

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

K601 **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	mm	23	0.600	FLUSH	Full	16.7	0.657	70	_____
		Alternate		0.500	FLUSH				63	
111-06	4200		25	0.915	FLUSH	Full	20.9	0.823	75	_____
		Alternate		0.750	HIT TWICE				60	
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**

K601 **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					60
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	71	_____
		Alternate							
122-10	4200	30	0.915	FLUSH	Full	28.8	1.134	62	_____
		Alternate	1.050	HIT TWICE					70
122-12	4200	34	1.050	HIT TWICE	Full	32.1	1.264	61	_____
		Alternate							
122-16	4200	44	1.550	FLUSH	Full	41.6	1.638	65	_____
		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.

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	151	REV 02
K601	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	60	_____	
			Alternate								
124 PLUS	-12	4400	34	1.275		Full	34.3	1.350	70	_____	
			Alternate								
124 PLUS	-24	4400	56	1.975	HIT TWICE	Full	60.3	2.374	47	_____	
			Alternate								
124 PLUS	-32	4400	70	2.500	HIT TWICE	Full	74.8	2.945	46	_____	
			Alternate								

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

K601 **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	71	_____
		Alternate							
124-10	4400	31	1.050	HIT TWICE	Full	32.6	1.283	60	_____
		Alternate							
124-12	4400	34	1.275		Full	33.9	1.335	71	_____
		Alternate							
124-16	4400	47	1.550	FLUSH	Full	41.4	1.630	65	_____
		Alternate							
124-20	4400	54	1.750	FLUSH	Full	51.9	2.043	56	_____
		Alternate							
124-24	4400	56	1.975	HIT TWICE	Full	60.3	2.374	47	_____
		Alternate							
124-32	4400	70	2.500	HIT TWICE	Full	74.8	2.945	46	_____
		Alternate							

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **92** **REV 03**

K601 **136** **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
136-12	4400	34	1.275		Full	35.3	1.390	67	_____
		Alternate							
136-16	4400	47	1.550	FLUSH	Full	42.0	1.654	64	_____
		Alternate							

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

K601 **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	59	_____
Alternate									
111-16	4400	47	1.550	FLUSH	Full	41.3	1.626	65	_____
Alternate									
111-20	4400	54	1.750	FLUSH	Full	51.3	2.020	57	_____
Alternate									
111-24	4400	56	1.975	HIT TWICE	Full	60.0	2.362	48	_____
Alternate									

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

K601 **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	61	_____
Alternate									
122-12	4400	34	1.275		Full	34.1	1.343	70	_____
Alternate									
122-16	4400	47	1.550	FLUSH	Full	42.3	1.665	63	_____
Alternate									
122-20	4400	54	1.750	FLUSH	Full	52.4	2.063	54	_____
Alternate									
122-24	4400	56	1.975	HIT TWICE	Full	60.9	2.398	46	_____
Alternate									

Crimper	Hose	Coupling	Crimp Instructions			CHART NUMBER		89	REV 00
122-32	4400		70	2.500	HIT TWICE	Full	72.9	2.870	49 _____
			Alternate						

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	148	REV 00
K601	124 PLUS	9600	One-piece	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 Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
124 PLUS	-12 9600	46	1.050	HIT TWICE	KNUR	32.2	1.268	61	_____

Alternate

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER		136	REV 00		
K601	136	9600	One-piece	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 Position	Crimp Length	Crimp Diameter		Dial Setting	
		mm					mm	in	Approx.	Actual
136-12	9600	46		1.275		Knurl	33.4	1.315	73	_____
			Alternate							
136-16	9600	50		1.550		Knurl	41.0	1.614	71	_____
			Alternate							
136-20	9600	54		1.750	FLUSH	Knurl	52.0	2.047	55	_____
			Alternate							

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	138	REV 00
K601	115	9600	One-piece	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 Position	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
115-12	9600	46	1.050	HIT TWICE	Knurl	32.4	1.276	60	_____

Alternate

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **93** **REV 01**

K601 **115** **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
115-16	4400	47	1.550	FLUSH	Full	41.4	1.630	65	_____
		Alternate							
115-20	4400	54	1.750	FLUSH	Full	50.1	1.972	60	_____
		Alternate							

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER		94	REV 00		
K601	115	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	Cover Skive Length		Die	Crimp Position	Crimp Length	Crimp Diameter		Dial Setting	
		mm					mm	in	Approx.	Actual
115-08	4400	27		0.915	FLUSH	Full	25.4	1.000	71	_____
			Alternate							
115-10	4400	27		1.275		Full	34.0	1.339	71	_____
			Alternate							
115-12	4400	33		1.275		Full	35.0	1.378	68	_____
			Alternate							