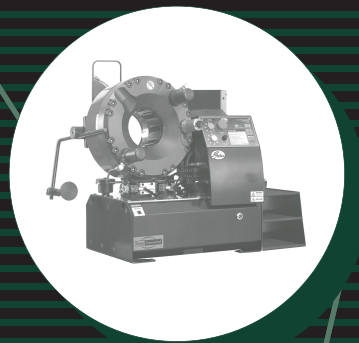


Crimp Data and Dies

Power Crimp® 707, MobileCrimp® 4-20, Power Crimp® 3000B,
OmniCrimp® 21, Power Crimp® 2001 and GC32-XD™ Crimpers





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Section Reference

Hydraulic Hose Crimp Data

BOP
C5C
C5E
C12M, C12M-MTF
C12, C12-MTF
CM2T®
CPSGS, CPSGS-MTF
CPS, CPS-MTF
EFG3K, EFG3K-MTF
EFG4K, EFG4K-MTF
EFG5K, EFG5K-MTF
EFG6K, EFG6K-MTF
G1
G1H
G2
G2AT-HMP
G2H, G2H-MTF
G2L
G2XH
G3K, G3K-MTF
G4K, G4K-MTF
G5K, G5K-MTF
G6K, G6K-MTF
GMV
GT7
GT8
GTH
HO
J2AT, J2AT-MTF
LOL/LOC
LW, LW-MTF
M500
M2T®, M2T-MTF
M2TH
M3K, M3K-MTF, M3K-XTF
M3KH
M4K+, M4K+-MTF, M4K+-XTF
M4KH, M4KH-MTF
M5K
M6K
MCPB+, MCPB+-MTF
MegaTech™ 250
MegaTech™ 300
MegaTech™ 500
MegaTech™ 1000
MegaTech™ II ACP
RFS
RLA
SHR
S/R-XH
TR500

Automotive Hose Crimp Data

Charter®
Multi-Use 1-Braid (19B)
Multi-Use 2-Braid (19B)
Safety Stripe

Industrial Hose Crimp Data

1000MP/Mine Spray
119B
19B
20B-HB
319MB
6B
Adapta Flex™
Cyclone™
Duro Flex®
Heat Master® (Aramid)
Premo Flex™
Terminator
Thermo AG® 570, 800



Hose Assembly Guide

Once the proper hose and couplings have been selected, the assembly can now be made. There are three types of assemblies:

- Permanent crimped
- Permanent swage
- "Field Attachable" couplings (crimping equipment needed)

Components, equipment and procedures vary for each type of couplings. However, measuring, cutting procedures and fitting orientation are the same.

1. Measuring Hose

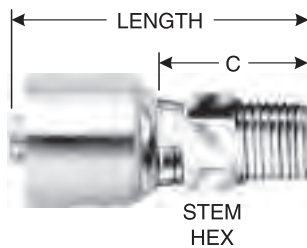
With some assemblies, the length must be within a tight tolerance for proper installation. This is especially true for short high-pressure hose assemblies.

Before cutting the hose, make sure you understand the difference between "cut hose length" and "assembly overall length" as shown below.

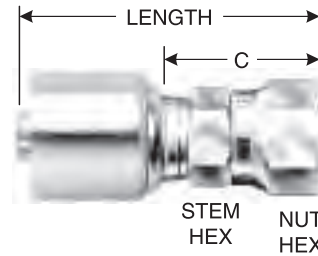
Cut-off value "C" is the length of that part of the coupling not directly in contact with or applied to the hose. Subtract the sum of the two "C" values from the overall length of the assembly to determine the approximate hose length to be cut.

All cut-off values are identified in the coupling tables found in the Gates hydraulic catalog.

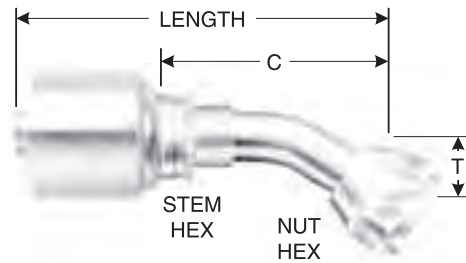
For male thread couplings, the cut-off is measured from the locking collar to the end of the threads as shown.



For straight female couplings, the cut-off is measured from the locking collar to either the end of the nut or seat depending on whether the nut can be pulled back exposing the seating surface.

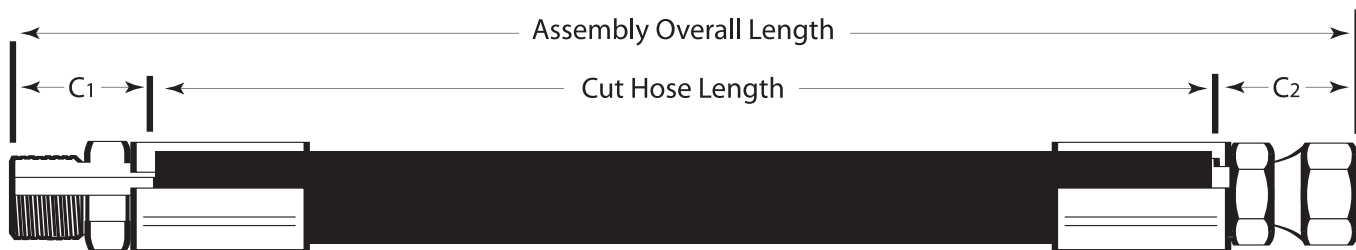


Bent tube couplings are measured to the center line of the seating surface as shown.



SAE Length Tolerances for Hydraulic Hose Assemblies and Specified Hose Length.

Length	Tolerance
For lengths from 0" up to and including 12"	± 1/8"
For lengths from 12" up to and including 18"	± 3/16"
For lengths from 18" up to and including 36"	± 1/4"
For lengths from 36"	± 1% of length measured to the nearest 1/8"



Cut Hose Length = Assembly Overall Length - (C₁ + C₂)

Hose Assembly Guide (cont'd)

2. Cutting Hose

CAUTION: When cutting hose, always wear safety glasses and avoid loose fitting clothing. Hearing protection is also strongly recommended.

After determining the hose cut length by deducting for fittings, cut the hose with a cut-off saw. There are two blade types that can be used: notched (serrated) or abrasive.

The notched blade gives a clean, efficient cut on non-spiral-reinforced hose (one- and two-wire braid hose and textile hose). Though notched blades will cut spiral hose, they are not recommended as they dull quickly and/or become damaged.

The abrasive wheel efficiently cuts all hose types, including spiral-reinforced hose. The drawback with this blade is the amount of debris it creates from cutting. As the blade wears out, its diameter becomes smaller and eventually requires replacement.

Once you've installed the appropriate blade, place the hose in the bending fixture. This draws the hose away as you cut, minimizing binding (squeezing) and makes cutting easier. Hand-held cutters can be used on some textile-reinforced hose.

Cutting PTFE hose requires special consideration. It can be cut cleanly with a cutting shear. Once the cut is made the PTFE tube must be deburred using a sharp knife.

Grounding Industrial hoses: When flammable materials are conveyed, follow these steps for grounding the static wire or wire helix to the couplings:

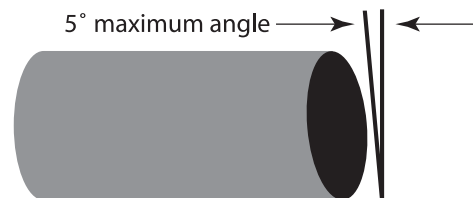
EXPOSING THE STATIC WIRE METHOD: Locate the static wire(s) in the end of the hose. If the wire(s) is not exposed, probe for it with a knife by cutting away a small part of the hose. When the wire(s) is located, note the direction that it is wound and cut the hose material away until approximately 5/8" ($\pm 1/8$ ") is exposed. Without damaging the wire(s), cut the hose end square. Check the electrical continuity of each static wire. When a satisfactory electrical test is achieved, bend the static wire(s) to the inside of the hose tube so that it will be in direct contact with the coupling shank (stem) and attach the coupling. Finally, check the electrical continuity after the couplings have been attached. The helical wire can be grounded in a similar fashion.

STAPLE METHOD: A metal staple(s) or flat brass pin(s) should be inserted into the center of the static wire(s) approximately 1/4". Remember that the static wire(s) travels at an angle due to the "Lazy Helix". Check the electrical continuity of each static wire. When a satisfactory electrical test is achieved, bend the remaining end(s) of the staple(s) or pin(s) inside the hose tube so that it will be in direct contact with the coupling shank (stem) and attach the coupling. Finally, check the electrical continuity after the couplings have been attached. The helical wire can be grounded in a similar fashion.

It is recommended that both static wires at each end of the hose be grounded by the methods described above. A minimum of one static wire (or wire helix) on each coupling must be grounded to achieve dissipation of static electricity.

NOTE: Cutting of any hose will generate some debris that, if not properly removed, can damage your hydraulic system.

When cutting any hose, keep the cut as straight as possible and square with the side of the hose. The maximum allowable angle of the cut is 5° (as shown below).



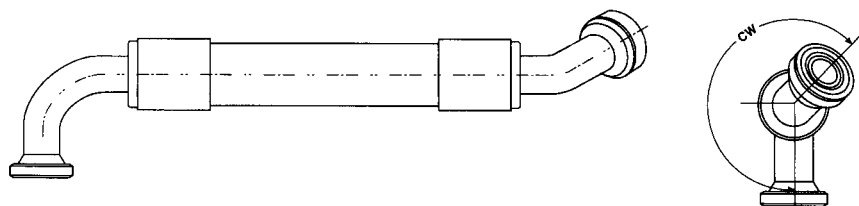
3. Fitting Orientation

Fitting orientation is necessary when neither fitting is straight (both are at an angle). Fittings must be oriented to each other to ensure proper installation with minimal stress on the hose from twisting.

