



PULSAR
HYDRAULICS LTD.

GY PC125 CRIMP SPECIFICATION

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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



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

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	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		

PULSAR |||| **CORONA 17** ||||

Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
110-04	4200	23	14	Full	15.7	0.618	1.7	_____
110-06	4200	25	19	Full	19.8	0.780	0.8	_____
110-08	4200	27	23	Full	23.3	0.917	0.3	_____

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	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			

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Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
112-04	4200	23	16	Full	16.8	0.661	0.8	_____
112-06	4200	25	19	Full	21.0	0.827	2.0	_____
112-08	4200	27	23	Full	25.0	0.984	2.0	_____
112-12	4200	34	31	Full	31.8	1.252	0.8	_____
112-16	4200	44	34	Full	40.6	1.598	6.6	_____

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	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			



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

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	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			



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

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
PC125	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			



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

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

PULSAR **SPIRAL 12**

PULSAR **124AC SPIRAL 12 ARMOR**

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

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	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		



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

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.

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 .		



Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
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	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	_____

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



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

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.

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	159	REV 00
PC125	136	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/-0.008		



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

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 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		

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

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.

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	185	REV 00
PC125	124 PIUS	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/-0.008		



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

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	186	REV 00
PC125	124	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			



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

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.

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		




Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
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	_____

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	176	REV 00
PC125	151	42/4400	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		

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PULSAR 151H

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

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 .		

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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 1/2" 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 1/2" 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.

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
151-05	5200-04	19	Full	19.5	0.768	0.5	_____
151-08	5120-06	23	Full	23.6	0.929	0.6	_____
151-10	5120-08	27	Full	28.6	1.126	1.6	_____
151-12	5120-10	31	Full	31.8	1.252	0.8	_____

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.

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			

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

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.

Crimper **Hose** **Coupling** **Crimp Instructions** **CHART NUMBER** **122** **REV 00**

PC125 119 4200 Skive

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



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
119-04	4200	21	16	Full	16.7	0.657	0.7	_____
119-06	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.

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 .		

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Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	164	REV 00
PC125	120J	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			

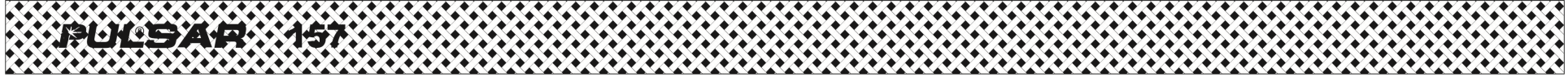
PULSAR 120J JACK HOSE

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

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 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

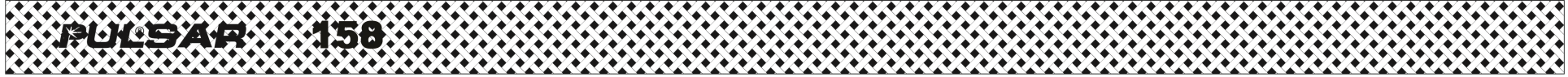


Hose	Ferrule	Crimp Insert Size	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
157-04	4700	-03	23	10	Knurl	11.3	0.445	1.3	_____
157-05	4700	-04	23	12	Knurl	12.7	0.500	0.7	_____
157-08	4700	-06	26	14	Knurl	16.0	0.630	2.0	_____
157-10	4700	-08	29	19	Knurl	20.5	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**

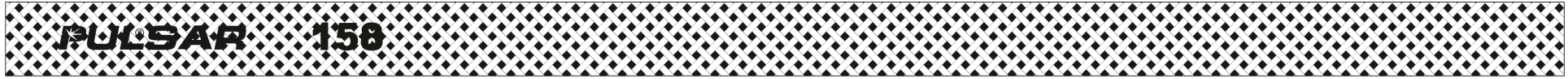
PC125 158 4700 One-piece Mark the hose at a distance from the end of the hose equal to the "Insertion Length". Install the fitting on the hose so that the mark is even with the end of the ferrule. Crimp the entire length of the ferrule to the Crimp Diameter given in the table. Tolerance +0.0mm/- 0.2mm or + 0.004/-0.008



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

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	191	REV 01
PC125	158	5000	One-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			



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

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** **157** **REV 00**

PC125 172 4700 Non-Skive 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



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

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

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



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

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.

