



AMERICAN BOA INC.



**Crimp-Tite™
Technology for
Braided Metal Hose**



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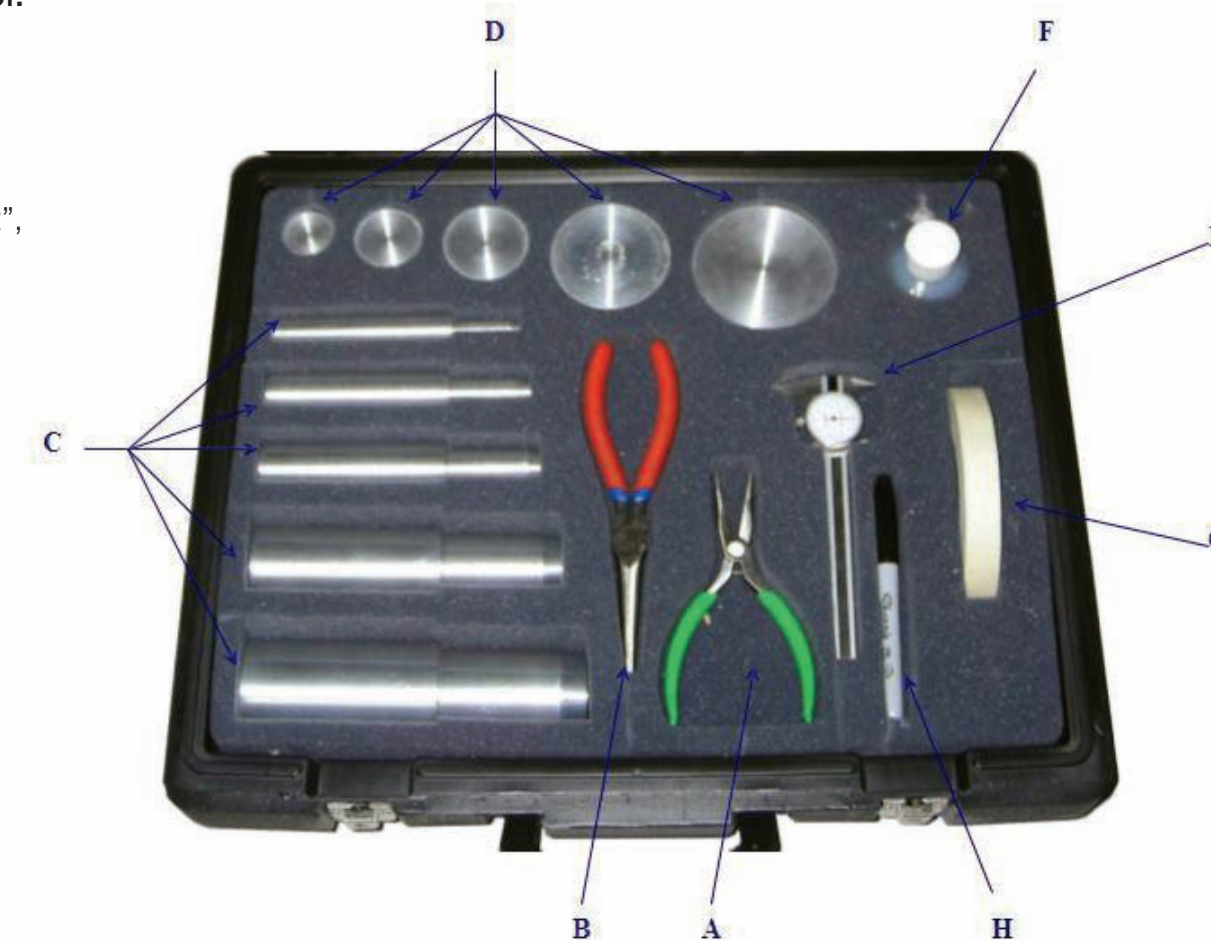
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Crimp-Tite™ Kit

