

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **49** **REV 02**

Finn **111** **9200** **One-Piece**
Power
32 Series

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-04	9200	20	32-16	FULL	16.9	0.665	0.9	_____
111-06	9200	21	32-19	FULL	20.6	0.811	1.6	_____
111-08	9200	26	32-22	FULL	23.7	0.933	1.7	_____
111-12	9200	32	32-30	FULL	31.8	1.252	1.8	_____
111-16	9200	40	32-39	FULL	40.6	1.598	1.6	_____

NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **40** **REV 06**

Finn **111** **9400** **One-Piece**
Power
32 Series

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-10	9400	29	32-30	FULL	30.8	1.213	0.8	_____
111-12	9400	32	32-34	FULL	35.2	1.386	1.2	_____
111-16	9400	39	32-39	FULL	43.1	1.697	4.1	_____
111-20	9400	39	32-45	FULL	50.6	1.992	5.6	_____
111-24	9400	58	32-51	FULL	56.7	2.232	5.7	_____
111-32	9400	58	32-69	FULL	70.2	2.764	1.2	_____

NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	50	REV 02
Finn Power 32 Series	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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-04	9200	20	32-16	FULL	17.7	0.697	1.7	_____
122-06	9200	21	32-19	FULL	21.5	0.846	2.5	_____
122-08	9200	25	32-22	FULL	24.6	0.969	2.6	_____
122-12	9200	32	32-30	FULL	32.9	1.295	2.9	_____
122-16	9200	40	32-39	FULL	41.6	1.638	2.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	57	REV 02
Finn Power 32 Series	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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-06	9400	21	32-22	FULL	24.0	0.945	2.0	_____
122-08	9400	25	32-26	FULL	27.9	1.098	1.9	_____
122-10	9400	29	32-30	FULL	31.5	1.240	1.5	_____
122-12	9400	32	32-34	FULL	35.9	1.413	1.9	_____
122-16	9400	39	32-39	FULL	43.7	1.720	4.7	_____
122-20	9400	39	32-51	FULL	52.8	2.079	1.8	_____
122-24	9400	58	32-57	FULL	59.5	2.343	2.5	_____
122-32	9400	58	32-69	FULL	72.5	2.854	3.5	_____

Crimper	Hose	Coupling	Crimp Instructions			CHART NUMBER		70	REV 02
Finn Power 32 Series	136	9500	One Piece						
Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting		
		mm			mm	in	Approx.	Actual	
136-12	9500	49	32-34	FULL	37.3	1.469	3.3	_____	
136-16	9500	56	32-39	FULL	43.9	1.728	4.9	_____	
136-20	9500	66	32-51	FULL	55.1	2.169	4.1	_____	
136-24	9500	75	32-63	FULL	64.2	2.528	1.2	_____	

Crimper		Hose	Coupling	Crimp Instructions			CHART NUMBER		71	REV 01
Finn Power 32 Series		115	9500	One-piece						
Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting		Approx.	Actual
		mm			mm	in				
115-16	9500	56	32-39	FULL	43.9	1.728	4.9			
115-24	9500	75	32-57	FULL	60.3	2.374	3.3			

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **61** **REV 05**

Finn **112** **9200** **Non-Skive**
Power
32 Series

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	9200	20	32-16	FULL	17.2	0.677	1.2	_____
112-06	9200	21	32-19	FULL	20.6	0.811	1.6	_____
112-08	9200	25	32-22	FULL	24.0	0.945	2.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	42	REV 07
Finn Power 32 Series	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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-06	9400	21	32-22	FULL	24.4	0.961	2.4	_____
124-08	9400	26	32-26	FULL	28.5	1.122	2.5	_____
124-10	9400	29	32-30	FULL	32.7	1.287	2.7	_____
124-12	9400	32	32-34	FULL	36.3	1.429	2.3	_____
124-16	9400	39	32-39	FULL	43.9	1.728	4.9	_____
124-20	9400	39	32-51	FULL	51.5	2.028	0.5	_____
124-24	9400	58	32-57	FULL	59.4	2.339	2.4	_____
124-32	9400	58	32-69	FULL	72.6	2.858	3.6	_____

