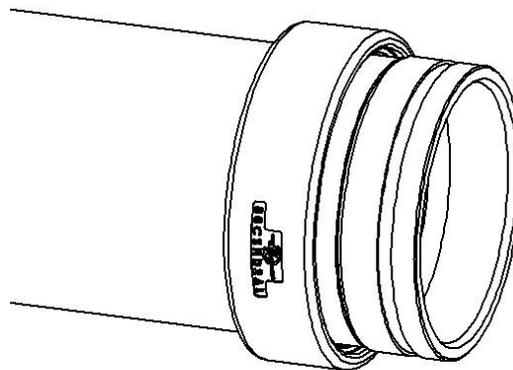
This Procedure is designed to aid in the crimping of PT Coupling Company CSHD2AL onto mating PT Coupling Company HD2 Hose Shanks. Using this procedure will help to ensure a proper connection with the hose shank and crimp sleeve.

PT Coupling CSHD2AL crimp sleeve will only work with lay flat hose and a PT Coupling Company HD2 Hose shank.

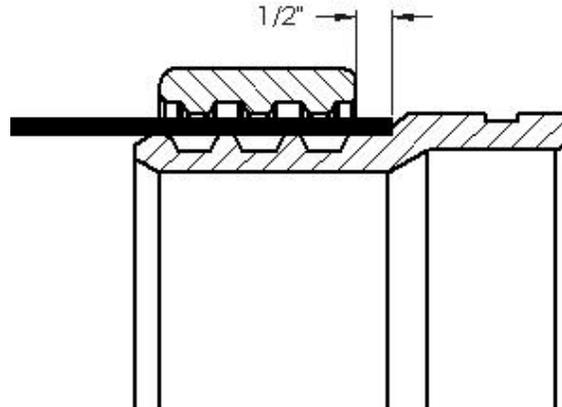
Step 1 - Squarely cut hose end and slide CSHD2 crimp sleeve over hose.



Step 2 - completely insert HD2 hose shank into hose.



Step 3 - Before crimping assembly make sure it is properly located in relation to the hose shank. This is achieved by measuring the distance between the hose stop and side of the crimp sleeve. The distance should be approximately 1/2". This can easily be achieved by using a piece of 1/2" plate as a gauge or by marking the hose 1/2" back.



Step 4 - Using PT Coupling's Universal Crimp O.D. Calculator determine proper crimp O.D. Crimp O.D. can vary due to hose wall thickness and hose wall compression percentage. For the HD2 lay flat hose crimp system, PT coupling recommends a hose wall compression of between **6% and 10%**. Use chart below to help fill in the cells of the crimp calculator.

SIZE	HD2 SHANK O.D.	CSHD2AL THICKNESS
8"	8.05"	.50"
10"	10.05"	.50"



**Universal Crimp O.D. Calculator**



If adjacent input is in inches, crimp O.D. will be in inches. If input is in mm, crimp O.D. will be in mm.

Hose Wall Thk	Shank O.D.	Compression %	Ferrule Thickness
.160	8.05	6%	.500

**Crimp O.D. 9.35**

Hose Wall Thk = (Hose O.D. - Hose I.D.) / 2 or measured  
 Shank O.D. = Mean hose shank O.D. found in chart below or measured  
 Compression % = Hose wall compression approximately 20% to 25%  
 Ferrule Thickness = Ferrule or sleeve wall thickness

(example of PT Coupling Universal Crimp O.D. Calculator)

Step 5 - After determining crimp OD Select proper crimp dies for crimper.

Step 6 - Jog crimp dies until they make contact with the crimp sleeve to verify sleeve is properly positioned.

Step 7 - Crimp sleeve to target O.D., then slightly rotate and crimp again to help ensure roundness.

Step 8 - Measure final crimp diameter to verify it reflects the determined crimp O.D.

**▲WARNING**

The integrity of the hose assembly should be verified by hydrostat proof testing. Reference NAHAD hose assembly guidelines for recommended testing procedures