



Printed: Feb 15 2024

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	83	REV 00
D206DC	111	4200	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		



Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-04	4200	23	0.520	Full	16.7	0.657	71	_____
111-06	4200	25	0.670	Full	20.9	0.823	69	_____
111-08	4200	27	0.830	Full	24.2	0.953	75	_____
111-12	4200	34	1.100	Full	31.8	1.252	70	_____
111-16	4200	44	1.500	Full	40.6	1.598	80	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	183	REV 00
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D206DC	110	4200	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.

PULSAR  **CORONA 17** 

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
110-04	4200	23	0.520	Full	15.7	0.618	80	_____
110-06	4200	25	0.670	Full	19.8	0.780	78	_____
110-08	4200	27	0.830	Full	23.3	0.917	82	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	86	REV 00
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D206DC	112	4200	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.

PULSAR 112 112CC

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	4200	23	0.520	Full	16.8	0.661	70	_____
112-06	4200	25	0.670	Full	21.0	0.827	69	_____
112-08	4200	27	0.830	Full	25.0	0.984	69	_____
112-12	4200	34	1.100	Full	31.8	1.252	70	_____
112-16	4200	44	1.500	Full	40.6	1.598	80	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	84	REV 01
D206DC	122	4200	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR 

NOVA 2

NOVA 2 ICE-BREAKER

122A 

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-04	4200	23	0.670	Full	17.8	0.701	94	_____
122-06	4200	25	0.830	Full	22.0	0.866	93	_____
122-08	4200	27	0.830	Full	25.5	1.004	65	_____
122-10	4200	30	1.100	Full	28.8	1.134	93	_____
122-12	4200	34	1.100	Full	32.1	1.264	67	_____
122-16	4200	44	1.500	Full	41.6	1.638	73	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	124	REV 00
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D206DC	114	4200	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.

PULSAR	 	NOVA 16	CARBONITE 16	AURORA 16		NOVA 16 EXTREME	
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Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-04	4200	23	0.670	Full	17.2	0.677	97	_____
114-06	4200	25	0.670	Full	20.8	0.819	70	_____
114-08	4200	27	0.830	Full	24.2	0.953	75	_____
114-10	4200	30	1.100	Full	28.5	1.122	95	_____
114-12	4200	34	1.100	Full	31.8	1.252	70	_____
114-16	4200	44	1.500	Full	40.6	1.598	80	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	151	REV 02
D206DC	124 PLUS	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR  **NOVA 12 PLUS** **CARBONITE 12 PLUS** **AURORA 12 PLUS** 

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
124 PLUS	-06 4400	25	0.830	Full	24.0	0.945	77	_____
124 PLUS	-08 4400	31	0.830	Full	26.4	1.039	58	_____
124 PLUS	-10 4400	31	1.100	Full	32.6	1.283	63	_____
124 PLUS	-12 4400	34	1.320	Full	34.3	1.350	94	_____
124 PLUS	-16 4400	47	1.500	Full	42.7	1.681	64	_____
124 PLUS	-20 4400	54	1.920	Full	49.6	1.953	94	_____
124 PLUS	-24 4400	56	2.140	Full	60.3	2.374	53	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	91	REV 01
D206DC	124	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR SPIRAL 12

PULSAR 124AC SPIRAL 12 ARMOR

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-06	4400	25	0.830	Full	23.1	0.909	84	_____
124-08	4400	31	0.830	Full	25.4	1.000	66	_____
124-10	4400	31	1.100	Full	32.6	1.283	63	_____
124-12	4400	34	1.320	Full	33.9	1.335	97	_____
124-16	4400	47	1.500	Full	41.4	1.630	74	_____
124-20	4400	54	1.920	Full	51.9	2.043	75	_____
124-24	4400	56	2.140	Full	60.3	2.374	53	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	192	REV 01
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D206DC 124 XTC 4400 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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.

PULSAR  **124XTC** 

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124 -06	4400 XTC	25	0.830	Full	23.1	0.909	84	_____
124 -08	4400 XTC	31	0.830	Full	25.4	1.000	66	_____
124 -10	4400 XTC	31	1.100	Full	32.6	1.283	63	_____
124 -12	4400 XTC	34	1.320	Full	33.9	1.335	97	_____
124 -16	4400 XTC	47	1.500	Full	41.4	1.630	74	_____
124 -20	4400 XTC	54	1.920	Full	51.9	2.043	75	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	193	REV 01
D206DC	124 XTC	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR  **124XTC** 

