

# Crimp Specifications

Hydraulic hose assemblies should be assembled to the fitting manufacturer's specifications for the specified hose and fittings. Measure each fitting in at least two opposing directions to ensure a round, symmetrical crimp.

Using a set of calipers, measure the finished crimp diameter across the fitting, from the center of the smooth surface to the center of the smooth surface on the opposing side. Do *not* measure the "ribs," as this will give you a false measurement.

Item Number	Hose I.D.	Hose Fitting	Crimp Diameter (inches/millimeters)	Die Position	D100(H/P/S) Suggested Die Set	D165 Suggested Die Set	D205 Suggested Die Set
<b>DIN IN 856 4SH Hydraulic Hose</b>							
4SH-12	3/4"	W Series	1.320" / 33.53 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM
4SH-16	1"	W Series	1.630" / 41.40 mm	Full crimp	D100DA-41MM*	D100-41MM	D200-41MM
4SH-20	1-1/4"	JJ Series	1.943" / 49.35 mm	Full crimp**	N/A	D100-47MM	D200-47MM
4SH-20	1-1/4"	W Series	1.990" / 50.55 mm	Full crimp	N/A	D100-47MM	D200-47MM
4SH-24	1-1/2"	JJ Series	2.195" / 55.75 mm	Full crimp**	N/A	N/A	D200DA-55MM*
4SH-24	1-1/2"	W Series	2.390" / 60.71 mm	Full crimp	N/A	N/A	D200DA-60MM*
4SH-32	2"	JJ Series	2.840" / 72.14 mm	Full crimp**	N/A	N/A	D200DA-72MM*
<b>HJK 10,000 PSI Hydraulic Jack Hose</b>							
HJK-04	1/4"	Braided	0.634" / 16.10 mm	Crimp to knurl	D100-16MM	D100-16MM	D200-16MM
HJK-06	3/8"	Braided	0.785" / 19.94 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
<b>KT Tough Cover Hydraulic Hose</b>							
KT-04	1/4"	Braided	0.600" / 15.24 mm	Crimp to knurl	D100-14MM	D100-14MM	D200-14MM
KT-04	1/4"	W Series	0.660" / 16.76 mm	Full crimp	D100-16MM	D100-16MM	D200-16MM
KT-06	3/8"	Braided	0.750" / 19.05 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
KT-06	3/8"	W Series	0.800" / 20.32 mm	Full crimp	D100-19MM	D100-19MM	D200-19MM
KT-08	1/2"	Braided	0.860" / 21.84 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
KT-08	1/2"	W Series	0.950" / 24.13 mm	Full crimp	D100-22MM	D100-22MM	D200-22MM
KT-10	5/8"	Braided	1.006" / 25.55 mm	Crimp to knurl	D100-25MM	D100-25MM	D200-25MM
KT-10	5/8"	W Series	1.170" / 29.72 mm	Full crimp	D100-28MM	D100-28MM	D200-28MM
KT-12	3/4"	Braided	1.151" / 29.24 mm	Crimp to knurl	D100-28MM	D100-28MM	D200-28MM
KT-12	3/4"	W Series	1.240" / 31.50 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM
KT-16	1"	Braided	1.455" / 36.96 mm	Crimp to knurl	D100-35MM	D100-35MM	D200-35MM
KT-16	1"	W Series	1.545" / 39.24 mm	Full crimp	D100DA-39MM*	D100-39MM	D200-39MM
<b>SAE 100R1 AT Hydraulic Hose</b>							
R1-04	1/4"	Braided	0.585" / 14.86 mm	Crimp to knurl	D100-14MM	D100-14MM	D200-14MM
R1-04	1/4"	W Series	0.655" / 16.64 mm	Full crimp	D100-16MM	D100-16MM	D200-16MM
R1-06	3/8"	Braided	0.750" / 19.05 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
R1-06	3/8"	W Series	0.790" / 20.07 mm	Full crimp	D100-19MM	D100-19MM	D200-19MM
R1-08	1/2"	Braided	0.860" / 21.84 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
R1-08	1/2"	W Series	0.935" / 23.75 mm	Full crimp	D100-22MM	D100-22MM	D200-22MM
R1-10	5/8"	Braided	1.000" / 25.40 mm	Crimp to knurl	D100-25MM	D100-25MM	D200-25MM
R1-12	3/4"	Braided	1.150" / 29.21 mm	Crimp to knurl	D100-28MM	D100-28MM	D200-28MM
R1-12	3/4"	W Series	1.250" / 31.75 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM
R1-16	1"	Braided	1.430" / 36.32 mm	Crimp to knurl	D100-35MM	D100-35MM	D200-35MM
R1-16	1"	W Series	1.625" / 41.28 mm	Full crimp	D100DA-41MM*	D100-39MM	D200-39MM
R1-20	1-1/4"	Braided	1.830" / 46.48 mm	Crimp to knurl	D100DA-46MM*	D100-43MM	D200-43MM
R1-20	1-1/4"	W Series	2.020" / 51.31 mm	Full crimp	N/A	D100-51MM	D200-51MM