Orientation procedure:

- Position far coupling vertically downward.
- Orientation angle is measured clockwise (as shown).

(Orientation angle tolerance should be $\pm 2^\circ$.)



Hose Assembly Guide (cont'd)

General



Skived Hose

4. Hose Preparation

CAUTION: When skiving or buffing hose, always wear safety glasses and avoid loose fitting clothing. If power skiving or buffing, hearing protection is recommended.

Skiving

Skiving removes the hose cover down to the reinforcement for coupling assembly and/or ferrule crimping. Some tools that can be used to skive are:

- Wire abrasion wheel.
- Hand-skiving tool (Gates Part No. 78030/ Product Number 7480-0413).

Thick-covered and some 6-wire hoses typically require skiving because the ferrule serrations cannot bite through the cover and into the wire. Hoses with a thin cover do not typically require skiving. Check Gates hydraulic catalog and crimp chart for specific information on skive length and diameter.

The skive length is the length of cover removed. For example, for 24G5K, the skive length is 2.75" and the skive diameter is "to the wire".

Buffing

Some non-wire-reinforced hose require buffing, which is similar to skiving but doesn't require removing the hose cover to the reinforcement.

When a hose is buffed, its cover is removed, but only to a specific diameter as defined by crimp data. A grinding wheel is necessary to buff a hose (not a wire wheel, which could damage the reinforcement).

NOTE: Skiving or buffing of any hose will generate some debris that if not properly removed can damage your hydraulic system.

5. Preassembly Using Two-Piece Couplings (GS, PCM, PCS & PC)

1. Lubricate the first two or three serrations on the stem with lightweight oil, i.e., 10W motor oil.
2. Clamp stem in vise on hex portion. Put ferrule over hose and push hose onto stem shoulder. (Photo 1 & 2)
3. Cutaway of assembly below shows the hose has bottomed against stem shoulder. To check for full insertion, pull the ferrule down. The stem shoulder should be level with the top of the ferrule.
4. Push ferrule so it rests against hex of stem. Hose and coupling are now ready for crimping. (Photo 3)



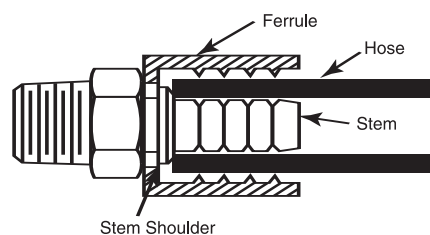
Photo 1



Photo 2



Photo 3



Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hose Assembly Guide (cont'd)

6. Preassembly Using MegaCrimp® Couplings (One Piece)

MegaCrimp was designed for easy insertion. No oil is needed for lubrication.

1. Place the hose next to the coupling. Use your thumb or mark the insertion depth with a grease pencil. Or, use the MegaCrimp® coupling insertion tool (Part #78017 / Product #7482-1342) for increased ease of measuring and marking of hose to ensure proper coupling insertion depth.
2. With your thumb (or mark) in place, push the coupling until the shell touches the tip of your thumb or the mark. Twist it slightly to ensure it is fully inserted.



MegaCrimp® Coupling (One-Piece)

7. Crimp Length

When crimping to a full length, Diagram A, place the top of the ferrule 1/8" below the top of the die fingers.

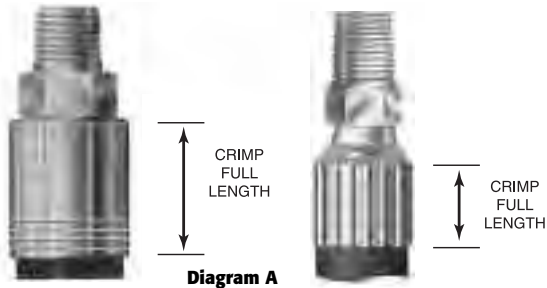


Diagram A

When crimping to a specified crimp length, Diagram B, measure and mark the ferrule for the correct length. Place the mark 1/8" below the top of the die fingers.

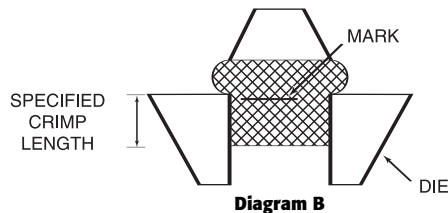


Diagram B

8. Crimp Procedures

NOTE: For specific instructions for your crimper, please refer to the appropriate operator's manual.

Listed below are basic crimp procedures.

1. Refer to crimp data chart for
 - a. Skive data (if necessary)
 - b. Die selection
 - c. Finished crimp diameter
 - d. Approximate crimp setting
2. Load the selected dies into the crimper. When using a die set for the first time, apply a thin coat of Molykote G lubricant to the contact surface and cone (not the bore of the die). This layer of lubricant must be thinly re-applied when contact surfaces become shiny. Locate dies in crimp position.
3. Adjust the machine to the proper crimp setting.
4. Insert the assembly and locate with the die fingers. (Approximately 1/8" below top of die. You do not want a "mushroom effect" on top of coupling.)
5. Install die cone if used.
6. Always wear safety glasses and **KEEP HANDS AWAY FROM MOVING PARTS.**



Incorrect

Correct

7. Activate crimp mechanism. Support hose by holding it under crimper base.
8. Remove assembly from dies and measure crimp diameter.

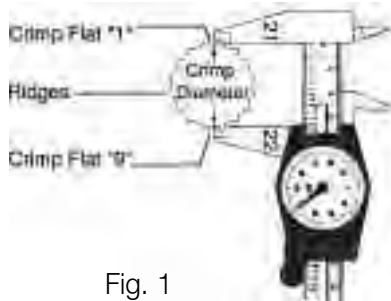
IMPORTANT SAFETY NOTE:

All settings are approximate! Machining tolerances exist for each crimper, die set and supporting piece of equipment which will affect your actual setting. Always check the crimp diameter to ensure that it is within the published limits. Record your actual crimper setting to achieve the specified crimp diameter for future use. Failure to heed this message could result in improperly made assemblies, blowing the hose out of the fittings at high pressure, and risk of fire and/or serious injury.

Hose Assembly Guide (cont'd)

9. Measuring Crimp Diameter

1. Using Gates "digital" dial calipers (Product No. 7369-0322, Part No. 78241) measure halfway between the ridges (Fig. 1). To be sure crimp diameter is being properly measured, mark a crimp flat. Beginning with that flat, count 9 flats to get the diameter. Be sure caliper blades DO NOT touch ridges.



2. Measure halfway between the ends of crimped portion of the ferrule (Fig.2)



10. Adjustment Procedures

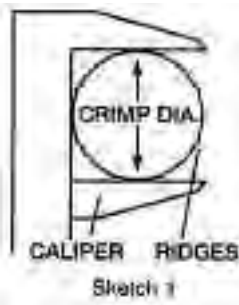
Should the actual crimp diameter NOT be within the tolerance specified in the Crimp Data Charts, check the calibration of the crimper. If the calibration is correct, a slight adjustment of the digital readout may be necessary.

REMEMBER: The digital readout settings listed in this manual are approximate! Machining tolerances exist for each crimper, die set, and supporting piece of equipment, which will affect your actual setting.

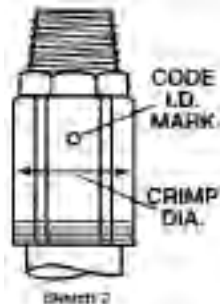
ALWAYS check the crimp diameter to assure it is within the published specifications!

(When NOT using 21 and 22 Dies)

1. Measure halfway between the ridges, and center the ferrule in the caliper jaws (Sketch 1). When using caliper, be sure caliper fingers do not touch ridges or part number stamp.



2. Measure halfway down the crimped portion of the ferrule. Be sure caliper blades DO NOT touch ridges. (Sketch 2)



To find the right adjustment to your digital setting, refer to your specific crimper section or your crimper's Operating Manual. When the setting has been calculated and your new crimp is within the specified tolerance, make sure to record your new Approximate Setting in the space provided in this manual under "User's Actual Setting" for future reference.

WARNING:

An incorrect hose assembly can rupture or blow apart in use, resulting in serious injury, death or property damage.

FOR SAFETY'S SAKE, USE A CRIMPER ONLY IF YOU:

1. Receive hands-on TRAINING with Gates crimper and assemblies.
2. Follow current GATES OPERATING MANUAL and CRIMP DATA for the Gates crimper.
3. Use only NEW (UNUSED) GATES hose and couplings.
4. Use SAFETY GLASSES.

REMEMBER: Others depend on you to make correct assemblies.

Swaging Procedures

PCTS Thermoplastic GT7 and GT8 Hoses.

Mark hose for proper insertion depth into coupling. See Gates Hose Swage Data chart for insertion depth. Use a lightweight oil to lubricate the inside diameter of hose. Place the coupling hex into a vise and insert hose to insertion depth.

