

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	49	REV 02
K24	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	Die	Crimp Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
111-04	9200	20	0.600	FLUSH	FULL	16.9	0.665	70	_____
		Alternate	0.500	FLUSH					0.500
111-06	9200	21	0.750	FLUSH	FULL	20.6	0.811	71	_____
		Alternate							
111-08	9200	26	0.915	FLUSH	FULL	23.7	0.933	76	_____
		Alternate	0.750	HIT TWICE					0.750

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

K24 **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	Die	Crimp Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
111-10	9400	29	1.050	HIT TWICE	FULL	30.8	1.213	65	_____
		Alternate							
111-12	9400	32	1.275	BELOW 1/2	FULL	35.2	1.386	68	_____
		Alternate							
111-16	9400	39	65		FULL	43.1	1.697	LUSH	_____
		Alternate							
111-20	9400	39	59		FULL	50.6	1.992	LUSH	_____
		Alternate							
111-24	9400	58	1.975	3/4" above hit twice	FULL	56.7	2.232	56	_____
		Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **50** **REV 02**

K24 **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 Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
122-04	9200	20	0.600	FLUSH	FULL	17.7	0.697	67	_____
		Alternate	0.500	FLUSH					0.500
122-06	9200	21	0.750	FLUSH	FULL	21.5	0.846	69	_____
		Alternate							
122-08	9200	25	0.915	FLUSH	FULL	24.6	0.969	73	_____
		Alternate	0.750	HIT TWICE					0.750

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** **57** **REV 02**

K24 **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 Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
122-06	9400	21	0.915	BELOW 1/4	FULL	24.0	0.945	75	_____
		Alternate							
122-08	9400	25	0.915	FLUSH	FULL	27.9	1.098	65	_____
		Alternate		1.050	HIT TWICE			1.050	
122-10	9400	29	1.050	HIT TWICE	FULL	31.5	1.240	63	_____
		Alternate							
122-12	9400	32	1.275	BELOW 1/2	FULL	35.9	1.413	66	_____
		Alternate							
122-16	9400	39	1.550	FLUSH	FULL	43.7	1.720	64	_____
		Alternate							
122-20	9400	39	1.750	FLUSH	FULL	52.8	2.079	52	_____
		Alternate							
122-24	9400	58	1.975	3/4" above hit twice	FULL	59.5	2.343	48	_____
		Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **42** **REV 07**

K24 **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 Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
124-06	9400	21	0.915	BELOW 1/4	FULL	24.4	0.961	74	_____
Alternate									
124-08	9400	26	0.915	FLUSH	FULL	28.5	1.122	63	_____
Alternate 1.50 HIT TWICE 1.50									
124-10	9400	29	1.050	HIT TWICE	FULL	32.7	1.287	59	_____
Alternate									
124-12	9400	32	1.275	BELOW 1/2	FULL	36.3	1.429	65	_____
Alternate									
124-24	9400	58	1.975	3/4" above hit twice	FULL	59.4	2.339	48	_____
Alternate									

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **41** **REV 06**

K24 **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 Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
122-10	9400	29	1.050	HIT TWICE	FULL	31.5	1.240	63	_____
		Alternate							
122-12	9400	32	1.275	BELOW 1/2	FULL	35.9	1.413	66	_____
		Alternate							
122-16	9400	39	1.550	FLUSH	FULL	43.7	1.720	64	_____
		Alternate							
122-20	9400	39	1.750	FLUSH	FULL	52.8	2.079	52	_____
		Alternate							
122-24	9400	58	1.975	3/4" above hit twice	FULL	59.5	2.343	48	_____
		Alternate							

Crimper Hose Coupling

Crimp Instructions

CHART NUMBER

41

REV 06

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.