\* Double Angle (DA) die sets require double angle tooling (sold separately) \*\* Skiving is required with R13 hose and JJ Series hose fittings.

Item Number	Hose I.D.	Hose Fitting	Crimp Diameter (inches/millimeters)	Die Position	D100(H/P/S) Suggested Die Set	D165 Suggested Die Set	D205 Suggested Die Set
<b>SAE 100R2 AT Hydraulic Hose</b>							
R2-04	1/4"	Braided	0.645" / 16.38 mm	Crimp to knurl	D100-16MM	D100-16MM	D200-16MM
R2-04	1/4"	W Series	0.695" / 17.65 mm	Full crimp	D100-16MM	D100-16MM	D200-16MM
R2-06	3/8"	Braided	0.800" / 20.32 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
R2-06	3/8"	W Series	0.850" / 21.59 mm	Full crimp	D100-19MM	D100-19MM	D200-19MM
R2-08	1/2"	Braided	0.910" / 23.11 mm	Crimp to knurl	D100-22MM	D100-22MM	D200-22MM
R2-08	1/2"	W Series	0.980" / 24.89 mm	Full crimp	D100-22MM	D100-22MM	D200-22MM
R2-10	5/8"	Braided	1.050" / 26.67 mm	Crimp to knurl	D100-25MM	D100-25MM	D200-25MM
R2-10	5/8"	W Series	1.215" / 30.86 mm	Full crimp	D100-28MM	D100-28MM	D200-28MM
R2-12	3/4"	Braided	1.190" / 30.23 mm	Crimp to knurl	D100-28MM	D100-28MM	D200-28MM
R2-12	3/4"	W Series	1.285" / 32.64 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM
R2-16	1"	Braided	1.480" / 37.59 mm	Crimp to knurl	D100-35MM	D100-35MM	D200-35MM
R2-16	1"	W Series	1.665" / 42.29 mm	Full crimp	D100DA-41MM*	D100-41MM	D200-41MM
R2-20	1-1/4"	Braided	1.920" / 48.77 mm	Crimp to knurl	N/A	D100-47MM	D200-47MM
R2-20	1-1/4"	W Series	2.065" / 52.45 mm	Full crimp	N/A	D100-51MM	D200-51MM
R2-24	1-1/2"	W Series	2.400" / 60.96 mm	Full crimp	N/A	N/A	D200DA-60MM*
R2-32	2"	W Series	2.870" / 72.90 mm	Full crimp	N/A	N/A	D200DA-72MM*
<b>SAE 100R3 General Purpose/Hydraulic Hose</b>							
R3-04	1/4"	Braided	0.615" / 15.62 mm	Crimp to knurl	D100-14MM	D100-14MM	D200-14MM
