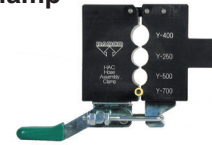


## Hose Assembly Construction Tools

**Mini Hose Cutter**  
90.320.7



**Hose Assembly Clamp**  
90.320.6 (HAC)



Part No.	OD	ID	Max. Working Pressure	Burst Pressure	Bend Radius	Recommended Hose Adapter	Crimp Die
90.700 (Y-700)	5 .20	2 .08	500 bar 7250 psi	1890 bar 27405 psi	20 .79	<i>MINILink</i> ® (M8) ORFS (9/16-18) D-24 (M12)	Mini-Crimp 90.710.8 See Reverse
90.705 (Y-705)	5 .20	2 .08	500 bar 7250 psi	1940 bar 28130 psi	20 .79	Zip (S12.65) ORFS (9/16-18) D-24 (M12) <i>MINILink</i> ® (M8)	

## Hose Assembly Construction

### Hose Preparation

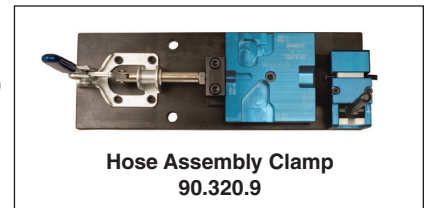
1. Measure hose.
2. Cut hose to appropriate length using the 90.320.7 Hose Cutter (a sharp knife can also be used). It is important to use a sharp edge, because a clean cut is necessary.
3. No burrs should be present if a clean cut was made. However, if burrs are present remove them with a sharp knife.

### Fitting Preparation

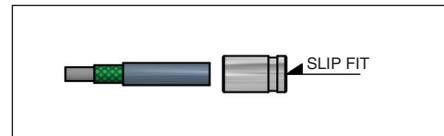
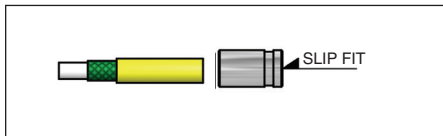
1. Inspect the fitting to ensure no damage occurred during shipment.

### Assembly Using 90.320.6 HAC (*Contact DADCO for Assembly Using the 90.320.9*)

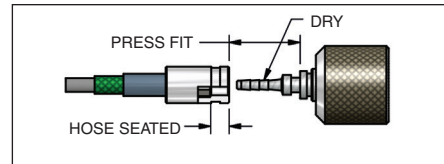
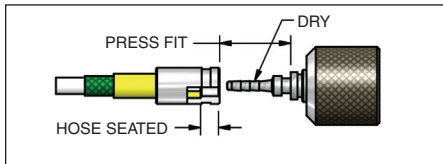
1. Secure the 90.320.6 Hose Assembly Clamp in a bench vise by its tab.
2. Insert the hose up through the 90.320.6, leaving enough hose extending up from the clamp to install the appropriate fitting.
3. Pull the lever to close the 90.320.6 (F.1).



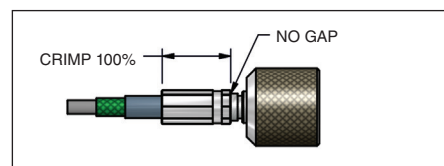
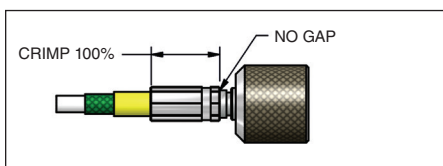
### 90.700 (Y-700) Permanent Fitting Installation / 90.705 (Y-705) Permanent Fitting Installation



1. Slip the ferrule onto the hose. Ensure the hose rests snug against the shoulder.



2. Press the dry nipple through the ferrule into the hose.
3. Insert the nipple into the hose by tapping the end of the hose adapter with a rubber mallet until the nipple bottoms out in the hose. Oil or grease should not be used.



4. Open the 90.320.6 Hose Assembly Clamp and remove the hose assembly. The hose assembly is now ready to be crimped. See the reverse side for instructions.

# DADCO's Mini-Crimp

## Mini-Crimp 90.710.8

For use with a hydraulic or pneumatic crimp machine.  
No Die Ring Required.

*The following steps are also applicable to the previous model, 90.710.1, Mini-Crimp.*



90.710.8  
Mini-Crimp

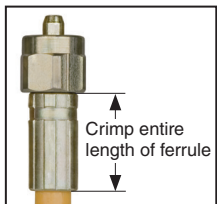
### Operation

**Please follow the guidelines below for proper operation:**

1. Place the Mini-Crimp 90.710.8 into the crimping machine. No die ring is required.
2. Insert the hose assembly from below through the center of the Mini-Crimp (F.1). For instructions on constructing a *MINILink*® Hose Assembly see the reverse side of this bulletin.
3. Activate the hydraulic or pneumatic crimping machine to permanently crimp the fitting to the hose.



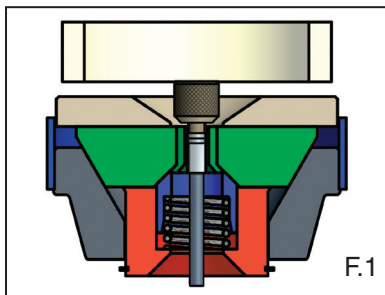
90.720  
Portable Crimping Unit



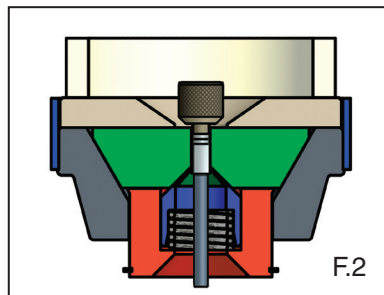
4. As the Mini-Crimp begins to close, position the fitting to ensure the entire length of the ferrule is crimped (F.2).

5. Remove the completed hose assembly from the Mini-Crimp.

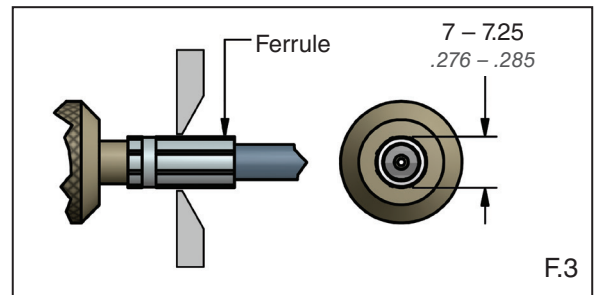
6. Measure the crimped ferrule diameter across the flats to verify it is within the crimp dimension range (F.3).



Mini-Crimp prior to activating the hydraulic or pneumatic crimping machine.



Mini-Crimp "bottoming out" as the crimping machine permanently affixes the fitting to the hose.



Crimped ferrule diameter =  
7.00 – 7.25  
0.276 – 0.285

**NOTE:** 90.700 (Y-700) / 90.705 (Y-705) hose assemblies with 90° hose adapters on each end must be crimped at the factory.