The following are the basic swage procedures. For specific instructions for your crimper or swager, please refer to the appropriate operator's manual. Swaging can be accomplished with either the Gates HS-1 Hand Swager (Part No. 78080/ Product No. 7483-1000) or with the Swager Conversion Kit for the Power Crimp® 707 (Part No. 78081/ Product No. 7480-0040).

1. See Swage Data chart to select specific pusher and die for each coupling and hose combination to be swaged. The Swage Tooling page contains specific part/product number information for each pusher and die.
2. Insert the correct die and pusher into the swaging machine.
3. Lubricate inner bore surfaces of dies with a thin film of lightweight oil.
4. Feed hose assembly through the dies and hold hose and coupling into the pusher. Start the swage.
5. Swage is complete when pusher bottoms out on dies.



Gates HS-1

Part No. 78080
Product No. 7483-1000

Swage Tooling



Swager Conversion Kit for the Power Crimp® 707 Crimper

Part No. 78081
Product No. 7480-0040

Pushers and Dies for PCTS Couplings and GT7 & GT8 Hose

PCTS Swage Pushers

Description	Part No.	Product No.
GM001	78100	7483-0308
GM002	78101	7483-0309
GM003	78102	7483-0310
GM004	78103	7483-0311
GM005	78104	7483-0312
GM006	78155	7483-0367
GM007	78149	7483-0356
GM008	78150	7483-0357
GM009	78105	7483-0313
GM010	78106	7483-0314
GM011	78107	7483-0315
GM012	78108	7483-0316
GM013	78109	7483-0317
GM023	78111	7483-0319
GM062	78152	7483-0363
GF002	78144	7483-0358
GF005	78148	7483-0355

(Cont on next column)

PCTS Swage Pushers (cont.)

Description	Part No.	Product No.
GF006	78125	7483-0333
GF008	78126	7483-0334
GF009	78127	7483-0335
GF010	78151	7483-0362
GF011	78128	7483-0336
GF012	78129	7483-0337
GF013	78130	7483-0338
GF014	78131	7483-0339
GF015	78132	7483-0340
GF016	78133	7483-0341
GF017	78147	7483-0361
GT204	78138	7483-0346
GT205	78139	7483-0347
GT206	78153	7483-0364
GT308	78154	7483-0366
GT310	78156	7483-0368
GT312	78143	7483-0351

PCTS Swage Dies

Description	Part No.	Product No.
G302	78090	7483-0300
G303	78091	7483-0301
G304	78092	7483-0302
G305	78093	7483-0303
G306	78094	7483-0304
G308	78095	7483-0305
G312	78096	7483-0306
G316	78097	7483-0307

GM = Male Pusher
GF = Female Pusher
GT = Tube Pusher

Gates Hose Swage Data

GT7 and GT7NC Thermoplastic Hoses

Use PCTS couplings with GT7 and GT7NC Thermoplastic hoses. Any combination of Gates, Synflex or Parker Pusher and Dies can be used to Swage Gates GT7 Thermoplastic hoses with Gates PCTS couplings.

Coupling			Assembly		Gates		Synflex		Parker	
Description	Part No.	Product No.	Hose Insertion Length +/- .03(in)	Finished Swage OD +/- .0025 (in)	Pusher	Die	Pusher	Die	Pusher	Die
2PCTS-2MP	80830	7336-1198-5	0.563	0.360	GM023	G302	MP023	302	PUM001	302
2PCTS-4MP	80831	7336-1199-5	0.563	0.360	GM004	G302	MP004	302	PUM004	302
3PCTS-2MP	80832	7336-1200-5	0.781	0.485	GM001	G303	MP001	303	PUM001	303
3PCTS-4MP	80833	7336-1201-5	0.781	0.485	GM004	G303	MP004	303	PUM004	303
4PCTS-2MP	80834	7336-1202-5	1.063	0.565	GM002	G304	MP002	304	PUM002	304
4PCTS-4MP	80835	7336-1203-5	1.063	0.565	GM004	G304	MP004	304	PUM004	304
4PCTS-6MP	80836	7336-1204-5	1.063	0.565	GM005	G304	MP005	304	PUM005	304
5PCTS-4MP	80837	7336-1205-5	1.063	0.625	GM004	G305	MP004	305	PUM004	305
6PCTS-4MP	80838	7336-1207-5	1.250	0.690	GM005	G306	MP005	306	PUM005	306
6PCTS-6MP	80839	7336-1208-5	1.250	0.690	GM005	G306	MP005	306	PUM005	306
6PCTS-8MP	80840	7336-1209-5	1.250	0.690	GM009	G306	MP009	306	PUM009	306
8PCTS-6MP	80824	7336-1211-5	1.500	0.840	GM008	G308	MP008	308	PUM008	308
8PCTS-8MP	80841	7336-1210-5	1.500	0.840	GM009	G308	MP009	308	PUM009	308
12PCTS-12MP	80704	7336-0033-5	1.688	1.105	GM011	G312	MP011	312	PUM011	312
16PCTS-16MP	80705	7336-0036-5	2.250	1.345	GM013	G316	MP013	316	PUM013	316
2PCTS-2MPX	80825	7337-1198-5	0.563	0.360	GM003	G302	MP003	302	PUT008	302
3PCTS-2MPX	80828	7337-1200-5	0.781	0.485	GM003	G303	MP003	303	PUT008	303
3PCTS-4MPX	80829	7337-1201-5	0.781	0.485	GM003	G303	MP003	303	PUT008	303
4PCTS-4MPX	80842	7337-1202-5	1.063	0.565	GM003	G304	MP003	304	PUT008	304
5PCTS-4MPX	80843	7337-1203-5	1.063	0.625	GM003	G305	MP003	305	PUT008	305
6PCTS-6MPX	80844	7337-1204-5	1.250	0.690	GM006	G306	MP006	306	PUT009	306
8PCTS-8MPX	80845	7337-1205-5	1.500	0.840	GM010	G308	MP010	308	PUT010	308
12PCTS-12MPX	80848	7337-0091-5	1.688	1.105	GM012	G312	MP012	312	PUT011	312
4PCTS-4MPX90	80846	7337-1210-5	1.063	0.565	GM062	G304	SP008	304	PUS001	304
6PCTS-6FP	80847	7337-0103-5	1.250	0.690	GF005	G306	FP004	306	PUF005	306
4PCTS-4FPX	80950	7338-1330-5	1.063	0.565	GF002	G304	FP002	304	PUF002	304
4PCTS-4MJ	80860	7336-1231-5	1.063	0.565	GM002	G304	MP002	304	PUM002	304
4PCTS-6MJ	80861	7336-1233-5	1.063	0.565	GM004	G304	MP004	304	PUM004	304
5PCTS-6MJ	80868	7336-1235-5	1.063	0.625	GM004	G305	MP004	305	PUM004	305
6PCTS-6MJ	80862	7336-1236-5	1.250	0.690	GM005	G306	MP005	306	PUM005	306
6PCTS-8MJ	80863	7336-1237-5	1.250	0.690	GM007	G306	MP007	306	PUM007	306
8PCTS-8MJ	80864	7336-1238-5	1.500	0.840	GM008	G308	MP008	308	PUM008	308
12PCTS-12MJ	80865	7336-0034-5	1.688	1.105	GM011	G312	MP011	312	PUM011	312
2PCTS-3FJX	80850	7338-1198-5	0.563	0.360	GF017	G302	FP017	302	PUF017	302
2PCTS-4FJSX ¹	80851	7338-1199-5	0.563	0.360	GF010	G302	FP010	302	PUF010	302
3PCTS-4FJSX ¹	80852	7338-1200-5	0.781	0.485	GF011	G303	FP011	303	PUF011	303
4PCTS-4FJSX ¹	80853	7338-1202-5	1.063	0.565	GF012	G304	FP012	304	PUF012	304
4PCTS-5FJSX ¹	80866	7338-1203-5	1.063	0.565	GF013	G304	FP013	304	PUF013	304
4PCTS-6FJX	80854	7338-1204-5	1.063	0.565	GF013	G304	FP013	304	PUF013	304
5PCTS-5FJSX ¹	80867	7338-1205-5	1.063	0.625	GF013	G305	FP013	305	PUF013	305
5PCTS-6FJX	80855	7338-1206-5	1.063	0.625	GF013	G305	FP013	305	PUF013	305
6PCTS-6FJX	80856	7338-1207-5	1.250	0.690	GF015	G306	FP015	306	PUF015	306

¹ Denotes dual seat



Gates Hose Swage Data

GT7 and GT7NC Thermoplastic Hoses

Use PCTS couplings with GT7 and GT7NC Thermoplastic hoses. Any combination of Gates, Synflex or Parker Pusher and Dies can be used to Swage Gates GT7 Thermoplastic hoses with Gates PCTS couplings.

