



PULSAR
HYDRAULICS LTD.

GY PC125 CRIMP SPECIFICATION

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Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **83** **REV 00**

PC125 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



		Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule						Approx.	Actual
		mm			mm	in		
111-04	4200	23	16	Full	16.7	0.657	0.7	_____
111-06	4200	25	19	Full	20.9	0.823	1.9	_____
111-08	4200	27	23	Full	24.2	0.953	1.2	_____
111-12	4200	34	31	Full	31.8	1.252	0.8	_____
111-16	4200	44	39	Full	40.6	1.598	1.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	183	REV 00
PC125	110	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		

PULSAR  **CORONA 17** 

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
110-04	4200	23	14	Full	15.7	0.618	1.7	_____
110-06	4200	25	19	Full	19.8	0.780	0.8	_____
110-08	4200	27	23	Full	23.3	0.917	0.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	86	REV 00
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PC125	112	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		
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PULSAR 112 112CC

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	4200	23	16	Full	16.8	0.661	0.8	_____
112-06	4200	25	19	Full	21.0	0.827	2.0	_____
112-08	4200	27	23	Full	25.0	0.984	2.0	_____
112-12	4200	34	31	Full	31.8	1.252	0.8	_____
112-16	4200	44	39	Full	40.6	1.598	1.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	84	REV 01
PC125	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		

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
122-04	4200	23	16	Full	17.8	0.701	1.8	_____
122-06	4200	25	19	Full	22.0	0.866	3.0	_____
122-08	4200	27	23	Full	25.5	1.004	2.5	_____
122-10	4200	30	27	Full	28.8	1.134	1.8	_____
122-12	4200	34	31	Full	32.1	1.264	1.1	_____
122-16	4200	44	41	Full	41.6	1.638	0.6	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **124** **REV 00**

PC125 **114** **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

PULSAR **NOVA 16** **CARBONITE 16** **AURORA 16** **NOVA 16 EXTREME**

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-04	4200	23	16	Full	17.2	0.677	1.2	_____
114-06	4200	25	19	Full	20.8	0.819	1.8	_____
114-08	4200	27	23	Full	24.2	0.953	1.2	_____
114-10	4200	30	27	Full	28.5	1.122	1.5	_____
114-12	4200	34	31	Full	31.8	1.252	0.8	_____
114-16	4200	44	39	Full	40.6	1.598	1.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	151	REV 02
PC125	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		

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

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter mm in		Dial Setting Approx. Actual	
124 PLUS	-06 4400	25	23	Full	24.0	0.945	1.0	_____
124 PLUS	-08 4400	31	23	Full	26.4	1.039	3.4	_____
124 PLUS	-10 4400	31	31	Full	32.6	1.283	1.6	_____
124 PLUS	-12 4400	34	31	Full	34.3	1.350	3.3	_____
124 PLUS	-16 4400	47	41	Full	42.7	1.681	1.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	91	REV 01
PC125	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		

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	19	Full	23.1	0.909	3.11	_____
124-08	4400	31	23	Full	25.4	1.000	2.4	_____
124-10	4400	31	31	Full	32.6	1.283	1.6	_____
124-12	4400	34	31	Full	33.9	1.335	2.9	_____
124-16	4400	47	41	Full	41.4	1.630	0.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	192	REV 01
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PC125	124 XTC	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



Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124 -06	4400 XTC	25	19	Full	23.1	0.909	3.11	_____
124 -08	4400 XTC	31	23	Full	25.4	1.000	2.4	_____
124 -10	4400 XTC	31	31	Full	32.6	1.283	1.6	_____
124 -12	4400 XTC	34	31	Full	33.9	1.335	2.9	_____
124 -16	4400 XTC	47	41	Full	41.4	1.630	0.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	193	REV 01
PC125	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	23	Full	23.8	0.937	0.8	_____
124 -08	5120 XTC	23	Full	27.1	1.067	4.1	_____
124 -10	5120 XTC	27	Full	30.0	1.181	3.0	_____
124 -12	5120 XTC	34	Full	34.6	1.362	0.6	_____
124 -16	5120 XTC	41	Full	42.4	1.669	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	92	REV 03
PC125	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		

PULSAR® SPIRAL 13

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	4400	34	34	Full	35.3	1.390	1.3	_____
136-16	4400	47	41	Full	42.0	1.654	1.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	159	REV 00
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PC125	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		
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		Fitting Insertion			Crimp Length	Dial Setting	
Hose	Ferrule		Die			Crimp Diameter	Approx. Actual
						mm in	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	160	REV 00
PC125	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		




		Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule				mm	in	Approx.	Actual
156 -12 PLUS	4400	34	34	Full	35.1	1.382	1.1	_____
156 -16 PLUS	4400	47	41	Full	42.0	1.654	1.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	185	REV 00
PC125	124 PIUS	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		

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

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	186	REV 00
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PC125	124	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		
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PULSAR **SPIRAL 12**

		Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule						Approx.	Actual
		mm			mm	in		
124-12	4200	34	31	Full	33.1	1.303	2.1	_____
124-16	4200	44	39	Full	40.4	1.591	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	95	REV 02
PC125	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		

PULSAR® 151

PULSAR® 151H

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
151-04	4500-04	14	Knurl	16.1	0.634	2.1	_____
151-05	4500-05	16	Full	18.3	0.720	2.3	_____
151-06	4500-06	19	Full	20.0	0.787	1.0	_____
151-08	4500-08	19	Full	22.9	0.902	3.9	_____
151-10	4500-10	23	Full	26.7	1.051	3.7	_____
151-12	4500-12	27	Full	30.8	1.213	3.8	_____
151-16	4500-16	34	Full	35.5	1.398	1.5	_____
151-20	4500-20	41	Full	43.5	1.713	2.5	_____
151-24	4500-24	41	Knurl	46.8	1.843	5.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	176	REV 00
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PC125	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




Hose	Ferrule	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
151-05	4200-04	23	16	Full	18.1	0.713	2.1	_____
151-08	4200-06	25	19	Full	22.9	0.902	3.9	_____
151-10	4400-08	31	27	Full	28.2	1.110	1.2	_____
151-12	4400-10	31	27	Full	30.8	1.213	3.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	177	REV 00
PC125	151	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 151

PULSAR 151H

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
151-05	5200-04	19	Full	19.5	0.768	0.5	_____
151-08	5120-06	23	Full	23.6	0.929	0.6	_____
151-10	5120-08	27	Full	28.6	1.126	1.6	_____
151-12	5120-10	31	Full	31.8	1.252	0.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	87	REV 01
PC125	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		

PULSAR® 141

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
141-12	4200	34	31	Full	33.1	1.303	2.1	_____
141-16	4200	44	39	Full	40.0	1.575	1.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	122	REV 00
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PC125	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



		Cover Skive Length			Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule		Die			mm	in	Approx.	Actual
		mm							
119-04	4200	21	16	Full	16.7	0.657	0.7	_____	
119-06	4200	21	19	Full	20.7	0.815	1.7	_____	

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	146	REV 02
PC125	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	4300	27	19	Full	21.4	0.843	2.4	_____
129G-06	5200	25	19	Full	20.4	0.803	1.4	_____
129G-06	4200	21	19	Full	20.4	0.803	1.4	_____
129G-08	4200	26	23	Full	25.5	1.004	2.5	_____
129G-08	5200	26	23	Full	24.2	0.953	1.2	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	164	REV 00
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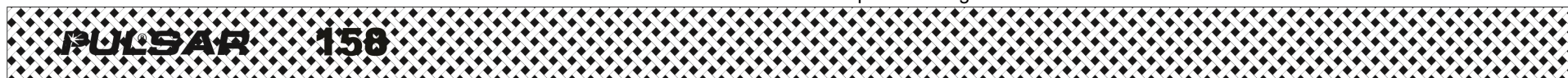
PC125	120J	4200	One-piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +0.1mm/- 0.2mm or + 0.004/-0.008		
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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	16	Full	16.8	0.661	0.8	_____
120J-06	4200	25	19	Full	21.0	0.827	2.0	_____

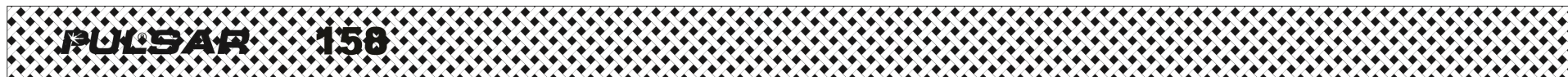
Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **190** **REV 01**