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 .



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

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

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	116	REV 00
PC125	112	5000 Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

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Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	113	REV 00
PC125	111	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
111-04	5000C	16	14	Full	15.9	0.626	1.9	_____
111-06	5000C	18	19	Full	19.3	0.760	0.3	_____
111-08	5000C	20	19	Full	23.2	0.913	3.12	_____
111-12	5000C	26	27	Full	29.9	1.177	2.9	_____
111-16	5000C	35	34	Full	38.1	1.500	4.1	_____

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	111	REV 00
PC125	122	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

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NOVA 2

NOVA 2 ICE-BREAKER

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Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	150	REV 01
PC125	124 PLUS	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			



Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
124 PLUS	-06 5420	25	19	Full	23.0	0.906	3.10	_____
124 PLUS	-08 5420	27	23	Full	26.2	1.031	3.2	_____
124 PLUS	-10 5420	30	27	Full	29.0	1.142	2.0	_____
124 PLUS	-12 5420	32	31	Full	33.4	1.315	2.4	_____
124 PLUS	-16 5420	43	41	Full	41.7	1.642	0.7	_____

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.

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	156	REV 00
PC125	124 PLUS	5000	Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			



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

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.

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	172	REV 00
PC125	156 PLUS	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

PULSAR // // //

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Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
156 -12 PLUS	5420	32	31	Full	33.9	1.335	2.9	_____
156 -16 PLUS	5420	43	34	Full	40.8	1.606	6.8	_____

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.

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	173	REV 01
PC125	156 PLUS	5000	Two-piece Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

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

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.

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	
		mm			mm	in	Approx.	Actual
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 .			



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	100	REV 00
PC125	111	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	
					mm	in	Approx.	Actual
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	_____

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	130	REV 00
PC125	114	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		



Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____
114-16	5200	44	34	Full	38.6	1.520	4.6	_____

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	102	REV 00
PC125	112	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

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

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	101	REV 00
PC125	122	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

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

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	105	REV 00
PC125	122	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	103	REV 02
PC125	124	5000	Two-piece	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR **SPIRAL 12**

PULSAR **124AC SPIRAL 12 ARMOR**

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
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	_____

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	106	REV 00
PC125	124	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

PULSAR **SPIRAL 12**

PULSAR **124AC SPIRAL 12 ARMOR**

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	108	REV 00
PC125	136	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR **SPIRAL 13**

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

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	110	REV 01
PC125	141	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

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Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
141-12	5200		31	Full	33.1	1.303	2.1	_____
141-16	5200		41	Full	41.0	1.614	0.0	_____

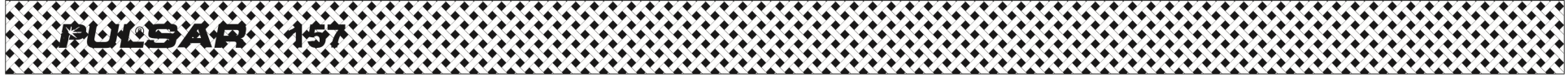
NOTE: Die and dial settings are approximate recommendations. Ferrules should be crimped with the largest diameter die set available to make the ridges on the finished crimp as small as possible. All crimp dimensions must be verified with a calibrated measuring device.

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 .		

PULSAR *SPIRAL 15*

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

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 .		



Hose	Ferrule	Crimp Insert Size	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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** **132** **REV 00**
 PC125 172 5000 Non-Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .



Hose	Ferrule	Fitting Insertion Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____
172-04	5517		12	Full	14.4	0.567	2.4	_____
172-05	5517		16	Full	17.1	0.673	1.1	_____
172-06	5517		16	Full	18.6	0.732	2.6	_____
172-08	5517		19	Full	22.9	0.902	3.9	_____

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 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	
				mm	in	Approx.	Actual
119M-16 S	4200	34	Full	40.1	1.579	6.1	_____
119M-16 S	4400	41	Full	42.2	1.661	1.2	_____
119M-16 S	5200	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.

