



D205M CRIMP SPECIFICATIONS

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.

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **49** **REV 02**

D205M 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	16	FULL	16.9	0.665	0.9	_____
111-06	9200	21	19	FULL	20.6	0.811	1.6	_____
111-08	9200	26	22	FULL	23.7	0.933	1.7	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **40** **REV 06**

D205M 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	30	FULL	30.8	1.213	0.8	_____
111-12	9400	32	34	FULL	35.2	1.386	1.2	_____
111-16	9400	39	39	FULL	43.1	1.697	4.1	_____
111-20	9400	39	50	FULL	50.6	1.992	0.6	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **50** **REV 02**

D205M 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	16	FULL	17.7	0.697	1.7	_____
122-06	9200	21	19	FULL	21.5	0.846	2.5	_____
122-08	9200	25	22	FULL	24.6	0.969	2.6	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **57** **REV 02**

D205M 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	22	FULL	24.0	0.945	2.0	_____
122-08	9400	25	26	FULL	27.9	1.098	1.9	_____
122-10	9400	29	30	FULL	31.5	1.240	1.5	_____
122-12	9400	32	34	FULL	35.9	1.413	1.9	_____
122-16	9400	39	39	FULL	43.7	1.720	4.7	_____
122-20	9400	39	50	FULL	52.8	2.079	2.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	70	REV 02
D205M	136	9500	One Piece			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	9500	49	34	FULL	37.3	1.469	3.3	_____
136-16	9500	56	39	FULL	43.9	1.728	4.9	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		71	REV 01
D205M	115	9500	One-piece					
Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm			mm	in	Approx.	Actual
115-16	9500	56	39	FULL	43.9	1.728	4.9	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **61** **REV 05**

D205M 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	16	FULL	17.2	0.677	1.2	_____
112-06	9200	21	19	FULL	20.6	0.811	1.6	_____
112-08	9200	25	22	FULL	24.0	0.945	2.0	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **42** **REV 07**

D205M 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	22	FULL	24.4	0.961	2.4	_____
124-08	9400	26	26	FULL	28.5	1.122	2.5	_____
124-10	9400	29	30	FULL	32.7	1.287	2.7	_____
124-12	9400	32	34	FULL	36.3	1.429	2.3	_____
124-16	9400	39	39	FULL	43.9	1.728	4.9	_____
124-20	9400	39	50	FULL	51.5	2.028	1.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	62	REV	05/05
D205M	124S	9600	Skive	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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124S-12	9600	47	30	KNURL	33.1	1.303	3.1	_____
124S-16	9600	50	39	KNURL	40.9	1.610	1.9	_____
124S-20	9600	54	47	KNURL	49.1	1.933	2.1	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **65** **REV 05/05**

D205M **115** **9600** **Skive**

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-08	9600	28	22	KNURL	25.9	1.020	3.9	_____
115-12	9600	47	30	KNURL	32.1	1.264	2.1	_____
115-16	9600	50	39	KNURL	39.9	1.571	0.9	_____
115-20	9600	54	47	KNURL	47.6	1.874	0.6	_____

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **63** **REV 05/05**

D205M 136 9600 Skive

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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
136-12	9600	47	30	KNURL	33.2	1.307	3.2	_____
136-16	9600	50	39	KNURL	41.0	1.614	2.0	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	64	REV 05/05
D205M	156	9600	Skive	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	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
156-16	9600	50	39	KNURL	39.9	1.571	0.9	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	66	REV 05/05
D205M	663 662	9600	Skive	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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	20	REV 06
D205M	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	14	FULL	15.9	0.626	1.9	_____
109-06	5500	16	FULL	18.5	0.728	2.5	_____
109-08	5500	19	FULL	21.9	0.862	2.9	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	76	REV 00
D205M	662 663	6500	One-piece			

