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Crimper Hose Coupling Crimp Instructions CHART NUMBER 83 REV 00

PC125 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

111A

\*ULSAR NOVA1 \*\* \*\*ULSAR

FULSAR 111FS

	Fitting Insertion		Crimp		Dial Setting
Hose Ferrule	Length	Die	Length	Crimp Diameter	Approx. Actual
	mm			mm in	
111-04 4200	23	16	Full	16.7 0.657	0.7
111-06 4200	25	19	Full	20.9 0.823	1.9
111-08 4200	27	23	Full	24.2 0.953	1.2
111-12 4200	34	31	Full	31.8 1.252	0.8
111-16 4200	44	34	Full	40.6 1.598	6.6

IT01 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 183 REV 00

PC125 110 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

PUĽSAR III	CORONA 17							
Hose Ferrule	In	tting sertion ength	Die	Crimp Length	Crimp D	iameter	Dial Set	•
		mm			mm	in		
110-04 4200	2	23	14	Full	15.7	0.618	1.7	
110-06 4200	2	25	19	Full	19.8	0.780	0.8	
110-08 4200	2	27	23	Full	23.3	0.917	0.3	

TT69 00 the largest diameter die



112-12 4200

112-16 4200

#### CRIMP SPECIFICATIONS

0.8 \_\_\_\_\_

6.6 \_\_\_\_\_

Crimper Hose Coupling Crimp Instructions CHART NUMBER 86 REV 00

PC125 112 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

#### **FULSAR** 112 112CC **Fitting Dial Setting** Insertion Crimp Length Length **Ferrule** Die **Crimp Diameter** Hose Approx. Actual mm mm in 23 Full 0.8 \_\_\_\_\_ 112-04 4200 16.8 0.661 16 2.0 \_\_\_\_\_ Full 112-06 4200 25 19 21.0 0.827 2.0 112-08 4200 27 23 Full 25.0 0.984

31

34

Full

Full

34

44

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.

31.8

40.6

1.252

1.598



Crimper Hose Coupling Crimp Instructions CHART NUMBER 84 REV 01

PC125 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

				are retrained and are	mp Blameter given in a	rio table. Teleral	100 - 0. 11111117 0	.2.11111 01 + 0.00 17	0.000
<b>PULSA</b>	R IIII	NOVA 2	,	NOVA 2 ICE	BREAKER		122A		
Hose	Ferrule		Fitting Insertic Length		Crimp Length	Crimp [	Diameter	Dial Se Approx.	J
			mm			mm	in		
122-04	4200		23	16	Full	17.8	0.701	1.8 _	
122-06	4200		25	19	Full	22.0	0.866	3.0 _	
122-08	4200		27	23	Full	25.5	1.004	2.5 _	
122-10	4200		30	27	Full	28.8	1.134	1.8 _	
122-12	4200		34	31	Full	32.1	1.264	1.1 _	
122-16	4200		44	41	Full	41.6	1.638	0.6 _	

IT02 01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 124 REV 00

PC125 114 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

*ULSAR	NOVA 16	CARBONITE 16		AURORA 16	NOVA 16		EXTREME	
Hose Ferrule		Fitting Insertion Length	Die	Crimp Length	Crimp [	Diameter	Dial Sett	•
		mm			mm	in		
114-04 4200		23	16	Full	17.2	0.677	1.2	
114-06 4200		25	19	Full	20.8	0.819	1.8	
114-08 4200		27	23	Full	24.2	0.953	1.2	
114-10 4200		30	27	Full	28.5	1.122	1.5	
114-12 4200		34	31	Full	31.8	1.252	0.8	
114-16 4200		44	34	Full	40.6	1.598	6.6	

IT34 00



Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	151	REV 02
PC125	124 PLUS	4400	One-piece	Mark the hose at a distance from the end of fitting on the hose so that the mark is even the ferrule to the Crimp Diameter given in the second	with the end of the ferrule. Crim	np the enti	re length of

PULSAR ||||| NOVA 12 PLUS CARBONITE 12 PLUS AURORA 12 PLUS |||||

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
		mm			mm in	_
124 <b>-06</b> PLUS	4400	25	23	Full	24.0 0.945	1.0
124 <b>-08</b> PLUS	4400	31	23	Full	26.4 1.039	3.4
124 <b>-10</b> PLUS	4400	31	31	Full	32.6 1.283	1.6
<sup>124</sup> -12 PLUS	4400	34	31	Full	34.3 1.350	3.3
<sup>124</sup> -16 PLUS	4400	47	41	Full	42.7 1.681	1.7

IT53 02



Crimper Hose Coupling Crimp Instructions CHART NUMBER 91 REV 01

PC125 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

# \*ULSAR SPIRAL12

#### **\*ULSAR 124AC SPIRAL12 ARMOR**

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
124-06 4400	25	19	Full	23.1 0.909	3.11
124-08 4400	31	23	Full	25.4 1.000	2.4
124-10 4400	31	31	Full	32.6 1.283	1.6
124-12 4400	34	31	Full	33.9 1.335	2.9
124-16 4400	47	41	Full	41.4 1.630	0.4

