

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	49	REV 02
PULSAR 111 P20		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
111-04	9200	20	#1 GREY	FULL	16.9	0.665	4.32	_____
111-06	9200	21	#2 GREY	FULL	20.6	0.811	4.76	_____
111-08	9200	26	#3 GREY	FULL	23.7	0.933	4.31	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	40	REV 06
PULSAR 111 P20		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
111-10	9400	29	#4 GREY	FULL	30.8	1.213	3.28	_____
111-12	9400	32	#5 BLACK	FULL	35.2	1.386	4.68	_____
111-16	9400	39	#6 BLACK	FULL	43.1	1.697	4.68	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	50	REV 02
PULSAR 122 P20		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	#2 GREY	FULL	17.7	0.697	5.98	_____
122-06	9200	21	#2 GREY	FULL	21.5	0.846	4.36	_____
122-08	9200	25	#3 GREY	FULL	24.6	0.969	3.91	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	57	REV 02
PULSAR 122 P20	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	#3 GREY	FULL	24.0	0.945	4.18	_____
122-08	9400	25	#4 GREY	FULL	27.9	1.098	4.57	_____
122-10	9400	29	#4 GREY	FULL	31.5	1.240	2.97	_____
122-12	9400	32	#5 BLACK	FULL	35.9	1.413	4.37	_____
122-16	9400	39	#6 BLACK	FULL	43.7	1.720	4.41	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	61	REV 05
PULSAR 112 P20		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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	9200	20	#1 GREY	FULL	17.2	0.677	4.19	_____
112-06	9200	21	#2 GREY	FULL	20.6	0.811	4.76	_____
112-08	9200	25	#3 GREY	FULL	24.0	0.945	4.18	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	42	REV 07
PULSAR 124 P20	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	#3 GREY	FULL	24.4	0.961	4.20	_____
124-08	9400	26	#4 GREY	FULL	28.5	1.122	4.32	_____
124-10	9400	29	#5 BLACK	FULL	32.7	1.287	5.79	_____
124-12	9400	32	#5 BLACK	FULL	36.3	1.429	4.19	_____
124-16	9400	39	#6 BLACK	FULL	43.9	1.728	4.32	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	20	REV 06
PULSAR 109 P20		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	#1 GREY	FULL	15.9	0.626	4.76	_____
109-06	5500	#2 GREY	FULL	18.5	0.728	5.63	_____
109-08	5500	#2 GREY	FULL	21.9	0.862	4.18	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	17	REV 12
PULSAR 111 P20	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	#1 GREY	FULL	17.2	0.677	4.19	_____
111-05	5502	#2 GREY	FULL	19.8	0.780	5.11	_____
111-06	5512	#2 GREY	FULL	20.6	0.811	4.76	_____
111-08	5502	#3 GREY	FULL	23.7	0.933	4.31	_____
111-10	5502	#4 GREY	FULL	28.5	1.122	4.32	_____
111-12	5502	#5 BLACK	FULL	32.3	1.272	5.97	_____
111-16	5502	#6 BLACK	FULL	43.2	1.701	4.63	_____
111-20	5501	#6 BLACK	FULL	48.9	1.925	2.06	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	18	REV 09
PULSAR 122 P20		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	#2 GREY	FULL	17.7	0.697	5.98	_____
122-06	5512	#2 GREY	FULL	21.8	0.858	4.22	_____
122-08	5502	#3 GREY	FULL	24.6	0.969	3.91	_____
122-10	5502	#4 GREY	FULL	29.5	1.161	3.86	_____
122-12	5502	#5 BLACK	FULL	33.2	1.307	5.57	_____
122-16	5502	#6 BLACK	FULL	44.1	1.736	4.23	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	37	REV 08
PULSAR 112 P20		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	#1 GREY	FULL	17.2	0.677	4.19	_____
112-05	5502	#2 GREY	FULL	19.8	0.780	5.11	_____
112-06	5512	#2 GREY	FULL	20.5	0.807	4.82	_____
112-08	5502	#3 GREY	FULL	24.0	0.945	4.18	_____
112-10	5502	#4 GREY	FULL	28.5	1.122	4.32	_____
112-12	5502	#5 BLACK	FULL	32.3	1.272	5.97	_____
112-16	5502	#6 BLACK	FULL	43.3	1.705	4.59	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	33	REV 05
PULSAR 122 P20		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	#3 GREY	FULL	24.0	0.945	4.18	_____
122-08	5504	#4 GREY	FULL	27.9	1.098	4.57	_____
122-10	5504	#4 GREY	FULL	31.5	1.240	2.97	_____
122-12	5504	#5 BLACK	FULL	35.9	1.413	4.37	_____
122-16	5504	#6 BLACK	FULL	43.7	1.720	4.41	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	32	REV 06
PULSAR 124 P20		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	#3 GREY	FULL	24.4	0.961	4.20	_____
124-08	5504	#4 GREY	FULL	28.5	1.122	4.32	_____
124-10	5504	#5 BLACK	FULL	32.7	1.287	5.79	_____
124-12	5504	#5 BLACK	FULL	36.3	1.429	4.19	_____
124-16	5504	#6 BLACK	FULL	43.9	1.728	4.32	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	67	REV 01
PULSAR 141 P20		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	#5 BLACK	FULL	33.0	1.299	5.66	_____
141-16	5503	#6 BLACK	FULL	41.1	1.618	5.56	_____
141-20	5503	#6 BLACK	FULL	44.5	1.752	4.52	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **59** **REV 07**