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	17	REV 12
D205M	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	16	FULL	17.2	0.677	1.2	_____
111-05	5502	19	FULL	19.8	0.780	0.8	_____
111-06	5512	19	FULL	20.6	0.811	1.6	_____
111-08	5502	22	FULL	23.7	0.933	1.7	_____
111-10	5502	26	FULL	28.5	1.122	2.5	_____
111-12	5502	30	FULL	32.3	1.272	2.3	_____
111-16	5502	39	FULL	43.2	1.701	4.2	_____
111-20	5501	47	FULL	48.9	1.925	1.9	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	18	REV 09
D205M	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	16	FULL	17.7	0.697	1.7	_____
122-06	5512	19	FULL	21.8	0.858	2.8	_____
122-08	5502	22	FULL	24.6	0.969	2.6	_____
122-10	5502	26	FULL	29.5	1.161	3.5	_____
122-12	5502	30	FULL	33.2	1.307	3.2	_____
122-16	5502	39	FULL	44.1	1.736	5.1	_____
122-20	5502	50	FULL	53.1	2.091	3.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	37	REV 08
D205M	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	16	FULL	17.2	0.677	1.2	_____
112-05	5502	19	FULL	19.8	0.780	0.8	_____
112-06	5512	19	FULL	20.5	0.807	1.5	_____
112-08	5502	22	FULL	24.0	0.945	2.0	_____
112-10	5502	26	FULL	28.5	1.122	2.5	_____
112-12	5502	30	FULL	32.3	1.272	2.3	_____
112-16	5502	39	FULL	43.3	1.705	4.3	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	33	REV 05
D205M	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	22	FULL	24.0	0.945	2.0	_____
122-08	5504	26	FULL	27.9	1.098	1.9	_____
122-10	5504	30	FULL	31.5	1.240	1.5	_____
122-12	5504	34	FULL	35.9	1.413	1.9	_____
122-16	5504	39	FULL	43.7	1.720	4.7	_____
122-20	5504	50	FULL	52.8	2.079	2.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	32	REV 06
D205M	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	22	FULL	24.4	0.961	2.4	_____
124-08	5504	26	FULL	28.5	1.122	2.5	_____
124-10	5504	30	FULL	32.7	1.287	2.7	_____
124-12	5504	34	FULL	36.3	1.429	2.3	_____
124-16	5504	39	FULL	43.9	1.728	4.9	_____
124-20	5504	50	FULL	52.4	2.063	2.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	67	REV 01
D205M	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	30	FULL	33.0	1.299	3.0	_____
141-16	5503	39	FULL	41.1	1.618	2.1	_____
141-20	5503	39	FULL	44.5	1.752	5.5	_____
141-24	5503	50	FULL	51.8	2.039	1.8	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	59	REV 07
D205M	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 its 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	22	FULL	24.9	0.980	2.9	_____
151-12	5503-10	-10	30	FULL	30.4	1.197	0.4	_____
151-16	5503-12	-14	34	FULL	34.8	1.370	0.8	_____
151-20	5503-16	-18	39	FULL	44.1	1.736	5.1	_____
151-24	5503-20	-22	47	FULL	47.2	1.858	0.2	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	68	REV 01
D205M	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	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	22	FULL	25.7	1.012	3.7	_____
132-10	5503	30	FULL	30.7	1.209	0.7	_____
132-12	5503	34	FULL	34.8	1.370	0.8	_____
132-16	5503	39	FULL	42.6	1.677	3.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	77	REV 0
D205M	172	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
172-02	9700	13	8	13.0	9.1	0.358	1.1	_____
172-03	5507		10	FULL	11.2	0.441	1.2	_____
172-04	5507		14	FULL	14.1	0.555	0.1	_____
172-05	5507		16	FULL	16.7	0.657	0.7	_____
172-06	5507		16	FULL	18.9	0.744	2.9	_____
172-08	5507		22	FULL	23.5	0.925	1.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	78	REV
D205M	182	5000	Non-Skive	Tolerance +/- 0.1mm or +/- 0.004 inches .		