PC125 **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



		Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule				mm	in	Approx.	Actual
158-03	4700	23	10	Knurl	11.3	0.445	1.3	_____
158-04	4700	23	12	Knurl	12.7	0.500	0.7	_____
158-06	4700	26	14	Knurl	16.0	0.630	2.0	_____
158-08	4700	29	19	Knurl	20.5	0.807	1.5	_____
158-10	4700	30	23	Knurl	25.6	1.008	2.6	_____
158-12	4700	34	27	Knurl	28.1	1.106	1.1	_____
158-14	4500	45	31	Knurl	32.3	1.272	1.3	_____
158-16	4700	45	34	Knurl	35.5	1.398	1.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	191	REV 01
PC125	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
158-04	5514	23	12	Full	12.7	0.500	0.7	_____
158-05	5514	23	12	Full	14.4	0.567	2.4	_____
158-06	5514	26	14	Full	16.0	0.630	2.0	_____
158-08	5514	29	19	Full	20.5	0.807	1.5	_____
158-10	5514	30	23	Full	24.8	0.976	1.8	_____
158-12	5514	34	23	Full	27.0	1.063	4.0	_____
158-16	5514	45	31	Full	34.4	1.354	3.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	157	REV 00
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PC125	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		
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		Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule				mm	in	Approx.	Actual
172-02	4700	13.3	10	Full	10.6	0.417	0.6	_____
172-03	4700	21.5	12	Full	13.1	0.516	1.1	_____
172-04	4700	23	14	Full	15.0	0.591	1.0	_____
172-06	4700	26	16	Full	18.8	0.740	2.8	_____
172-08	4700	29	23	Full	24.1	0.949	1.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	175	REV 00
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PC125	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		
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PULSAR® 182

		Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule				mm	in	Approx.	Actual
182-04	4700	23	12	Full	14.1	0.555	2.1	_____
182-06	4700	26	16	Full	18.4	0.724	2.4	_____
182-08	4700	29	23	Full	23.8	0.937	0.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	189	REV 00
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PC125	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



		Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule				mm	in	Approx.	Actual
173-06	4700	26	19	FULL	19.4	0.764	0.4	_____
173-08	4700	29	23	FULL	24.8	0.976	1.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	96	REV 00
PC125	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	
		mm	mm			mm	in	Approx.	Actual
109-04	5000C		20	14	Full	15.5	0.610	1.5	_____
109-06	5000C		20	16	Full	18.7	0.736	2.7	_____
109-08	5000C		22	19	Full	22.6	0.890	3.6	_____
109-10	5000C	21		27	Full	27.6	1.087	0.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	184	REV 00
PC125	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	14	Full	15.1	0.594	1.1	_____
110-06	5000C	20	16	Full	18.7	0.736	2.7	_____
110-08	5000C	22	19	Full	22.5	0.886	3.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	116	REV 00
PC125	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	14	Full	15.9	0.626	1.9	_____
112-06	5000C	18	19	Full	19.2	0.756	0.2	_____
112-08	5000C	20	23	Full	23.5	0.925	0.5	_____
112-10	5000C	20	27	Full	27.6	1.087	0.6	_____
112-12	5000C	26	27	Full	29.9	1.177	2.9	_____
112-16	5000C	35	34	Full	38.1	1.500	4.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	113	REV 00
PC125	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	14	Full	15.9	0.626	1.9	_____
111-06	5000C	18	19	Full	19.3	0.760	0.3	_____
111-08	5000C	20	19	Full	23.2	0.913	3.12	_____
111-12	5000C	26	27	Full	29.9	1.177	2.9	_____
111-16	5000C	35	34	Full	38.1	1.500	4.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	111	REV 00
PC125	122	5000	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	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-04	5000C	16	14	Full	16.4	0.646	2.4	_____
122-06	5000C	18	19	Full	20.0	0.787	1.0	_____
122-08	5000C	20	23	Full	23.8	0.937	0.8	_____
122-10	5000C	20	27	Full	27.9	1.098	0.9	_____
122-12	5000C	26	27	Full	30.1	1.185	3.1	_____
122-16	5000C	35	34	Full	38.4	1.512	4.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	150	REV 01
PC125	124 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	
		mm			mm	in	Approx.	Actual
124 PLUS	-06 5420	25	19	Full	23.0	0.906	3.10	_____
124 PLUS	-08 5420	27	23	Full	26.2	1.031	3.2	_____
124 PLUS	-10 5420	30	27	Full	29.0	1.142	2.0	_____
124 PLUS	-12 5420	32	31	Full	33.4	1.315	2.4	_____
124 PLUS	-16 5420	43	41	Full	41.7	1.642	0.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	156	REV 00
PC125	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	23	Full	24.1	0.949	1.1	_____
124 PLUS	-08 5120	27	Full	27.5	1.083	0.5	_____
124 PLUS	-10 5120	27	Full	30.0	1.181	3.0	_____
124 PLUS	-12 5120	34	Full	34.6	1.362	0.6	_____
124 PLUS	-16 5120	41	Full	42.4	1.669	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	172	REV 00
PC125	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	
		mm			mm	in	Approx.	Actual
156 PLUS	-12 5420	32	31	Full	33.9	1.335	2.9	_____
156 PLUS	-16 5420	43	39	Full	40.8	1.606	1.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	173	REV 01
PC125	156 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
156 PLUS	-12 5120	34	Full	35.1	1.382	1.1	_____
156 PLUS	-16 5120	41	Full	42.0	1.654	1.0	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	112	REV 00
PC125	G102	5000	Non Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
G102-06	5000C	18	19	Full	19.3	0.760	0.3	_____
G102-08	5000C	22	19	Full	23.0	0.906	3.10	_____
G102-12	5000C	28	27	Full	31.3	1.232	4.3	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	196	REV 00
PC125	G103	5000	Non Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
G103-06	5000C	18	19	Full	19.3	0.760	0.3	_____
G103-08	5000C	20	23	Full	23.6	0.929	0.6	_____
G103-12	5000C	26	27	Full	31.0	1.220	4.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	153	REV 00
PC125	114	5000	Two-piece	Tolerance + 0.1/-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
114-04	5000C	16	14	Full	15.9	0.626	1.9	_____
114-06	5000C	18	19	Full	19.1	0.752	0.1	_____
114-08	5000C	20	19	Full	22.6	0.890	3.6	_____
114-10	5000C	20	23	Full	26.7	1.051	3.7	_____
114-12	5000C	26	27	Full	29.8	1.173	2.8	_____
114-16	5000C	35	34	Full	37.7	1.484	3.7	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	100	REV 00
PC125	111	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			



Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
111-04	5200	23	16	Full	17.9	0.705	1.9	_____
111-06	5200	25	19	Full	20.6	0.811	1.6	_____
111-08	5200	27	23	Full	23.4	0.921	0.4	_____
111-12	5200	34	27	Full	30.9	1.217	3.9	_____
111-16	5200	44	34	Full	38.7	1.524	4.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	130	REV 00
PC125	114	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

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CARBONITE 16

AURORA 16

NOVA 16 EXTREME

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-04	5200	23	16	Full	18.2	0.717	2.2	_____
114-06	5200	25	19	Full	20.4	0.803	1.4	_____
114-08	5200	27	23	Full	23.5	0.925	0.5	_____
114-10	5200	30	23	Full	27.2	1.071	4.2	_____
114-12	5200	34	27	Full	30.5	1.201	3.5	_____
114-16	5200	44	34	Full	38.6	1.520	4.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	102	REV 00
PC125	112	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 112 112CC

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
112-04	5200	23	16	Full	18.2	0.717	2.2	_____
112-06	5200	25	19	Full	20.9	0.823	1.9	_____
112-08	5200	27	23	Full	23.5	0.925	0.5	_____
112-10	5200	30	23	Full	27.2	1.071	4.2	_____
112-12	5200	34	27	Full	30.5	1.201	3.5	_____
112-16	5200	44	34	Full	38.6	1.520	4.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	101	REV 00
PC125	122	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

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Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-04	5200	23	19	Full	19.1	0.752	0.1	_____
122-06	5200	25	19	Full	21.4	0.843	2.4	_____
122-08	5200	27	23	Full	24.5	0.965	1.5	_____
122-10	5200	30	27	Full	27.7	1.091	0.7	_____
122-12	5200	34	27	Full	31.2	1.228	4.2	_____
122-16	5200	44	39	Full	39.4	1.551	0.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	105	REV 00
PC125	122	5000	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	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-04	5420	24	16	Full	17.3	0.681	1.3	_____
122-06	5420	25	19	Full	22.5	0.886	3.5	_____
122-08	5420	27	23	Full	25.8	1.016	2.8	_____
122-10	5420	30	27	Full	28.7	1.130	1.7	_____
122-12	5420	32	31	Full	33.6	1.323	2.6	_____
122-16	5420	43	41	Full	41.3	1.626	0.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	103	REV 02
PC125	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	23	Full	23.8	0.937	0.8	_____
124-08	5120	23	Full	27.1	1.067	4.1	_____
124-10	5120	27	Full	30.0	1.181	3.0	_____
124-12	5120	34	Full	34.6	1.362	0.6	_____
124-16	5120	41	Full	42.4	1.669	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	106	REV 00
PC125	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 mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-06	5420	25	19	Full	22.8	0.898	3.8	_____
124-08	5420	27	23	Full	26.0	1.024	3.0	_____
124-10	5420	30	27	Full	29.0	1.142	2.0	_____
124-12	5420	32	31	Full	33.6	1.323	2.6	_____
124-16	5420	43	41	Full	41.7	1.642	0.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	108	REV 00
PC125	136	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® SPIRAL 13