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

Finn **124S** **9600** **Skive**
Power
32 Series

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124S-12	9600	47	32-30	KNURL	33.1	1.303	3.1	_____
124S-16	9600	50	32-39	KNURL	40.9	1.610	1.9	_____
124S-20	9600	54	32-45	KNURL	49.1	1.933	4.1	_____
124S-24	9600	56	32-51	KNURL	56.0	2.205	5.0	_____
124S-32	9600	82	32-69	KNURL	71.2	2.803	2.2	_____

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

Finn **115** **9600** **Skive**
Power
32 Series

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-08	9600	28	32-22	KNURL	25.9	1.020	3.9	_____
115-12	9600	47	32-30	KNURL	32.1	1.264	2.1	_____
115-16	9600	50	32-39	KNURL	39.9	1.571	0.9	_____
115-20	9600	54	32-45	KNURL	47.6	1.874	2.6	_____

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

Finn **136** **9600** **Skive**
Power
32 Series

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	9600	47	32-30	KNURL	33.2	1.307	3.2	_____
136-16	9600	50	32-39	KNURL	41.0	1.614	2.0	_____

Crimper	Hose	Coupling	Skive	Crimp Instructions	CHART NUMBER		64	REV 05/05
Finn Power 32 Series	156	9600		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.				
		Cover Skive Length		Die	Crimp Length	Crimp Diameter		Dial Setting
	Hose	Ferrule				mm	in	Approx. Actual
	156-16	9600	mm 50	32-39	KNURL	39.9	1.571	0.9 _____

Crimper	Hose	Coupling	Skive	Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
Finn Power 32 Series	663 662	9600		32-69	KNURL	70.4	2.772	1.4	_____

Crimp Instructions
 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.

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	20	REV 06
Finn Power 32 Series	109	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
109-04	5500	32-14	FULL	15.9	0.626	1.9	_____
109-06	5500	32-16	FULL	18.5	0.728	2.5	_____
109-08	5500	32-19	FULL	21.9	0.862	2.9	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		76	REV 00
Finn Power 32 Series	662 663	6500	One-piece					
Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
662 -32	6500	86	32-74	FULL	77.3	3.043	3.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	17	REV 12
Finn Power 32 Series	111	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
111-04	5501	32-16	FULL	17.2	0.677	1.2	_____
111-05	5502	32-19	FULL	19.8	0.780	0.8	_____
111-06	5512	32-19	FULL	20.6	0.811	1.6	_____
111-08	5502	32-22	FULL	23.7	0.933	1.7	_____
111-10	5502	32-26	FULL	28.5	1.122	2.5	_____
111-12	5502	32-30	FULL	32.3	1.272	2.3	_____
111-16	5502	32-39	FULL	43.2	1.701	4.2	_____
111-20	5501	32-45	FULL	48.9	1.925	3.9	_____
111-24	5502	32-51	FULL	56.7	2.232	5.7	_____
111-32	5502	32-69	FULL	70.2	2.764	1.2	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	18	REV 09
Finn Power 32 Series	122	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
122-04	5502	32-16	FULL	17.7	0.697	1.7	_____
122-06	5512	32-19	FULL	21.8	0.858	2.8	_____
122-08	5502	32-22	FULL	24.6	0.969	2.6	_____
122-10	5502	32-26	FULL	29.5	1.161	3.5	_____
122-12	5502	32-30	FULL	33.2	1.307	3.2	_____
122-16	5502	32-39	FULL	44.1	1.736	5.1	_____
122-20	5502	32-51	FULL	53.1	2.091	2.1	_____
122-24	5502	32-57	FULL	59.6	2.346	2.6	_____
122-32	5502	32-69	FULL	72.5	2.854	3.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	37	REV 08
Finn Power 32 Series	112	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
112-04	5501	32-16	FULL	17.2	0.677	1.2	_____
112-05	5502	32-19	FULL	19.8	0.780	0.8	_____
112-06	5512	32-19	FULL	20.5	0.807	1.5	_____
112-08	5502	32-22	FULL	24.0	0.945	2.0	_____
112-10	5502	32-26	FULL	28.5	1.122	2.5	_____
112-12	5502	32-30	FULL	32.3	1.272	2.3	_____
112-16	5502	32-39	FULL	43.3	1.705	4.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	33	REV 05
Finn Power 32 Series	122	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
122-06	5504	32-22	FULL	24.0	0.945	2.0	_____
122-08	5504	32-26	FULL	27.9	1.098	1.9	_____
122-10	5504	32-30	FULL	31.5	1.240	1.5	_____
122-12	5504	32-34	FULL	35.9	1.413	1.9	_____
122-16	5504	32-39	FULL	43.7	1.720	4.7	_____
122-20	5504	32-51	FULL	52.8	2.079	1.8	_____

