

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.

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

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

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.