Coupling			Assembly		Gates		Synflex		Parker	
Description	Part No.	Product No.	Hose Insertion Length +/- .03(in)	Finished Swage OD +/- .0025 (in)	Pusher	Die	Pusher	Die	Pusher	Die
6PCTS-8FJSX ¹	80857	7338-1208-5	1.250	0.690	GF005	G306	FP005	306	PUF005	306
8PCTS-8FJSX ¹	80858	7338-1209-5	1.500	0.840	GF016	G308	FP016	308	PUF016	308
8PCTS-10FJSX ¹	80859	7338-1210-5	1.500	0.840	GF006	G308	FP006	308	PUF006	308
8PCTS-12FJX	80898	7338-1217-5	1.500	0.840	GF008	G308	FP008	308	PUF008	308
12PCTS-10FJX	80899	7338-1218-5	1.688	1.105	GF016	G312	FP016	312	PUF016	312
12PCTS-12FJX	80708	7338-0160-5	1.688	1.105	GF008	G312	FP008	312	PUF008	312
16PCTS-16FJX	80709	7338-0161-5	2.250	1.345	GF009	G316	FP009	316	PUF009	316
4PCTS-4FJX45	80910	7338-1251-5	1.063	0.565	GT204	G304	TP204	304	PUT001	304
6PCTS-6FJX45	80915	7338-1245-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
6PCTS-6FJX45L	80893	7338-1250-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
6PCTS-8FJX45	80916	7338-1246-5	1.250	0.690	GT308	G306	TP308	306	PUT004	306
6PCTS-8FJX45L	80894	7338-1249-5	1.250	0.690	GT308	G306	TP308	306	PUT004	306
12PCTS-12FJX45	80918	7338-0155-5	1.688	1.105	GT312	G312	TP312	312	PUT005	312
4PCTS-4FJX90S	80870	7338-1272-5	1.063	0.565	GT204	G304	TP204	304	PUT001	304
4PCTS-5FJX90S	80871	7338-1274-5	1.063	0.565	GT205	G304	TP205	304	PUT002	304
5PCTS-6FJX90S	80869	7338-1276-5	1.063	0.625	GT206	G305	TP206	305	PUT003	305
6PCTS-6FJX90S	80872	7338-1278-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
6PCTS-6FJX90L	80935	7338-1279-5	1.063	0.690	GT206	G306	TP206	306	PUT003	306
6PCTS-8FJX90S	80873	7338-1280-5	1.250	0.690	GT308	G306	TP308	306	PUT004	306
6PCTS-8FJX90L	80888	7338-1281-5	1.250	0.690	GT308	G306	TP308	306	PUT004	306
8PCTS-8FJX90S	80874	7338-1282-5	1.500	0.840	GT308	G308	TP308	308	PUT004	308
12PCTS-12FJX90L	80938	7338-0151-5	1.688	1.105	GT312	G312	TP312	312	PUT005	312
12PCTS-12FJX90S	80877	7338-0150-5	1.688	1.105	GT312	G312	TP312	312	PUT005	312
4PCTS-6MB	80880	7336-1247-5	1.063	0.565	GM004	G304	MP004	304	PUM004	304
6PCTS-6MB	80881	7336-1250-5	1.250	0.690	GM005	G306	MP005	306	PUM005	306
8PCTS-8MB	80926	7336-1252-5	1.500	0.840	GM009	G308	MP009	308	PUM009	308
6PCTS-6MFFOR	80925	7336-1300-5	1.250	0.690	GM007	G306	MP007	306	PUM007	306
4PCTS-4FFORX	80883	7338-1299-5	1.063	0.565	GT205	G304	TP205	304	PUT002	304
4PCTS-6FFORX	80886	7338-1298-5	1.063	0.565	GT206	G304	TP206	304	PUT003	304
6PCTS-6FFORX	80884	7338-1300-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
8PCTS-8FFORX	80885	7338-1301-5	1.500	0.840	GT308	G308	TP308	308	PUT004	308
4PCTS-4FFORX45	80889	7338-1304-5	1.063	0.565	GT205	G304	TP205	304	PUT002	304
6PCTS-6FFORX45	80890	7338-1305-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
8PCTS-8FFORX45	80891	7338-1306-5	1.500	0.840	GT308	G308	TP308	308	PUT004	308
4PCTS-4FFORX90S	80895	7338-1310-5	1.063	0.565	GT205	G304	TP205	304	PUT002	304
4PCTS-4FFORX90L	80902	7338-1320-5	1.063	0.565	GT205	G304	TP205	304	PUT002	304
6PCTS-6FFORX90S	80896	7338-1311-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
6PCTS-6FFORX90L	80903	7338-1322-5	1.250	0.690	GT206	G306	TP206	306	PUT003	306
8PCTS-8FFORX90S	80897	7338-1312-5	1.500	0.840	GT308	G308	TP308	308	PUT004	308
8PCTS-8FFORX90L	80904	7336-1324-5	1.500	0.840	GT308	G308	TP308	308	PUT004	308
4PCTS-4FJISX	80940	7338-0164-5	1.063	0.565	GF013	G304	FP013	304	PUF013	304
6PCTS-6FJISX	80941	7338-0165-5	1.250	0.690	GF004	G306	FP004	306	PUF005	306
8PCTS-8FJISX	80942	7338-0166-5	1.500	0.840	GF006	G308	FP006	308	PUF006	308

¹ Denotes dual seat



Swaging Procedures

C-14 PTFE Hose

NOTE: Always use eye protection when making assemblies.

Step 1 – Hose Cutting

After determining hose cut length by deducting for fittings, cut hose with shear. No taping or deburring is necessary, since shearing the hose holds braid flaring to a minimum.

Step 2 – Hose Insertion

Place ferrule in hose insertion die holder with tapered end down. Place insertion dies in die holder so that taper will guide hose into ferrule. Push hose through dies with a slight twisting motion until seated; pull hose out. Insertion dies will fall out as you remove hose. Check end of ferrule for full insertion.

Step 3 – Hose Expansion and Stem Insertion

Next, select proper size expansion rod and secure in a vise. Push hose over bead several times to expand tube. Place stem (and nut if used) on rod. Push hose onto stem until stem is completely inserted - no gaps between shoulder on stem and ferrule. If a gap exists, ferrule must be twisted and pushed forward until gap is eliminated.

Step 4 – Swaging

Select proper size dies and pusher and install them in the Gates HS-1 hand swager (Part No. 78080/ Product No. 7483-1000) or swager conversion kit for the PC707.

If using the PC707 with conversion kit installed, remove actuator rod to swage. Lubricate bore of die set with light oil. Using one hand to hold assembly so fitting remains seated in pusher, start swage. Swage is complete when pusher bottoms out on dies. When swaging is complete, reinstall actuator rod into crimp position.

When swage is complete, ferrule outside diameter must be within the following range:

Hose Size	Swage O.D. (In.)	Hose Size	Swage O.D. (In.)
-4	.350 – .355	-10	.673 – .678
-5	.404 – .409	-12	.800 – .805
-6	.478 – .483	-16	1.044 – 1.049
-8	.568 – .573		

If ferrule outside diameter is not within the above range, check for die wear and replace if necessary.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

¹ Denotes dual seat



Swage Tooling

Pushers and Dies for C14 Hose and Couplings

C14 Hose Insertion Dies

Description	Part No.	Product No.
HD-4C14	78521	7483-0503
HD-5C14	78522	7483-0504
HD-6C14	78523	7483-0505
HD-8C14	78524	7483-0506
HD-10C14	78525	7483-0507
HD-12C14	78526	7483-0508
HD-16C14	78527	7483-0509

C14 Swage Dies

Description	Part No.	Product No.
SD-4C14	78539	7483-0513
SD-5C14	78540	7483-0514
SD-6C14	78541	7483-0515
SD-8C14	78542	7483-0516
SD-10C14	78543	7483-0517
SD-12C14	78544	7483-0518
SD-16C14	78545	7483-0519

C14 Swage Pushers

Description	Part No.	Product No.
P-C14-4FJSX	78500	7483-0536
P-C14-5FJSX	78501	7483-0537
P-C14-6FJX	78502	7483-0538
P-C14-6FSX	78503	7483-0539
P-C14-8FJSX	78504	7483-0540
P-C14-10FJSX	78505	7483-0541
P-C14-12FJX	78506	7483-0542
P-C14-12FSX	78507	7483-0543
P-C14-16FJSX	78508	7483-0540
P-C14-2MP	78510	7483-0550
P-C14-4MP	78511	7483-0545
P-C14-6MP	78512	7483-0546
P-C14-8MP-8 & 10ABC	78513	7483-0547
P-C14-12MP-12ABC	78514	7483-0548
P-C14-16MP	78515	7483-0549
P-C14-4TUBE	78548	7483-0530
P-C14-5TUBE	78549	7483-0531
P-C14-6TUBE	78550	7483-0532
P-C14-8TUBE	78551	7483-0533
P-C14-10TUBE	78552	7483-0534
P-C14-12TUBE	78553	7483-0521
P-C14-12TUBE-JS	78554	7483-0552
P-C14-16TUBE-JS	78555	7483-0580
P-C14-6TBFLX	78565	7483-0552
P-C14-12TBFLX	78568	7483-0553
P-C14-16TBFLX	78569	7483-0554

C14 Hose Expanders

Description	Part No.	Product No.
HE-4C14	78530	7483-0555
HE-5C14	78531	7483-0556
HE-6C14	78532	7483-0557
HE-8C14	78533	7483-0558
HE-10C14	78534	7483-0559
HE-12C14	78535	7483-0560
HE-16C14	78536	7483-0561

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Gates Hose Swage Data

C14 PTFE

Use C14 couplings with C14 hose.

Gates pushers and dies MUST BE USED to swage Gates C14 hose with Gates C14 couplings.

