

# TECHNICAL BULLETIN

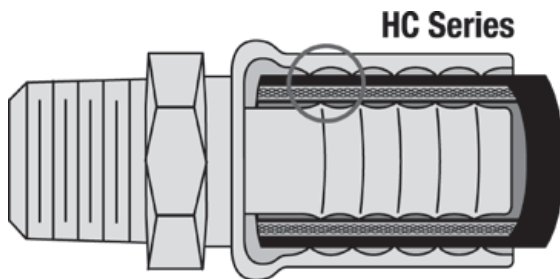
## ***Suggested Crimp Specifications***

If this is the initial use of your crimper you must first calibrate your machine according to the instructions in your operator's manual.

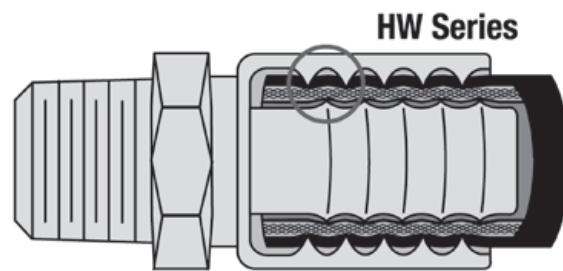
This is a suggested crimp diameter, please use this as a guide line only. Each machine and die sets are different, and parts will eventually wear, which will effect actual crimper settings.

Make sure that you are using the correct crimp diameters for the size of hose and style fitting you are using, as they are different.

### ***HC - Compression Style***



### ***HW - Grip Style***



### **2 Wire Suggested Crimp Specifications**

Hose Part #	Hose Size	Die	HC Micrometer Setting	HC Crimp Specification	HW Micrometer Setting	HW Crimp Specification
A-P100R16-4	1/4"	15	.875	.625 +/- .005	2.220	.678 +/- .005
A-P100R16-6	3/8"	18	.415	.725 +/- .005	2.190	.795 +/- .005
A-P100R16-8	1/2"	21	1.090	.870 +/- .005	3.000	.945 +/- .005
A-P100R16-10	5/8"	25	.530	1.005 +/- .005	Not Applicable	Not Applicable
A-P100R16-10	5/8"	28	Not Applicable	Not Applicable	2.300	1.180 +/- .005
A-P100R16-12	3/4"	28	1.210	1.150 +/- .005	3.620	1.245 +/- .005
P100R16-16	1"	37	.340	1.470 +/- .005	2.750	1.565 +/- .005

### **4 Wire Suggested Crimp Specifications**

Hose Part #	Hose Size	Die	HW Micrometer Setting	HW Crimp Specification
A-38624SH-12	3/4"	31	2.500	1.32 +/- .005
A-38624SH-16	1"	39	2.400	1.63 +/- .005
A-38624SH-20	1 1/4"	49	1.500	1.99 +/- .005



After crimping, each fitting must be checked with a caliper. Make adjustments to the crimper as required.