IT09 01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 192 REV 01

PC125 124 XTC 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

PULSAR	124XTC				
Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
124 -06 4400 XTC	25	19	Full	23.1 0.909	3.11
124 -08 4400 XTC	31	23	Full	25.4 1.000	2.4
124 -10 4400 XTC	31	31	Full	32.6 1.283	1.6
124 -12 4400 XTC	34	31	Full	33.9 1.335	2.9
124 -16 4400 XTC	47	41	Full	41.4 1.630	0.4

IT76 01



Crimper

Hose

Coupling

**Crimp Instructions** 

**CHART NUMBER** 

193 REV 01

PC125

124 XTC 5000

Two-piece

Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

*ULSAR	124XTC				
Hose Ferrule		Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
				mm in	
124 -06 5120 XTC		23	Full	23.8 0.937	0.8
124 -08 5120 XTC		23	Full	27.1 1.067	4.1
124 -10 5120 XTC	I	27	Full	30.0 1.181	3.0
124 -12 5120 XTC		34	Full	34.6 1.362	0.6
124 -16 5120 XTC		41	Full	42.4 1.669	1.4

IT77 01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 92 REV 03

PC125 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. Telerance +0.1 mm/. 0.2 mm or + 0.004/.0.00

the ferrule to the Crimp Diameter given in the table. Tolerance +0.1mm/- 0.2mm or + 0.004/-0.008

# FULSAR SPIRAL13

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
136-12 4400	34	34	Full	35.3 1.390	1.3
136-16 4400	47	41	Full	42.0 1.654	1.0

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IT10



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Crimper Hose Coupling Crimp Instructions CHART NUMBER 159 REV 00

PC125 136 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

**PULSAR SPIRAL13** 

Fitting

Insertion Crimp Dial Setting
Hose Ferrule Die Length Crimp Diameter Approx. Actual

mm

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.

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Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	160	REV 00
PC125	156 PLUS	44/4600	One-piece	Mark the hose at a distance from the end of fitting on the hose so that the mark is even the ferrule to the Crimp Diameter given in	with the end of the ferrule. Crim	np the enti	re length of

PULSAR |||| NOVA 15

	Fitting Insertion		Crimp		Dial Setting
Hose Ferrule		Die	Length	Crimp Diameter	Approx. Actual
				mm in	
156 <b>-12 4400</b> PLUS	34	34	Full	35.1 1.382	1.1
<sup>156</sup> -16 4400 PLUS	47	41	Full	42.0 1.654	1.0

IT59 00



Crimper	Hose	Coupling		Crimp Instructi	ons	CHART NUMBER	185 R	EV 00	
PC125	124 PLUS	4600	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/-0.00					
*ULS	AR	NOVA	12 PLUS	CARBONITE	12 PLUS	AURORA 18	2 PLUS	111111	
			Fitting Inserti		Crimp		Dial S	Setting	
Hose	Ferrule			Die	Length	Crimp Diameter	Approx	k. Actual	
						mm in			

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 REV 00** 186

Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the PC125 124 4200 One-piece 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

#### **FULSAR SPIRAL12**

	Fitting Insertion		Crimp		Dial Setting
Hose Ferrule	Length	Die	Length	Crimp Diameter	Approx. Actual
	mm			mm in	_
124-12 4200	34	31	Full	33.1 1.303	2.1
124-16 4200	44	34	Full	40.4 1.591	6.4

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IT72



Crimper Hose Coupling Crimp Instructions CHART NUMBER 95 REV 02

PC125 151 4500 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

**FULSAR** 151

**PULSAR** 151H

			Crimp		Dial Setting
Hose	Ferrule	Die	Length	Crimp Diameter	Approx. Actual
				mm in	
151-04	4500-04	14	Knurl	16.1 0.634	2.1
151-05	4500-05	16	Full	18.3 0.720	2.3
151-06	4500-06	19	Full	20.0 0.787	1.0
151-08	4500-08	19	Full	22.9 0.902	3.9
151-10	4500-10	23	Full	26.7 1.051	3.7
151-12	4500-12	27	Full	30.8 1.213	3.8
151-16	4500-16	34	Full	35.5 1.398	1.5
151-20	4500-20	41	Full	43.5 1.713	2.5
151-24	4500-24	41	Knurl	46.8 1.843	5.8

IT12 02

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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 REV 00** 176

Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the PC125 151 42/4400 One-piece 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

\*ULSAR 151

**FULSAR** 151H

	Fitting Insertion		Crimp		Dial Setting
Hose Ferrule		Die	Length	Crimp Diameter	Approx. Actual
				mm in	_
151 <b>-</b> 05 <sup>4200-04</sup>	23	16	Full	18.1 0.713	2.1
151 <b>-</b> 08 <sup>4200-06</sup>	25	19	Full	22.9 0.902	3.9
151 <b>-</b> 10 4400-08	31	27	Full	28.2 1.110	1.2
151-12 <sup>4400-10</sup>	31	27	Full	30.8 1.213	3.8

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.

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**IT67** 



Crimper Hose Coupling Crimp Instructions CHART NUMBER 177 REV 00

PC125 151 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

**\*ULSAR** 151

**PULSAR** 151H

A note on crimping 100R5 hose:

SAE 100R5 series hoses were initially designed as a flexible replacement to copper tubing, which is commonly defined by it's outside diameter. The result is that 100R5 hoses have smaller inside diameters than their nominal size (dash size) would indicate. For example, 151-08, nominally 1/2", actually has an I.D. of 13/32", since that is the I.D. of ½" O.D. copper tube. This creates confusion when crimping using inserts and ferrules designed for "full dimension hoses", where the nominal size is the inside diameter (ie. -08 hose is ½" I.D.). Be careful to check that selection of the appropriate sized ferrule and insert for the hose you are crimping. Quite often it will be smaller than the dash size of the R5 hose.