R3-06	3/8"	Braided	0.790" / 20.07 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM
R3-08	1/2"	Braided	0.950" / 24.13 mm	Crimp to knurl	D100-22MM	D100-22MM	D200-22MM
R3-12	3/4"	Braided	1.240" / 31.50 mm	Crimp to knurl	D100-31MM	D100-31MM	D200-31MM
R3-16	1"	Braided	1.520" / 36.61 mm	Crimp to knurl	D100-35MM	D100-35MM	D200-35MM
<b>SAE 100R4 Suction and Return Hose</b>							
R4-12	3/4"	Braided	1.233" / 31.32 mm	Crimp to knurl	D100-31MM	D100-31MM	D100-31MM
R4-12	3/4"	Suction	1.280" / 32.51 mm		D100-31MM	D100-31MM	D100-31MM
R4-16	1"	Braided	1.466" / 37.24 mm	Crimp to knurl	D100-35MM	D100-35MM	D100-35MM
R4-16	1"	Suction	1.540" / 39.12 mm		D100DA-39MM*	D100-39MM	D100-39MM
R4-20	1-1/4"	Braided	1.780" / 45.21 mm	Crimp to knurl	N/A	D100-43MM	D100-43MM
R4-20	1-1/4"	Suction	1.825" / 46.36 mm		N/A	D100-43MM	D100-43MM
R4-24	1-1/2"	Suction	2.040" / 51.82 mm		N/A	N/A	D200-51MM
R4-32	2"	Suction	2.480" / 62.99 mm		N/A	N/A	D200DA-62MM*
<b>SAE 100R5 General Purpose/Truck Hose</b>							
R5-04	3/16"	R5 Series	0.535" / 13.59 mm	Crimp to knurl	D100-12MM	D100-12MM	D100-12MM
R5-05	1/4"	Braided	0.660" / 16.76 mm	Crimp to knurl	D100-16MM	D100-16MM	D100-16MM
R5-06	5/16"	R5 Series	0.725" / 18.42 mm	Crimp to knurl	D100-16MM	D100-16MM	D100-16MM
R5-08	13/32"	R5 Series	0.830" / 21.08 mm	Crimp to knurl	D100-19MM	D100-19MM	D100-19MM
R5-10	1/2"	Braided	0.917" / 23.29 mm	Crimp to knurl	D100-22MM	D100-22MM	D100-22MM
R5-12	5/8"	Braided	1.035" / 26.29 mm	Crimp to knurl	D100-25MM	D100-25MM	D100-25MM
R5-16	7/8"	R5 Series	1.240" / 31.50 mm	Crimp to knurl	D100-31MM	D100-31MM	D100-31MM
R5-20	1-1/8"	R5 Series	1.533" / 38.94 mm	Crimp to knurl	D100DA-38MM*	D100-35MM	D100-35MM
R5-24	1-3/8"	R5 Series	1.730" / 43.94 mm	Crimp to knurl	D100DA-43MM*	D100-43MM	D100-43MM
R5-32	1-13/16"	R5 Series	2.225" / 56.52 mm	Crimp to knurl	N/A	N/A	D200DA-55MM*

