

| Crimper     | Hose | Coupling | Crimp Instructions | CHART NUMBER  | 49 | REV 02 |
|-------------|------|----------|--------------------|---|----|--------|
| PC707<br>6D | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 111-04 | 9200    | 20                             | G   | FULL            | 16.9           | 0.665 | 0.15         | _____  |
| 111-06 | 9200    | 21                             | J   | FULL            | 20.6           | 0.811 | 0.1          | _____  |
| 111-08 | 9200    | 26                             | L   | FULL            | 23.7           | 0.933 | 1.85         | _____  |
| 111-12 | 9200    | 32                             | P   | FULL            | 31.8           | 1.252 | 3.4          | _____  |
| 111-16 | 9200    | 40                             | S   | FULL            | 40.6           | 1.598 | 5.65         | _____  |

| Crimper     | Hose | Coupling |           | Crimp Instructions  | CHART NUMBER | 40 | REV 06 |
|-------------|------|----------|-----------|---|--------------|----|--------|
| PC707<br>6D | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 111-10 | 9400    | 29                             | P   | FULL            | 30.8           | 1.213 | 1.45         | _____  |
| 111-12 | 9400    | 32                             | P   | FULL            | 35.2           | 1.386 | 10           | _____  |
| 111-20 | 9400    | 39                             | AA  | FULL            | 50.6           | 1.992 | 2.8          | _____  |

| Crimper     | Hose | Coupling |           | Crimp Instructions  | CHART NUMBER | 50 | REV 02 |
|-------------|------|----------|-----------|---|--------------|----|--------|
| PC707<br>6D | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 122-04 | 9200    | 20                             | G   | FULL            | 17.7           | 0.697 | 1.7          | _____  |
| 122-06 | 9200    | 21                             | J   | FULL            | 21.5           | 0.846 | 1.9          | _____  |
| 122-08 | 9200    | 25                             | L   | FULL            | 24.6           | 0.969 | 3.6          | _____  |
| 122-12 | 9200    | 32                             | P   | FULL            | 32.9           | 1.295 | 5.6          | _____  |
| 122-16 | 9200    | 40                             | S   | FULL            | 41.6           | 1.638 | 7.6          | _____  |

| Crimper     | Hose | Coupling |           | Crimp Instructions  | CHART NUMBER | 57 | REV 02 |
|-------------|------|----------|-----------|---|--------------|----|--------|
| PC707<br>6D | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 122-06 | 9400    | 21                             | L   | FULL            | 24.0           | 0.945 | 2.4          | _____  |
| 122-08 | 9400    | 25                             | N   | FULL            | 27.9           | 1.098 | 3.3          | _____  |
| 122-10 | 9400    | 29                             | P   | FULL            | 31.5           | 1.240 | 2.85         | _____  |
| 122-20 | 9400    | 39                             | AA  | FULL            | 52.8           | 2.079 | 7.1          | _____  |

| Crimper     | Hose | Coupling |           | Crimp Instructions  | CHART NUMBER | 61 | REV 05 |
|-------------|------|----------|-----------|---|--------------|----|--------|
| PC707<br>6D | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 112-04 | 9200    | 20                             | G   | FULL            | 17.2           | 0.677 | 0.75         | _____  |
| 112-06 | 9200    | 21                             | J   | FULL            | 20.6           | 0.811 | 0.1          | _____  |
| 112-08 | 9200    | 25                             | L   | FULL            | 24.0           | 0.945 | 2.4          | _____  |