	Cri	Dial Setting	
Hose Ferrule	Die Ler	ngth Crimp Diameter	Approx. Actual
		mm in	_
151 <b>-</b> 05 5200-04	19 Full	l 19.5 0.768	0.5
151-08 <sup>5120-06</sup>	23 Full	23.6 0.929	0.6
151-10 <sup>5120-08</sup>	27 Full	l 28.6 1.126	1.6
151-12 <sup>5120-10</sup>	31 Full	I 31.8 1.252	0.8

IT68 00

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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 87 REV 01

PC125 141 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

#### **PULSAR** 141

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
141-12 4200	34	31	Full	33.1 1.303	2.1
141-16 4200	44	34	Full	40.0 1.575	6.0

IT05 01



Crimper	Hose	Coupling		Crimp Instruc	ctions	CHART N	UMBER	122	REV 00
PC125	119	4200	Skive	fitting on the hose s	distance from the end on so that the mark is even rimp Diameter given in	with the end of	the ferrule. Cr	imp the er	ntire length of
<b>≯</b> (	JĽSAR	119	<b>₽ULSAR</b>	119 B	PULSAR	119 Y	*ULS	AR	119 H
Hose	Ferrule	Cover Skive Length		Die	Crimp Length	Crimp [	Diameter	_	al Setting prox. Actua
		mm				mm	in		
119-0	4 4200	21		16	Full	16.7	0.657	0	.7
119-0	6 4200	21		19	Full	20.7	0.815	1	.7

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.

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IT33



Crimper Hose Coupling Crimp Instructions CHART NUMBER 146 REV 01

PC125 129G 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

PULSAR	129G				
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
129G-06 4300	27	19	Full	21.4 0.843	2.4
129G-06 5200	25	19	Full	20.4 0.803	1.4
129G-06 4200	21	19	Full	20.4 0.803	1.4



120J

PC125

# CRIMP SPECIFICATIONS

Crimper Hose Coupling Crimp Instructions CHART NUMBER 164 REV 00

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

#### PULSAR 120J JACK HOSE

4200

One-piece

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
120J-04 4200	23	16	Full	16.8 0.661	0.8
120J-06 4200	25	19	Full	21.0 0.827	2.0

IT63 00



Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	161	REV 01
PC125	157	4700	One-piece	Mark the hose at a distance from the end of itting on the hose so that the mark is even the ferrule to the Crimp Diameter given in the	with the end of the ferrule. Crim	np the enti	re length of

# PUCSAR 157

		Crimp Insert	Fitting Insertion		Crimp		Dial Setting
Hose	Ferrule	Size		Die	Length	Crimp Diamete	r Approx. Actual
						mm in	
157-04	4700	-03	23	10	Knurl	11.3 0.445	1.3
157-05	4700	-04	23	12	Knurl	12.7 0.500	0.7
157-08	4700	-06	26	14	Knurl	16.0 0.630	2.0
157-10	4700	-08	29	19	Knurl	20.5 0.807	1.5
157-16	4500	-16	45	31	Knurl	32.3 1.272	1.3

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 190 REV 01

PC125 158 4700 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 +0.0mm/- 0.2mm or + 0.004/-0.008

PUCSAA 158

	Fitting Insert		Crimp			Dial Set	ting
Hose Ferru	ıle	Die	Length	Crimp D	iameter	Approx.	Actual
				mm	in		
158-03 4700	23	10	Knurl	11.3	0.445	1.3	
158-04 4700	23	12	Knurl	12.7	0.500	0.7	
158-06 4700	26	14	Knurl	16.0	0.630	2.0 _	
158-08 4700	29	19	Knurl	20.5	0.807	1.5	
158-10 4700	30	23	Knurl	25.6	1.008	2.6 _	
158-12 4700	34	27	Knurl	28.1	1.106	1.1	
158-16 4700	45	34	Knurl	35.5	1.398	1.5	

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Crimper Hose Coupling Crimp Instructions CHART NUMBER 191 REV 01

PC125 158 5000 One-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

# PULSAP 158

		Fitting Insertion		Crimp		Dial Setting
Hose	Ferrule		Die	Length	Crimp Diameter	Approx. Actual
					mm in	
158-04	5514	23	12	Full	12.7 0.500	0.7
158-05	5514	23	12	Full	14.4 0.567	2.4
158-06	5514	26	14	Full	16.0 0.630	2.0
158-08	5514	29	19	Full	20.5 0.807	1.5
158-10	5514	30	23	Full	24.8 0.976	1.8
158-12	5514	34	23	Full	27.0 1.063	4.0
158-16	5514	45	31	Full	34.4 1.354	3.4

06-Sep-22



Crimper Coupling **Crimp Instructions CHART NUMBER REV 00** Hose 157

Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the PC125 4700 Non-Skive 172 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 +0.0mm/- 0.2mm or + 0.004/-0.008