PULSAR 151 5000 Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .

P20

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
151-05	5503-04	-04	#1 GREY	FULL	17.4	0.685	4.12	_____
151-06	5503-05	-05	#2 GREY	FULL	20.8	0.819	4.67	_____
151-08	5503-06	-06	#2 GREY	FULL	20.0	0.787		_____
151-10	5503-08	-08	#4 GREY	FULL	24.9	0.980	5.92	_____
151-12	5503-10	-10	#4 GREY	FULL	30.4	1.197	3.46	_____
151-16	5503-12	-14	#5 BLACK	FULL	34.8	1.370	4.86	_____
151-20	5503-16	-18	#6 BLACK	FULL	44.1	1.736	4.23	_____
151-24	5503-20	-22	#6 BLACK	FULL	47.2	1.858	2.86	_____

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	68	REV 01
PULSAR 132 P20		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	#2 GREY	FULL	17.7	0.697	5.98	_____
132-05	5503	#2 GREY	FULL	21.5	0.846	4.36	_____
132-06	5503	#2 GREY	FULL	20.7	0.815	4.71	_____
132-08	5503	#4 GREY	FULL	25.7	1.012	5.55	_____
132-10	5503	#4 GREY	FULL	30.7	1.209	3.33	_____
132-12	5503	#5 BLACK	FULL	34.8	1.370	4.86	_____
132-16	5503	#6 BLACK	FULL	42.6	1.677	4.92	_____
132-20	5503	#6 BLACK	FULL	46.6	1.835	3.12	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	77	REV 0
PULSAR 172 P20		5000 Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
172-04	5507	#1 GREY	FULL	14.1	0.555	5.56	_____
172-05	5507	#1 GREY	FULL	16.7	0.657	4.41	_____
172-06	5507	#2 GREY	FULL	18.9	0.744	5.45	_____
172-08	5507	#3 GREY	FULL	23.5	0.925	4.42	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		78	REV
PULSAR 182 P20		5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose	Ferrule		Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
182-04	5507		#1 GREY	FULL	13.9	0.547	5.65	_____
182-06	5507		#2 GREY	FULL	18.5	0.728	5.63	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	79	REV 0
PULSAR 173 P20		5000 Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
173-04	5507	#1 GREY	FULL	14.1	0.555	5.56	_____
173-06	5507	#2 GREY	FULL	19.0	0.748	5.41	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	58	REV 00
PULSAR 37AL P20		5508	Non-Skive			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
37AL-04	5508	#1 GREY		14.2	0.559	5.52	_____
37AL-06	5508	#2 GREY		19.0	0.748	5.41	_____
37AL-08	5508	#3 GREY		23.0	0.906	4.62	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **21** **REV 10**

