



MASTER CRIMP SPECIFICATIONS

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Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	49	REV 02
	111	9200	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
111-04	9200	20	FULL	16.9	0.665
111-06	9200	21	FULL	20.6	0.811
111-08	9200	26	FULL	23.7	0.933

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	40	REV 06
	111	9400	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
111-10	9400	29	FULL	30.8	1.213
111-12	9400	32	FULL	35.2	1.386
111-16	9400	39	FULL	43.1	1.697
111-20	9400	39	FULL	50.6	1.992
111-24	9400	58	FULL	56.7	2.232
111-32	9400	58	FULL	70.2	2.764

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	50	REV 02
	122	9200	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
122-04	9200	20	FULL	17.7	0.697
122-06	9200	21	FULL	21.5	0.846
122-08	9200	25	FULL	24.6	0.969

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	57	REV 02
	122	9400	One Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
122-06	9400	21	FULL	24.0	0.945
122-08	9400	25	FULL	27.9	1.098
122-10	9400	29	FULL	31.5	1.240
122-12	9400	32	FULL	35.9	1.413
122-16	9400	39	FULL	43.7	1.720
122-20	9400	39	FULL	52.8	2.079
122-24	9400	58	FULL	59.5	2.343
122-32	9400	58	FULL	72.5	2.854

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	70	REV 02
	136	9500	One Piece	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
136-12	9500	49	FULL	37.3	1.469
136-16	9500	56	FULL	43.9	1.728
136-20	9500	66	FULL	55.1	2.169
136-24	9500	75	FULL	64.2	2.528

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	71	REV 01
	115	9500	One-piece	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
115-12	9500	49	FULL	37	1.457
115-16	9500	56	FULL	43.9	1.728
115-24	9500	75	FULL	60.3	2.374

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	61	REV 05
	112	9200	Non-Skive	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
112-04	9200	20	FULL	17.2	0.677
112-06	9200	21	FULL	20.6	0.811
112-08	9200	25	FULL	24.0	0.945

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	42	REV 07
	124	9400	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
124-06	9400	21	FULL	24.4	0.961
124-08	9400	26	FULL	28.5	1.122
124-10	9400	29	FULL	32.7	1.287
124-12	9400	32	FULL	36.3	1.429
124-16	9400	39	FULL	43.9	1.728
124-20	9400	39	FULL	51.5	2.028
124-24	9400	58	FULL	59.4	2.339
124-32	9400	58	FULL	72.6	2.858

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **62** **REV 05/05**

124S 9600 Skive

Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
124S-12	9600	47	KNURL	33.1	1.303
124S-16	9600	50	KNURL	40.9	1.610
124S-20	9600	54	KNURL	49.1	1.933
124S-24	9600	56	KNURL	56.0	2.205
124S-32	9600	82	KNURL	71.2	2.803

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **65** **REV 05/05**

115 9600 Skive

Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
115-08	9600	28	KNURL	25.9	1.020
115-12	9600	47	KNURL	32.1	1.264
115-16	9600	50	KNURL	39.9	1.571
115-20	9600	54	KNURL	47.6	1.874

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **63** **REV 05/05**

136 9600 Skive

Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
136-12	9600	47	KNURL	33.2	1.307
136-16	9600	50	KNURL	41.0	1.614

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **64** **REV 05/05**

156 9600 Skive

Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
156-16	9600	50	KNURL	39.9	1.571

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	66	REV 05/05
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663 662	9600	Skive				
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Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
663 -32 662	9600	82	KNURL	70.4	2.772

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	20	REV 06
	109	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
109-04	5500	FULL	15.9	0.626
109-06	5500	FULL	18.5	0.728
109-08	5500	FULL	21.9	0.862

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	76	REV 00
	662 663	6500	One-piece	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
662 -32 663	6500	86	FULL	77.3	3.043

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	81	REV 1
	663	8000	Interlock			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
663-32	8604	85	29	FULL	73.0	2.874

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	82	REV 1
	665	8000	Interlock	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
665-32	8606	85	29	FULL	81	3.189

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	17	REV 12
	111	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
111-04	5501	FULL	17.2	0.677
111-05	5502	FULL	19.8	0.780
111-06	5512	FULL	20.6	0.811
111-08	5502	FULL	23.7	0.933
111-10	5502	FULL	28.5	1.122
111-12	5502	FULL	32.3	1.272
111-16	5502	FULL	43.2	1.701
111-20	5501	FULL	48.9	1.925
111-24	5502	FULL	56.7	2.232
111-32	5502	FULL	70.2	2.764

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	18	REV 09
	122	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
122-04	5502	FULL	17.7	0.697
122-06	5512	FULL	21.8	0.858
122-08	5502	FULL	24.6	0.969
122-10	5502	FULL	29.5	1.161
122-12	5502	FULL	33.2	1.307
122-16	5502	FULL	44.1	1.736
122-20	5502	FULL	53.1	2.091
122-24	5502	FULL	59.6	2.346
122-32	5502	FULL	72.5	2.854