\* Double Angle (DA) die sets require double angle tooling (sold separately) \*\* Skiving is required with R13 hose and JJ Series hose fittings.

# Crimp Specifications

Item Number	Hose I.D.	Hose Fitting	Crimp Diameter (inches/millimeters)	Die Position	D100(H/P/S) Suggested Die Set	D165 Suggested Die Set	D205 Suggested Die Set
<b>SAE 100R7 Thermoplastic Hose</b>							
R7-02	1/8"	3 Series	0.358" / 9.09 mm	Crimp to knurl	D100-08MM	D100-08MM	D100-08MM
R7-03	3/16"	3 Series	0.478" / 12.14 mm	Crimp to knurl	D100-12MM	D100-12MM	D100-12MM
R7-04	1/4"	3 Series	0.555" / 14.10 mm	Crimp to knurl	D100-14MM	D100-14MM	D100-14MM
R7-05	5/16"	3 Series	0.630" / 16.00 mm	Crimp to knurl	D100-16MM	D100-16MM	D100-16MM
R7-06	3/8"	3 Series	0.675" / 17.15 mm	Crimp to knurl	D100-16MM	D100-16MM	D100-16MM
R7-08	1/2"	3 Series	0.825" / 20.96 mm	Crimp to knurl	D100-19MM	D100-19MM	D100-19MM
<b>SAE 100R8 (reduced O.D.) Thermoplastic Hose</b>							
R8-02	1/8"	3 Series	0.358" / 9.09 mm	Crimp to knurl	D100-08MM	D100-08MM	D100-08MM
R8-03	3/16"	3 Series	0.478" / 12.14 mm	Crimp to knurl	D100-12MM	D100-12MM	D100-12MM
R8-04	1/4"	3 Series	0.555" / 14.10 mm	Crimp to knurl	D100-14MM	D100-14MM	D100-14MM
R8-05	5/16"	3 Series	0.630" / 16.00 mm	Crimp to knurl	D100-16MM	D100-16MM	D100-16MM
R8-06	3/8"	3 Series	0.675" / 17.15 mm	Crimp to knurl	D100-16MM	D100-16MM	D100-16MM
R8-08	1/2"	3 Series	0.825" / 20.96 mm	Crimp to knurl	D100-19MM	D100-19MM	D100-19MM
<b>SAE 100R12 Hydraulic Hose</b>							
R12-06	3/8"	W Series	0.870" / 22.10 mm	Full crimp	D100-22MM	D100-22MM	D200-22MM
R12-08	1/2"	W Series	1.010" / 25.65 mm	Full crimp	D100-25MM	D100-25MM	D200-25MM
R12-12	3/4"	W Series	1.320" / 33.53 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM
R12-16	1"	W Series	1.630" / 41.40 mm	Full crimp	D100DA-41MM*	D100-41MM	D200-41MM
R12-20	1-1/4"	JJ Series	1.975" / 50.17 mm	Full crimp**	N/A	D100-47MM	D200-47MM
R12-20	1-1/4"	W Series	2.045" / 51.94 mm	Full crimp	N/A	D100-51MM	D200-51MM
R12-24	1-1/2"	JJ Series	2.230" / 56.64 mm	Full crimp**	N/A	N/A	D200DA-55MM*
R12-24	1-1/2"	W Series	2.375" / 60.33 mm	Full crimp	N/A	N/A	D200DA-60MM*
R12-32	2"	JJ Series	2.835" / 72.01 mm	Full crimp**	N/A	N/A	D200DA-72MM*
R12-32	2"	W Series	2.885" / 73.28 mm	Full crimp	N/A	N/A	D200DA-72MM*
<b>SAE 100R13 Hydraulic Hose</b>							
R13-12	3/4"	W Series	1.335" / 33.91 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM
R13-16	1"	W Series	1.645" / 41.78 mm	Full crimp	N/A	D100-39MM	D200-39MM
R13-20	1-1/4"	JJ Series	2.050" / 52.07 mm	Full crimp**	N/A	D100-51MM	D200-51MM
R13-24	1-1/2"	JJ Series	2.320" / 58.93 mm	Full crimp**	N/A	N/A	D200DA-58MM*
R13-32	2"	JJ Series	2.980" / 75.69 mm	Full crimp**	N/A	N/A	D200DA-75MM*
<b>SAE 100R14A Teflon/PTFE Hose</b>							
R14-04	3/16"	T Series	0.395" / 10.03 mm	Crimp to knurl	D100-10MM	D100-10MM	D200-10MM
R14-05	1/4"	T Series	0.430" / 10.92 mm	Crimp to knurl	D100-10MM	D100-10MM	D200-10MM
R14-06	5/16"	T Series	0.490" / 12.45 mm	Crimp to knurl	D100-12MM	D100-12MM	D200-12MM
R14-07	3/8"	T Series	0.565" / 14.35 mm	Crimp to knurl	D100-14MM	D100-14MM	D200-14MM
R14-10	1/2"	T Series	0.695" / 17.65 mm	Crimp to knurl	D100-16MM	D100-16MM	D200-16MM
R14-14	3/4"	T Series	0.995" / 25.27 mm	Crimp to knurl	D100-25MM	D100-25MM	D200-25MM
R14-18	1"	T Series	1.225" / 31.12 mm	Crimp to knurl	D100-31MM	D100-31MM	D200-31MM

