

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	49	REV 02
PC707 6D	111	9200	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-04	9200	20	G	FULL	16.9	0.665	0.15	_____
111-06	9200	21	J	FULL	20.6	0.811	0.1	_____
111-08	9200	26	L	FULL	23.7	0.933	1.85	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	40	REV 06
PC707 6D	111	9400	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-10	9400	29	P	FULL	30.8	1.213	1.45	_____
111-12	9400	32	P	FULL	35.2	1.386	10	_____
111-20	9400	39	AA	FULL	50.6	1.992	2.8	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	50	REV 02
PC707 6D	122	9200	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-04	9200	20	G	FULL	17.7	0.697	1.7	_____
122-06	9200	21	J	FULL	21.5	0.846	1.9	_____
122-08	9200	25	L	FULL	24.6	0.969	3.6	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	57	REV 02
PC707 6D	122	9400	One Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
122-06	9400	21	L	FULL	24.0	0.945	2.4	_____
122-08	9400	25	N	FULL	27.9	1.098	3.3	_____
122-10	9400	29	P	FULL	31.5	1.240	2.85	_____
122-20	9400	39	AA	FULL	52.8	2.079	7.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	61	REV 05
PC707 6D	112	9200	Non-Skive	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	9200	20	G	FULL	17.2	0.677	0.75	_____
112-06	9200	21	J	FULL	20.6	0.811	0.1	_____
112-08	9200	25	L	FULL	24.0	0.945	2.4	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	42	REV 07
PC707 6D	124	9400	One-Piece	Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +/- 0.1 mm or +/- 0.004 inches .			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124-06	9400	21	L	FULL	24.4	0.961	3.2	_____
124-08	9400	26	N	FULL	28.5	1.122	4.5	_____
124-10	9400	29	P	FULL	32.7	1.287	5.2	_____
124-20	9400	39	AA	FULL	51.5	2.028	4.55	_____

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
PC707 6D	151	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

A note on crimping 100R5 hose:

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

Hose	Ferrule	Crimp Insert Size	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
151-05	5503-04	-04	G	FULL	17.4	0.685	1.15	_____
151-06	5503-05	-05	J	FULL	20.8	0.819	0.5	_____
151-08	5503-06	-06	H	FULL	20.0	0.787	2.75	_____
151-10	5503-08	-08	L	FULL	24.9	0.980	4.2	_____
151-12	5503-10	-10	P	FULL	30.4	1.197	0.65	_____
151-16	5503-12	-14	P	FULL	34.8	1.370	9.35	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	68	REV 01
PC707 6D	132	5000	Non-Skive Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
132-04	5503	G	FULL	17.7	0.697	1.7	_____
132-05	5503	J	FULL	21.5	0.846	1.9	_____
132-06	5503	J	FULL	20.7	0.815	0.3	_____
132-08	5503	L	FULL	25.7	1.012	5.75	_____
132-10	5503	P	FULL	30.7	1.209	1.25	_____
132-12	5503	P	FULL	34.8	1.370	9.35	_____
132-16	5503	S	FULL	42.6	1.677	9.6	_____

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

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

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER		78	REV
PC707 6D	182	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .				
Hose Ferrule		Die	Crimp Length	Crimp Diameter		Dial Setting		Actual
				mm	in	Approx.		
182-06	5507	G	FULL	18.5	0.728	3.3	_____	
182-08	5507	L	FULL	23.1	0.909	0.65	_____	

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

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

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

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

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

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

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

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

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

PC707 124 5000 Skive Tolerance +/- 0.1mm or +/- 0.004 inches .
6D

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

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

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

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

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

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

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

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

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

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	56	REV G
PC707 6D	157	4000	Non Skive			

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

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **45** **REV 01**

PC707 3130 9700 **Non-Skive** Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.
6D

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
3130-04	9700	24	D	24.0mm	14.1	0.555	0.25	_____
3130-05	9700	22	E	22.5mm	16.0	0.630	0.85	_____
3130-06	9700	28	G	28.5mm	17.1	0.673	0.55	_____
3130-08	9700	27	J	27.0mm	21.0	0.827	0.9	_____
3130-12	9700	35	N	35mm	27.4	1.079	2.3	_____

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

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	47	REV 01
PC707 6D	183	9700	Non-Skive	Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.			

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

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	48	REV 00
PC707 6D	170	9700	Non-Skive	Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.			

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

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	11	REV 00
PC707 6D	141	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
141-16	5904	S	FULL	42.2	1.661	8.8	_____
141-20	5904	AA	FULL	50.5	1.988	2.6	_____

Crimper Hose Coupling

Crimp Instructions

CHART NUMBER

11

REV 00

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