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

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
124-06	5504	32-22	FULL	24.4	0.961	2.4	_____
124-08	5504	32-26	FULL	28.5	1.122	2.5	_____
124-10	5504	32-30	FULL	32.7	1.287	2.7	_____
124-12	5504	32-34	FULL	36.3	1.429	2.3	_____
124-16	5504	32-39	FULL	43.9	1.728	4.9	_____
124-20	5504	32-51	FULL	52.4	2.063	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	67	REV 01
Finn Power 32 Series	141	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
141-12	5503	32-30	FULL	33.0	1.299	3.0	_____
141-16	5503	32-39	FULL	41.1	1.618	2.1	_____
141-20	5503	32-39	FULL	44.5	1.752	5.5	_____
141-24	5503	32-51	FULL	51.8	2.039	0.8	_____
141-32	5503	32-63	FULL	65.6	2.583	2.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
Finn Power 32 Series	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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
151-04	5503-03	-03	32-14	FULL	15.5	0.610	1.5	_____
151-05	5503-04	-04	32-16	FULL	17.4	0.685	1.4	_____
151-06	5503-05	-05	32-19	FULL	20.8	0.819	1.8	_____
151-08	5503-06	-06	32-19	FULL	20.0	0.787	1.0	_____
151-10	5503-08	-08	32-22	FULL	24.9	0.980	2.9	_____
151-12	5503-10	-10	32-30	FULL	30.4	1.197	0.4	_____
151-16	5503-12	-14	32-34	FULL	34.8	1.370	0.8	_____
151-20	5503-16	-18	32-39	FULL	44.1	1.736	5.1	_____
151-24	5503-20	-22	32-45	FULL	47.2	1.858	2.2	_____
151-32	5901-32	-29	32-57	FULL	62.7	2.468	5.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	68	REV 01
Finn Power 32 Series	132	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
132-04	5503	32-16	FULL	17.7	0.697	1.7	_____
132-05	5503	32-19	FULL	21.5	0.846	2.5	_____
132-06	5503	32-19	FULL	20.7	0.815	1.7	_____
132-08	5503	32-22	FULL	25.7	1.012	3.7	_____
132-10	5503	32-30	FULL	30.7	1.209	0.7	_____
132-12	5503	32-34	FULL	34.8	1.370	0.8	_____
132-16	5503	32-39	FULL	42.6	1.677	3.6	_____
132-20	5503	32-45	FULL	46.6	1.835	1.6	_____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		77	REV 0
Finn Power 32 Series		172	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting		Actual
		mm			mm	in	Approx.		
172-03	5507		32-10	FULL	11.2	0.441	1.2	_____	
172-04	5507		32-14	FULL	14.1	0.555	0.1	_____	
172-05	5507		32-16	FULL	16.7	0.657	0.7	_____	
172-06	5507		32-16	FULL	18.9	0.744	2.9	_____	
172-08	5507		32-22	FULL	23.5	0.925	1.5	_____	