|                |             |                 |           |   |                     |           |               |
|----------------|-------------|-----------------|-----------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |           | <b>Crimp Instructions</b>   | <b>CHART NUMBER</b> | <b>42</b> | <b>REV 07</b> |
| PC707<br>6D    | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 124-06 | 9400    | 21                             | L   | FULL            | 24.4           | 0.961 | 3.2          | _____  |
| 124-08 | 9400    | 26                             | N   | FULL            | 28.5           | 1.122 | 4.5          | _____  |
| 124-10 | 9400    | 29                             | P   | FULL            | 32.7           | 1.287 | 5.2          | _____  |
| 124-20 | 9400    | 39                             | AA  | FULL            | 51.5           | 2.028 | 4.55         | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>20</b> | <b>REV 06</b> |
| PC707<br>6D    | 109         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 109-04 | 5500    | E   | FULL         | 15.9           | 0.626 | 0.65         | _____  |
| 109-06 | 5500    | G   | FULL         | 18.5           | 0.728 | 3.3          | _____  |
| 109-08 | 5500    | J   | FULL         | 21.9           | 0.862 | 2.7          | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>17</b> | <b>REV 12</b> |
| PC707<br>6D    | 111         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 111-04 | 5501    | G   | FULL         | 17.2           | 0.677 | 0.75         | _____  |
| 111-05 | 5502    | H   | FULL         | 19.8           | 0.780 | 2.35         | _____  |
| 111-06 | 5512    | J   | FULL         | 20.6           | 0.811 | 0.1          | _____  |
| 111-08 | 5502    | L   | FULL         | 23.7           | 0.933 | 1.85         | _____  |
| 111-10 | 5502    | N   | FULL         | 28.5           | 1.122 | 4.5          | _____  |
| 111-12 | 5502    | P   | FULL         | 32.3           | 1.272 | 4.4          | _____  |
| 111-20 | 5501    | U   | FULL         | 48.9           | 1.925 | 1.4          | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>18</b> | <b>REV 09</b> |
| PC707<br>6D    | 122         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 122-04 | 5502    | G   | FULL         | 17.7           | 0.697 | 1.7          | _____  |
| 122-06 | 5512    | J   | FULL         | 21.8           | 0.858 | 2.5          | _____  |
| 122-08 | 5502    | L   | FULL         | 24.6           | 0.969 | 3.6          | _____  |
| 122-10 | 5502    | N   | FULL         | 29.5           | 1.161 | 6.45         | _____  |
| 122-12 | 5502    | P   | FULL         | 33.2           | 1.307 | 6.2          | _____  |
| 122-20 | 5502    | AA  | FULL         | 53.1           | 2.091 | 7.7          | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>37</b> | <b>REV 08</b> |
| PC707<br>6D    | 112         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 112-04 | 5501    | G   | FULL         | 17.2           | 0.677 | 0.75         | _____  |
| 112-05 | 5502    | H   | FULL         | 19.8           | 0.780 | 2.35         | _____  |
| 112-06 | 5512    | H   | FULL         | 20.5           | 0.807 | 3.75         | _____  |
| 112-08 | 5502    | L   | FULL         | 24.0           | 0.945 | 2.4          | _____  |
| 112-10 | 5502    | N   | FULL         | 28.5           | 1.122 | 4.5          | _____  |
| 112-12 | 5502    | P   | FULL         | 32.3           | 1.272 | 4.4          | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>33</b> | <b>REV 05</b> |
| PC707<br>6D    | 122         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 122-06 | 5504    | L   | FULL         | 24.0           | 0.945 | 2.4          | _____  |
| 122-08 | 5504    | N   | FULL         | 27.9           | 1.098 | 3.3          | _____  |
| 122-10 | 5504    | P   | FULL         | 31.5           | 1.240 | 2.85         | _____  |
| 122-20 | 5504    | AA  | FULL         | 52.8           | 2.079 | 7.1          | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>32</b> | <b>REV 06</b> |
| PC707<br>6D    | 124         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 124-06 | 5504    | L   | FULL         | 24.4           | 0.961 | 3.2          | _____  |
| 124-08 | 5504    | N   | FULL         | 28.5           | 1.122 | 4.5          | _____  |
| 124-10 | 5504    | P   | FULL         | 32.7           | 1.287 | 5.2          | _____  |
| 124-20 | 5504    | AA  | FULL         | 52.4           | 2.063 | 6.3          | _____  |

|                |             |                 |  |                     |           |               |
|----------------|-------------|-----------------|--|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>67</b> | <b>REV 01</b> |
| PC707<br>6D    | 141         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 141-12 | 5503    | P   | FULL         | 33.0           | 1.299 | 5.8          | _____  |
| 141-16 | 5503    | S   | FULL         | 41.1           | 1.618 | 6.65         | _____  |