Coupling			Assembly				Swaging Tools	
Description	Part No.	Product No.	Hose Insertion Length +/- .03(in)	C14 Hose Insertion Die	C14 Hose Expander Die	Finished Swage OD +/- .0025 (in)	Pusher	Die
4C14-2MP-SS	G40100-0402S	7753-0008-5	-	HD-4C14	HE-4C14	0.3525	P-C14-2MP	SD-4C14
4C14-4MP-SS	G40100-0404S	7753-0001-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4MP	SD-4C14
5C14-4MP-SS	G40100-0504S	7753-0002-5	-	HD-5C14	HE-5C14	0.4065	P-C14-4MP	SD-5C14
6C14-4MP-SS	G40100-0604S	7753-0009-5	-	HD-6C14	HE-6C14	0.4805	P-C14-4MP	SD-6C14
6C14-6MP-SS	G40100-0606S	7753-0003-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6MP	SD-6C14
8C14-6MP-SS	G40100-0806S	7753-0010-5	-	HD-8C14	HE-8C14	0.5705	P-C14-6MP	SD-8C14
8C14-8MP-SS	G40100-0808S	7753-0004-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8MP-8&10ABC	SD-8C14
10C14-8MP-SS	G40100-1008S	7753-0005-5	-	HD-10C14	HE-10C14	0.6755	P-C14-8MP-8&10ABC	SD-10C14
12C14-12MP-SS	G40100-1212S	7753-0006-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12MP-12ABC	SD-12C14
16C14-16MP-SS	G40100-1616S	7753-0007-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16MP	SD-16C14
4C14-2MP-B	G40100-0402B	7753-1008-5	-	HD-4C14	HE-4C14	0.3525	P-C14-2MP	SD-4C14
4C14-4MP-B	G40100-0404B	7753-1001-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4MP	SD-4C14
5C14-4MP-B	G40100-0504B	7753-1002-5	-	HD-5C14	HE-5C14	0.4065	P-C14-4MP	SD-5C14
6C14-4MP-B	G40100-0604B	7753-1009-5	-	HD-6C14	HE-6C14	0.4805	P-C14-4MP	SD-6C14
6C14-6MP-B	G40100-0606B	7753-1003-5	-	HD-6C14	HE-6C14	0.4805	P-C14-4MP	SD-6C14
8C14-6MP-B	G40100-0806B	7753-1010-5	-	HD-8C14	HE-8C14	0.5705	P-C14-6MP	SD-8C14
8C14-8MP-B	G40100-0808B	7753-1004-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8MP-8&10ABC	SD-8C14
10C14-8MP-B	G40100-1008B	7753-1005-5	-	HD-10C14	HE-10C14	0.6755	P-C14-8MP-8&10ABC	SD-10C14
12C14-12MP-B	G40100-1212B	7753-1006-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12MP-12ABC	SD-12C14
16C14-16MP-B	G40100-1616B	7753-1007-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16MP	SD-16C14
4C14-4MIX	G40500-0404	7753-2030-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
5C14-5MIX	G40500-0505	7753-2031-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5TUBE	SD-5C14
6C14-6MIX	G40500-0606	7753-2032-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8MIX	G40500-0808	7753-2033-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10MIX	G40500-1010	7753-2034-5	-	HD-10C14	HE-10C14	0.6775	P-C14-10TUBE	SD-10C14
4C14-4MIX45	G40502-0404	7753-2035-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
6C14-6MIX45	G40502-0606	7753-2036-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8MIX45	G40502-0808	7753-2037-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10MIX45	G40502-1010	7753-2069-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12MIX45	G40502-1212	7753-2070-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE	SD-12C14
4C14-4MIX90	G40504-0404	7753-2038-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
5C14-5MIX90	G40504-0505	7753-2039-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5TUBE	SD-5C14
6C14-6MIX90	G40504-0606	7753-2040-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8MIX90	G40504-0808	7753-2041-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10MIX90	G40504-1010	7753-2042-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12MIX90	G40504-1212	7753-2071-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE	SD-12C14
4C14-4FJSX-SS ¹	G40170-0404S	7753-0012-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4FJSX	SD-4C14
5C14-5FJSX-SS ¹	G40170-0505S	7753-0013-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5FJSX	SD-5C14
6C14-6FJX-SS	G40170-0606S	7753-0014-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6FJX	SD-6C14
8C14-8FJSX-SS ¹	G40170-0808S	7753-0015-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8FJSX	SD-8C14
10C14-10FJSX-SS ¹	G40170-1010S	7753-0016-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10FJSX	SD-10C14
12C14-12FJX-SS	G40170-1212S	7753-0017-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12FJX	SD-12C14
16C14-16FJSX-SS ¹	G40170-1616S	7753-0018-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16FJSX	SD-16C14
4C14-4FJSX-B ¹	G40170-0404B	7753-1012-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4FJSX	SD-4C14
5C14-5FJSX-B ¹	G40170-0505B	7753-1013-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5FJSX	SD-5C14
6C14-6FJX-B	G40170-0606B	7753-1014-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6FJX	SD-6C14

¹ Denotes dual seat. ² When swaging, do not keep the flange between the pusher and swage die. ³ When swaging, keep the flange between the pusher and swage die.



Gates Hose Swage Data

PTFE

Use C14 couplings with C14 hose.

Gates pushers and dies MUST BE USED to swage Gates C14 hose with Gates C14 couplings.

Coupling			Assembly				Swaging Tools	
Description	Part No.	Product No.	Hose Insertion Length +/- .03(in)	C14 Hose Insertion Die	C14 Hose Expander Die	Finished Swage OD +/- .0025 (in)	Pusher	Die
6C14-6FSX-B	G40200-0606B	7753-1019-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6FSX	SD-6C14
8C14-8FJSX-B ¹	G40170-0808B	7753-1015-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8FJSX	SD-8C14
10C14-10FJSX-B ¹	G40170-1010B	7753-1016-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10FJSX	SD-10C14
12C14-12FJX-B	G40170-1212B	7753-1017-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12FJX	SD-12C14
12C14-12FSX-B	G40200-1212B	7753-1020-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12FSX	SD-12C14
16C14-16FJSX-B ¹	G40170-1616B	7753-1018-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16FJSX	SD-16C14
4C14-4FSX45	G40202-0404S	7753-2021-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
5C14-5FSX45	G40202-0505S	7753-2022-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5TUBE	SD-5C14
6C14-6FSX45	G40202-0606S	7753-2023-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8FSX45	G40202-0808S	7753-2024-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10FSX45	G40202-1010S	7753-2063-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12FSX45	G40202-1212S	7753-2064-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE-JS	SD-12C14
4C14-4FSX90	G40205-0404S	7753-2025-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
5C14-5FSX90	G40205-0505S	7753-2026-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5TUBE	SD-5C14
6C14-6FSX90	G40205-0606S	7753-2027-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8FSX90	G40205-0808S	7753-2028-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10FSX90	G40205-1010S	7753-2029-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12FSX90	G40205-1212S	7753-2066-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE-JS	SD-12C14
4C14-4FJX45	G40175-0404	7753-2049-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
5C14-5FJX45	G40175-0505	7753-2050-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5TUBE	SD-5C14
6C14-6FJX45	G40175-0606	7753-2051-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8FJX45	G40175-0808	7753-2052-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10FJX45	G40175-1010	7753-2053-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12FJX45	G40175-1212	7753-2054-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE-JS	SD-12C14
16C14-16FJX45	G40175-1616	7753-2055-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16TUBE-JS	SD-16C14
4C14-4FJX90	G40179-0404	7753-2056-5	-	HD-4C14	HE-4C14	0.3525	P-C14-4TUBE	SD-4C14
5C14-5FJX90	G40179-0505	7753-2057-5	-	HD-5C14	HE-5C14	0.4065	P-C14-5TUBE	SD-5C14
6C14-6FJX90	G40179-0606	7753-2058-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TUBE	SD-6C14
8C14-8FJX90	G40179-0808	7753-2043-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8TUBE	SD-8C14
10C14-10FJX90	G40179-1010	7753-2060-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12FJX90	G40179-1212	7753-2061-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE-JS	SD-12C14
16C14-16FJX90	G40179-1616	7753-2062-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16TUBE-JS	SD-16C14
8C14-8ABC-B	G40460-0808B	7753-1036-5	-	HD-8C14	HE-8C14	0.5705	P-C14-8MP-8 & 10ABC	SD-8C14
10C14-8ABC-B	G40460-1008B	7753-1037-5	-	HD-10C14	HE-10C14	0.6755	P-C14-8MP-8 & 10ABC	SD-10C14
10C14-10ABC-B	G40460-1010B	7753-1038-5	-	HD-10C14	HE-10C14	0.6755	P-C14-8MP-8 & 10ABC	SD-10C14
12C14-12ABC-B	G40460-1212B	7753-1039-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12MP-12ABC	SD-12C14
10C14-8STA-B	G40461-1008B	7753-1041-5	-	HD-10C14	HE-10C14	0.6755	P-C14-8TUBE	SD-10C14
10C14-10STA-B	G40461-1010B	7753-1042-5	-	HD-10C14	HE-10C14	0.6755	P-C14-10TUBE	SD-10C14
12C14-12STA-B	G40461-1212B	7753-1043-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TUBE	SD-12C14
6C14-6TBFLX ²	G40543-0606	7753-1025-5	-	HD-6C14	HE-6C14	0.4805	P-C14-6TBFLX	SD-6C14
12C14-12TBFLX ³	G40543-1212	7753-1026-5	-	HD-12C14	HE-12C14	0.8025	P-C14-12TBFLX	SD-12C14
16C14-16TBFLX ³	G40543-1616	7753-1027-5	-	HD-16C14	HE-16C14	1.0465	P-C14-16TBFLX	SD-16C14

¹ Denotes dual seat. ² When swaging, do not keep the flange between the pusher and swage die. ³ When swaging, keep the flange between the pusher and swage die.

