

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **83** **REV 00**

K24 **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	FLUSH					0.500
111-06	4200	25	0.750	FLUSH	Full	20.9	0.823	70	_____
		Alternate							
111-08	4200	27	0.915	BELOW 1/4	Full	24.2	0.953	75	_____
		Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **84** **REV 01**

K24 **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	FLUSH					0.500
122-06	4200	25	0.750	FLUSH	Full	22.0	0.866	67	_____
		Alternate							
122-08	4200	27	0.915	FLUSH	Full	25.5	1.004	70	_____
		Alternate							
122-10	4200	30	0.915	FLUSH	Full	28.8	1.134	63	_____
		Alternate	1.50	HIT TWICE					1.50
122-16	4200	44	1.550	FLUSH	Full	41.6	1.638	69	_____
		Alternate							

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	151	REV 02
K24	124 PLUS	4400	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	Approx.	Actual
			mm				mm	in		
124 PLUS	-06	4400	25	0.915	BELOW 1/4	Full	24.0	0.945	75	_____
			Alternate							
124 PLUS	-10	4400	31	1.050	HIT TWICE	Full	32.6	1.283	59	_____
			Alternate							
124 PLUS	-12	4400	34	1.275	BELOW 1/2	Full	34.3	1.350	71	_____
			Alternate							
124 PLUS	-16	4400	47	1.550	FLUSH	Full	42.7	1.681	66	_____
			Alternate							
124 PLUS	-24	4400	56	1.975	3/4" above hit twice	Full	60.3	2.374	46	_____
			Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **91** **REV 01**

K24 **124** **4400** **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
124-08	4400	31	0.915	FLUSH	Full	25.4	1.000	70	_____
		Alternate							
124-10	4400	31	1.050	HIT TWICE	Full	32.6	1.283	59	_____
		Alternate							
124-16	4400	47	1.550	FLUSH	Full	41.4	1.630	70	_____
		Alternate							
124-20	4400	54	1.750	FLUSH	Full	51.9	2.043	56	_____
		Alternate							
124-24	4400	56	1.975	3/4" above hit twice	Full	60.3	2.374	46	_____
		Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **88** **REV 00**

K24 **111** **4400** **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
111-06	4400	25	0.750	FLUSH	Full	21.7	0.854	68	_____
		Alternate							
111-12	4400	34	1.050	HIT TWICE	Full	33.0	1.299	58	_____
		Alternate							
111-16	4400	47	1.550	FLUSH	Full	41.3	1.626	70	_____
		Alternate							
111-20	4400	54	1.750	FLUSH	Full	51.3	2.020	57	_____
		Alternate							
111-24	4400	56	1.975	3/4" above hit twice	Full	60.0	2.362	47	_____
		Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **89** **REV 00**

K24 **122** **4400** **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
122-06	4400	25	0.750	FLUSH	Full	22.8	0.898	65	_____
		Alternate							
122-08	4400	31	0.915	FLUSH	Full	24.9	0.980	72	_____
		Alternate							
122-10	4400	31	1.050	HIT TWICE	Full	32.2	1.268	60	_____
		Alternate							
122-12	4400	34	1.275	BELOW 1/2	Full	34.1	1.343	71	_____
		Alternate							
122-16	4400	47	1.550	FLUSH	Full	42.3	1.665	67	_____
		Alternate							
122-20	4400	54	1.750	FLUSH	Full	52.4	2.063	54	_____
		Alternate							
122-24	4400	56	1.975	3/4" above hit twice	Full	60.9	2.398	44	_____
		Alternate							