| Crimper     | Hose | Coupling | Crimp Instructions                                     | CHART NUMBER | 59 | REV 07 |
|-------------|------|----------|--|--------------|----|--------|
| PC707<br>6D | 151  | 5000     | Non-Skive<br>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<br>Insert<br>Size | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                         |     |                 | mm             | in    | Approx.      | Actual |
| 151-05 | 5503-04 | -04                     | G   | FULL            | 17.4           | 0.685 | 1.15         | _____  |
| 151-06 | 5503-05 | -05                     | J   | FULL            | 20.8           | 0.819 | 0.5          | _____  |
| 151-08 | 5503-06 | -06                     | H   | FULL            | 20.0           | 0.787 | 2.75         | _____  |
| 151-10 | 5503-08 | -08                     | L   | FULL            | 24.9           | 0.980 | 4.2          | _____  |
| 151-12 | 5503-10 | -10                     | P   | FULL            | 30.4           | 1.197 | 0.65         | _____  |
| 151-16 | 5503-12 | -14                     | P   | FULL            | 34.8           | 1.370 | 9.35         | _____  |

|                |             |                   |   |                     |           |               |
|----------------|-------------|-------------------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b>   | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>68</b> | <b>REV 01</b> |
| PC707<br>6D    | 132         | 5000<br>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    | G   | FULL         | 17.7           | 0.697 | 1.7          | _____  |
| 132-05 | 5503    | J   | FULL         | 21.5           | 0.846 | 1.9          | _____  |
| 132-06 | 5503    | J   | FULL         | 20.7           | 0.815 | 0.3          | _____  |
| 132-08 | 5503    | L   | FULL         | 25.7           | 1.012 | 5.75         | _____  |
| 132-10 | 5503    | P   | FULL         | 30.7           | 1.209 | 1.25         | _____  |
| 132-12 | 5503    | P   | FULL         | 34.8           | 1.370 | 9.35         | _____  |
| 132-16 | 5503    | S   | FULL         | 42.6           | 1.677 | 9.6          | _____  |

|                |             |                 |  |                     |           |              |
|----------------|-------------|-----------------|--|---------------------|-----------|--------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>77</b> | <b>REV 0</b> |
| PC707<br>6D    | 172         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |              |

| Hose   | Ferrule | Fitting<br>Insertion<br>Length<br>mm | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                                      |     |                 | mm             | in    | Approx.      | Actual |
| 172-04 | 5507    |                                      | D   | FULL            | 14.1           | 0.555 | 0.25         | _____  |
| 172-05 | 5507    |                                      | G   | FULL            | 16.7           | 0.657 | 2.25         | _____  |
| 172-06 | 5507    |                                      | H   | FULL            | 18.9           | 0.744 | 0.6          | _____  |
| 172-08 | 5507    |                                      | L   | FULL            | 23.5           | 0.925 | 1.45         | _____  |

| Crimper     | Hose | Coupling |           | Crimp Instructions                        | CHART NUMBER | 78 | REV |
|-------------|------|----------|-----------|---|--------------|----|-----|
| PC707<br>6D | 182  | 5000     | Non-Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |              |    |     |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 182-06 | 5507    | G   | FULL         | 18.5           | 0.728 | 3.3          | _____  |

|                |             |                 |  |                     |           |              |
|----------------|-------------|-----------------|--|---------------------|-----------|--------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b>                              | <b>CHART NUMBER</b> | <b>79</b> | <b>REV 0</b> |
| PC707<br>6D    | 173         | 5000            | Non-Skive<br>Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |              |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 173-04 | 5507    | D   | FULL         | 14.1           | 0.555 | 0.25         | _____  |
| 173-06 | 5507    | H   | FULL         | 19.0           | 0.748 | 0.75         | _____  |

| Crimper     | Hose | Coupling | Crimp Instructions | CHART NUMBER | 58 | REV 00 |
|-------------|------|----------|--------------------|--------------|----|--------|
| PC707<br>6D | 37AL | 5508     | Non-Skive          |              |    |        |

| Hose    | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|---------|---------|-----|--------------|----------------|-------|--------------|--------|
|         |         |     |              | mm             | in    | Approx.      | Actual |
| 37AL-04 | 5508    | D   |              | 14.2           | 0.559 | 0.45         | _____  |
| 37AL-06 | 5508    | H   |              | 19.0           | 0.748 | 0.75         | _____  |
| 37AL-08 | 5508    | L   |              | 23.0           | 0.906 | 0.45         | _____  |