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
182-04	5507	12	FULL	13.9	0.547	1.9	_____
182-06	5507	16	FULL	18.5	0.728	2.5	_____
182-08	5507	22	FULL	23.1	0.909	1.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	79	REV 0
D205M	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	14	FULL	14.1	0.555	0.1	_____
173-06	5507	19	FULL	19.0	0.748	0.0	_____
173-08	5518	22	FULL	24.0	0.945	2.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	58	REV 00
D205M	37AL	5508	Non-Skive			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
37AL-04	5508	14		14.2	0.559	0.2	_____
37AL-06	5508	19		19.0	0.748	0.0	_____
37AL-08	5508	22		23.0	0.906	1.0	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	21	REV 10
D205M	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	16	FULL	17.5	0.689	1.5	_____
111-05	5904	19	16	FULL	18.2	0.717	2.2	_____
111-06	5904	20	19	FULL	21.0	0.827	2.0	_____
111-08	5904	26	22	FULL	25.1	0.988	3.1	_____
111-10	5904	28	26	FULL	27.6	1.087	1.6	_____
111-12	5904	33	30	FULL	31.7	1.248	1.7	_____
111-16	5904	37	39	FULL	40.3	1.587	1.3	_____
111-20	5901	32	47	FULL	47.0	1.850	0.0	_____
111-24	5901	36	50	FULL	54.3	2.138	4.3	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	22	REV 09
D205M	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	16	FULL	18.1	0.713	2.1	_____
122-05	5904	19	19	FULL	19.1	0.752	0.1	_____
122-06	5904	20	19	FULL	21.9	0.862	2.9	_____
122-08	5904	26	22	FULL	25.9	1.020	3.9	_____
122-10	5904	28	26	FULL	28.5	1.122	2.5	_____
122-12	5904	33	30	FULL	32.5	1.280	2.5	_____
122-16	5904	37	39	FULL	41.0	1.614	2.0	_____
122-20	5904	41	50	FULL	51.5	2.028	1.5	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	23	REV 08
D205M	124	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
124-06	5905	19	22	FULL	22.3	0.878	0.3	_____
124-08	5905	25	26	FULL	26.6	1.047	0.6	_____
124-10	5904	28	26	FULL	29.7	1.169	3.7	_____
124-12	5904	33	30	FULL	32.9	1.295	2.9	_____
124-16	5904	37	39	FULL	41.0	1.614	2.0	_____
124-20	5904	41	50	FULL	51.2	2.016	1.2	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	26	REV 12
D205M	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	16	FULL	17.3	0.681	1.3	_____
112-05	5904	19	16	FULL	18.2	0.717	2.2	_____
112-06	5904	20	19	FULL	20.9	0.823	1.9	_____
112-08	5904	26	22	FULL	25.3	0.996	3.3	_____
112-10	5904	28	26	FULL	27.6	1.087	1.6	_____
112-12	5904	33	30	FULL	31.7	1.248	1.7	_____
112-16	5904	37	39	FULL	40.4	1.591	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	27	REV 05
D205M	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	26	FULL	26.0	1.024	0.0	_____
113-10	5904	28	26	FULL	28.5	1.122	2.5	_____
113-12	5904	33	30	FULL	32.5	1.280	2.5	_____
113-16	5904	37	39	FULL	41.0	1.614	2.0	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	24	REV 12
D205M	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	22	FULL	22.1	0.870	0.1	_____
115-08	5905	26	26	FULL	26.4	1.039	0.4	_____
114-10	5904	28	26	FULL	29.2	1.150	3.2	_____
114-12	5904	33	30	FULL	33.3	1.311	3.3	_____
114-16	5904	37	39	FULL	41.3	1.626	2.3	_____
114-20	5904	41	50	FULL	50.7	1.996	0.7	_____

