

**1.** Cut hose square and clean the hose bore.

**2.** Mount the stem in a vice, and lubricate the inside of hose with heavy oil (gear oil works well) or hydraulic oil.

**3.** Mark the end of the hose with the insertion length given on the crimp chart, and push the hose onto the stem until the hose bottoms against the stem shoulder.

**4.** Make sure the insertion mark now aligns with the end of the ferrule.

**5.** Position the fitting in the crimper so that it will crimp the full length of the ferrule, without damaging the hex or thread, and crimp to the correct dimension

**6.** Verify the crimp dimensions by measuring at the midpoint of the crimp.