**FULSAR** 172

**PULSAR** 

**PULSAR** 172T

	Fitting Insertion		Crimp		Dial Setting
Hose Ferrule		Die	Length	Crimp Diameter	Approx. Actual
				mm in	_
172-02 4700	13.3	10	Full	10.6 0.417	0.6
172-03 4700	21.5	12	Full	13.1 0.516	1.1
172-04 4700	23	14	Full	15.0 0.591	1.0
172-06 4700	26	16	Full	18.8 0.740	2.8
172-08 4700	29	23	Full	24.1 0.949	1.1

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	175	REV 00
PC125	182	4700	Non-Skive	Mark the hose at a distance from the end fitting on the hose so that the mark is eve the ferrule to the Crimp Diameter given in	n with the end of the ferrule. Cri	mp the ent	ire length of

#### PULSAR 182

	Fitting Insertion		Crimp		Dial Setting
Hose Ferrule		Die	Length	Crimp Diameter	Approx. Actual
				mm in	<del>-</del>
182-04 4700	23	12	Full	14.1 0.555	2.1
182-06 4700	26	16	Full	18.4 0.724	2.4
182-08 4700	29	23	Full	23.8 0.937	0.8

IT66 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 189 REV 00

PC125 173 4700 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 formula to the Crimp Diameter given in the table. Telegrapes +0.0mm/, 0.2mm or +0.004/, 0.00

the ferrule to the Crimp Diameter given in the table. Tolerance +0.0mm/- 0.2mm or + 0.004/-0.008

\*\*ULSAR 173

		Fitting Insertion		Crimp		Dial Setting
Hose	Ferrule		Die	Length	Crimp Diameter	Approx. Actual
					mm in	_
173-06	4700	26	19	FULL	19.4 0.764	0.4
173-08	4700	29	23	FULL	24.8 0.976	1.8

PUL 173 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 96 REV 00

PC125 109 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

*ULSAR	109	109CC		<b>₩</b> L	ILSAR 109T	
Hose Ferrule	Cover Skive Length	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm	mm			mm in	
109-04 5000C		20	14	Full	15.5 0.610	1.5
109-06 5000C		20	16	Full	18.7 0.736	2.7
109-08 5000C		22	19	Full	22.6 0.890	3.6
109-10 5000C	21		27	Full	27.6 1.087	0.6

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 184 REV 00

PC125 110 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

PULSAR IIII	CORONA 17	<b>    </b>			
Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
110-04 5000C	20	14	Full	15.1 0.594	1.1
110-06 5000C	20	16	Full	18.7 0.736	2.7
110-08 5000C	22	19	Full	22.5 0.886	3.5

IT70 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 116 REV 00

PC125 112 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

PULSAR	112 112CC				
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
112-04 5000C	16	14	Full	15.9 0.626	1.9
112-06 5000C	18	19	Full	19.2 0.756	0.2
112-08 5000C	20	23	Full	23.5 0.925	0.5
112-10 5000C	20	27	Full	27.6 1.087	0.6
112-12 5000C	26	27	Full	29.9 1.177	2.9
112-16 5000C	35	34	Full	38.1 1.500	4.1

IT30 00



111-12 5000C

111-16 5000C

26

35

### CRIMP SPECIFICATIONS

29.9 1.177

1.500

38.1

Crimper Hose Coupling Crimp Instructions CHART NUMBER 113 REV 00

PC125 111 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

*UL®S	SAR	NOVA1	<b>E 3</b>	*ULSAR	111A		*ULS	AR 1	111FS
Hose F	errule	Cover Skive Length		Die	Crimp Length	Crimp [	Diameter	Dial S Approx	•
		mm				mm	in		
111-04 5	000C	16		14	Full	15.9	0.626	1.9 .	
111-06 5	000C	18		19	Full	19.3	0.760	0.3	
111-08 5	000C	20		19	Full	23.2	0.913	3.12 .	

34

Full

Full

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 111 REV 00

PC125 122 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

PUĽSAR III	NOVA 2	NOVA 2 ICE-BRE	AKER	122A	11111
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
122-04 5000C	16	14	Full	16.4 0.646	2.4
122-06 5000C	18	19	Full	20.0 0.787	1.0
122-08 5000C	20	23	Full	23.8 0.937	0.8
122-10 5000C	20	27	Full	27.9 1.098	0.9
122-12 5000C	26	27	Full	30.1 1.185	3.1
122-16 5000C	35	34	Full	38.4 1.512	4.4

IT26 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 150 REV 01

PC125 124 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

PI US

#ULSAR	NOVA 12 PLUS	CARBONITE 1	2 PLUS	AURORA 12	PLUS
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
124 <b>-</b> 06 5420 PLUS	25	19	Full	23.0 0.906	3.10
124 <b>-08 5420</b> PLUS	27	23	Full	26.2 1.031	3.2
<sup>124</sup> -10 5420 PLUS	30	27	Full	29.0 1.142	2.0
<sup>124</sup> -12 5420 PLUS	32	31	Full	33.4 1.315	2.4
<sup>124</sup> -16 5420 PLUS	43	41	Full	41.7 1.642	0.7