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
124 -06	5120 XTC	0.830	Full	23.8	0.937	78	_____
124 -08	5120 XTC	0.830	Full	27.1	1.067	53	_____
124 -10	5120 XTC	1.100	Full	30.0	1.181	84	_____
124 -12	5120 XTC	1.320	Full	34.6	1.362	92	_____
124 -16	5120 XTC	1.500	Full	42.4	1.669	66	_____
124 -20	5120 XTC	1.920	Full	51.6	2.031	78	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	92	REV 03
D206DC	136	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR **SPIRAL 13**

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	4400	34	1.320	Full	35.3	1.390	86	_____
136-16	4400	47	1.500	Full	42.0	1.654	69	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	159	REV 00
D206DC	136	4600	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR® SPIRAL 13

Hose	Ferrule	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-20	4600	60	2.140	Full	57.0	2.244	79	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	160	REV 00
D206DC	156 PLUS	44/4600	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR

NOVA 15

Hose	Ferrule	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
156 PLUS	-12 4400	34	1.320	Full	35.1	1.382	88	_____
156 PLUS	-16 4400	47	1.500	Full	42.0	1.654	69	_____
156 PLUS	-20 4600	60	2.140	Full	57.0	2.244	79	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	185	REV 00
D206DC	124 PLUS	4600	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR  **NOVA 12 PLUS** **CARBONITE 12 PLUS** **AURORA 12 PLUS** 

		Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule				mm	in	Approx.	Actual
124 PLUS	-20 4600	60	1.920	Full	53.5	2.106	63	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	186	REV 00
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D206DC	124	4200	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.



Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-12	4200	34	1.100	Full	33.1	1.303	59	_____
124-16	4200	44	1.500	Full	40.4	1.591	82	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	95	REV 02
D206DC	151	4500	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.




Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
151-04	4500-04	0.520	Knurl	16.1	0.634	76	_____
151-05	4500-05	0.670	Full	18.3	0.720	90	_____
151-06	4500-06	0.670	Full	20.0	0.787	76	_____
151-08	4500-08	0.830	Full	22.9	0.902	86	_____
151-10	4500-10	0.830	Full	26.7	1.051	56	_____
151-12	4500-12	1.100	Full	30.8	1.213	77	_____
151-16	4500-16	1.320	Full	35.5	1.398	84	_____
151-20	4500-20	1.500	Full	43.5	1.713	58	_____
151-24	4500-24	1.730	Knurl	46.8	1.843	78	_____
151-32	4500-32	2.140	Full	59.8	2.354	57	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	176	REV 00
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D206DC	151	42/4400	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.




Fitting
Insertion

Crimp
Length

Dial Setting

Hose Ferrule

Die

Crimp Diameter

Approx. Actual

mm in

151-05	4200-04	23	0.670	Full	18.1	0.713	91	_____
151-08	4200-06	25	0.830	Full	22.9	0.902	86	_____
151-10	4400-08	31	1.100	Full	28.2	1.110	98	_____
151-12	4400-10	31	1.100	Full	30.8	1.213	77	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	177	REV 00
D206DC	151	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® 151

PULSAR® 151H

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
151-05	5200-04	0.670	Full	19.5	0.768	80	_____
151-08	5120-06	0.830	Full	23.6	0.929	80	_____
151-10	5120-08	1.100	Full	28.6	1.126	95	_____
151-12	5120-10	1.100	Full	31.8	1.252	70	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	87	REV 01
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D206DC	141	4200	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		
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PULSAR 141

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
141-12	4200	34	1.100	Full	33.1	1.303	59	_____
141-16	4200	44	1.500	Full	40.0	1.575	85	_____
141-20	4400	54	1.920	Full	50.3	1.980	88	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	122	REV 00
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D206DC	119	4200	Skive
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
119-04	4200	21	0.520	Full	16.7	0.657	71	_____
119-06	4200	21	0.670	Full	20.7	0.815	71	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	146	REV 02
D206DC	129G	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 129G

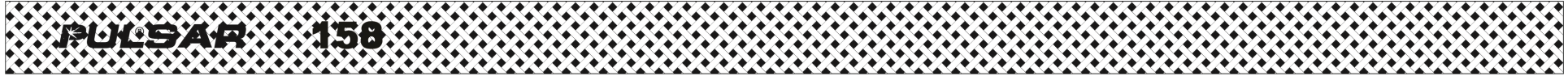
Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
129G-06	5200	25	0.670	Full	20.4	0.803	73	_____
129G-06	4200	21	0.670	Full	20.4	0.803	73	_____
129G-08	5200	26	0.830	Full	24.2	0.953	75	_____
129G-08	4200	26	0.830	Full	25.5	1.004	65	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	164	REV 00
D206DC	120J	4200	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR 120J JACK HOSE