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	37	REV 08
	112	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
112-04	5501	FULL	17.2	0.677
112-05	5502	FULL	19.8	0.780
112-06	5512	FULL	20.5	0.807
112-08	5502	FULL	24.0	0.945
112-10	5502	FULL	28.5	1.122
112-12	5502	FULL	32.3	1.272
112-16	5502	FULL	43.3	1.705

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	33	REV 05
	122	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
122-06	5504	FULL	24.0	0.945
122-08	5504	FULL	27.9	1.098
122-10	5504	FULL	31.5	1.240
122-12	5504	FULL	35.9	1.413
122-16	5504	FULL	43.7	1.720
122-20	5504	FULL	52.8	2.079

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	32	REV 06
	124	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
124-06	5504	FULL	24.4	0.961
124-08	5504	FULL	28.5	1.122
124-10	5504	FULL	32.7	1.287
124-12	5504	FULL	36.3	1.429
124-16	5504	FULL	43.9	1.728
124-20	5504	FULL	52.4	2.063

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	67	REV 01
	141	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
141-12	5503	FULL	33.0	1.299
141-16	5503	FULL	41.1	1.618
141-20	5503	FULL	44.5	1.752
141-24	5503	FULL	51.8	2.039
141-32	5503	FULL	65.6	2.583

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
	151	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

A note on crimping 100R5 hose:

SAE 100R5 series hoses were initially designed as a flexible replacement to copper tubing, which is commonly defined by it's outside diameter. The result is that 100R5 hoses have smaller inside diameters than their nominal size (dash size) would indicate. For example, 151-08, nominally 1/2", actually has an I.D. of 13/32", since that is the I.D. of 1/2" O.D. copper tube. This creates confusion when crimping using inserts and ferrules designed for "full dimension hoses", where the nominal size is the inside diameter (ie. -08 hose is 1/2" I.D.). Be careful to check that selection of the appropriate sized ferrule and insert for the hose you are crimping. Quite often it will be smaller than the dash size of the R5 hose.

Hose	Ferrule	Crimp Insert Size	Crimp Length	Crimp Diameter	
				mm	in
151-04	5503-03	-03	FULL	15.5	0.610
151-05	5503-04	-04	FULL	17.4	0.685
151-06	5503-05	-05	FULL	20.8	0.819
151-08	5503-06	-06	FULL	20.0	0.787
151-10	5503-08	-08	FULL	24.9	0.980
151-12	5503-10	-10	FULL	30.4	1.197
151-16	5503-12	-14	FULL	34.8	1.370
151-20	5503-16	-18	FULL	44.1	1.736
151-24	5503-20	-22	FULL	47.2	1.858

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
151-32	5901-32	-29	FULL	62.7	2.468	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	68	REV 01
	132	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
132-04	5503	FULL	17.7	0.697
132-05	5503	FULL	21.5	0.846
132-06	5503	FULL	20.7	0.815
132-08	5503	FULL	25.7	1.012
132-10	5503	FULL	30.7	1.209
132-12	5503	FULL	34.8	1.370
132-16	5503	FULL	42.6	1.677
132-20	5503	FULL	46.6	1.835

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	77	REV 0
	172	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
172-02	9700	13	13.0	9.1	0.358
172-03	5507		FULL	11.2	0.441
172-04	5507		FULL	14.1	0.555
172-05	5507		FULL	16.7	0.657
172-06	5507		FULL	18.9	0.744
172-08	5507		FULL	23.5	0.925

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	78	REV
	182	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
182-04	5507	FULL	13.9	0.547
182-06	5507	FULL	18.5	0.728
182-08	5508	FULL	22.2	0.874

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	79	REV 0
	173	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
173-04	5507	FULL	14.1	0.555
173-06	5507	FULL	19.0	0.748
173-08	5508	FULL	24.0	0.945

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	58	REV 00
	37AL	5508	Non-Skive			

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
37AL-04	5508		14.2	0.559
37AL-06	5508		19.0	0.748
37AL-08	5508		23.0	0.906

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	21	REV 10
	111	5000	Skive			
				Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
111-04	5904	19	FULL	17.5	0.689
111-05	5904	19	FULL	18.2	0.717
111-06	5904	20	FULL	21.0	0.827
111-08	5904	26	FULL	25.1	0.988
111-10	5904	28	FULL	27.6	1.087
111-12	5904	33	FULL	31.7	1.248
111-16	5904	37	FULL	40.3	1.587
111-20	5901	32	FULL	47.4	1.866
111-24	5901	36	FULL	54.3	2.138
111-32	5901	49	FULL	68.1	2.681