PULSAR 111 5000 Skive Tolerance +/- 0.1mm or +/- 0.004 inches .
P20

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-04	5904	19	#1 GREY	FULL	17.5	0.689	4.52	_____
111-05	5904	19	#2 GREY	FULL	18.2	0.717	5.76	_____
111-06	5904	20	#2 GREY	FULL	21.0	0.827	4.58	_____
111-08	5904	26	#4 GREY	FULL	25.1	0.988	5.81	_____
111-10	5904	28	#4 GREY	FULL	27.6	1.087	4.72	_____
111-12	5904	33	#4 GREY	FULL	31.7	1.248	2.88	_____
111-16	5904	37	#6 BLACK	FULL	40.3	1.587	5.92	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	22	REV 09
PULSAR 122 P20		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
122-04	5904	17	#2 GREY	FULL	18.1	0.713	5.81	_____
122-05	5904	19	#2 GREY	FULL	19.1	0.752	5.36	_____
122-06	5904	20	#2 GREY	FULL	21.9	0.862	4.18	_____
122-08	5904	26	#4 GREY	FULL	25.9	1.020	5.46	_____
122-10	5904	28	#4 GREY	FULL	28.5	1.122	4.32	_____
122-12	5904	33	#5 BLACK	FULL	32.5	1.280	5.88	_____
122-16	5904	37	#6 BLACK	FULL	41.0	1.614	5.61	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **23** **REV 08**

PULSAR 124 5000 Skive Tolerance +/- 0.1mm or +/- 0.004 inches .

P20

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-06	5905	19	#2 GREY	FULL	22.3	0.878	4.20	_____
124-08	5905	25	#4 GREY	FULL	26.6	1.047	5.15	_____
124-10	5904	28	#4 GREY	FULL	29.7	1.169	3.77	_____
124-12	5904	33	#5 BLACK	FULL	32.9	1.295	5.72	_____
124-16	5904	37	#6 BLACK	FULL	41.0	1.614	5.61	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **26** **REV 12**

PULSAR 112 5000 Skive Tolerance +/- 0.1mm or +/- 0.004 inches .

P20

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	5904	19	#1 GREY	FULL	17.3	0.681	4.14	_____
112-05	5904	19	#2 GREY	FULL	18.2	0.717	5.76	_____
112-06	5904	20	#2 GREY	FULL	20.9	0.823	4.62	_____
112-08	5904	26	#4 GREY	FULL	25.3	0.996	5.72	_____
112-10	5904	28	#4 GREY	FULL	27.6	1.087	4.72	_____
112-12	5904	33	#4 GREY	FULL	31.7	1.248	2.88	_____
112-16	5904	37	#6 BLACK	FULL	40.4	1.591	5.87	_____

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
PULSAR 113 P20		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
113-08	5904	26	#4 GREY	FULL	26.0	1.024	5.41	_____
113-10	5904	28	#4 GREY	FULL	28.5	1.122	4.32	_____
113-12	5904	33	#5 BLACK	FULL	32.5	1.280	5.88	_____
113-16	5904	37	#6 BLACK	FULL	41.0	1.614	5.61	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	24	REV 12
PULSAR 115 P20		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	#2 GREY	FULL	22.1	0.870	4.92	_____
115-08	5905	26	#4 GREY	FULL	26.4	1.039	5.23	_____
114-10	5904	28	#4 GREY	FULL	29.2	1.150	3.99	_____
114-12	5904	33	#5 BLACK	FULL	33.3	1.311	5.52	_____
114-16	5904	37	#6 BLACK	FULL	41.3	1.626	5.47	_____
114-20	5904	41	#6 BLACK	FULL	50.7	1.996	1.16	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		72	REV 01
PULSAR P20	119B 118	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
119B -04	5904	19	#1 GREY	FULL	17.1	0.673	4.23	_____
119B -06	5904	20	#2 GREY	FULL	21.0	0.827	4.58	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		51	REV 00
PULSAR 119H P20		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
119H-06	5904	20	#2 GREY	FULL	21.0	0.827	4.58	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		53	REV 00
PULSAR 120J P20		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
120J-04	5904	19	#2 GREY	FULL	18.1	0.713	5.81	_____
120J-06	5904	20	#2 GREY	FULL	21.9	0.862	4.18	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	56	REV G
PULSAR 157 P20		4000	Non Skive			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
157-08	4000	#1 GREY	FULL	14.5	0.571	5.38	_____
157-10	4000	#1 GREY	FULL	17.2	0.677	4.19	_____
157-12	4000	#2 GREY	FULL	20.4	0.803	4.84	_____
157-16	4000	#4 GREY	FULL	26.6	1.047	5.15	_____

Crimper	Hose	Coupling	Crimp Instructions			CHART NUMBER		52	REV 0
PULSAR 111 P20		9000SB	Skive						
Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	11	REV 00
PULSAR 141 P20		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	#6 BLACK	FULL	42.2	1.661	5.72	_____
141-20	5904	#6 BLACK	FULL	50.5	1.988	1.26	_____

Crimper Hose Coupling

Crimp Instructions

CHART NUMBER

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REV 00