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER		72	REV 01	
D205M	119B 118	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
119B -04	5904	19		16	FULL	17.1	0.673	1.1	_____
119B -06	5904	20		19	FULL	21.0	0.827	2.0	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		51	REV 00
D205M	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	19	FULL	21.0	0.827	2.0	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		53	REV 00
D205M	120J	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
120J-04	5904	19	16	FULL	18.1	0.713	2.1	_____
120J-06	5904	20	19	FULL	21.9	0.862	2.9	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	56	REV G
D205M	157	4000	Non Skive			

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
157-04	4000	8	FULL	8.9	0.350	0.9	_____
157-04	4012SS-04 4042SS-04 4092SS-04	8	FULL	8.3	0.327	0.3	_____
157-05	4000	10	FULL	10.3	0.406	0.3	_____
157-06	4000	12	FULL	12.2	0.480	0.2	_____
157-08	4000	14	FULL	14.5	0.571	0.5	_____
157-10	4000	16	FULL	17.2	0.677	1.2	_____
157-12	4000	19	FULL	20.4	0.803	1.4	_____
157-16	4000	26	FULL	26.6	1.047	0.6	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	45	REV 01
D205M	3130	9700	Non-Skive	Leave a section of ferrule nearest thread end of fitting uncrimped, crimp only to the position described in "Crimp Length". Crimp diameter tolerance +/- 0.1mm.		

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
3130-02	9700	13	8	13.0mm	9.9	0.390	1.9	_____
3130-03	9700	20	12	20.5mm	12.1	0.476	0.1	_____
3130-04	9700	24	14	24.0mm	14.1	0.555	0.1	_____
3130-05	9700	22	16	22.5mm	16.0	0.630	0.0	_____
3130-06	9700	28	16	28.5mm	17.1	0.673	1.1	_____
3130-08	9700	27	19	27.0mm	21.0	0.827	2.0	_____
3130-12	9700	35	26	35mm	27.4	1.079	1.4	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	46	REV 01
D205M	3R80	9800	Non-Skive			

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
3R80-03	9800	24	12	24mm	13.2	0.520	1.2	_____
3R80-04	9800	24	16	24mm	16.6	0.654	0.6	_____
3R80-06	9800	28	19	28.5mm	19.6	0.772	0.6	_____
3R80-08	9800	32	22	32mm	22.4	0.882	0.4	_____
3R80-12	9800	34	26	33.5mm	28.6	1.126	2.6	_____
3R80-16	9800	46	34	46mm	37.1	1.461	3.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	47	REV 01
D205M	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	in	Approx.	Actual

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	48	REV 00
D205M	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	
					mm	in	Approx.	Actual
170-04	9700	24	12	KNURL	13.8	0.543	1.8	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		52	REV 0	
D205M	111	9000SB	Skive						
Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
111-03	9000SB	19		10	17mm	11.6	0.457	1.6	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		3	REV 08	
D205M	156	8000	Interlock						
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
156-12	8604	52	15	34	FULL	34.0	1.339	0.0	_____
156-16	8604	65	17	39	FULL	42.2	1.661	3.2	_____

Crimper	Hose	Coupling	Crimp Instructions		CHART NUMBER		5	REV 07	
D205M	136	8000	Interlock						
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
136-12	8604	52	15	34	FULL	34.1	1.343	0.1	_____
136-16	8604	65	17	39	FULL	42.1	1.657	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		6	REV 08	
D205M	115	8000	Interlock						
Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
115-16	8604	65	17	39	FULL	42.1	1.657	3.1	_____
115-20	8604	74	21.5	50	FULL	51.1	2.012	1.1	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	11	REV 00
D205M	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	39	FULL	42.2	1.661	3.2	_____
141-20	5904	50	FULL	50.5	1.988	0.5	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	13	REV 04
D205M	124	8000	Interlock			

Hose	Ferrule	Cover Skive Length	Tube Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
124-12	8604	52	15	30	FULL	33.4	1.315	3.4	_____
124-16	8604	65	17	39	FULL	41.7	1.642	2.7	_____
124-20	8604	74	21.5	50	FULL	51.9	2.043	1.9	_____

Crimper Hose Coupling

Crimp Instructions

CHART NUMBER

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REV 04