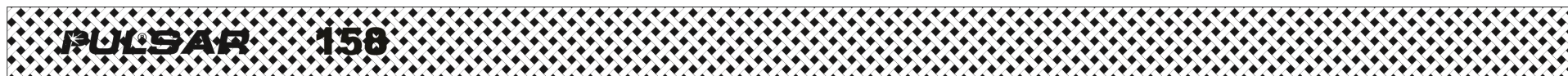
Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
120J-04	4200	23	0.520	Full	16.8	0.661	70	_____
120J-06	4200	25	0.670	Full	21.0	0.827	69	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	195	REV H
D206DC	158	4000	Non Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		



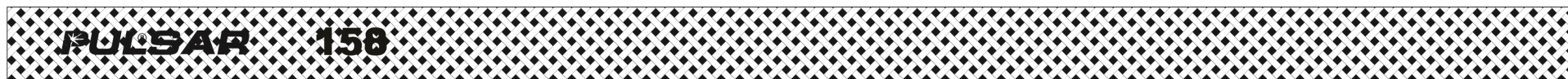
Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
158-07	4000	0.520	Full	14.5	0.571	90	_____
158-08	4000	0.670	Full	17.2	0.677	97	_____
158-10	4000	0.670	Full	20.4	0.803	73	_____
158-14	4000	0.830	Full	26.6	1.047	56	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	190	REV 01
D206DC	158	4700	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 +0.0mm/- 0.2mm or + 0.004/-0.008 inches.		



Hose	Ferrule	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting		
					mm	in	Approx.	Actual	
158-06	4700	26	0.520	Knurl	16.0	0.630	77	_____	
158-08	4700	29	0.670	Knurl	20.5	0.807	72	_____	
158-10	4700	30	0.830	Knurl	25.6	1.008	64	_____	
158-12	4700	34	1.100	Knurl	28.1	1.106	99	_____	
158-14	4500	-16	45	1.100	Knurl	32.3	1.272	66	_____
158-16	4700	45	1.320	Knurl	35.5	1.398	84	_____	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	191	REV 01
D206DC	158	5000	One-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		



Hose	Ferrule	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
158-05	5514	23	0.520	Full	14.4	0.567	91	_____
158-06	5514	26	0.520	Full	16.0	0.630	77	_____
158-08	5514	29	0.670	Full	20.5	0.807	72	_____
158-10	5514	30	0.830	Full	24.8	0.976	71	_____
158-12	5514	34	0.830	Full	27.0	1.063	53	_____
158-16	5514	45	1.320	Full	34.4	1.354	93	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	157	REV 00
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D206DC	172	4700	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 +0.0mm/- 0.2mm or + 0.004/-0.008 inches.		
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Fitting
Insertion

Crimp
Length

Dial Setting
Approx. Actual

Hose Ferrule

Die

Crimp Diameter

mm in

172-04	4700	23	0.520	Full	15.0	0.591	86	_____
172-06	4700	26	0.670	Full	18.8	0.740	86	_____
172-08	4700	29	0.830	Full	24.1	0.949	76	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	175	REV 00
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D206DC	182	4700	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 +0.0mm/- 0.2mm or + 0.004/-0.008 inches.		
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PULSAR 182

Hose	Ferrule	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
182-04	4700	23	0.520	Full	14.1	0.555	93	_____
182-06	4700	26	0.670	Full	18.4	0.724	89	_____
182-08	4700	29	0.830	Full	23.8	0.937	78	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	189	REV 00
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D206DC	173	4700	One-piece
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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 +0.0mm/- 0.2mm or + 0.004/-0.008 inches.



Fitting
Insertion

Hose	Ferrule		Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
173-06	4700	26	0.670	FULL	19.4	0.764	81	_____
173-08	4700	29	0.830	FULL	24.8	0.976	71	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	96	REV 00
D206DC	109	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® 109 109CC

PULSAR® 109T

Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting	Approx.	Actual
		mm	mm			mm in			
109-04	5000C		20	0.520	Full	15.5 0.610	81	_____	
109-06	5000C		20	0.670	Full	18.7 0.736	87	_____	
109-08	5000C		22	0.830	Full	22.6 0.890	88	_____	
109-10	5000C	21		0.830	Full	27.6 1.087	49	_____	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	184	REV 00
D206DC	110	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR  **CORONA 17** 

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
110-04	5000C	20	0.520	Full	15.1	0.594	85	_____
110-06	5000C	20	0.670	Full	18.7	0.736	87	_____
110-08	5000C	22	0.830	Full	22.5	0.886	89	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	116	REV 00
D206DC	112	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 112 112CC

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
112-04	5000C	16	0.520	Full	15.9	0.626	78	_____
112-06	5000C	18	0.670	Full	19.2	0.756	83	_____
112-08	5000C	20	0.830	Full	23.5	0.925	81	_____
112-10	5000C	20	0.830	Full	27.6	1.087	49	_____
112-12	5000C	26	1.100	Full	29.9	1.177	85	_____
112-16	5000C	35	1.500	Full	38.1	1.500	100	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	113	REV 00
D206DC	111	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		



Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
111-04	5000C	16	0.520	Full	15.9	0.626	78	_____
111-06	5000C	18	0.670	Full	19.3	0.760	82	_____
111-08	5000C	20	0.830	Full	23.2	0.913	83	_____
111-12	5000C	26	1.100	Full	29.9	1.177	85	_____
111-16	5000C	35	1.500	Full	38.1	1.500	100	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	111	REV 00
D206DC	122	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR **NOVA 2** **NOVA 2 ICE-BREAKER** **122A**

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
122-04	5000C	16	0.520	Full	16.4	0.646	74	_____
122-06	5000C	18	0.670	Full	20.0	0.787	76	_____
122-08	5000C	20	0.830	Full	23.8	0.937	78	_____
122-10	5000C	20	1.100	Full	27.9	1.098	100	_____
122-12	5000C	26	1.100	Full	30.1	1.185	83	_____
122-16	5000C	35	1.500	Full	38.4	1.512	98	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	150	REV 01
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D206DC	124 PLUS	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		
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PULSAR 	NOVA 12 PLUS	CARBONITE 12 PLUS	AURORA 12 PLUS	
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Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124 PLUS	-06 5420	25	0.830	Full	23.0	0.906	85	_____
124 PLUS	-08 5420	27	0.830	Full	26.2	1.031	60	_____
124 PLUS	-10 5420	30	1.100	Full	29.0	1.142	92	_____
124 PLUS	-12 5420	32	1.100	Full	33.4	1.315	57	_____
124 PLUS	-16 5420	43	1.500	Full	41.7	1.642	72	_____
124 PLUS	-20 5420	44	1.730	Full	47.5	1.870	72	_____
124 PLUS	-24 5420	57	2.140	Full	56.0	2.205	87	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	156	REV 00
D206DC	124 PLUS	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		







Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
124 PLUS	-06 5120	0.830	Full	24.1	0.949	76	_____
124 PLUS	-08 5120	0.830	Full	27.5	1.083	49	_____
124 PLUS	-10 5120	1.100	Full	30.0	1.181	84	_____
124 PLUS	-12 5120	1.320	Full	34.6	1.362	92	_____
124 PLUS	-16 5120	1.500	Full	42.4	1.669	66	_____
124 PLUS	-20 5120	1.920	Full	50.7	1.996	85	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	172	REV 00
D206DC	156 PLUS	5000 Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			




Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting	Approx.	Actual
		mm			mm in			
156 PLUS	-12 5420	32	1.320	Full	33.9 1.335	97	_____	
156 PLUS	-16 5420	43	1.500	Full	40.8 1.606	79	_____	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	173	REV 01
D206DC	156 PLUS	5000 Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

PULSAR

NOVA 15

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
156 PLUS	-12 5120	1.320	Full	35.1	1.382	88	_____
156 PLUS	-16 5120	1.500	Full	42.0	1.654	69	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	112	REV 00
D206DC	G102	5000	Non Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
G102-06	5000C	18	0.670	Full	19.3	0.760	82	_____
G102-08	5000C	22	0.830	Full	23.0	0.906	85	_____
G102-12	5000C	28	1.100	Full	31.3	1.232	73	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	196	REV 00
D206DC	G103	5000	Non Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
G103-06	5000C	18	0.670	Full	19.3	0.760	82	_____
G103-08	5000C	20	0.830	Full	23.6	0.929	80	_____
G103-12	5000C	26	1.100	Full	31.0	1.220	76	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	153	REV 00
D206DC	114	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		







Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
114-04	5000C	16	0.520	Full	15.9	0.626	78	_____
114-06	5000C	18	0.670	Full	19.1	0.752	84	_____
114-08	5000C	20	0.830	Full	22.6	0.890	88	_____
114-10	5000C	20	0.830	Full	26.7	1.051	56	_____
114-12	5000C	26	1.100	Full	29.8	1.173	85	_____
114-16	5000C	35	1.320	Full	37.7	1.484	67	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	100	REV 00
D206DC	111	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		



Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-04	5200	23	0.670	Full	17.9	0.705	93	_____
111-06	5200	25	0.670	Full	20.6	0.811	72	_____
111-08	5200	27	0.830	Full	23.4	0.921	82	_____
111-12	5200	34	1.100	Full	30.9	1.217	77	_____
111-16	5200	44	1.500	Full	38.7	1.524	95	_____
111-20	5200	54	1.730	Full	48.6	1.913	63	_____
111-24	5200	56	2.140	Full	57.0	2.244	79	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	130	REV 00
D206DC	114	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		








Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-04	5200	23	0.670	Full	18.2	0.717	91	_____
114-06	5200	25	0.670	Full	20.4	0.803	73	_____
114-08	5200	27	0.830	Full	23.5	0.925	81	_____
114-10	5200	30	0.830	Full	27.2	1.071	52	_____
114-12	5200	34	1.100	Full	30.5	1.201	80	_____
114-16	5200	44	1.500	Full	38.6	1.520	96	_____
114-20	5200	54	1.920	Full	49.2	1.937	97	_____
114-24	5200	56	2.140	Full	56.5	2.224	83	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	102	REV 00
D206DC	112	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 112 112CC

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	5200	23	0.670	Full	18.2	0.717	91	_____
112-06	5200	25	0.670	Full	20.9	0.823	69	_____
112-08	5200	27	0.830	Full	23.5	0.925	81	_____
112-10	5200	30	0.830	Full	27.2	1.071	52	_____
112-12	5200	34	1.100	Full	30.5	1.201	80	_____
112-16	5200	44	1.500	Full	38.6	1.520	96	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	101	REV 00
D206DC	122	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 

NOVA 2

NOVA 2 ICE-BREAKER

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Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter mm in	Dial Setting Approx.	Actual
122-04	5200	23	0.670	Full	19.1 0.752	84	_____
122-06	5200	25	0.830	Full	21.4 0.843	97	_____
122-08	5200	27	0.830	Full	24.5 0.965	73	_____
122-10	5200	30	0.830	Full	27.7 1.091	48	_____
122-12	5200	34	1.100	Full	31.2 1.228	74	_____
122-16	5200	44	1.500	Full	39.4 1.551	90	_____
122-20	5200	54	1.920	Full	51.5 2.028	79	_____
122-24	5200	56	2.140	Full	59.9 2.358	57	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	105	REV 00
D206DC	122	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 

NOVA 2

NOVA 2 ICE-BREAKER

122A 

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter mm in	Dial Setting Approx.	Actual
122-04	5420	24	0.670	Full	17.3 0.681	98	_____
122-06	5420	25	0.830	Full	22.5 0.886	89	_____
122-08	5420	27	0.830	Full	25.8 1.016	63	_____
122-10	5420	30	1.100	Full	28.7 1.130	94	_____
122-12	5420	32	1.320	Full	33.6 1.323	99	_____
122-16	5420	43	1.500	Full	41.3 1.626	75	_____
122-20	5420	44	1.920	Full	49.4 1.945	95	_____
122-24	5420	57	2.140	Full	56.6 2.228	83	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	103	REV 02
D206DC	124	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR **SPIRAL 12**

PULSAR **124AC SPIRAL 12 ARMOR**

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
124-06	5120	0.830	Full	23.8	0.937	78	_____
124-08	5120	0.830	Full	27.1	1.067	53	_____
124-10	5120	1.100	Full	30.0	1.181	84	_____
124-12	5120	1.320	Full	34.6	1.362	92	_____
124-16	5120	1.500	Full	42.4	1.669	66	_____
124-20	5120	1.920	Full	51.6	2.031	78	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	106	REV 00
D206DC	124	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR **SPIRAL 12**

PULSAR **124AC SPIRAL 12 ARMOR**

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
124-06	5420	25	0.830	Full	22.8	0.898	86	_____
124-08	5420	27	0.830	Full	26.0	1.024	61	_____
124-10	5420	30	1.100	Full	29.0	1.142	92	_____
124-12	5420	32	1.320	Full	33.6	1.323	99	_____
124-16	5420	43	1.500	Full	41.7	1.642	72	_____
124-20	5420	44	1.920	Full	49.8	1.961	92	_____
124-24	5420	57	2.140	Full	56.0	2.205	87	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	108	REV 00
D206DC	136	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR **SPIRAL 13**

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	5420	32	1.320	Full	34.5	1.358	92	_____
136-16	5420	43	1.500	Full	41.5	1.634	73	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	110	REV 01
D206DC	141	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 141

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
141-12	5200		1.100	Full	33.1	1.303	59	_____
141-16	5200		1.500	Full	41.0	1.614	77	_____
141-20	5420		1.920	Full	49.5	1.949	94	_____
141-24	5420		2.140	Full	56.0	2.205	87	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	109	REV 00
D206DC	156	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® SPIRAL 15

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
156-16	5420	43	1.500	Full	41.6	1.638	73	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	132	REV 00
D206DC	172	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® 172

PULSAR® 172N

PULSAR® 172T

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
172-04	5517		0.520	Full	14.4	0.567	91	_____
172-05	5517		0.670	Full	17.1	0.673	99	_____
172-06	5517		0.670	Full	18.6	0.732	87	_____
172-08	5517		0.830	Full	22.9	0.902	86	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	194	REV 01
D206DC	119MS	42/44/50	Non Skive			