|                |             |                 |       |   |                     |           |               |
|----------------|-------------|-----------------|-------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |       | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>21</b> | <b>REV 10</b> |
| PC707<br>6D    | 111         | 5000            | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Cover<br>Skive<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                          |     |                 | mm             | in    | Approx.      | Actual |
| 111-04 | 5904    | 19                       | G   | FULL            | 17.5           | 0.689 | 1.3          | _____  |
| 111-05 | 5904    | 19                       | G   | FULL            | 18.2           | 0.717 | 2.7          | _____  |
| 111-06 | 5904    | 20                       | J   | FULL            | 21.0           | 0.827 | 0.9          | _____  |
| 111-08 | 5904    | 26                       | L   | FULL            | 25.1           | 0.988 | 4.6          | _____  |
| 111-10 | 5904    | 28                       | N   | FULL            | 27.6           | 1.087 | 2.7          | _____  |
| 111-12 | 5904    | 33                       | P   | FULL            | 31.7           | 1.248 | 3.2          | _____  |
| 111-16 | 5904    | 37                       | S   | FULL            | 40.3           | 1.587 | 5.05         | _____  |

|                |             |                 |       |   |                     |           |               |
|----------------|-------------|-----------------|-------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |       | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>22</b> | <b>REV 09</b> |
| PC707<br>6D    | 122         | 5000            | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Cover<br>Skive<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                          |     |                 | mm             | in    | Approx.      | Actual |
| 122-04 | 5904    | 17                       | G   | FULL            | 18.1           | 0.713 | 2.5          | _____  |
| 122-05 | 5904    | 19                       | H   | FULL            | 19.1           | 0.752 | 0.95         | _____  |
| 122-06 | 5904    | 20                       | J   | FULL            | 21.9           | 0.862 | 2.7          | _____  |
| 122-08 | 5904    | 26                       | L   | FULL            | 25.9           | 1.020 | 6.15         | _____  |
| 122-10 | 5904    | 28                       | N   | FULL            | 28.5           | 1.122 | 4.5          | _____  |
| 122-12 | 5904    | 33                       | P   | FULL            | 32.5           | 1.280 | 4.8          | _____  |
| 122-16 | 5904    | 37                       | S   | FULL            | 41.0           | 1.614 | 6.45         | _____  |
| 122-20 | 5904    | 41                       | AA  | FULL            | 51.5           | 2.028 | 4.55         | _____  |

|                |             |                 |       |   |                     |           |               |
|----------------|-------------|-----------------|-------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |       | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>23</b> | <b>REV 08</b> |
| PC707<br>6D    | 124         | 5000            | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Cover<br>Skive<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                          |     |                 | mm             | in    | Approx.      | Actual |
| 124-06 | 5905    | 19                       | J   | FULL            | 22.3           | 0.878 | 3.45         | _____  |
| 124-08 | 5905    | 25                       | N   | FULL            | 26.6           | 1.047 | 0.75         | _____  |
| 124-10 | 5904    | 28                       | N   | FULL            | 29.7           | 1.169 | 6.85         | _____  |
| 124-12 | 5904    | 33                       | P   | FULL            | 32.9           | 1.295 | 5.6          | _____  |
| 124-16 | 5904    | 37                       | S   | FULL            | 41.0           | 1.614 | 6.45         | _____  |
| 124-20 | 5904    | 41                       | AA  | FULL            | 51.2           | 2.016 | 3.95         | _____  |

|                |             |                 |       |   |                     |           |               |
|----------------|-------------|-----------------|-------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |       | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>26</b> | <b>REV 12</b> |
| PC707<br>6D    | 112         | 5000            | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Cover<br>Skive<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                          |     |                 | mm             | in    | Approx.      | Actual |
| 112-04 | 5904    | 19                       | G   | FULL            | 17.3           | 0.681 | 0.8          | _____  |
| 112-05 | 5904    | 19                       | G   | FULL            | 18.2           | 0.717 | 2.7          | _____  |
| 112-06 | 5904    | 20                       | J   | FULL            | 20.9           | 0.823 | 0.7          | _____  |
| 112-08 | 5904    | 26                       | L   | FULL            | 25.3           | 0.996 | 5            | _____  |
| 112-10 | 5904    | 28                       | N   | FULL            | 27.6           | 1.087 | 2.7          | _____  |
| 112-12 | 5904    | 33                       | P   | FULL            | 31.7           | 1.248 | 3.2          | _____  |
| 112-16 | 5904    | 37                       | S   | FULL            | 40.4           | 1.591 | 5.25         | _____  |