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Item Number	Hose I.D.	Hose Fitting	Crimp Diameter (inches/millimeters)	Die Position	D100(H/P/S) Suggested Die Set	D165 Suggested Die Set	D205 Suggested Die Set	
<b>SAE 100R16 Hydraulic Hose</b>								
R16-04	1/4"	Braided	0.615" / 15.62 mm	Crimp to knurl	D100-14MM	D100-14MM	D200-14MM	
R16-04	1/4"	W Series	0.655" / 16.64 mm	Full crimp	D100-16MM	D100-16MM	D200-16MM	
R16-06	3/8"	Braided	0.760" / 19.30 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM	
R16-06	3/8"	W Series	0.815" / 20.70 mm	Full crimp	D100-19MM	D100-19MM	D200-19MM	
R16-08	1/2"	Braided	0.880" / 22.35 mm	Crimp to knurl	D100-22MM	D100-22MM	D200-22MM	
R16-08	1/2"	W Series	0.945" / 24.00 mm	Full crimp	D100-25MM	D100-25MM	D200-25MM	
R16-10	5/8"	Braided	1.010" / 25.65 mm	Crimp to knurl	D100-25MM	D100-25MM	D200-25MM	
R16-10	5/8"	W Series	1.180" / 29.97 mm	Full crimp	D100-28MM	D100-28MM	D200-28MM	
R16-12	3/4"	Braided	1.150" / 29.21 mm	Crimp to knurl	D100-28MM	D100-28MM	D200-28MM	
R16-12	3/4"	W Series	1.230" / 31.24 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM	
R16-16	1"	Braided	1.425" / 36.20 mm	Crimp to knurl	D100-35MM	D100-35MM	D200-35MM	
R16-16	1"	W Series	1.555" / 39.50 mm	Full crimp	D100DA-39MM*	D100-39MM	D200-39MM	
<b>SAE 100R17 Hydraulic Hose</b>								
R17-04	1/4"	Braided	0.570" / 14.48 mm	Crimp to knurl	D100-14MM	D100-14MM	D200-14MM	
R17-04	1/4"	W Series	0.625" / 15.88 mm	Full crimp	D100-14MM	D100-14MM	D200-14MM	
R17-06	3/8"	Braided	0.725" / 18.42 mm	Crimp to knurl	D100-16MM	D100-16MM	D200-16MM	
R17-06	3/8"	W Series	0.779" / 19.79 mm	Full crimp	D100-19MM	D100-19MM	D200-19MM	
R17-08	1/2"	Braided	0.840" / 21.34 mm	Crimp to knurl	D100-19MM	D100-19MM	D200-19MM	
R17-08	1/2"	W Series	0.950" / 24.13 mm	Full crimp	D100-22MM	D100-22MM	D200-22MM	
R17-10	5/8"	Braided	1.015" / 25.78 mm	Crimp to knurl	D100-25MM	D100-25MM	D200-25MM	
R17-10	5/8"	W Series	1.170" / 29.72 mm	Full crimp	D100-28MM	D100-28MM	D200-28MM	
R17-12	3/4"	Braided	1.160" / 29.46 mm	Crimp to knurl	D100-28MM	D100-28MM	D200-28MM	
R17-12	3/4"	W Series	1.275" / 32.39 mm	Full crimp	D100-31MM	D100-31MM	D200-31MM	
R17-16	1"	Braided	<i>Braided Hose Fittings are not recommended for use with 1" SAE 10R17 hose.</i>					
R17-16	1"	W Series	1.564" / 39.73 mm	Full crimp	D100-39MM	D100-39MM	D200-39MM	
<b>SAE J2064 Type C Class II Air Conditioning/Refrigerant Hose</b>								
BH-06	5/16"	Beadlock	0.684" / 17.37 mm	Middle of shell	Use DT71500 Air Conditioning Hose Crimper			
BH-08	13/32"	Beadlock	0.785" / 19.94 mm	Middle of shell				
BH-10	1/2"	Beadlock	0.905" / 22.99 mm	Middle of shell				
BH-12	5/8"	Beadlock	1.050" / 26.67 mm	Middle of shell				

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