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	22	REV 09
	122	5000	Skive			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
122-04	5904	17	FULL	18.1	0.713
122-05	5904	19	FULL	19.1	0.752
122-06	5904	20	FULL	21.9	0.862
122-08	5904	26	FULL	25.9	1.020
122-10	5904	28	FULL	28.5	1.122
122-12	5904	33	FULL	32.5	1.280
122-16	5904	37	FULL	41.0	1.614
122-20	5904	41	FULL	51.5	2.028
122-24	5904	47	FULL	60.3	2.374
122-32	5904	60	FULL	75.2	2.961

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	23	REV 08
	124	5000	Skive			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
124-06	5905	19	FULL	22.3	0.878
124-08	5905	25	FULL	26.6	1.047
124-10	5904	28	FULL	29.7	1.169
124-12	5904	33	FULL	32.9	1.295
124-16	5904	37	FULL	41.0	1.614
124-20	5904	41	FULL	51.2	2.016
124-24	5904	47	FULL	60.1	2.366
124-32	5904	60	FULL	75.0	2.953

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	26	REV 12
	112	5000	Skive			
				Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
112-04	5904	19	FULL	17.3	0.681
112-05	5904	19	FULL	18.2	0.717
112-06	5904	20	FULL	20.9	0.823
112-08	5904	26	FULL	25.3	0.996
112-10	5904	28	FULL	27.6	1.087
112-12	5904	33	FULL	31.7	1.248
112-16	5904	37	FULL	40.4	1.591

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	27	REV 05
	113	5000	Skive			
				Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
113-08	5904	26	FULL	26.0	1.024
113-10	5904	28	FULL	28.5	1.122
113-12	5904	33	FULL	32.5	1.280
113-16	5904	37	FULL	41.0	1.614

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	24	REV 12
	115	5000	Skive			
				Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
115-06	5905	19	FULL	22.1	0.870
115-08	5905	26	FULL	26.4	1.039
114-10	5904	28	FULL	29.2	1.150
114-12	5904	33	FULL	33.3	1.311
114-16	5904	37	FULL	41.3	1.626
114-20	5904	41	FULL	50.7	1.996
114-24	5904	47	FULL	60.0	2.362
114-32	5904	60	FULL	75.2	2.961

Crimper	Hose	Coupling	Skive	Crimp Instructions	CHART NUMBER 72 REV 01		
	119B 118	5000		Tolerance +/- 0.1mm or +/- 0.004 inches .			
			Cover Skive length		Crimp Length	Crimp Diameter	
	Hose	Ferrule				mm	in
	119B -04 118	5904	19		FULL	17.1	0.673
	119B -06 118	5904	20		FULL	21.0	0.827

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	51	REV 00
	119H	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
119H-06	5904	20	FULL	21.0	0.827

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	53	REV 00
	120J	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Cover Skive Length	Crimp Length	Crimp Diameter	
		mm		mm	in
120J-04	5904	19	FULL	18.1	0.713
120J-06	5904	20	FULL	21.9	0.862

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	56	REV G
	157	4000	Non Skive			

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
157-03	4000	FULL	7.7	0.303
157-04	4000	FULL	8.9	0.350
157-04	4012SS-04 4042SS-04 4092SS-04	FULL	8.3	0.327
157-05	4000	FULL	10.3	0.406
157-06	4000	FULL	12.2	0.480
157-08	4000	FULL	14.5	0.571
157-10	4000	FULL	17.2	0.677
157-12	4000	FULL	20.4	0.803
157-16	4000	FULL	26.6	1.047

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	45	REV 01
	3130	9700	Non-Skive	Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
3130-02	9700	13	13.0mm	9.9	0.390
3130-03	9700	20	20.5mm	12.1	0.476
3130-04	9700	24	24.0mm	14.1	0.555
3130-05	9700	22	22.5mm	16.0	0.630
3130-06	9700	28	28.5mm	17.1	0.673
3130-08	9700	27	27.0mm	21.0	0.827
3130-12	9700	35	35mm	27.4	1.079
3130-16	9700	44	44mm	34	1.339

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	46	REV 01
	3R80	9800	Non-Skive			

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
3R80-03	9800	24	24mm	13.2	0.520
3R80-04	9800	24	24mm	16.6	0.654
3R80-06	9800	28	28.5mm	19.6	0.772
3R80-08	9800	32	32mm	22.4	0.882
3R80-12	9800	34	33.5mm	28.6	1.126
3R80-16	9800	46	46mm	37.1	1.461

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	47	REV 01
	183	9700	Non-Skive	Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
183-08	9800		32mm	ONLY	#Error
183-12	9800		FULL	ONLY	#Error

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	48	REV 00
	170	9700	Non-Skive	Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.		