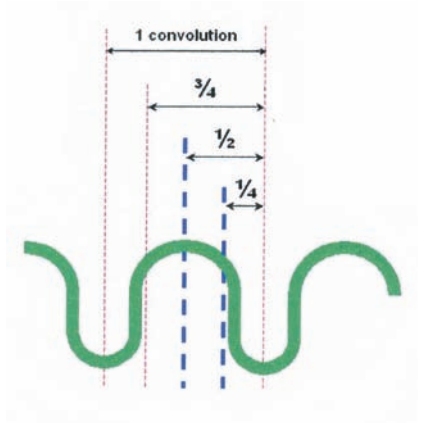
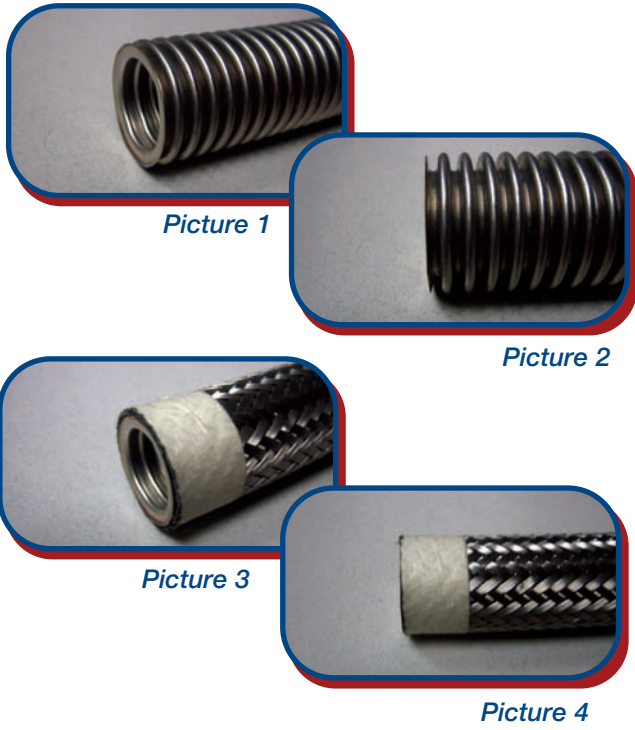
The Crimp-Tite™ Kit is composed of:

- A. 1 small pliers: 1/2" through 3/4",
- B. 1 large pliers: 1" through 2",
- C. 5 seal seat gauges: 1/2" through 2",
- D. 5 ferrule seat gauges:
1/2" through 2",
- E. 1 caliper,
- F. 1 lubricant bottle (Waterless
Hand Sanitizer™)
- G. 1 tape (Model No. S11735/
Supplier: ULINE),
- H. 1 permanent marker.



1 • Braided Metal Hose Preparation:

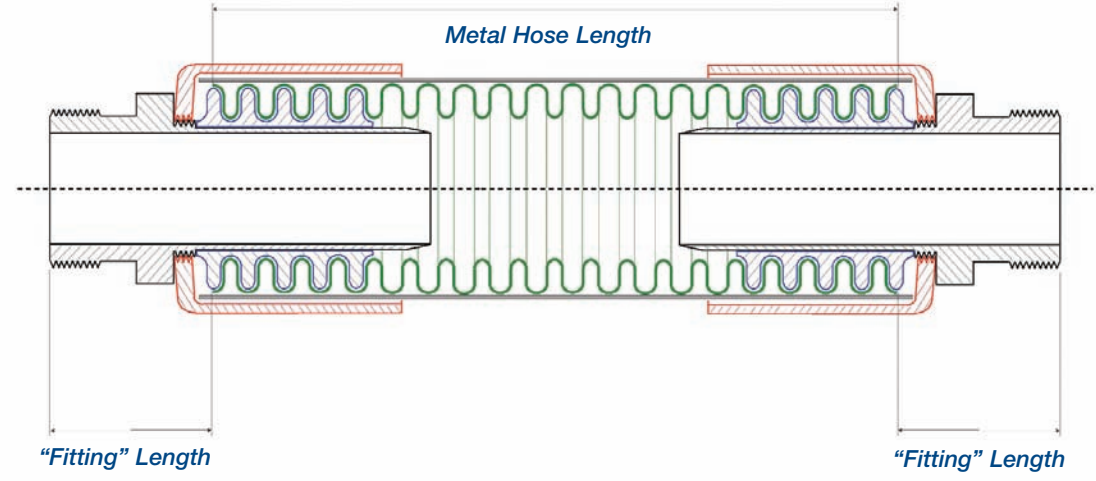
1. Saw / cut Crimp-Tite™ Braided Metal Hose to length,
2. Remove the flexible metal hose from the braid,
3. Prepare both ends of the flexible metal hose by sanding / grinding until there is 1/4 to 1/2 a convolution remaining (see *picture 1 & 2 + drawings & chart*),
4. Make sure to remove all burrs and loose strands,
5. Insert the braid onto the flexible metal hose,
6. Prepare both ends by applying masking tape around the braid (see *picture 3 & 4*),
7. Trim the excess braid on both ends,



Metal Hose Length = OAL – 2 x “Fitting” Length with

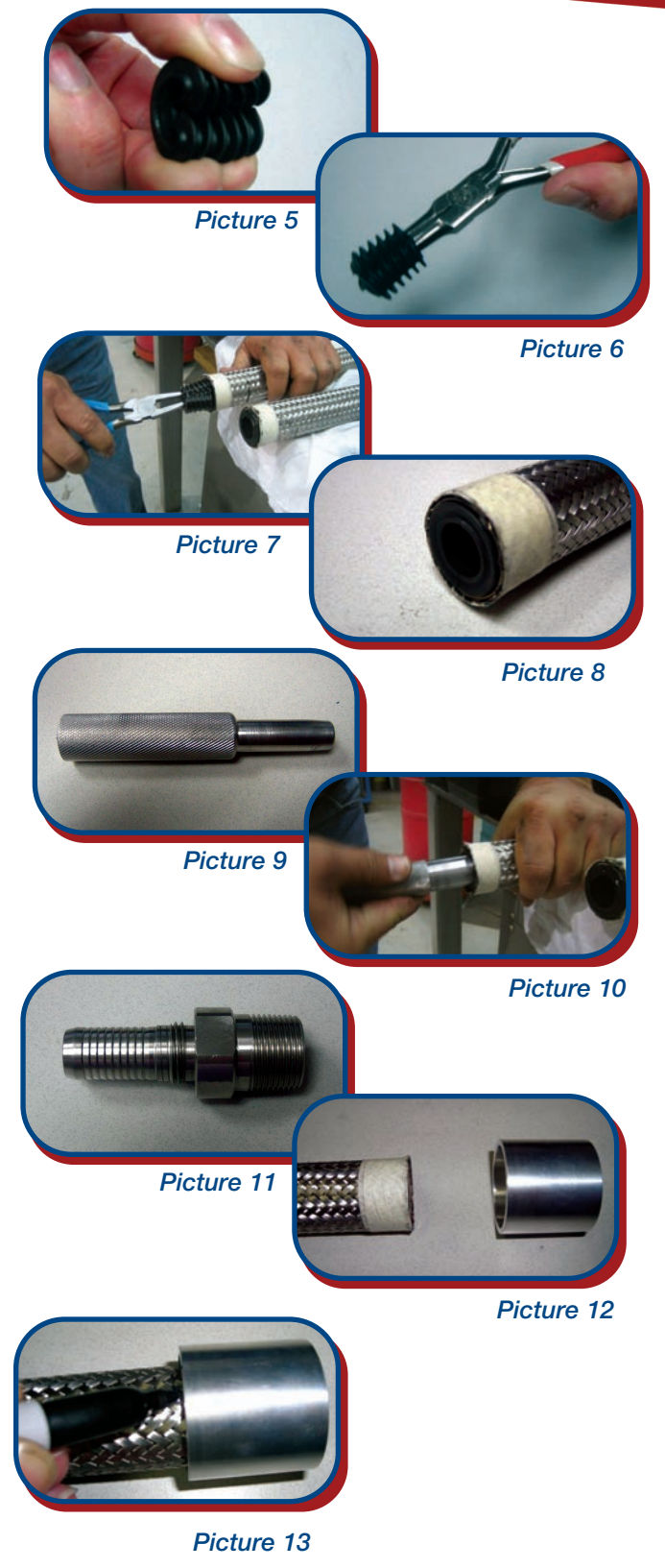
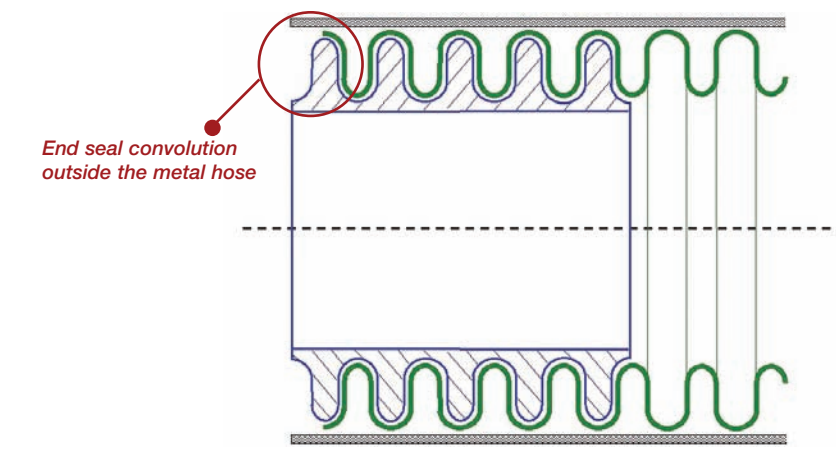
Crimp-Tite™	“Fitting” Length
1/2”	1.67”
3/4”	2.00”
1”	2.35”
1 1/2”	2.68”
2”	2.62”