Power Crimp® 707



Power Crimp® 707

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

Omnicrimp® 21 / Power Crimp® 3000B

GC32-XD™



Gates Corporation

Visit www.gates.com/ecrimp for hose crimp specs not listed in this catalog.

Calibration Procedures & Adjustment

Power Crimp® 707 Calibration Procedure

NOTE: Check calibration after every 100 crimps.

1. Before initiating calibration procedure, cycle crimper 5 times. To cycle, dial in a setting of 2.00 and run crimper down to shutoff with no die set loaded.
2. Install **"733"** die set to calibrate the machine using an **8G MegaCrimp®** coupling.
3. Set digital readout setting to **5.20**. (Rotating knob on top of switch box clockwise will increase the number; counterclockwise will decrease the number. When changing the setting, always move to a higher number then down to the desired setting. Example: To change from 5.00 to 5.20, move dial up to 6.00 then down to 5.20.) The readout figures may jump a number; i.e. 5.20 to 5.19 or 5.21. This will not affect the crimp OD.
4. Insert coupling to crimp approximately 1/8" below top of die and install die cone. (See photo 1).
5. Slide die cone assembly under ram and depress crimp switch. Release switch immediately when machine stops.
6. Remove coupling and measure crimp diameter, which should measure 1.000"±.003". To properly measure crimp diameter, refer to the Hose Assembly Guide instructions, Item #9, at the beginning of this manual.
7. If coupling is not within 1.000" (± .003") of the crimp diameter, adjust actuator rod (See photo 2).
8. To increase crimp OD – Hold 1-1/16" actuator rod while loosening the 3/4" lock-nut. Rotate actuator rod clockwise (one full turn of actuator rod is approximately 0.024" crimp OD) then tighten lock-nut down. CAUTION: Do not overtighten lock nut.
9. To decrease crimp OD – Hold 1-1/16" actuator rod while loosening 3/4" lock nut. Rotate actuator rod counter clockwise (One full turn of actuator rod is approximately 0.024" crimp OD) then tighten lock-nut down. CAUTION – Do not overtighten lock-nut.
10. Repeat steps 3 through 7 to verify correct crimp OD.



Photo 1



CLOCKWISE

Photo 2

Adjustment Procedure

Should the actual crimp diameter NOT be within the tolerance specified in the Crimp Data Charts, check the calibration of the crimper. If the calibration is correct, a slight adjustment of the digital readout may be necessary. To obtain a smaller crimp diameter, change the digital readout to a smaller number, or vice versa. Changing the digital readout by .05 (Example: 5.50 to 5.55) will change the crimp diameter by .001".

$$\left(\frac{\text{Target Crimp OD} - \text{Measured Crimp OD}}{\text{Published Approx. Setting}} \right) \times 50 + \text{Published Approx. Setting} = \text{Adjusted Setting}$$

Remember to record your *Actual* adjusted crimp setting in the column provided in the crimp data chart.

Hose Size (in)	Hose O.D. (in)	Hose I.D. (in)	Crimp Depth (in)	Crimp Width (in)	Die Size (in)	Die Length (in)	Die Width (in)	Die Height (in)	Die Weight (lb)	Die Part No.	Adjusted Setting
3/8	0.375	0.312	0.015	0.125	0.375	0.125	0.125	0.125	0.125		
1/2	0.500	0.437	0.015	0.125	0.500	0.125	0.125	0.125	0.125		
5/8	0.625	0.562	0.015	0.125	0.625	0.125	0.125	0.125	0.125		
3/4	0.750	0.687	0.015	0.125	0.750	0.125	0.125	0.125	0.125		
1	1.000	0.937	0.015	0.125	1.000	0.125	0.125	0.125	0.125		
1 1/4	1.375	1.312	0.015	0.125	1.375	0.125	0.125	0.125	0.125		
1 1/2	1.500	1.437	0.015	0.125	1.500	0.125	0.125	0.125	0.125		
2	2.000	1.937	0.015	0.125	2.000	0.125	0.125	0.125	0.125		
2 1/2	2.625	2.562	0.015	0.125	2.625	0.125	0.125	0.125	0.125		
3	3.000	2.937	0.015	0.125	3.000	0.125	0.125	0.125	0.125		
3 1/2	3.500	3.437	0.015	0.125	3.500	0.125	0.125	0.125	0.125		
4	4.000	3.937	0.015	0.125	4.000	0.125	0.125	0.125	0.125		
4 1/2	4.500	4.437	0.015	0.125	4.500	0.125	0.125	0.125	0.125		
5	5.000	4.937	0.015	0.125	5.000	0.125	0.125	0.125	0.125		
5 1/2	5.500	5.437	0.015	0.125	5.500	0.125	0.125	0.125	0.125		
6	6.000	5.937	0.015	0.125	6.000	0.125	0.125	0.125	0.125		
6 1/2	6.500	6.437	0.015	0.125	6.500	0.125	0.125	0.125	0.125		
7	7.000	6.937	0.015	0.125	7.000	0.125	0.125	0.125	0.125		
7 1/2	7.500	7.437	0.015	0.125	7.500	0.125	0.125	0.125	0.125		
8	8.000	7.937	0.015	0.125	8.000	0.125	0.125	0.125	0.125		
8 1/2	8.500	8.437	0.015	0.125	8.500	0.125	0.125	0.125	0.125		
9	9.000	8.937	0.015	0.125	9.000	0.125	0.125	0.125	0.125		
9 1/2	9.500	9.437	0.015	0.125	9.500	0.125	0.125	0.125	0.125		
10	10.000	9.937	0.015	0.125	10.000	0.125	0.125	0.125	0.125		

Crimp Tooling

Power Crimp® 707, 700 Series 8-Finger Dies

Die Sets

Die Set	720	721/ 731	722/ 732	733	734	735	737*	739*
Part No.	78920	78943/ 78931	78944/ 78932	78933	78934	78935	78937	78939
Product No.	7482-0920	7482-1217/ 7482-0931	7482-1218/ 7482-0932	7482-0933	7482-0934	7482-0935	7482-0937	7482-0939

* Must Use No-Notch Die Cone.

Specialty and Automotive Dies

Die Set	740	741	742	743	744*	745	746	CC-7C3	CC-7C4
Part No.	78950	78951	78952	78953	78954	78955	78956	78941	78942
Product No.	7482-0947	7482-0941	7482-0942	7482-0943	7482-0944	7482-0945	7482-0946	7482-1122	7482-1123
Use	6AC	8AC	10AC	12AC	Power Steering	Grease Fitting	Misc.	Clamp Collars	Clamp Collars

* Must use No-Notch Die Cone.

GL and GLP Dies

Die Set	771	772	773	774	775	781	782	783
Part No.	78957	78958	78959	78960	78961	78578	78579	78580
Product No.	7482-1347	7482-1348	7482-1359	7482-1360	7482-1361	7482-1231	7482-1232	7482-1233

Die Tooling Supplies (Supplied with new crimpers)

Item	Part No.	Product No.
Notched Die Cone	78736	7482-0239
No-Notched Die Cone	78747	7482-0297
Die Back Up Ring	78727	7482-0115
3oz Jar Molykote G Paste	78755	7482-0311
Digital Caliper	78241	7369-0322