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		78	REV
Finn Power 32 Series	182	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting		Actual
				mm	in	Approx.		
182-04	5507	32-12	FULL	13.9	0.547	1.9		_____
182-06	5507	32-16	FULL	18.5	0.728	2.5		_____
182-08	5508	32-22	FULL	22.2	0.874	0.2		_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		79	REV 0
Finn Power 32 Series	173	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting		Actual
				mm	in	Approx.		
173-04	5507	32-14	FULL	14.1	0.555	0.1		_____
173-06	5507	32-19	FULL	19.0	0.748	0.0		_____
173-08	5508	32-22	FULL	24.0	0.945	2.0		_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER		58	REV 00
Finn Power 32 Series	37AL	5508	Non-Skive				
Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
37AL-04	5508	32-14		14.2	0.559	0.2	_____
37AL-06	5508	32-19		19.0	0.748	0.0	_____
37AL-08	5508	32-22		23.0	0.906	1.0	_____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		21	REV 10
Finn Power 32 Series		111	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting		
		mm			mm	in	Approx.	Actual	
111-04	5904	19	32-16	FULL	17.5	0.689	1.5	_____	
111-05	5904	19	32-16	FULL	18.2	0.717	2.2	_____	
111-06	5904	20	32-19	FULL	21.0	0.827	2.0	_____	
111-08	5904	26	32-22	FULL	25.1	0.988	3.1	_____	
111-10	5904	28	32-26	FULL	27.6	1.087	1.6	_____	
111-12	5904	33	32-30	FULL	31.7	1.248	1.7	_____	
111-16	5904	37	32-39	FULL	40.3	1.587	1.3	_____	
111-20	5901	32	32-45	FULL	47.4	1.866	2.4	_____	
111-24	5901	36	32-51	FULL	54.3	2.138	3.3	_____	
111-32	5901	49	32-63	FULL	68.1	2.681	5.1	_____	

NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		22	REV 09
Finn Power 32 Series		122	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting		
		mm			mm	in	Approx.	Actual	
122-04	5904	17	32-16	FULL	18.1	0.713	2.1	_____	
122-05	5904	19	32-19	FULL	19.1	0.752	0.1	_____	
122-06	5904	20	32-19	FULL	21.9	0.862	2.9	_____	
122-08	5904	26	32-22	FULL	25.9	1.020	3.9	_____	
122-10	5904	28	32-26	FULL	28.5	1.122	2.5	_____	
122-12	5904	33	32-30	FULL	32.5	1.280	2.5	_____	
122-16	5904	37	32-39	FULL	41.0	1.614	2.0	_____	
122-20	5904	41	32-51	FULL	51.5	2.028	0.5	_____	
122-24	5904	47	32-57	FULL	60.3	2.374	3.3	_____	
122-32	5904	60	32-74	FULL	75.2	2.961	1.2	_____	

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		23	REV 08
Finn Power 32 Series		124	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting		
		mm			mm	in	Approx.	Actual	
124-06	5905	19	32-22	FULL	22.3	0.878	0.3	_____	
124-08	5905	25	32-26	FULL	26.6	1.047	0.6	_____	
124-10	5904	28	32-26	FULL	29.7	1.169	3.7	_____	
124-12	5904	33	32-30	FULL	32.9	1.295	2.9	_____	
124-16	5904	37	32-39	FULL	41.0	1.614	2.0	_____	
124-20	5904	41	32-51	FULL	51.2	2.016	0.2	_____	
124-24	5904	47	32-57	FULL	60.1	2.366	3.1	_____	
124-32	5904	60	32-74	FULL	75.0	2.953	1.0	_____	

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		26	REV 12
Finn Power 32 Series		112	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting		
		mm			mm	in	Approx.	Actual	
112-04	5904	19	32-16	FULL	17.3	0.681	1.3	_____	
112-05	5904	19	32-16	FULL	18.2	0.717	2.2	_____	
112-06	5904	20	32-19	FULL	20.9	0.823	1.9	_____	
112-08	5904	26	32-22	FULL	25.3	0.996	3.3	_____	
112-10	5904	28	32-26	FULL	27.6	1.087	1.6	_____	
112-12	5904	33	32-30	FULL	31.7	1.248	1.7	_____	
112-16	5904	37	32-39	FULL	40.4	1.591	1.4	_____	

NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER		27	REV 05
Finn Power 32 Series	113	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
		Cover Skive Length		Die	Crimp Length	Crimp Diameter		Dial Setting
	Hose	Ferrule				mm	in	Approx. Actual
	113-08	5904	26	32-26	FULL	26.0	1.024	0.0 _____
	113-10	5904	28	32-26	FULL	28.5	1.122	2.5 _____
	113-12	5904	33	32-30	FULL	32.5	1.280	2.5 _____
	113-16	5904	37	32-39	FULL	41.0	1.614	2.0 _____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		24	REV 12
Finn Power 32 Series		115	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting		
					mm	in	Approx.	Actual	
115-06	5905	19	32-22	FULL	22.1	0.870	0.1	_____	
115-08	5905	26	32-26	FULL	26.4	1.039	0.4	_____	
114-10	5904	28	32-26	FULL	29.2	1.150	3.2	_____	
114-12	5904	33	32-30	FULL	33.3	1.311	3.3	_____	
114-16	5904	37	32-39	FULL	41.3	1.626	2.3	_____	
114-20	5904	41	32-45	FULL	50.7	1.996	5.7	_____	
114-24	5904	47	32-57	FULL	60.0	2.362	3.0	_____	
114-32	5904	60	32-74	FULL	75.2	2.961	1.2	_____	

NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		72	REV 01
Finn	Power	119B	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
32 Series			Cover Skive length	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule					mm	in	Approx.	Actual
119B -04	5904		19	32-16	FULL	17.1	0.673	1.1	_____
119B -06	5904		20	32-19	FULL	21.0	0.827	2.0	_____

Crimper		Hose	Coupling	Skive	Crimp Instructions	CHART NUMBER		51	REV 00
Finn Power 32 Series		119H	5000		Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting		Actual
		mm			mm	in	Approx.		
119H-06	5904	20	32-19	FULL	21.0	0.827	2.0		_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER		53	REV 00
Finn Power 32 Series	120J	5000	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
		Cover Skive Length		Die	Crimp Length	Crimp Diameter		Dial Setting
	Hose	Ferrule				mm	in	Approx. Actual
	120J-04	5904	19	32-16	FULL	18.1	0.713	2.1 _____
	120J-06	5904	20	32-19	FULL	21.9	0.862	2.9 _____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		56	REV G
Finn Power 32 Series		157	4000	Non Skive					
Hose	Ferrule			Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
157-05	4000			32-10	FULL	10.3	0.406	0.3	_____
157-06	4000			32-12	FULL	12.2	0.480	0.2	_____
157-08	4000			32-14	FULL	14.5	0.571	0.5	_____
157-10	4000			32-16	FULL	17.2	0.677	1.2	_____
157-12	4000			32-19	FULL	20.4	0.803	1.4	_____
157-16	4000			32-26	FULL	26.6	1.047	0.6	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **45** **REV 01**

Finn **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.

Power

32 Series

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
3130-03	9700	20	32-12	20.5mm	12.1	0.476	0.1	_____
3130-04	9700	24	32-14	24.0mm	14.1	0.555	0.1	_____
3130-05	9700	22	32-16	22.5mm	16.0	0.630	0.0	_____
3130-06	9700	28	32-16	28.5mm	17.1	0.673	1.1	_____
3130-08	9700	27	32-19	27.0mm	21.0	0.827	2.0	_____
3130-12	9700	35	32-26	35mm	27.4	1.079	1.4	_____