Hose	Ferrule	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm		mm	in
170-04	9700	24	KNURL	13.8	0.543

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	52	REV 0
	111	9000SB	Skive			

Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
111-03	9000SB	19		17mm	11.6	0.457

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		80	REV 00
	154	8400	Interlock					
Hose	Ferrule	Cover Skive length	Tube Skive Length	Crimp Length	Crimp Diameter			
		mm	mm		mm	in		
154-08	8404	61	18	FULL	29.8	1.173		

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	3	REV 08
	156	8000	Interlock			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
156-12	8604	52	15	FULL	34.0	1.339
156-16	8604	65	17	FULL	42.2	1.661
156-20	8606	74	21.5	FULL	55.8	2.197
156-24	8606	81	22	FULL	63.6	2.504
156-32	8606	85	29	FULL	81.5	3.209

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	5	REV 07
	136	8000	Interlock			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
136-12	8604	52	15	FULL	34.1	1.343
136-16	8604	65	17	FULL	42.1	1.657
136-20	8606	74	21.5	FULL	55.8	2.197
136-24	8606	81	22	FULL	63.6	2.504
136-32	8606	85	29	FULL	81.0	3.189

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	6	REV 08
	115	8000	Interlock			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
115-12	8604	52	15	FULL	34.0	1.339
115-16	8604	65	17	FULL	42.1	1.657
115-20	8604	74	21.5	FULL	51.1	2.012
115-24	8604	81	22	FULL	57.1	2.248
115-32	8604	85	29	FULL	73.0	2.874
115-32	8604	85	29	FULL	73.0	2.874

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	11	REV 00
	141	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Crimp Length	Crimp Diameter	
			mm	in
141-16	5904	FULL	42.2	1.661
141-20	5904	FULL	50.5	1.988
141-24	5904	FULL	60.1	2.366
141-32	5904	FULL	74.9	2.949

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	13	REV 04
	124	8000	Interlock			
			Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Crimp Length	Crimp Diameter	
		mm	mm		mm	in
124-12	8604	52	15	FULL	33.4	1.315
124-16	8604	65	17	FULL	41.7	1.642
124-20	8604	74	21.5	FULL	51.9	2.043
124-24	8604	81	22	FULL	58.0	2.283
124-32	8604	85	29	FULL	73.3	2.886

Crimping Specifications

Hose
184SC SEWER CLEANER HOSE

Coupling
9800

Hose	Ferrule	Fitting Insertion Depth	Crimp Length		Crimp Diameter	
			mm +/- .130	mm +/- .13	in +/- .005	
184SC-12	9800-12 Fitting	44.5	1.750	38.1	30.5	1.202
184SC-16	9800-16 Fitting	54.0	2.125	44.5	37.6	1.481
184SC-12	9800-12 Mender	44.0	1.750	38.1	30.5	1.202
184SC-12	9800-12 Mender	44.0	1.750	34.3	37.6	1.481

Mark the hose at a distance from the end of the hose equal to the "Fitting Insertion Depth".

Install the fitting on the hose so that the mark is even with the end of the ferrule.

Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length".

Crimping Specifications

Hose
185SC SEWER CLEANER HOSE

Coupling
9800

Hose	Ferrule	Fitting Insertion Depth	Crimp Length		Crimp Diameter	
			mm +/- .130	mm +/- .13	in +/- .005	
185SC-12	9800-12 Fitting	44.5	1.750	38.1	30.5	1.202
185SC-16	9800-16 Fitting	54.0	2.125	44.5	37.6	1.481
185SC-12	9800-12 Mender	44.0	1.750	38.1	30.5	1.202
185SC-12	9800-12 Mender	44.0	1.750	34.3	37.6	1.481

Mark the hose at a distance from the end of the hose equal to the "Fitting Insertion Depth".

Install the fitting on the hose so that the mark is even with the end of the ferrule.

Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length".

Crimping Specifications

Hose
G961 & G981 AGRICULTURAL SPRAY HOSE

Coupling
5000

Hose	Ferrule	Hose OD		Crimp Length	Crimp Diameter	
		mm +/- .4	in +/- .015		mm +/- .1	in +/- .004
G961-038	5503-06	18.5	0.729	FULL	19.5	0.768
G961-050	5503-08	22.0	0.867	FULL	23.0	0.906
G961-075	5503-12	31.0	1.221	FULL	32.3	1.273
G981-038	5503-06	18.0	0.709	FULL	19.3	0.760
G981-050	5503-08	22.0	0.867	FULL	23.4	0.922

These specifications are GUIDELINES

*** IF THE CRIMP DOESN'T LOOK RIGHT IT PROBABLY IS NOT RIGHT***

*** These are industrial hoses, and as such, different production batches may vary slightly in outside diameter. Therefore it is absolutely necessary to CHECK THE O.D. of the hose. If it does not match the Hose O.D. given in the chart, the crimp diameter must be adjusted accordingly.****