Coupling **REV 00** Crimper Hose **Crimp Instructions CHART NUMBER** 156

5000 Two-piece PC125 124

PIUS

Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

**\*ULSAR ||||** NOVA 12 PLUS **CARBONITE 12 PLUS** 

		Crimp		Dial Setting
Hose Ferrule	Die	Length	Crimp Diameter	Approx. Actual
			mm in	
<sup>124</sup> -06 5120 PLUS	23	Full	24.1 0.949	1.1
124 <b>-</b> 08 5120 PLUS	27	Full	27.5 1.083	0.5
124 -10 5120 PLUS	27	Full	30.0 1.181	3.0
124 -12 5120 PLUS	34	Full	34.6 1.362	0.6
<sup>124</sup> -16 5120 PLUS	41	Full	42.4 1.669	1.4

IT56 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 172 REV 00

PC125 156 5000

PLUS

Two-piece Tolerance

Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

*ULSAR	NOVA 15				11111
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
<sup>156</sup> -12 5420 PLUS	32	31	Full	33.9 1.335	2.9
<sup>156</sup> -16 5420 PLUS	43	34	Full	40.8 1.606	6.8

IT64 00



Coupling **Crimp Instructions CHART NUMBER** 173 **REV 01** Crimper Hose

Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches . PC125 156 5000 Two-piece

PIUS

**\*ULSAR |||||** 

NOVA 15

		Crimp		Dial Setting
Hose Ferrule	Die	Length	Crimp Diameter	Approx. Actual
			mm in	_
<sup>156</sup> <b>-12 5120</b> PLUS	34	Full	35.1 1.382	1.1
<sup>156</sup> -16 5120 PLUS	41	Full	42.0 1.654	1.0

IT65 01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 112 REV 00

PC125 102R 5000 Non Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
102R-08 5000C	22	19	Full	23.0 0.906	3.10
102R-12 5503	28	27	Full	31.3 1.232	4.3



Crimper Hose Coupling Crimp Instructions CHART NUMBER 153 REV 00

PC125 114 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

PULSAI	R ////	NOVA 16	CARBONITE 16		AURORA 16		NOVA 16	EXTREME	
Hose	Ferrule	Cover Skive Length		Die	Crimp Length	Crimp [	Diameter	Dial Se Approx.	J
		mm				mm	in		
114-04	5000C	16		14	Full	15.9	0.626	1.9 _	
114-06	5000C	18		19	Full	19.1	0.752	0.1 _	
114-08	5000C	20		19	Full	22.6	0.890	3.6 _	
114-10	5000C	20		23	Full	26.7	1.051	3.7 _	
114-12	5000C	26		27	Full	29.8	1.173	2.8 _	
114-16	5000C	35		34	Full	37.7	1.484	3.7 _	

IT55 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 100 REV 00

PC125 111 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

*ULSAR NOVA1	**ULSAR	111A	<b>₽ULSAR</b>	111FS
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Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
111-04 5200	23	16	Full	17.9 0.705	1.9
111-06 5200	25	19	Full	20.6 0.811	1.6
111-08 5200	27	23	Full	23.4 0.921	0.4
111-12 5200	34	27	Full	30.9 1.217	3.9
111-16 5200	44	34	Full	38.7 1.524	4.7

IT15 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 130 REV 00

PC125 114 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

₽UĽSA	R      <b> </b>	NOVA 16	CARBONIT	E 16	AURORA 16		NOVA 16	EXTREME	
Hose	Ferrule		Fitting Insertio Length	n Die	Crimp Length	Crimp [	Diameter	Dial Set Approx.	J
			mm			mm	in		
114-04	5200		23	16	Full	18.2	0.717	2.2 _	
114-06	5200		25	19	Full	20.4	0.803	1.4	
114-08	5200		27	23	Full	23.5	0.925	0.5 _	
114-10	5200		30	23	Full	27.2	1.071	4.2 _	
114-12	5200		34	27	Full	30.5	1.201	3.5 <b>_</b>	
114-16	5200		44	34	Full	38.6	1.520	4.6 <b>_</b>	

IT40 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 102 REV 00

PC125 112 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

FULSAR 112	112CC				
Hose Ferrule	Fitting Insertio Length		Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
112-04 5200	23	16	Full	18.2 0.717	2.2
112-06 5200	25	19	Full	20.9 0.823	1.9
112-08 5200	27	23	Full	23.5 0.925	0.5
109-10 5200	30	23	Full	27.2 1.071	4.2
112-12 5200	34	27	Full	30.5 1.201	3.5
112-16 5200	44	34	Full	38.6 1.520	4.6

IT17 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 101 REV 00

PC125 122 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

PUĽSAR	NOVA 2	^	NOVA 2 ICE-BRE	AKER		122A		
Hose Ferrule		Fitting Insertio Length		Crimp Length	Crimp Dian	meter	Dial Set	•
		mm			mm	in		
122-04 5200		23	19	Full	19.1 0.	.752	0.1	
122-06 5200		25	19	Full	21.4 0.	.843	2.4	
122-08 5200		27	23	Full	24.5 0.	.965	1.5	
122-10 5200		30	27	Full	27.7 1.	.091	0.7	
122-12 5200		34	27	Full	31.2 1.	.228	4.2	
122-16 5200		44	34	Full	39.4 1.	.551	5.4	