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
136-12	5420	32	34	Full	34.5	1.358	0.5	_____
136-16	5420	43	41	Full	41.5	1.634	0.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	110	REV 01
PC125	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		31	Full	33.1	1.303	2.1	_____
141-16	5200		41	Full	41.0	1.614	0.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	109	REV 00
PC125	156	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® SPIRAL 15

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
156-16	5420	43	41	Full	41.6	1.638	0.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	132	REV 00
PC125	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
172-02	9700	13	8	13.0	9.6	0.378	1.6	_____
172-03	9700	20.2	12	19.8	12.6	0.496	0.6	_____
172-03	9000SB	19	10	18	11.4	0.449	1.4	_____
172-03	5517		10	Full	11.9	0.469	1.9	_____
172-04	5517		12	Full	14.4	0.567	2.4	_____
172-05	5517		16	Full	17.1	0.673	1.1	_____
172-06	5517		16	Full	18.6	0.732	2.6	_____
172-08	5517		19	Full	22.9	0.902	3.9	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	194	REV 01
PC125	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 S	4200	39	Full	40.1	1.579	1.1	_____
119M-16 S	5200	39	Full	39.4	1.551	0.4	_____
119M-16 S	4400	41	Full	42.2	1.661	1.2	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	134	REV 0
PC125	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	12	Full	14.5	0.571	2.5	_____
173-06	5517	16	Full	18.8	0.740	2.8	_____
173-08	5518	23	Full	25.0	0.984	2.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	133	REV 0
PC125	182	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR® 182

PULSAR® 182NY

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
182-04	5517	12	Full	14.1	0.555	2.1	_____
182-06	5517	16	Full	18.2	0.717	2.2	_____
182-08	5517	19	Full	22.6	0.890	3.6	_____
182-12	5517	27	Full	29.8	1.173	2.8	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	181	REV 0
PC125	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			

PULSAR® 111-03

		Crimp Insert Size	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule					mm	in	Approx.	Actual
111-03	4500	-04	19	14	Full	14.8	0.583	0.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	88	REV 00
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PC125	111	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



Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-06	4400	25	19	Full	21.7	0.854	2.7	_____
111-08	4400	31	23	Full	23.8	0.937	0.8	_____
111-12	4400	34	31	Full	33.0	1.299	2.0	_____
111-16	4400	47	41	Full	41.3	1.626	0.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	90	REV 01
PC125	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		

PULSAR 112 112CC

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-06	4400	25	19	Full	21.7	0.854	2.7	_____
112-08	4400	31	23	Full	24.0	0.945	1.0	_____
112-10	4400	31	27	Full	31.1	1.224	4.1	_____
112-12	4400	34	31	Full	33.0	1.299	2.0	_____
112-16	4400	47	39	Full	40.7	1.602	1.7	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **131** **REV 00**

PC125 **114** **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

PULSAR **NOVA 16** **CARBONITE 16** **AURORA 16** **NOVA 16 EXTREME**

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-06	4400	25	19	Full	22.1	0.870	3.1	_____
114-08	4400	31	23	Full	24.0	0.945	1.0	_____
114-10	4400	31	27	Full	31.1	1.224	4.1	_____
114-12	4400	34	31	Full	33.0	1.299	2.0	_____
114-16	4400	47	39	Full	40.7	1.602	1.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	89	REV 00
PC125	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		

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	19	Full	22.8	0.898	3.8	_____
122-08	4400	31	23	Full	24.9	0.980	1.9	_____
122-10	4400	31	31	Full	32.2	1.268	1.2	_____
122-12	4400	34	31	Full	34.1	1.343	3.1	_____
122-16	4400	47	41	Full	42.3	1.665	1.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	114	REV 00
PC125	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		Dial Setting	
					mm	in	Approx.	Actual
119-04	5000C	16	14	Full	15.9	0.626	1.9	_____
119-04	5200	22	16	Full	17.9	0.705	1.9	_____
119-06	5200	25	19	Full	20.1	0.791	1.1	_____
119-06	5000C	18	16	Full	18.7	0.736	2.7	_____
119-08	5000C	20	19	Full	23.2	0.913	3.12	_____
119-08	5200	25	23	Full	23.4	0.921	0.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	154	REV 00
PC125	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		