|                |             |                 |       |   |                     |           |               |
|----------------|-------------|-----------------|-------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |       | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>27</b> | <b>REV 05</b> |
| PC707<br>6D    | 113         | 5000            | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Cover<br>Skive<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                          |     |                 | mm             | in    | Approx.      | Actual |
| 113-08 | 5904    | 26                       | L   | FULL            | 26.0           | 1.024 | 6.35         | _____  |
| 113-10 | 5904    | 28                       | N   | FULL            | 28.5           | 1.122 | 4.5          | _____  |
| 113-12 | 5904    | 33                       | P   | FULL            | 32.5           | 1.280 | 4.8          | _____  |
| 113-16 | 5904    | 37                       | S   | FULL            | 41.0           | 1.614 | 6.45         | _____  |

|                |             |                 |       |   |                     |           |               |
|----------------|-------------|-----------------|-------|---|---------------------|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> |       | <b>Crimp Instructions</b>                 | <b>CHART NUMBER</b> | <b>24</b> | <b>REV 12</b> |
| PC707<br>6D    | 115         | 5000            | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                     |           |               |

| Hose   | Ferrule | Cover<br>Skive<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|--------------------------|-----|-----------------|----------------|-------|--------------|--------|
|        |         |                          |     |                 | mm             | in    | Approx.      | Actual |
| 115-06 | 5905    | 19                       | J   | FULL            | 22.1           | 0.870 | 3.1          | _____  |
| 115-08 | 5905    | 26                       | N   | FULL            | 26.4           | 1.039 | 0.35         | _____  |
| 114-10 | 5904    | 28                       | N   | FULL            | 29.2           | 1.150 | 5.85         | _____  |
| 114-12 | 5904    | 33                       | P   | FULL            | 33.3           | 1.311 | 6.35         | _____  |
| 114-16 | 5904    | 37                       | S   | FULL            | 41.3           | 1.626 | 7            | _____  |
| 114-20 | 5904    | 41                       | AA  | FULL            | 50.7           | 1.996 | 3            | _____  |

| Crimper     |         | Hose               | Coupling | Skive        | Crimp Instructions                        | CHART NUMBER |              | 72 | REV 01 |
|-------------|---------|--------------------|----------|--------------|---|--------------|--------------|----|--------|
| PC707<br>6D |         | 119B<br>118        | 5000     | Skive        | Tolerance +/- 0.1mm or +/- 0.004 inches . |              |              |    |        |
| Hose        | Ferrule | Cover Skive length | Die      | Crimp Length | Crimp Diameter                            |              | Dial Setting |    | Actual |
|             |         | mm                 |          |              | mm  | in           | Approx.      |    |        |
| 119B -04    | 5904    | 19                 | G        | FULL         | 17.1                                      | 0.673        | 0.55         |    | _____  |
| 119B -06    | 5904    | 20                 | J        | FULL         | 21.0                                      | 0.827        | 0.9          |    | _____  |

| Crimper     | Hose    | Coupling                 |       | Crimp Instructions                        | CHART NUMBER    |                | 51    | REV 00       |        |
|-------------|---------|--------------------------|-------|---|-----------------|----------------|-------|--------------|--------|
| PC707<br>6D | 119H    | 5000                     | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                 |                |       |              |        |
| Hose        | Ferrule | Cover<br>Skive<br>Length |       | Die                                       | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|             |         | mm                       |       |   |                 | mm             | in    | Approx.      | Actual |
| 119H-06     | 5904    | 20                       |       | J   | FULL            | 21.0           | 0.827 | 0.9          | _____  |

| Crimper     | Hose    | Coupling                 |       | Crimp Instructions                        | CHART NUMBER    |                | 53    | REV 00       |        |
|-------------|---------|--------------------------|-------|---|-----------------|----------------|-------|--------------|--------|
| PC707<br>6D | 120J    | 5000                     | Skive | Tolerance +/- 0.1mm or +/- 0.004 inches . |                 |                |       |              |        |
| Hose        | Ferrule | Cover<br>Skive<br>Length |       | Die                                       | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|             |         | mm                       |       |   |                 | mm             | in    | Approx.      | Actual |
| 120J-04     | 5904    | 19                       |       | G   | FULL            | 18.1           | 0.713 | 2.5          | _____  |
| 120J-06     | 5904    | 20                       |       | J   | FULL            | 21.9           | 0.862 | 2.7          | _____  |