IT16 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 105 REV 00

PC125 122 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

*ULSAR	NOVA 2	NOVA 2 ICE-BRE	AKER	122A	11111
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
122-04 5420	24	16	Full	17.3 0.681	1.3
122-06 5420	25	19	Full	22.5 0.886	3.5
122-08 5420	27	23	Full	25.8 1.016	2.8
122-10 5420	30	27	Full	28.7 1.130	1.7
122-12 5420	32	31	Full	33.6 1.323	2.6
122-16 5420	43	41	Full	41.3 1.626	0.3

IT20 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 103 REV 02

PC125 124 5000 Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

#### **FULSAR SPIRAL12**

#### \*ULSAR 124AC SPIRAL12 ARMOR

		Crimp		Dial Setting
Hose Ferrule	Die	Length	Crimp Diameter	Approx. Actual
			mm in	_
124-06 5120	23	Full	23.8 0.937	0.8
124-08 5120	23	Full	27.1 1.067	4.1
124-10 5120	27	Full	30.0 1.181	3.0
124-12 5120	34	Full	34.6 1.362	0.6
124-16 5120	41	Full	42.4 1.669	1.4

IT18 02



Crimper Hose Coupling Crimp Instructions CHART NUMBER 106 REV 00

PC125 124 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

### \*ULSAR SPIRAL12

#### \*ULSAR (124AC SPIRAL12 ARMOR)

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
		mm			mm in	
124-06	5420	25	19	Full	22.8 0.898	3.8
124-08	5420	27	23	Full	26.0 1.024	3.0
124-10	5420	30	27	Full	29.0 1.142	2.0
124-12	5420	32	31	Full	33.6 1.323	2.6
124-16	5420	43	41	Full	41.7 1.642	0.7

IT21 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 108 REV 00

PC125 136 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

*ULSAR SPIRAL13		
Cover Skive Hose Ferrule Length	Crimp Die Length Crimp Diameter	Dial Setting Approx. Actual
mm	mm in	
136-12 5420 32	34 Full 34.5 1.358	0.5
136-16 5420 43	41 Full 41.5 1.634	0.5

IT23 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 110 REV 01

PC125 141 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

<b>₽ULSAR</b> 141					
Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
141-12 5200		31	Full	33.1 1.303	2.1
141-16 5200		41	Full	41.0 1.614	0.0

IT25 01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 109 REV 00

PC125 156 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

*ULSAR ©	PIRAL15				
Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
156-16 5420	43	41	Full	41.6 1.638	0.6

IT24 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 144 REV 00

PC125 157 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

# PULSAR 157

Hose	Ferrule	Crimp Insert Size	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
11000	rondio			<u> </u>	mm in	rippiox. riotaai
157-05	5514	-04	12	Full	12.7 0.500	0.7
157-06	5514	-05	12	Full	14.4 0.567	2.4
157-08	5514	-06	14	Full	16.0 0.630	2.0
157-10	5514	-08	19	Full	20.5 0.807	1.5
157-12	5514	-10	23	Full	24.8 0.976	1.8

00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 132 REV 00

PC125 172 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

*ULSAR	172	<b>₽ULSAR</b>	172N		*UL®	SAR	172T	
Hose Ferrule		Fitting Insertion Length	Die	Crimp Length	Crimp D	Diameter	Dial Set Approx.	•
		mm			mm	in		
172-02 9700		13	8	13.0	9.6	0.378	1.6 _	
172-03 9000SB		19	10	18	11.4	0.449	1.4 _	
172-03 5517			10	Full	11.9	0.469	1.9 _	

 172-05 5517
 16
 Full
 17.1 0.673
 1.1 \_\_\_\_\_

 172-06 5517
 16
 Full
 18.6 0.732
 2.6 \_\_\_\_\_

12

Full

172-08 5517 Full 22.9 0.902 3.9 \_\_\_\_\_

172-04 5517

TO1

14.4 0.567



Crimper Hose Coupling Crimp Instructions CHART NUMBER 194 REV 01

PC125 119MS 42/44/50 Non Skive

#### Green Line 119MS MINE SPRAY HOSE MSHA COVER

Hose Ferrule	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
			mm in	
119M-16 4200 S	34	Full	40.1 1.579	6.1
119M-16 4400 S	41	Full	42.2 1.661	1.2
119M-16 5200 S	34	Full	39.4 1.551	5.4

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.

01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 134 REV 0

PC125 173 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

**≯ULSAR** 173

**₱ULSAR** 173T

		Dial Setting		
Hose Ferrule	Die	Length	Crimp Diameter	Approx. Actual
			mm in	
173-04 5517	12	Full	14.5 0.571	2.5
173-06 5517	16	Full	18.8 0.740	2.8
173-08 5518	23	Full	25.0 0.984	2.0

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.

06-Sep-22



Crimper Hose Coupling Crimp Instructions CHART NUMBER 133 REV 0

PC125 182 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

FULSAR 182 FULSAR 182NY

		Crimp				
Hose Ferrule	Die	Length	Crimp Diameter	Approx. Actual		
			mm in	·		
182-04 5517	12	Full	14.1 0.555	2.1		
182-06 5517	16	Full	18.2 0.717	2.2		
182-08 5517	19	Full	22.6 0.890	3.6		
182-12 5517	27	Full	29.8 1.173	2.8		

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.