Green Line® G663

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	155	REV 00
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PC125	665	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

Green Line® G665

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	152	REV 00
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PC125	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		
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PULSAR	653	B.O.P HOSE	MSHA	API16D
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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	
		mm				mm	in	Approx.	Actual
653-06	4400	26	34	19	Full	22.8	0.898	3.8	_____
653-08	4400	33	36	23	Full	24.9	0.980	1.9	_____
653-12	4400	38	43	31	Full	34.1	1.343	3.1	_____
653-16	4400	49	52	41	Full	42.3	1.665	1.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	104	REV 00
PC125	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		Dial Setting	
					mm	in	Approx.	Actual
115-06	5120		23	Full	23.6	0.929	0.6	_____
115-08	5120		23	Full	27.1	1.067	4.1	_____
115-10	5120	27	27	Full	31.0	1.220	4.0	_____
115-12	5120		34	Full	34.7	1.366	0.7	_____
115-16	5120		41	Full	42.1	1.657	1.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	107	REV 00
PC125	115	5000	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		Dial Setting	
					mm	in	Approx.	Actual
115-06	5420	25	19	Full	22.8	0.898	3.8	_____
115-08	5420	27	23	Full	26.0	1.024	3.0	_____
115-12	5420	32	31	Full	34.3	1.350	3.3	_____
115-16	5420	43	41	Full	41.6	1.638	0.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	93	REV 01
PC125	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		

PULSAR® 115

Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-06	4400	25	23	Full	23.4	0.921	0.4	_____
115-16	4400	47	41	Full	41.4	1.630	0.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	94	REV 00
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PC125	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

PULSAR® 115

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-08	4400	27	23	Full	25.4	1.000	2.4	_____
115-10	4400	27	31	Full	34.0	1.339	3.0	_____
115-12	4400	33	34	Full	35.0	1.378	1.0	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	145	REV 01
PC125	113	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

PULSAR® 113

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
113-08	5420	27	23	Full	26.1	1.028	3.1	_____
113-10	5420	30	27	Full	27.7	1.091	0.7	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	68	REV 01
PC125	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	16	Full	17.7	0.697	1.7	_____
132-05	5503	19	Full	21.5	0.846	2.5	_____
132-06	5503	19	Full	20.7	0.815	1.7	_____
132-08	5503	23	Full	25.7	1.012	2.7	_____
132-10	5503	27	Full	30.7	1.209	3.7	_____
132-12	5503	34	Full	34.8	1.370	0.8	_____
132-16	5503	41	Full	42.6	1.677	1.6	_____
132-20	5503	41	Full	46.6	1.835	5.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
PC125	151	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 151

PULSAR 151H

A note on crimping 100R5 hose:

SAE 100R5 series hoses were initially designed as a flexible replacement to copper tubing, which is commonly defined by it's outside diameter. The result is that 100R5 hoses have smaller inside diameters than their nominal size (dash size) would indicate. For example, 151-08, nominally 1/2", actually has an I.D. of 13/32", since that is the I.D. of 1/2" O.D. copper tube. This creates confusion when crimping using inserts and ferrules designed for "full dimension hoses", where the nominal size is the inside diameter (ie. -08 hose is 1/2" I.D.). Be careful to check that selection of the appropriate sized ferrule and insert for the hose you are crimping. Quite often it will be smaller than the dash size of the R5 hose.

Hose	Ferrule	Crimp Insert Size	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
151-04	5503-03	-03	14	Full	15.5	0.610	1.5	_____
151-05	5503-04	-04	16	Full	17.4	0.685	1.4	_____
151-06	5503-05	-05	19	Full	20.8	0.819	1.8	_____
151-08	5503-06	-06	19	Full	20.0	0.787	1.0	_____
151-10	5503-08	-08	23	Full	24.9	0.980	1.9	_____
151-12	5503-10	-10	27	Full	30.4	1.197	3.4	_____
151-16	5503-12	-14	34	Full	34.8	1.370	0.8	_____
151-20	5503-16	-18	41	Full	44.1	1.736	3.1	_____

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	67	REV 02
PC125	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	31	Full	33.0	1.299	2.0	_____
141-16	5503	41	Full	41.1	1.618	0.1	_____
141-20	5503	41	Full	46.0	1.811	5.0	_____