



PULSAR
HYDRAULICS LTD

DE30 CRIMP SPECIFICATIONS

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Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	83	REV 00
DE 30	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.			



Hose	Ferrule	Cover Skive Length mm	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
111-04	4200		23	0.520	Full	16.7	0.657	71	_____
111-06	4200		25	0.670	Full	20.9	0.823	69	_____
111-08	4200		27	0.830	Full	24.2	0.953	75	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	84	REV 01
DE 30	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.



Hose	Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
122-04	4200		23	0.670	Full	17.8	0.701	94	_____
122-06	4200		25	0.830	Full	22.0	0.866	93	_____
122-08	4200		27	0.830	Full	25.5	1.004	65	_____

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	49	REV 02
DE 30	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	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
111-04	9200		20	0.520	Full	16.9	0.665	69	_____
111-06	9200		21	0.670	Full	20.6	0.811	72	_____
111-08	9200		26	0.830	Full	23.7	0.933	79	_____

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	50	REV 02
DE 30	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	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
		mm	mm			mm	in	Approx.	Actual
122-04	9200		20	0.670	Full	17.7	0.697	95	_____
122-06	9200		21	0.830	Full	21.5	0.846	97	_____
122-08	9200		25	0.830	Full	24.6	0.969	72	_____