06-Sep-22



Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	181	REV 0
PC125	111	4500	One-piece	Mark the hose at a distance from the end of itting on the hose so that the mark is even the ferrule to the Crimp Diameter given in the second of the control	with the end of the ferrule. Crim	np the enti	re length of

<b>#U</b> LSAR	111-03					
Hose Ferrule	Crimp Insert Size	Fitting Insertion	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
111-03 4500	-04	19	14	Full	mm in 14.8 0.583	0.8



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

Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the PC125 111 4400 One-piece 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

**\*ULSAR** NOVA1 **\*ULSAR** 111A **PULSAR** 

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
111-06 4400	25	19	Full	21.7 0.854	2.7
111-08 4400	31	23	Full	23.8 0.937	0.8
111-12 4400	34	31	Full	33.0 1.299	2.0
111-16 4400	47	41	Full	41.3 1.626	0.3

IT06 00



Crimper Hose Coupling **Crimp Instructions CHART NUMBER** 90 **REV 01** 

Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the PC125 4400 112 One-piece 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

**\*ULSAR** 112CC 112

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
112-06 4400	25	19	Full	21.7 0.854	2.7
112-08 4400	31	23	Full	24.0 0.945	1.0
112-10 4400	31	27	Full	31.1 1.224	4.1
112-12 4400	34	31	Full	33.0 1.299	2.0
112-16 4400	47	34	Full	40.7 1.602	6.7



Crimper Hose Coupling Crimp Instructions CHART NUMBER 131 REV 00

PC125 114 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

*ULSA	R      <b> </b>	NOVA 16	CARBONIT	E 16		AURORA 16		NOVA 16	EXTREME	
Hose	Ferrule		Fitting Insertio Length		Die	Crimp Length	Crimp D	)iameter	Dial Set Approx.	tting Actual
			mm				mm	in		
114-06	4400		25	1	9	Full	22.1	0.870	3.1 _	
114-08	4400		31	2	23	Full	24.0	0.945	1.0 _	
114-10	4400		31	2	27	Full	31.1	1.224	4.1 _	
114-12	4400		34	3	31	Full	33.0	1.299	2.0 _	
114-16	4400		47	3	34	Full	40.7	1.602	6.7 _	

IT41 00



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

Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the 4400 PC125 122 One-piece 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

**PULSAR !!!!!** NOVA 2 **NOVA 2 ICE-BREAKER** 122A

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
122-06 4400	25	19	Full	22.8 0.898	3.8
122-08 4400	31	23	Full	24.9 0.980	1.9
122-10 4400	31	31	Full	32.2 1.268	1.2
122-12 4400	34	31	Full	34.1 1.343	3.1
122-16 4400	47	41	Full	42.3 1.665	1.3



119-04 5000C

119-06 5000C

119-08 5000C

119-06 5200

16

25

18

20

#### CRIMP SPECIFICATIONS

**REV 00** Crimper Hose Coupling **Crimp Instructions CHART NUMBER** 114 Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches. PC125 119 5000 Skive **PULSAR \*ULSAR** \*ULSAR **BULSAR** 119 H 119 B 119 119 Y Cover **Dial Setting** Skive Crimp Length Length **Ferrule** Die **Crimp Diameter** Hose Approx. Actual mm mm in 119-04 5200 22 Full 0.705 16 17.9

14

19

16

19

Full

Full

Full

Full

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.

15.9

20.1

0.626

0.791

0.736

23.2 0.913

2.7 \_\_\_\_\_

3.12 \_\_\_\_\_

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IT28



Crimper	Hose	Coupling		Crimp Instruction	ns	CHART NUMBER	154 REV 00
PC125	663	4400	One Piece	fitting on the hose so the	at the mark is even v	the hose equal to the "Insertic vith the end of the ferrule. Cri e table. Tolerance +0.1mm/- 0	mp the entire length of
Gred	en Line	G663					
Hose	e Ferrule		Fitting Inserti Length	on	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
			mm			mm in	



Crimper	Hose	Coupling		Crimp Instructions		CHART NUMBER	155 REV	00
PC125	665	4400	One Piece	fitting on the hose so that th	e mark is even w	the hose equal to the "Insertic vith the end of the ferrule. Cri e table. Tolerance +0.1mm/- 0	mp the entire leng	th of
Gred	en Line	G665						
Hose	Ferrule	Cover Skive Length		Die	Crimp Length	Crimp Diameter	Dial Set Approx.	ting Actual
		mm				mm in		

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	152	REV 00
PC125	653	4400	One-piece	Mark the hose at a distance from the end of fitting on the hose so that the mark is even the ferrule to the Crimp Diameter given in the second	with the end of the ferrule. Crim	np the ent	ire length of

**PULSAR** 653 B.O.P HOSE MSHA API16D

A note on crimping BOP hose:

Blow Out Preventer hoses must be assembled with FG-firejacket sleeve and BOP over ferrule, according to Pulsar Hydraulics Ltd. Assembly Instructions in order to achieve API 16D flame specification.