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem	Ferrule		Skive / Buff		Crimp		Crimper			
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
16	BOP	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
4	C5C	3/16	03PC	04PC2F-2	80416	-----	-----	-----	FULL	0.620	731	4.32	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.690	731	7.89	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.690	721	3.98	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	-----	FULL	0.765	731	11.71	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	-----	FULL	0.765	721	6.75	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.860	732	7.30	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.860	722	7.30	
10	C5C	1/2	08PC	10PC2F-2B	80476	-----	-----	-----	FULL	1.050	733	7.78	
12	C5C	5/8	10PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.230	734	9.03	
4	C5E	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	0.660	731	6.36	
5	C5E	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.660	731	6.36	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.795	722	4.17	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.795	732	4.17	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.890	732	8.74	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.890	722	8.74	
10	C5E	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	0.990	733	4.76	
12	C5E	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.140	734	4.59	
6	C12M	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	C12M	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
12	C12M	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	C12M	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	C12M	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
6	C12M-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	C12M-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
12	C12M-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	C12M-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	C12M-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
6	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	722	7.61	
8	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	732	7.61	
8	CM2T	1/2	8G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	733	7.08	
16	CPS	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
12	CPSGS	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	735	13.29	
12	CPSGS-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	735	13.29	
16	CPS-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	EFG3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
20	EFG3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
6	EFG4K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	EFG4K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	733	8.88	
10	EFG4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	EFG4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.00	
16	EFG4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	EFG4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
6	EFG4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.30	
8	EFG4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	733	8.99	
10	EFG4K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	EFG4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	EFG4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	EFG4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
6	EFG5K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	EFG5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	733	8.88	
10	EFG5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	EFG5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	EFG5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
6	EFG5K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	3.96	
8	EFG5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	733	8.99	
10	EFG5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	EFG5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	EFG5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
6	EFG6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	EFG6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	733	8.88	
10	EFG6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	EFG6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	EFG6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
6	EFG6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper		User's Actual Setting
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	
8	EFG6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	733	8.99	
10	EFG6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	EFG6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	EFG6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
3	G1	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	0.620	731	3.47	
3	G1	3/16	03PC	03PC2F-2	80415	0.835	WIRE	-----	FULL	0.620	731	3.47	
3	G1	3/16	Grease	03MPG	-----	0.625	WIRE	-----	0.500	0.450	745	5.80	
3	G1	3/16	Grease	03MPGB	-----	0.625	WIRE	-----	0.500	0.450	V	4.10	
3	G1	3/16	Grease	03MPGB	-----	0.625	WIRE	-----	0.500	0.450	745	5.80	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	731	8.31	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	721	4.00	
4	G1	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.680	731	6.53	
4	G1	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.680	721	2.45	
4	G1	1/4	04PC	04PC2F-2	80416	0.910	WIRE	-----	FULL	0.625	731	4.07	
5	G1	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	722	3.54	
5	G1	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	732	3.54	
5	G1	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.750	721	6.00	
5	G1	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.750	731	10.10	
5	G1	5/16	05PC	05PC2F-2	80417	0.835	WIRE	-----	FULL	0.720	731	8.92	
5	G1	5/16	05PC	05PC2F-2	80417	0.835	WIRE	-----	FULL	0.720	721	4.75	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	722	6.40	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	732	6.40	
6	G1	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.835	722	5.44	
6	G1	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.835	732	5.44	
6	G1	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.735	721	5.50	
6	G1	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.735	731	9.68	
8	G1	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.010	733	5.57	
8	G1	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.960	733	2.95	
8	G1	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	732	10.53	
8	G1	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	722	10.53	
10	G1	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.135	734	4.16	
10	G1	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.100	733	10.00	
10	G1	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	1.075	733	8.74	
12	G1	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	735	5.89	
12	G1	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.275	734	10.56	
12	G1	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.170	734	5.97	
16	G1	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	737 ²	6.65	
16	G1	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.650	736	10.43	
16	G1	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.545	736	5.25	
20	G1	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.050	739 ²	4.25	
20	G1	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	1.975	720 ²	2.35	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	721	4.75	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	731	9.46	
4	G1H	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.685	731	7.03	
4	G1H	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.685	721	3.00	
4	G1H	1/4	04PC	04PC2F-2	80416	0.910	WIRE	-----	FULL	0.620	731	3.82	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	732	6.67	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	722	6.67	
6	G1H	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.845	732	6.22	
6	G1H	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.845	722	6.22	
6	G1H	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.720	731	8.92	
6	G1H	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.720	721	4.75	
8	G1H	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.020	733	6.07	
8	G1H	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.945	732	11.04	
8	G1H	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.945	722	11.04	
8	G1H	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	732	10.53	
8	G1H	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	722	10.53	
10	G1H	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.135	734	4.16	
10	G1H	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.085	733	9.24	
10	G1H	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	1.070	733	8.49	
12	G1H	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	735	5.89	
12	G1H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.275	734	11.11	
12	G1H	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.190	734	6.96	
16	G1H	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	737 ²	6.65	
16	G1H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.635	736	9.69	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		User's Actual Setting
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	
16	G1H	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	1.540	736	5.00	
20	G1H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.050	739 ²	4.25	
20	G1H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	1.975	720 ²	2.35	
8	G2AT-HMP	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	733	7.58	
8	G2AT-HMP	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	732	11.98	
8	G2AT-HMP	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	722	11.98	
8	G2AT-HMP	1/2	08PC	08PC2F-2C	80473	0.970	WIRE	-----	FULL	0.970	732	11.98	
8	G2AT-HMP	1/2	08PC	08PC2F-2C	80473	0.970	WIRE	-----	FULL	0.970	722	11.98	
10	G2AT-HMP	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
10	G2AT-HMP	5/8	10PC	10PC2F-2C	80447	1.187	WIRE	-----	FULL	1.085	733	9.24	
12	G2AT-HMP	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	G2AT-HMP	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.205	734	7.70	
16	G2AT-HMP	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	737 ²	8.28	
16	G2AT-HMP	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	1.585	736	7.22	
3	G2	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	0.655	731	5.25	
3	G2	3/16	03PC	03PC2F-2	80415	0.750	WIRE	-----	FULL	0.655	731	5.60	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	721	5.75	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	731	10.10	
4	G2	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	731	7.55	
4	G2	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	721	3.75	
4	G2	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.655	731	5.60	
5	G2	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	732	4.99	
5	G2	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.72	
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	732	8.57	
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	722	8.57	
6	G2	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.880	722	7.61	
6	G2	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.880	732	7.61	
6	G2	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.775	731	11.72	
6	G2	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.775	721	7.50	
8	G2	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	733	7.58	
8	G2	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	733	3.96	
8	G2	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	733	3.45	
10	G2	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
10	G2	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	734	3.15	
10	G2	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	8.99	
12	G2	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	G2	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	735	3.47	
12	G2	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	734	8.44	
16	G2	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	737 ²	8.28	
16	G2	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.675	736	11.66	
16	G2	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.585	736	7.22	
20	G2	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	739 ²	8.04	
20	G2	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.065	720 ²	6.77	
20	G2	1 1/4	20PC	20PC2F-2	80427	2.187	WIRE	-----	FULL	2.000	720 ²	3.58	
20	G2H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	739 ²	8.04	
20	G2H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.065	720 ²	6.77	
20	G2H	1 1/4	20PC	20PC2F-2	80427	2.187	WIRE	-----	FULL	2.015	720 ²	4.31	
20	G2H-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	739 ²	8.04	
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.730	721	5.25	
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.730	731	9.93	
6	G2L	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	732	7.61	
6	G2L	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	722	7.61	
8	G2L	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	733	7.44	
10	G2L	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	734	5.02	
12	G2L	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.385	735	7.81	
16	G2L	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	737 ²	5.00	
20	G2L	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	739 ²	8.04	
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	731	10.10	
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	721	5.75	
6	G2XH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	722	8.57	
6	G2XH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	732	8.57	
8	G2XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	733	7.58	
10	G2XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
12	G2XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
16	G2XH	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	737 ²	6.65	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
4	G3H	1/4	04PC	04PC2F-2	80416	0.785	0.540	-----	FULL	0.670	731	6.87	
4	G3H	1/4	04PC	04PC2F-2	80416	0.785	0.540	-----	FULL	0.670	721	1.93	
5	G3H	5/16	05PC	05PC2F-2	80417	0.750	0.620	-----	FULL	0.775	721	7.50	
5	G3H	5/16	05PC	05PC2F-2	80417	0.750	0.620	-----	FULL	0.775	731	12.22	
6	G3H	3/8	06PC	06PC2F-2	80418	0.785	0.690	-----	FULL	0.785	722	3.68	
6	G3H	3/8	06PC	06PC2F-2	80418	0.785	0.690	-----	FULL	0.785	732	3.68	
8	G3H	1/2	08PC	10PC2F-2B	80476	0.880	0.900	-----	FULL	1.035	733	7.03	
12	G3H	3/4	12PC	12PC2F-4	80422	1.562	1.200	-----	FULL	1.365	735	6.90	
16	G3H	1	16PC	16PC2F-2	80424	1.500	1.450	-----	FULL	1.615	736	8.85	
20	G3H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.985	720 ²	2.84	
20	G3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
20	G3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
12	G4H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.330	735	5.13	
12	G4H	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	735	4.63	
16	G4H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.700	736	13.05	
16	G4H	1	16PC	16PC2F-4	80425	-----	-----	-----	FULL	1.680	736	12.06	
20	G4H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.010	720 ²	4.07	
10	G4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	G4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	G4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	G4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
6	G4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	G4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
12	G4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	G4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
20	G4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
8	G5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
10	G5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	G5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	735	13.29	
16	G5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
8	G5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
10	G5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	G5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	735	13.29	
16	G5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
6	G6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	G6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
10	G6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	G6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	735	13.29	
16	G6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
6	G6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	733	4.00	
8	G6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	733	9.95	
10	G6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	735	4.18	
12	G6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	735	13.29	
16	G6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
12	GMV	3/4	12G	MegaCrimp	-----	1.375	1.200	1.50	FULL	1.430	735	10.19	
16	GMV	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	737 ²	9.02	
20	GMV	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.110	739 ²	7.38	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	731	8.31	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	721	4.00	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.755	731	10.53	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.755	721	6.25	
6	GT7/GT7NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.865	722	7.19	
8	GT7/GT7NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.020	733	6.07	
12	GT7/GT7NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.330	735	4.68	
16	GT7/GT7NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.680	737 ²	3.03	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	731	10.10	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	721	6.00	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.900	732	9.08	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.900	722	9.08	
8	GT8/GT8NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	733	6.94	
12	GT8/GT8NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.360	735	6.14	
16	GT8/GT8NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.680	737 ²	3.03	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
3	GTH	3/16	03PC	03PC2F-2	80415	0.687	0.410	-----	FULL	0.635	731	5.08	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	731	10.10	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	721	6.00	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	731	12.50	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	721	8.25	
6	GTH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	722	6.63	
8	GTH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	7.03	
