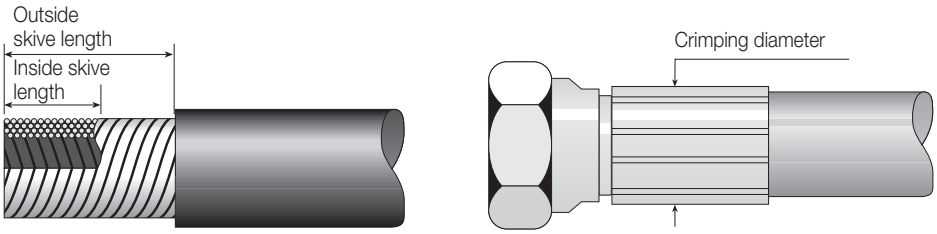
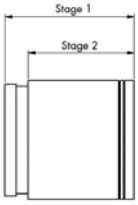
ValCon®
QUALITY HYDRAULICS

Crimp chart for ValCon® hose fittings

Version 10.19 (1)

This crimp chart does not release the hose line producer from his duty to perform the hose and hose line tests required according to DIN or other standards.
The indicated values are guiding values based on test assemblies and thus to be regarded as a mere recommendation.
Due to the common manufacturing tolerances of hoses and fittings, we recommend checking the bore collapse.





V8-1SN

DN	Size	Inch	Ferrule	Initial crimping diameter
6	4	1/4	VC2-04	15,9
8	5	5/16	VC2-05	17,8
10	6	3/8	VC2-06	19,5
12	8	1/2	VC2-08	23,0
16	10	5/8	VC2-10	27,0
19	12	3/4	VC2-12	30,7
25	16	1	VC2-16	39,2

V8-1SC

Size	Zoll	Ferrule	Initial crimping diameter (mm) Stage 1	Initial crimping diameter (mm) Stage 2	DN
4	1/4	VC2-04	15,9	15,3	6
5	5/16	VC2-05	17,5		8
6	3/8	VC2-06	18,9		10
8	1/2	VC2-08	22,4	22,3	12
10	5/8	VC2-10	26,5		16
12	3/4	VC2-12	30,0		19
16	1	VC2-16	38,3	37,4	25

Crimping of the **1SC** must be carried out with staged crimping for some nominal widths, as otherwise tapering can occur around the latch area of the nipple.
Tapering means that the control of the bore collapse cannot be carried out using the test gauge. To do this, the entire length of the ferrule is first crimped with the **Stage 1** dimension. Then crimping is carried out behind the ferrule groove with the **Stage 2** dimension, until bore collapse can be measured with a test gauge.

V8-2SC

DN	Size	Inch	Ferrule	Initial crimping diameter
6	4	1/4	VC2-04	16,4
8	5	5/16	VC2-05	18,2
10	6	3/8	VC2-06	19,7
12	8	1/2	VC2-08	23,5
16	10	5/8	VC2-10	27,8
19	12	3/4	VC2-12	31,1
25	16	1	VC2-16	39,6

V8-2SN

Size	Inch	Ferrule	Initial crimping diameter	DN
4	1/4	VC1-04	17,4	6
5	5/16	VC1-05	19,3	8
6	3/8	VC1-06	21,5	10
8	1/2	VC1-08	24,7	12
10	5/8	VC1-10	28,0	16
12	3/4	VC1-12	31,5	19
16	1	VC1-16	40,3	25

V8-4SP

DN	Size	Inch	Ferrule	Initial crimping diameter	Outside skive length
6	–	–	–	–	–
8	–	–	–	–	–
10	6	3/8	VC4-06	23,6	25
12	8	1/2	VC4-08	26,3	26
16	10	5/8	VC4-10	29,5	31
19	12	3/4	VC4-12	34,0	33
25	16	1	VC4-16	43,7	46

V8-MP

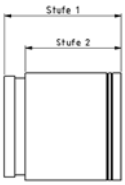
DN	Size	Inch	Ferrule	Initial crimping diameter
6	4	1/4	VC2-04	16,5
8	5	5/16	VC2-05	18,0
10	6	3/8	VC2-06	19,5
12	8	1/2	VC2-08	23,5
16	10	5/8	VC2-10	27,5
19	12	3/4	VC1-12	31,5
25	16	1	VC1-16	39,5

V8-1HWS

DN	Size	Zoll	Ferrule	Initial crimping diameter (mm) Stage 1	Initial crimping diameter (mm) Stage 2
6	4	1/4	VC2-04	15,9	15,4
10	6	3/8	VC2-06	18,8	18,6
12	8	1/2	VC2-08	22,8	22,5

V8-2HWS

Size	Zoll	Ferrule	Initial crimping diameter (mm) Stage 1	Initial crimping diameter (mm) Stage 2	DN
4	1/4	VC2-04	16,3		6
6	3/8	VC2-06	19,9		10
8	1/2	VC2-08	23,6		12



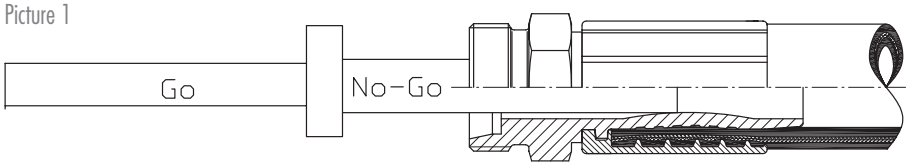
Crimping of the **1HWS** and **2HWS** must be carried out with staged crimping for some nominal widths, as otherwise tapering can occur around the latch area of the nipple.
Tapering means that the control of the bore collapse cannot be carried out using the test gauge. To do this, the entire length of the ferrule is first crimped with the **Stage 1** dimension. Then crimping is carried out behind the ferrule groove with the **Stage 2** dimension, until bore collapse can be measured with a test gauge.

Technical changes and typographical errors reserved.

Description of bore collapse check procedure

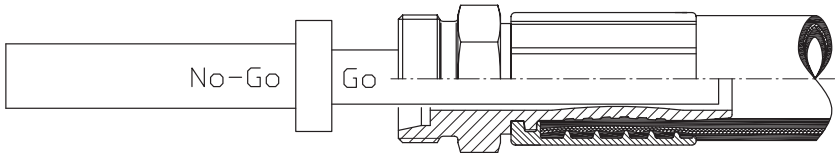
1. **Select the test gauge corresponding to the size of hose.**
2. **Swage to – or stay above – the stated initial crimping diameter.**
3. **The No-Go end of the test gauge should stop at the middle of the ferrule.**

Picture 1



4. **The Go end of the test gauge should pass through the tail end of the hose fitting.**

Picture 2



Warning: Use of incorrect parts or incorrect crimping may lead to leakage, failure or bursting of the hose line and may – particularly in operations with high operational pressure – result in material damage and/or personal injury. All information given in this brochure has been compiled thoroughly and is given to the best of our knowledge. Liability and warranty claims of any kind are excluded. Subject to change without notice. All values are given in millimetres (mm).

If you have any questions, please contact your dealer.