Green Line 119MS MINE SPRAY HOSE MSHA COVER

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
119M-16	5200	1.500	Full	39.4	1.551	90	_____
S							
119M-16	4400	1.500	Full	42.2	1.661	68	_____
S							
119M-16	4200	1.500	Full	40.1	1.579	84	_____
S							

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	165	REV 00
D206DC	186SC	9800	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

186SC Lateral Sewer Cleaning Hose

Hose	Ferrule	Insertion Depth	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
186S-04 C	9800	28.5	0.520	27.4	14.4	0.567	91	_____
186S-06 C	9800	30.4	0.670	27.4	17.5	0.689	96	_____
186S-08 C	9800	31.8	0.830	31.8	22.1	0.870	92	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	166	REV 00
D206DC	185SC	9800	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

185SC Sewer Cleaning Hose 3000 psi

Hose	Ferrule	Insertion Depth	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
185S-12 C	9800	44.5	1.100	38.1	30.5	1.201	80	_____
185S-12 C	9800 Mender	44.0	1.100	38.1	30.5	1.201	80	_____
185S-16 C	9800 Mender	44.0	1.320	34.3	37.6	1.480	68	_____
185S-16 C	9800	54.0	1.320	44.5	37.6	1.480	68	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	167	REV 00
D206DC	184SC	9800	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

184SC Sewer Cleaning Hose 2500 psi

Hose	Ferrule	Insertion Depth	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
184S-12 C	9800	44.5	1.100	38.1	30.5	1.201	80	_____
184S-12 C	9800 Mender	44.0	1.100	38.1	30.5	1.201	80	_____
184S-16 C	9800	54.0	1.320	44.5	37.6	1.480	68	_____
184S-16 C	9800 Mender	44.0	1.320	34.3	37.6	1.480	68	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	134	REV 0
D206DC	173	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		



Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
173-04	5517	0.520	Full	14.5	0.571	90	_____
173-06	5517	0.670	Full	18.8	0.740	86	_____
173-08	5518	0.830	Full	25.0	0.984	69	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	133	REV 0
D206DC	182	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

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PULSAR® 182NY

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
182-04	5517	0.520	Full	14.1	0.555	93	_____
182-06	5517	0.670	Full	18.2	0.717	91	_____
182-08	5517	0.830	Full	22.6	0.890	88	_____
182-12	5517	1.100	Full	29.8	1.173	85	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	181	REV 0
D206DC	111	4500	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR 111-03

Hose	Ferrule	Crimp Insert Size	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
111-03	4500	-04	19	0.520	Full	14.8	0.583	87	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	52	REV 0
D206DC	111	9000SB	Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

PULSAR® 111-03

Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Dial Setting	
						Approx.	Actual
		mm	mm			mm	in

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	88	REV 00
D206DC	111	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		



Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-06	4400	25	0.830	Full	21.7	0.854	95	_____
111-08	4400	31	0.830	Full	23.8	0.937	78	_____
111-12	4400	34	1.100	Full	33.0	1.299	60	_____
111-16	4400	47	1.500	Full	41.3	1.626	75	_____
111-20	4400	54	1.920	Full	51.3	2.020	80	_____
111-24	4400	56	2.140	Full	60.0	2.362	56	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	90	REV 01
D206DC	112	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR 112 112CC

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-06	4400	25	0.830	Full	21.7	0.854	95	_____
112-08	4400	31	0.830	Full	24.0	0.945	77	_____
112-10	4400	31	1.100	Full	31.1	1.224	75	_____
112-12	4400	34	1.100	Full	33.0	1.299	60	_____
112-16	4400	47	1.500	Full	40.7	1.602	80	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	131	REV 00
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D206DC	114	4400	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.

PULSAR	NOVA 16	CARBONITE 16	AURORA 16	NOVA 16 EXTREME
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Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-06	4400	25	0.830	Full	22.1	0.870	92	_____
114-08	4400	31	0.830	Full	24.0	0.945	77	_____
114-10	4400	31	1.100	Full	31.1	1.224	75	_____
114-12	4400	34	1.100	Full	33.0	1.299	60	_____
114-16	4400	47	1.500	Full	40.7	1.602	80	_____
114-20	4400	54	1.920	Full	50.6	1.992	86	_____
114-24	4400	57	2.140	Full	57.8	2.276	73	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	89	REV 00
D206DC	122	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR **NOVA 2** **NOVA 2 ICE-BREAKER** **122A**

