

CRIMP CHART - R1T

Hose: SAE 100R1AT and DIN EN 853 1SN

Ferrule: FMP1

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter	.600	.640	.715	.800	.930	1.080	1.235	1.525	1.870	2.110	2.705
Crimp Travel	.152	.140	.151	.162	.196	.161	.209	.254	.215	.370	.169
Die Size	#3 Smooth Face	#3 Smooth Face	#4 Smooth Face	#4 Smooth Face	#5 Smooth Face	#6 Smooth Face	#7 Smooth Face	#8 Smooth Face	#10 Smooth Face	N/A	N/A
Ferrule Pre-Crimp Diameter	.752	.780	.866	.962	1.126	1.241	1.444	1.779	2.085	2.480	2.874
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - R2T

Hose: SAE 100R2AT and DIN EN 853 2SN

Ferrule: FHP2

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter	.625	.700	.775	.830	1.010	1.150	1.290	1.685	2.027	2.354	2.819
Crimp Travel	.170	.172	.171	.223	.195	.209	.215	.198	.178	.200	.173
Die Size	#3 Smooth Face	#4 Smooth Face	#4 Smooth Face	#5 Smooth Face	#5 Smooth Face	#6 Smooth Face	#7 Smooth Face	#9 Smooth Face	#10 Smooth Face	N/A	N/A
Ferrule Pre-Crimp Diameter	.795	.872	.946	1.053	1.205	1.359	1.505	1.883	2.205	2.554	2.992
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - R3

Hose: SAE 100R3

Ferrule: FLP

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter		.650	.748	.838	1.023	1.122	1.374	1.622	1.980		
Crimp Travel		.098	.118	.107	.099	.208	.122	.189	.150		
Die Size		#3 Smooth Face	#4 Smooth Face	#4 Smooth Face	#5 Smooth Face	#6 Smooth Face	#7 Smooth Face	#9 Smooth Face	#10 Smooth Face		
Ferrule Pre-Crimp Diameter	.760	.819	.863	.942	1.122	1.315	1.497	1.812	2.132		
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length		FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL		
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - R4

Hose: SAE100R4

Ferrule: FLP

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter							1.300	1.590	1.990	2.230	2.680
Crimp Travel							.196	.221	.140	.135	.200
Die Size							#7 Smooth Face	#8/#9 Smooth Face	#10 Smooth Face	N/A	N/A
Ferrule Pre-Crimp Diameter							1.497	1.825	2.133	2.365	2.884
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length							FULL	FULL	FULL	FULL	FULL
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - R6

Hose: SAE 100R6

Ferrule: FTP

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter		.570	.645	.716	.893	1.000	1.118	1.405			
Crimp Travel		.099	.103	.111	.107	.122	.142	.165			
Die Size		#3 Smooth Face	#3 Smooth Face	#4 Smooth Face	#5 Smooth Face	#5 Smooth Face	#6 Smooth Face	#7 Smooth Face			
Ferrule Pre-Crimp Diameter		.669	.748	.827	1.000	1.122	1.260	1.570			
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length		FULL	FULL	FULL	FULL	FULL	FULL	FULL			
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - TP7 & TP7N

Hose: SAE 100R7 & 100R8

Ferrule: FTP

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter	.448	.570	.649	.744	.897	1.019	1.157	1.452			
Crimp Travel	.063	.099	.099	.083	.103	.103	.103	.123			
Die Size	#2 Smooth Face	#3 Smooth Face	#3 Smooth Face	#4 Smooth Face	#5 Smooth Face		#6 Smooth Face	#7 Smooth Face			
Ferrule Pre-Crimp Diameter	.511	.669	.748	.827	1.000	1.122	1.260	1.575			
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length	FULL	FULL	FULL	FULL	FULL		FULL	FULL			
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - TP8 & TP8N

Hose: SAE 100R8

Ferrule: FTP

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter	.448	.570	.649	.744	.897	1.019	1.157	1.452			
Crimp Travel	.063	.099	.099	.083	.103	.103	.103	.123			
Die Size	#2 Smooth Face	#3 Smooth Face	#3 Smooth Face	#4 Smooth Face	#5 Smooth Face		#6 Smooth Face	#7 Smooth Face			
Ferrule Pre-Crimp Diameter	.511	.669	.748	.827	1.000	1.122	1.260	1.575			
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length	FULL	FULL	FULL	FULL	FULL		FULL	FULL			
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - R12

Hose: SAE 100R12

Ferrule: FEP12

Stems: All "EH" Series

NOTE: DO NOT CRIMP DIN 4SH OR 4SP TO THIS CRIMP CHART. SEE DIN 4SH OR 4SP CHART FOR PROPER SPECIFICATIONS.

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter					1.034	1.168	1.330	1.661	1.955		
Crimp Travel					.147	.171	.166	.150	.250		
Die Size					#6 Smooth Face	#6 Smooth Face	#7 Smooth Face	#9 Smooth Face	#10 Smooth Face		
Ferrule Pre-Crimp Diameter					1.181	1.339	1.496	1.811	2.205		
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Skive Length					1.102	1.220	1.456	1.889	2.126		
Stake Die (Size)											
Stake (Travel)											

CRIMP CHART - 4SP

Hose: DIN EN 856 4SP

Ferrule: FEP12

Stems: All "EH" Series

NOTE: DO NOT CRIMP DIN 4SH OR R12 TO THIS CRIMP CHART. SEE DIN 4SH OR R12 CHART FOR PROPER SPECIFICATIONS.