Crimper		Hose	Coupling	Crimp Instructions			CHART NUMBER		46	REV 01
Finn Power 32 Series		3R80	9800	Non-Skive						
Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting		Approx.	Actual
		mm			mm	in				
3R80-03	9800	24	32-12	24mm	13.2	0.520	1.2			
3R80-04	9800	24	32-16	24mm	16.6	0.654	0.6			
3R80-06	9800	28	32-19	28.5mm	19.6	0.772	0.6			
3R80-08	9800	32	32-22	32mm	22.4	0.882	0.4			
3R80-12	9800	34	32-26	33.5mm	28.6	1.126	2.6			
3R80-16	9800	46	32-34	46mm	37.1	1.461	3.1			

Crimper		Hose	Coupling	Non-Skive	Crimp Instructions	CHART NUMBER		47	REV 01
Finn Power 32 Series		183	9700		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		Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm				mm	in	Approx.	Actual

Crimper		Hose	Coupling	Non-Skive	Crimp Instructions	CHART NUMBER		48	REV 00
Finn Power 32 Series		170	9700		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	Die	Crimp Length	Crimp Diameter		Dial Setting		Actual
		mm			mm	in			
170-04	9700	24	32-12	KNURL	13.8	0.543	1.8		_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		52	REV 0	
Finn Power 32 Series	111	9000SB	Skive						
Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
111-03	9000SB	19		32-10	17mm	11.6	0.457	1.6	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		80	REV 00	
Finn Power 32 Series	154	8400	Interlock						
Hose	Ferrule	Cover Skive length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
154-08	8404	61	18	32-26	FULL	29.8	1.173	3.8	_____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		3	REV 08
Finn Power 32 Series		156	8000	Interlock					
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
156-12	8604	52	15	32-34	FULL	34.0	1.339	0.0	_____
156-16	8604	65	17	32-39	FULL	42.2	1.661	3.2	_____
156-20	8606	74	21.5	32-51	FULL	55.8	2.197	4.8	_____
156-24	8606	81	22	32-63	FULL	63.6	2.504	0.6	_____
156-32	8606	85	29	32-78	FULL	81.5	3.209	3.5	_____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		5	REV 07
Finn Power 32 Series		136	8000	Interlock					
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
136-12	8604	52	15	32-34	FULL	34.1	1.343	0.1	_____
136-16	8604	65	17	32-39	FULL	42.1	1.657	3.1	_____
136-20	8606	74	21.5	32-51	FULL	55.8	2.197	4.8	_____
136-24	8606	81	22	32-63	FULL	63.6	2.504	0.6	_____
136-32	8606	85	29	32-78	FULL	81.0	3.189	3.0	_____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		6	REV 08
Finn Power 32 Series		115	8000	Interlock					
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
115-12	8604	52	15	32-34	FULL	34.0	1.339	0.0	_____
115-16	8604	65	17	32-39	FULL	42.1	1.657	3.1	_____
115-20	8604	74	21.5	32-51	FULL	51.1	2.012	0.1	_____
115-24	8604	81	22	32-57	FULL	57.1	2.248	0.1	_____
115-32	8604	85	29	32-69	FULL	73.0	2.874	4.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	11	REV 00
Finn Power 32 Series	141	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
141-16	5904	32-39	FULL	42.2	1.661	3.2	_____
141-20	5904	32-45	FULL	50.5	1.988	5.5	_____
141-24	5904	32-57	FULL	60.1	2.366	3.1	_____
141-32	5904	32-74	FULL	74.9	2.949	0.9	_____

Crimper		Hose	Coupling	Crimp Instructions		CHART NUMBER		13	REV 04
Finn Power 32 Series		124	8000	Interlock					
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
124-12	8604	52	15	32-30	FULL	33.4	1.315	3.4	_____
124-16	8604	65	17	32-39	FULL	41.7	1.642	2.7	_____
124-20	8604	74	21.5	32-51	FULL	51.9	2.043	0.9	_____
124-24	8604	81	22	32-57	FULL	58.0	2.283	1.0	_____
124-32	8604	85	29	32-69	FULL	73.3	2.886	4.3	_____

Crimper Hose Coupling

Crimp Instructions

CHART NUMBER

13

REV 04

NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.