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-06	4400	25	0.830	Full	22.8	0.898	86	_____
122-08	4400	31	0.830	Full	24.9	0.980	70	_____
122-10	4400	31	1.100	Full	32.2	1.268	66	_____
122-12	4400	34	1.320	Full	34.1	1.343	95	_____
122-16	4400	47	1.500	Full	42.3	1.665	67	_____
122-20	4400	54	1.920	Full	52.4	2.063	72	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	114	REV 00
D206DC	119	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter mm in	Dial Setting Approx. Actual
119-04	5000C	16	0.520	Full	15.9 0.626	78 _____
119-04	5200	22	0.670	Full	17.9 0.705	93 _____
119-06	5000C	18	0.670	Full	18.7 0.736	87 _____
119-06	5200	25	0.670	Full	20.1 0.791	76 _____
119-08	5000C	20	0.830	Full	23.2 0.913	83 _____
119-08	5200	25	0.830	Full	23.4 0.921	82 _____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	148	REV 00
D206DC	124 PLUS	9600 One-piece	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.			



NOVA 12 PLUS
CARBONITE 12 PLUS
AURORA 12 PLUS


Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
124 PLUS	-12 9600	46	1.100	Knurl	32.2	1.268	66	_____
124 PLUS	-16 9600	50	1.500	Knurl	40.1	1.579	84	_____
124 PLUS	-20 9600	54	1.730	Knurl	48.0	1.890	68	_____
124 PLUS	-24 9600	56	2.140	Knurl	56.0	2.205	87	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **135** **REV 00**

D206DC 124 9600 One-piece

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.

PULSAR **SPIRAL 12**

PULSAR **124AC SPIRAL 12 ARMOR**

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-12	9600	46	1.100	Knurl	33.1	1.303	59	_____
124-16	9600	50	1.500	Knurl	40.9	1.610	78	_____
124-20	9600	54	1.920	Knurl	50.0	1.969	90	_____
124-24	9600	56	2.140	Knurl	56.0	2.205	87	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	162	REV 00
D206DC	156 PLUS	9600 One-piece	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.			

PULSAR *NOVA 15*

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting	Approx.	Actual
		mm			mm in			
156 PLUS	-12 9600	46	1.100	Knurl	32.2 1.268	66	_____	
156 PLUS	-16 9600	50	1.500	Knurl	40.5 1.594	81	_____	
156 PLUS	-20 9600	54	1.920	Knurl	52.0 2.047	75	_____	
156 PLUS	-24 9600	56	2.140	Knurl	58.4 2.299	68	_____	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	137	REV 00
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D206DC	156	9600	One-piece
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Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
156-12	9600	46	1.100	Knurl	32.2	1.268	66	_____
156-16	9600	50	1.500	Knurl	40.5	1.594	81	_____
156-20	9600	54	1.920	Knurl	52.0	2.047	75	_____
156-24	9600	56	2.140	Knurl	58.4	2.299	68	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	136	REV 00
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D206DC	136	9600	One-piece
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Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	9600	46	1.100	Knurl	33.4	1.315	57	_____
136-16	9600	50	1.500	Knurl	41.0	1.614	77	_____
136-20	9600	54	1.920	Knurl	52.0	2.047	75	_____
136-24	9600	56	2.140	Knurl	58.4	2.299	68	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	154	REV 00
D206DC	663	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

Green Line® 6663

		Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule						Approx.	Actual
		mm			mm	in		

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	168	REV 00
D206DC	663	9600	One-piece	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.		

Green Line® 6663

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	155	REV 00
D206DC	665	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

Green Line® 6665

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	169	REV 00
D206DC	665	9600	One Piece	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.		

Green Line 6665

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Dial Setting		
					Crimp Diameter		Approx. Actual
					mm	in	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	152	REV 00
D206DC	653	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR 653 B.O.P HOSE MSHA API16D

A note on crimping BOP hose:

Blow Out Preventer hoses must be assembled with FG-firejacket sleeve and BOP over ferrule, according to Pulsar Hydraulics Ltd. Assembly Instructions in order to achieve API 16D flame specification.

Hose	Ferrule	Cover Skive Length	Over Ferrule Crimp	Die	Crimp Length	Crimp Diameter	Dial Setting	Approx.	Actual
		mm				mm in			
653-06	4400	26	34	0.830	Full	22.8 0.898	86	_____	
653-08	4400	33	36	0.830	Full	24.9 0.980	70	_____	
653-12	4400	38	43	1.320	Full	34.1 1.343	95	_____	
653-16	4400	49	52	1.500	Full	42.3 1.665	67	_____	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	138	REV 00
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D206DC	115	9600	One-piece
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Cover must be removed before the fittings can be attached. Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.