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter					1.034	1.168	1.365	1.661	2.040		
Crimp Travel					.147	.171	.131	.150	.165		
Die Size					#6 Smooth Face	#6 Smooth Face	#7 Smooth Face	#9 Smooth Face	#10 Smooth Face		
Ferrule Pre-Crimp Diameter					1.181	1.339	1.496	1.811	2.205		
Guage Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Skive Length					1.102	1.220	1.456	1.889	2.126		
Stake Die (Size)											
Stake (Travel)											

POWER STEERING CRIMP CHART

Hose: SAE 100R3

Ferrule: ORI Special Power Steering Ferrule

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter		.550		.695	.850						
Crimp Travel		.140		.180	.210						
Die Size		#3 P/S Bubble		#4 P/S Bubble	#10 A/C Bubble						
Pre-Crimp Diameter		.690		.875	1.060						
Gauge Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp Length		.750		.800	1.200						
Stake (Location)		Flush		Flush	Flush						
Stake (Travel)		#3 S/D .040 after firm contact with stem		#4 S/D .040 after firm contact with stem	#5 S/D .040 after firm contact with stem						

CRIMP CHART - PRESSURE WASH HOSE

Hose: PW

Ferrule: FMP1

Stems: All "EH" Series

Size	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
Dash Size	-3	-4	-5	-6	-8	-10	-12	-16	-20	-24	-32
Crimp Diameter	.606	.642	.716	.790	.933	1.059	1.240	1.531	1.901	2.110	2.705
Crimp Travel	.142	.145	.150	.155	.185	.201	.177	.162	.186	.173	.169
Die Size	#3 Smooth Face	#3 Smooth Face	#4 Smooth Face	#4 Smooth Face	#5 Smooth Face	#6 Smooth Face	#7 Smooth Face	#8 Smooth Face	#10 Smooth Face	N/A	N/A
Ferrule Pre-Crimp Diameter	.748	.787	.866	.945	1.118	1.260	1.417	1.693	2.087	2.283	2.874
Gauge Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL	FULL
Stake Die (Size)											
Stake (Travel)											

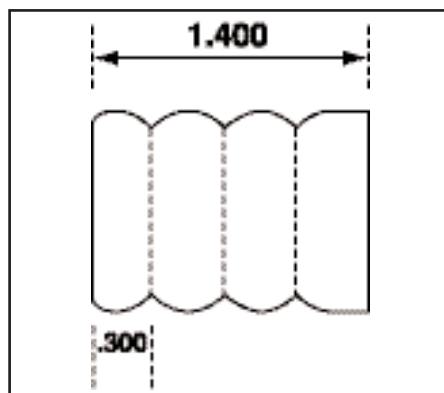
CRIMP CHART - AUTOMOTIVE AIR CONDITIONING

Hose: SAE J-2064 Barrier Hose

Fitting: Bead Lock/Bubble Crimp Couplings

Size				5/16	13/32	1/2	5/8				
# Size				#6	#8	#10	#12				
Crimp Diameter				.660	.830	.936	1.014				
Crimp Travel				.162	.160	.154	.191				
Die Size				#6 Bubble	#8 Bubble	#10 Bubble	#12 Bubble				
Ferrule Pre-Crimp Diameter				.822	.990	1.090	1.205				
Gauge Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length				1.050	1.050	1.050	1.050				

* Locate the top edge of the crimp die tooth .300 from the front of the shell (ferrule) on all sizes.



CRIMP CHART - REDUCED O.D. AIR CONDITIONING BARRIER HOSE

Hose: Goodyear Galaxy Reduced O.D. Barrier Hose

Fitting: TNH® Reduced Bead Lock Fittings

Size				5/16	13/32	1/2	5/8				
# Size				#6	#8	#10	#12				
Crimp Diameter				.550	.654	.730	.890				
Crimp Travel				.110	.140	.115	.135				
Die Size				#6 Bubble	#8 Bubble	#10 Bubble	#12 Bubble				
Ferrule Pre-Crimp Diameter				.660	.794	.845	1.025				
Gauge Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length				1.050	1.050	1.050	1.050				

**CRIMP CHART FOR
SMARTCRIMPER
TEFLON STAINLESS STEEL SMOOTHBORE**

Hose: PTFE T-30 Stainless Smoothbore Teflon Hose (.030 Wall)

Fitting: FTS Smart Ferrule

Size (Actual)	3/16	1/4	5/16	3/8	13/32	1/2	5/8	3/4	7/8	1	1 1/8
# Size	#4	#5	#6	#7	#8	#10	#12	#14	#16		#20
Crimp Diameter	.385	.460	.525	.590	.620	.720	.910	.986	1.130	1.235	1.375
Crimp Travel	.097	.085	.090	.085	.105	.105	.120	.134	.142	.239	.349
Die Size	#2.5 Smooth	#3 Smooth	#3 Smooth	#3.5 Smooth	#3.5 Smooth	#4 Smooth	#5 Smooth				
Ferrule Pre-Crimp Diameter	.482	.545	.615	.675	.725	.825	1.030				
Gauge Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length											

CRIMP CHART 4SH

Hose: DIN EN 856 4SH											
Ferrule: FEP12 Stem: All "EH" Series											
Size (Actual)	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4	1 1/2	2
# Size	#3	#4	#5	#6	#8	#10	#12	#16	#20	#24	#32
Crimp Diameter						1.158	1.362	1.661	2.03		
Crimp Travel						.170	.134	.150	.170		
Die Size						#6 Smooth	#7 Smooth	#9 Smooth	#10 Smooth		
Ferrule Pre-Crimp Diameter						1.328	1.496	1.811	2.20		
Gauge Pressure											
Dial Indicator Setting	DIAL SETTING IS ALWAYS 1/2 OF THE CRIMP TRAVEL										
Crimp/Swage Length											