

Crimper	Hose	Coupling	Crimp Instructions			CHART NUMBER		83	REV 00	
K16	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.						
			Fitting Insertion Length	Die	Crimp Position	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule								Approx.	Actual
			mm				mm	in		
111-04	4200		23	0.600	FLUSH	Full	16.7	0.657	70	_____
			Alternate	0.500					63	
111-06	4200		25	0.750	FLUSH	Full	20.9	0.823	71	_____
			Alternate							
111-08	4200		27	0.915	FLUSH	Full	24.2	0.953	74	_____
			Alternate	0.750					60	

Crimper	Hose	Coupling	Crimp Instructions				CHART NUMBER		84	REV 01
K16	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.						
			Fitting Insertion Length	Die	Crimp Position	Crimp Length	Crimp Diameter		Dial Setting	
Hose	Ferrule								Approx.	Actual
			mm				mm	in		
122-04	4200		23	0.600	FLUSH	Full	17.8	0.701	67	_____
			Alternate	0.500					60	
122-06	4200		25	0.750	FLUSH	Full	22.0	0.866	68	_____
			Alternate							
122-08	4200		27	0.915	FLUSH	Full	25.5	1.004	70	_____
			Alternate							