PULSAR 115

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-12	9600	46	1.100	Knurl	32.4	1.276	65	_____
115-16	9600	50	1.500	Knurl	40.5	1.594	81	_____
115-20	9600	54	1.730	Knurl	48.0	1.890	68	_____
115-24	9600	56	2.140	Knurl	55.0	2.165	95	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	104	REV 00
D206DC	115	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 115

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter mm in	Dial Setting Approx.	Actual
115-06	5120	27	0.830	Full	23.6 0.929	80	_____
115-08	5120		0.830	Full	27.1 1.067	53	_____
115-10	5120		1.100	Full	31.0 1.220	76	_____
115-12	5120		1.320	Full	34.7 1.366	91	_____
115-16	5120		1.500	Full	42.1 1.657	69	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	107	REV 00
D206DC	115	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 115

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
115-06	5420	25	0.830	Full	22.8	0.898	86	_____
115-08	5420	27	0.830	Full	26.0	1.024	61	_____
115-12	5420	32	1.320	Full	34.3	1.350	94	_____
115-16	5420	43	1.500	Full	41.6	1.638	73	_____
115-20	5420	44	1.730	Full	48.0	1.890	68	_____
115-24	5420	57	2.140	Full	55.6	2.189	90	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	93	REV 01
D206DC	115	4400	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.		

PULSAR 115

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-06	4400	25	0.830	Full	23.4	0.921	82	_____
115-16	4400	47	1.500	Full	41.4	1.630	74	_____
115-20	4400	54	1.920	Full	50.1	1.972	90	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	94	REV 00
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D206DC	115	4400	One-piece
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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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches.

PULSAR 115

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
		mm						
115-08	4400	27	0.830	Full	25.4	1.000	66	_____
115-10	4400	27	1.320	Full	34.0	1.339	96	_____
115-12	4400	33	1.320	Full	35.0	1.378	89	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	145	REV 01
D206DC	113	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

113

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
113-08	5420	27	0.830	Full	26.1	1.028	60	_____
113-10	5420	30	0.830	Full	27.7	1.091	48	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	68	REV 01
D206DC	132	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 132

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
132-04	5503	0.670	Full	17.7	0.697	95	_____
132-05	5503	0.830	Full	21.5	0.846	97	_____
132-06	5503	0.670	Full	20.7	0.815	71	_____
132-08	5503	0.830	Full	25.7	1.012	64	_____
132-10	5503	1.100	Full	30.7	1.209	78	_____
132-12	5503	1.320	Full	34.8	1.370	90	_____
132-16	5503	1.500	Full	42.6	1.677	65	_____
132-20	5503	1.730	Full	46.6	1.835	79	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
D206DC	151	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® 151

PULSAR® 151H

Hose	Ferrule	Crimp Insert Size	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
151-04	5503-03	-03	0.520	Full	15.5	0.610	81	_____
151-05	5503-04	-04	0.670	Full	17.4	0.685	97	_____
151-06	5503-05	-05	0.670	Full	20.8	0.819	70	_____
151-08	5503-06	-06	0.670	Full	20.0	0.787	76	_____
151-10	5503-08	-08	0.830	Full	24.9	0.980	70	_____
151-12	5503-10	-10	1.100	Full	30.4	1.197	81	_____
151-16	5503-12	-14	1.320	Full	34.8	1.370	90	_____
151-20	5503-16	-18	1.730	Full	44.1	1.736	99	_____
151-24	5503-20	-22	1.730	Full	47.2	1.858	74	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	67	REV 02
D206DC	141	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 141

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
141-12	5503	1.100	Full	33.0	1.299	60	_____
141-16	5503	1.500	Full	41.1	1.618	76	_____
141-20	5503	1.730	Full	46.0	1.811	84	_____
141-24	5503	1.920	Full	51.8	2.039	76	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	48	REV 00
D206DC	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.		

PULSAR® 170

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
170-04	9700	24	0.520	Knurl	13.8	0.543	95	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	70	REV 03
D206DC	136	9500	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches		

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CAUTION: REVISED CRIMP SPECIFICATIONS FOR 9500-20 FITTINGS ONLY

PULSAR **SPIRAL 13**

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	9500	49	1.320	Full	37.3	1.469	70	_____
136-20	9500 63.5mm OD Shell	66	2.140	Full	56.0	2.205	87	_____
136-20	R9500 65.0mm OD Shell	84	2.140	Full	57.7	2.272	74	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	71	REV 01
D206DC	115	9500	One-pieceN	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 +0.1mm/- 0.2mm or + 0.004/-0.008 inches		

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CAUTION: REVISED CRIMP SPECIFICATIONS FOR 9500-20 FITTINGS ONLY

PULSAR 115

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-12	9500	49	1.320	Full	37.0	1.457	73	_____
115-20	R9500 65.0mm OD Shell	84	1.920	Full	53.9	2.122	60	_____
115-24	9500	75	2.140	Full	60.3	2.374	53	_____