| Crimper     | Hose | Coupling | Crimp Instructions | CHART NUMBER | 56 | REV G |
|-------------|------|----------|--------------------|--------------|----|-------|
| PC707<br>6D | 157  | 4000     | Non Skive          |              |    |       |

| Hose   | Ferrule | Die | Crimp Length | Crimp Diameter |       | Dial Setting |        |
|--------|---------|-----|--------------|----------------|-------|--------------|--------|
|        |         |     |              | mm             | in    | Approx.      | Actual |
| 157-08 | 4000    | D   | FULL         | 14.5           | 0.571 | 1            | _____  |
| 157-10 | 4000    | G   | FULL         | 17.2           | 0.677 | 0.75         | _____  |
| 157-12 | 4000    | H   | FULL         | 20.4           | 0.803 | 3.55         | _____  |
| 157-16 | 4000    | N   | FULL         | 26.6           | 1.047 | 0.75         | _____  |

|                |             |                 |                           |   |           |               |
|----------------|-------------|-----------------|---------------------------|---|-----------|---------------|
| <b>Crimper</b> | <b>Hose</b> | <b>Coupling</b> | <b>Crimp Instructions</b> | <b>CHART NUMBER</b>   | <b>45</b> | <b>REV 01</b> |
| PC707<br>6D    | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|---------|---------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
|         |         |                                |     |                 | mm             | in    | Approx.      | Actual |
| 3130-04 | 9700    | 24                             | D   | 24.0mm          | 14.1           | 0.555 | 0.25         | _____  |
| 3130-05 | 9700    | 22                             | E   | 22.5mm          | 16.0           | 0.630 | 0.85         | _____  |
| 3130-06 | 9700    | 28                             | G   | 28.5mm          | 17.1           | 0.673 | 0.55         | _____  |
| 3130-08 | 9700    | 27                             | J   | 27.0mm          | 21.0           | 0.827 | 0.9          | _____  |
| 3130-12 | 9700    | 35                             | N   | 35mm            | 27.4           | 1.079 | 2.3          | _____  |

| Crimper     | Hose    | Coupling | Crimp Instructions             |     | CHART NUMBER    |                | 46    | REV 01       |        |
|-------------|---------|----------|--------------------------------|-----|-----------------|----------------|-------|--------------|--------|
| PC707<br>6D | 3R80    | 9800     | Non-Skive                      |     |                 |                |       |              |        |
| Hose        | Ferrule |          | Fitting<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |       | Dial Setting |        |
|             |         |          | mm                             |     |                 | mm             | in    | Approx.      | Actual |
| 3R80-04     | 9800    |          | 24                             | G   | 24mm            | 16.6           | 0.654 | 2.05         | _____  |
| 3R80-06     | 9800    |          | 28                             | H   | 28.5mm          | 19.6           | 0.772 | 1.95         | _____  |
| 3R80-08     | 9800    |          | 32                             | J   | 32mm            | 22.4           | 0.882 | 3.65         | _____  |
| 3R80-12     | 9800    |          | 34                             | N   | 33.5mm          | 28.6           | 1.126 | 4.65         | _____  |

| Crimper     |         | Hose                     | Coupling | Non-Skive | Crimp Instructions  | CHART NUMBER   |    | 47           | REV 01 |
|-------------|---------|--------------------------|----------|-----------|---|----------------|----|--------------|--------|
| PC707<br>6D |         | 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 |           | Crimp Instructions  | CHART NUMBER | 48 | REV 00 |
|-------------|------|----------|-----------|---|--------------|----|--------|
| PC707<br>6D | 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<br>Insertion<br>Length | Die | Crimp<br>Length | Crimp Diameter |    | Dial Setting |        |
|------|--|---------|--------------------------------|-----|-----------------|----------------|----|--------------|--------|
|      |  |         | mm                             |     |                 | mm             | in | Approx.      | Actual |
|      |  |         |                                |     |                 |                |    |              |        |

| Crimper     | Hose | Coupling |           | Crimp Instructions                        | CHART NUMBER | 11 | REV 00 |
|-------------|------|----------|-----------|---|--------------|----|--------|
| PC707<br>6D | 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    | S   | FULL         | 42.2           | 1.661 | 8.8          | _____  |
| 141-20 | 5904    | AA  | FULL         | 50.5           | 1.988 | 2.6          | _____  |

Crimper    Hose    Coupling

Crimp Instructions

CHART NUMBER    11    REV 00

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.