Chart: OAL / Metal Hose Length



2 • Crimp-Tite™ Assembly:

8. Apply lubricant on the seal,
9. Fold seal in half and hold with the specific pliers (see *picture 5 & 6*),
10. Insert seal into the metal hose (see *picture 7*)
11. Make sure that the end seal convolution is outside the metal hose (see *picture 8 & drawing*),
12. Insert the seal seat gauge into the crimp seal and rotate the tool to ensure the seal is fully seated (see *picture 9 & 10*),
13. Unscrew ferrule from stem (see *picture 11*),
14. Slide the ferrule seat gauge over the braid and mark line at the edge of the ferrule on braid (used as reference during ferrule/stem assembly) (see *picture 12 & 13*),
15. Apply lubricant on the stem and if possible inside the seal,
16. Screw ferrule onto stem (see *picture 14*),
17. Insert the ferrule and stem assembly into the crimp seal and hose (see *picture 15 & 16*),
18. Make sure that ferrule and stem assemblies are inserted to the previously marked reference line on the braid (see *picture 17*),



3 • Crimp Operation:

19. Crimp both ends once according to the chart below (see *picture 18 & 19 + Chart*),
Note: The 2” Crimp-Tite™ has to be crimped twice with a rotation to re-crimp on the segment marks.
20. With a caliper, control the ferrule OD after the crimp operation (see *picture 20 & 21*),
Note: The crimp diameter has to be measured in the middle of the ferrule.

Ø Nominal	Crimp Diameter	
	Min.	Max.
1/2”	0.925”	0.935”
3/4”	1.260”	1.270”
1”	1.575”	1.585”
1 1/2”	2.315”	2.325”
2”	2.830”	2.840”