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 .			



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

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 .		

PULSAR 182

PULSAR 182NY

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

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 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® 111-03

Hose	Ferrule	Crimp Insert Size	Fitting Insertion	Die	Crimp Length	Crimp Diameter		Dial Setting	
						mm	in	Approx.	Actual
111-03	4500	-04	19	14	Full	14.8	0.583	0.8	_____

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.

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

PC125 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



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

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	90	REV 01
PC125	112	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 112 112CC

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

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	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			



Hose	Ferrule	Fitting Insertion Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
114-06	4400	25	19	Full	22.1	0.870	3.1	_____
114-08	4400	31	23	Full	24.0	0.945	1.0	_____
114-10	4400	31	27	Full	31.1	1.224	4.1	_____
114-12	4400	34	31	Full	33.0	1.299	2.0	_____
114-16	4400	47	34	Full	40.7	1.602	6.7	_____

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.

Crimper	Hose	Coupling		Crimp Instructions	CHART NUMBER	89	REV 00
PC125	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			



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

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** **114** **REV 00**
 PC125 119 5000 Skive Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .



Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
119-04	5200	22	16	Full	17.9	0.705	1.9	_____
119-04	5000C	16	14	Full	15.9	0.626	1.9	_____
119-06	5200	25	19	Full	20.1	0.791	1.1	_____
119-06	5000C	18	16	Full	18.7	0.736	2.7	_____
119-08	5000C	20	19	Full	23.2	0.913	3.12	_____

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	154	REV 00
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PC125	663	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			
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Green Line **G663**

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

Crimper	Hose	Coupling	Crimp Instructions	CHART NUMBER	155	REV 00
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PC125	665	4400	One Piece
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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

Green Line G665

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual

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 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 **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	
						mm	in	Approx.	Actual
653-06	4400	26	34	19	Full	22.8	0.898	3.8	_____
653-08	4400	33	36	23	Full	24.9	0.980	1.9	_____
653-12	4400	38	43	31	Full	34.1	1.343	3.1	_____
653-16	4400	49	52	41	Full	42.3	1.665	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	104	REV 00
PC125	115	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .			

PULSAR 115

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-06	5120		23	Full	23.6	0.929	0.6	_____
115-08	5120		23	Full	27.1	1.067	4.1	_____
115-10	5120	27	27	Full	31.0	1.220	4.0	_____
115-12	5120		34	Full	34.7	1.366	0.7	_____
115-16	5120		41	Full	42.1	1.657	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	107	REV 00
PC125	115	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR[®] 115

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
115-06	5420	25	19	Full	22.8	0.898	3.8	_____
115-08	5420	27	23	Full	26.0	1.024	3.0	_____
115-12	5420	32	31	Full	34.3	1.350	3.3	_____
115-16	5420	43	41	Full	41.6	1.638	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	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	
					mm	in	Approx.	Actual
115-06	4400	25	23	Full	23.4	0.921	0.4	_____
115-16	4400	47	41	Full	41.4	1.630	0.4	_____

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.

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			

PULSAR[®] **115**

Hose	Ferrule	Cover Skive Length	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
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	_____

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	145	REV 01
PC125	113	5000	Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 113

Hose	Ferrule	Cover Skive Length mm	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
113-08	5420	27	23	Full	26.1	1.028	3.1	_____
113-10	5420	30	27	Full	27.7	1.091	0.7	_____

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.

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 .		

PULSAR® 132

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
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	_____

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	59	REV 07
PC125	151	5000	Non-Skive	Tolerance + 0.1/-0.2mm or + 0.004/-0.008 inches .		

PULSAR 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 1/2" 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 1/2" 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.

Hose	Ferrule	Crimp Insert Size	Die	Crimp Length	Crimp Diameter		Dial Setting	
					mm	in	Approx.	Actual
151-04	5503-03	-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.

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**

Hose	Ferrule	Die	Crimp Length	Crimp Diameter		Dial Setting	
				mm	in	Approx.	Actual
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	_____