Hose	Ferrule	Cover Skive Length	Over Ferrule Crimp	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
		mm				mm in	• • •
653-06	4400	26	34	19	Full	22.8 0.898	3.8
653-08	3 4400	33	36	23	Full	24.9 0.980	1.9
653-12	2 4400	38	43	31	Full	34.1 1.343	3.1
653-16	4400	49	52	41	Full	42.3 1.665	1.3

IT54 00



Crimper Hose Coupling Crimp Instructions CHART NUMBER 104 REV 00

PC125 115 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

#### **PULSAR** 115 Cover **Dial Setting** Skive Crimp Length Length **Ferrule** Die **Crimp Diameter** Hose Approx. Actual mm mm in 115-06 5120 Full 0.6 23 23.6 0.929 4.1 \_\_\_\_\_ 23 115-08 5120 Full 1.067 27.1 4.0 \_\_\_\_\_ 115-10 5120 27 Full 1.220 27 31.0 0.7 \_\_\_\_\_ 115-12 5120 34 Full 34.7 1.366 115-16 5120 41 Full 42.1 1.657

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IT19



Crimper Hose Coupling Crimp Instructions CHART NUMBER 107 REV 00

PC125 115 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

#### **PULSAR** 115 Cover **Dial Setting** Skive Crimp Length Length **Ferrule** Die **Crimp Diameter** Hose Approx. Actual mm mm in 115-06 5420 25 19 Full 3.8 \_\_\_\_\_ 22.8 0.898 3.0 \_\_\_\_\_ 23 115-08 5420 27 Full 26.0 1.024 3.3 \_\_\_\_\_ 115-12 5420 32 31 Full 34.3 1.350 0.6 \_\_\_\_\_ 115-16 5420 43 41 41.6 Full 1.638



Crimper Hose Coupling Crimp Instructions CHART NUMBER 93 REV 01

PC125 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

#### **PULSAR** 115

Hose Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	
115-06 4400	25	23	Full	23.4 0.921	0.4
115-16 4400	47	41	Full	41.4 1.630	0.4



Crimper Hose Coupling Crimp Instructions CHART NUMBER 94 REV 00

PC125 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

#### FULSAR 115

Hose Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter	Dial Setting Approx. Actual
	mm			mm in	_
115-08 4400	27	23	Full	25.4 1.000	2.4
115-10 4400	27	31	Full	34.0 1.339	3.0
115-12 4400	33	34	Full	35.0 1.378	1.0



Crimper Hose Coupling Crimp Instructions CHART NUMBER 145 REV 01

PC125 113 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

PULSAR 113								
Cover Skive Hose Ferrule Length	Crimp Die Length Crimp Diam	Dial Setting neter Approx. Actual						
mm	mm	in						
113-08 5420 27	23 Full 26.1 1.0	028 3.1						
113-10 5420 30	27 Full 27.7 1.0	0.7						

IT48 01



Crimper Hose Coupling Crimp Instructions CHART NUMBER 68 REV 01

PC125 132 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

#### ₱ULSAR 132

Lloop Formula	Die	Crimp Length	Crimo Diameter	Dial Setting
Hose Ferrule	Die	Lengui	Crimp Diameter	Approx. Actual
		_	mm in	
132-04 5503	16	Full	17.7 0.697	1.7
132-05 5503	19	Full	21.5 0.846	2.5
132-06 5503	19	Full	20.7 0.815	1.7
132-08 5503	23	Full	25.7 1.012	2.7
132-10 5503	27	Full	30.7 1.209	3.7
132-12 5503	34	Full	34.8 1.370	0.8
132-16 5503	41	Full	42.6 1.677	1.6
132-20 5503	41	Full	46.6 1.835	5.6



Crimper Hose Coupling Crimp Instructions CHART NUMBER 59 REV 07

PC125 151 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches.

**FULSAR** 151

Crimn

**PULSAR** 151H

A note on crimping 100R5 hose:

SAE 100R5 series hoses were initially designed as a flexible replacement to copper tubing, which is commonly defined by it's outside diameter. The result is that 100R5 hoses have smaller inside diameters than their nominal size (dash size) would indicate. For example, 151-08, nominally 1/2", actually has an I.D. of 13/32", since that is the I.D. of ½" O.D. copper tube. This creates confusion when crimping using inserts and ferrules designed for "full dimension hoses", where the nominal size is the inside diameter (ie. -08 hose is ½" I.D.). Be careful to check that selection of the appropriate sized ferrule and insert for the hose you are crimping. Quite often it will be smaller than the dash size of the R5 hose.

		Insert		Crimp		Dial Setting
Hose	Ferrule	Size	Die	Length	Crimp Diameter	Approx. Actual
454.04	5503-03	0.0	4.4	- "	mm in	
151-04	3303-03	-03	14	Full	15.5 0.610	1.5
151-05	5503-04	-04	16	Full	17.4 0.685	1.4
151-06	5503-05	-05	19	Full	20.8 0.819	1.8
151-08	5503-06	-06	19	Full	20.0 0.787	1.0
151-10	5503-08	-08	23	Full	24.9 0.980	1.9
151-12	5503-10	-10	27	Full	30.4 1.197	3.4
151-16	5503-12	-14	34	Full	34.8 1.370	0.8
151-20	5503-16	-18	41	Full	44.1 1.736	3.1

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.

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Crimper Hose Coupling Crimp Instructions CHART NUMBER 67 REV 02

PC125 141 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .

#### **PULSAR** 141

		Crimp		Dial Setting
Hose Ferrule	Die	Length	Crimp Diameter	Approx. Actual
			mm in	
141-12 5503	31	Full	33.0 1.299	2.0
141-16 5503	41	Full	41.1 1.618	0.1
141-20 5503	41	Full	46.0 1.811	5.0

AG111 02