

1. Cut hose square and clean the hose bore.

2. Mount the stem in a vice, and lubricate the nipple stem and inside of hose with heavy oil (gear oil works well) or hydraulic oil.

3. Remove the hose cover completely to the length indicated on the crimp chart, using a wire wheel or hand skiver. Check the skive length.

4. Place the ferrule over the end of the hose, and push the hose onto the stem until the hose bottoms against the stem shoulder.

5. Push the ferrule back towards the fitting thread so that the collar aligns correctly over the groove in the stem.

6. Position the fitting in the crimper so that it will crimp the full length of the ferrule, without damaging the hex or thread, and crimp to the correct dimension

7. Verify the crimp dimensions by measuring at the midpoint of the crimp.