10	GTH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.154	734	5.25	
12	GTH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.390	735	8.00	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	721	5.75	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	731	10.10	
4	J2AT ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	731	7.55	
4	J2AT ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	721	3.75	
4	J2AT ²	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.640	731	4.84	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	732	8.81	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	722	8.81	
6	J2AT ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	732	6.89	
6	J2AT ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	722	6.89	
6	J2AT ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	721	6.75	
6	J2AT ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	731	11.21	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	731	10.10	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	721	5.75	
4	J2AT-MTF ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	721	3.75	
4	J2AT-MTF ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	731	7.55	
4	J2AT-MTF ²	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.640	731	4.84	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	722	8.81	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	732	8.81	
6	J2AT-MTF ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	722	6.89	
6	J2AT-MTF ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	732	6.89	
6	J2AT-MTF ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	731	11.21	
6	J2AT-MTF ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	721	6.75	
12	LW	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	LW	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
12	LW-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	735	12.55	
16	LW-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	737 ²	6.00	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
4	M2T	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.27	
4	M2T	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M2T	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	731	4.33	
4	M2T	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	731	4.94	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	722	7.61	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	732	7.61	
6	M2T	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	732	6.65	
6	M2T	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	722	6.65	
6	M2T	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	731	9.68	
6	M2T	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	721	5.50	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	0.810	732	3.53	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	0.810	722	3.53	
8	M2T	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	6.83	
8	M2T	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	1.025	733	6.22	
8	M2T	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	722	10.53	
8	M2T	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	732	10.53	
8	M2T	1/2	08PC-SS	08PC1F-M2SS	85029	-----	-----	-----	FULL	1.000	733	4.69	
10	M2T	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.155	734	5.15	
10	M2T	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	1.110	733	10.50	
10	M2T	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	1.075	733	8.74	
10	M2T	5/8	10PC-SS	10PC1F-M2SS	85030	-----	-----	-----	FULL	1.110	733	10.40	
12	M2T	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	735	6.90	
12	M2T	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	1.330	735	4.48	
12	M2T	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.195	734	7.20	
12	M2T	3/4	12PC-SS	12PC1F-M2SS	85031	-----	-----	-----	FULL	1.330	735	4.31	
16	M2T	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.725	737 ²	4.74	
16	M2T	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	1.680	736	11.91	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem	Ferrule		Skive / Buff		Crimp			Crimper		
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
16	M2T	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	1.510	736	3.52	
16	M2T	1	16PC-SS	16PC1F-M2SS	85032	-----	-----	-----	FULL	1.655	736	10.39	
10	M2TH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	734	4.84	
10	M2TH-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	734	4.84	
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M2T-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M2T-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.52	
4	M2T-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	731	4.33	
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	732	7.88	
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	722	7.88	
6	M2T-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	732	6.95	
6	M2T-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	722	6.95	
6	M2T-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	721	5.50	
6	M2T-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	731	9.68	
8	M2T-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	6.83	
8	M2T-MTF	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	1.025	733	6.22	
8	M2T-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	732	10.53	
8	M2T-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	722	10.53	
10	M2T-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.155	734	5.15	
10	M2T-MTF	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	1.110	733	10.50	
10	M2T-MTF	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	1.075	733	8.74	
12	M2T-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	735	6.90	
12	M2T-MTF	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	1.330	735	5.03	
12	M2T-MTF	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.195	734	7.20	
16	M2T-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.725	737 ²	4.74	
16	M2T-MTF	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	1.680	736	11.91	
16	M2T-MTF	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	1.510	736	3.52	
10	M2TN	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	734	4.84	
8	M2T PLUS	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	7.03	
10	M2T PLUS	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.125	734	3.70	
12	M2T PLUS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	735	6.90	
16	M2T PLUS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	737 ²	4.14	
16	M2T PLUS	1	16G	MegaCrimp	-----	-----	-----	-----	FULL	1.710	737 ²	4.14	
8	M2T PLUS-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	7.03	
10	M2T PLUS-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.125	734	3.70	
12	M2T PLUS-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	735	6.90	
16	M2T PLUS-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	737 ²	4.14	
16	M2T PLUS-MTF	1	16G	MegaCrimp	-----	-----	-----	-----	FULL	1.710	737 ²	4.14	
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	731	8.06	
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	721	3.75	
4	M3K	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	731	6.53	
4	M3K	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	721	2.45	
5	M3K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	722	3.54	
5	M3K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	732	3.54	
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.72	
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	732	4.72	
6	M3K	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	731	11.12	
6	M3K	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	721	7.25	
6	M3K	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	731	8.15	
6	M3K	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	721	4.00	
8	M3K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	733	5.06	
8	M3K	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	722	12.43	
8	M3K	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	732	12.43	
8	M3K	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	732	10.05	
8	M3K	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	722	10.05	
10	M3K	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
10	M3K	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	734	3.15	
10	M3K	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	8.99	
12	M3K	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
12	M3K	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M3K	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	735	3.47	
12	M3K	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	734	8.44	
16	M3K	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	737 ²	8.83	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper		User's Actual Setting
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	
16	M3K	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	736	8.25	
20	M3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	739 ²	4.25	
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	721	3.75	
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	731	8.44	
4	M3K-MTF	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	721	2.45	
4	M3K-MTF	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	731	6.78	
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.99	
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	732	4.99	
6	M3K-MTF	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	721	7.25	
6	M3K-MTF	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	731	11.37	
6	M3K-MTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	731	8.15	
6	M3K-MTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	721	4.00	
8	M3K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	733	5.06	
8	M3K-MTF	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	722	12.73	
8	M3K-MTF	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	732	12.73	
8	M3K-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	722	10.05	
8	M3K-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	732	10.05	
10	M3K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
10	M3K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	734	3.70	
10	M3K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	8.99	
12	M3K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
12	M3K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M3K-MTF	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	735	4.02	
12	M3K-MTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	734	8.44	
16	M3K-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	737 ²	8.83	
16	M3K-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	736	8.25	
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	731	8.44	
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	721	3.75	
5	M3K-XTF	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	732	3.54	
5	M3K-XTF	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	722	3.54	
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.99	
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	732	4.99	
6	M3K-XTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	721	4.00	
6	M3K-XTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	731	8.15	
8	M3K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	733	5.06	
8	M3K-XTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	722	10.05	
8	M3K-XTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	732	10.05	
10	M3K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
10	M3K-XTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	5.89	
12	M3K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
12	M3K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M3K-XTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	734	8.44	
16	M3K-XTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	737 ²	8.17	
16	M3K-XTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	736	8.25	
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	721	3.75	
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	731	7.80	
6	M3KH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	732	4.99	
6	M3KH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.99	
8	M3KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	733	5.06	
10	M3KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	734	5.89	
12	M3KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M3KH	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M4K+	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M4K+	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.37	
4	M4K+	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	731	4.08	
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	722	7.61	
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	732	7.61	
6	M4K+	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	722	7.43	
6	M4K+	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	732	7.13	
6	M4K+	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	731	9.68	
6	M4K+	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	721	5.50	
8	M4K+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	733	8.08	
8	M4K+	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	733	4.00	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
8	M4K+	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	722	11.49	
8	M4K+	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	732	11.49	
10	M4K+	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	734	5.02	
10	M4K+	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	733	10.25	
10	M4K+	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	8.99	
12	M4K+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M4K+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M4K+-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M4K+-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.37	
4	M4K+-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	731	4.33	
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	732	7.61	
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	722	7.88	
6	M4K+-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	722	7.61	
6	M4K+-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	732	7.61	
6	M4K+-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	731	9.68	
6	M4K+-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	721	5.50	
8	M4K+-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	733	8.08	
8	M4K+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	733	4.00	
8	M4K+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	732	11.49	
8	M4K+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	722	11.49	
10	M4K+-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	734	5.02	
10	M4K+-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	733	10.25	
10	M4K+-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	8.99	
12	M4K+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M4K+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
4	M4K+-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M4K+-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.52	
6	M4K+-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	732	7.61	
6	M4K+-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	722	7.61	
8	M4K+-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	6.87	
10	M4K+-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	734	5.02	
12	M4K+-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M4K+-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
8	M4KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.025	733	6.02	
10	M4KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.165	734	5.64	
12	M4KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	M4KH-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
4	M4K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	-----	FULL	0.715	731	8.82	
4	M4K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	-----	FULL	0.715	721	4.50	
4	M4K-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M4K-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.37	
4	M4K-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	731	4.08	
6	M4K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	-----	FULL	0.870	732	7.61	
6	M4K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	-----	FULL	0.870	722	7.61	
6	M4K-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	732	7.61	
6	M4K-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	722	7.61	
6	M4K-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	731	9.68	
6	M4K-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	721	5.50	
8	M4K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	-----	FULL	1.060	733	8.08	
8	M4K-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	733	4.30	
8	M4K-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	732	11.49	
8	M4K-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	722	11.49	
10	M4K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	-----	FULL	1.165	734	5.64	
10	M4K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	733	10.25	
10	M4K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	733	8.99	
12	M4K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	-----	FULL	1.395	735	8.17	
12	M4K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
4	M4K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	-----	FULL	0.715	721	4.50	
4	M4K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	-----	FULL	0.715	731	8.82	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		User's Actual Setting
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	
4	M4K-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.37	
4	M4K-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
6	M4K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	-----	FULL	0.870	732	7.61	
6	M4K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	-----	FULL	0.870	722	7.13	
8	M4K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	-----	FULL	1.035	733	7.03	
10	M4K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	-----	FULL	1.160	734	5.64	
12	M4K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	-----	FULL	1.395	735	8.17	
12	M4K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
6	M4K-XTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	733	7.03	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	731	8.82	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	721	4.50	
4	M5K	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	731	6.27	
4	M5K	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	721	2.19	
4	M5K	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	731	4.33	
4	M5K	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	731	4.94	
5	M5K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.795	722	4.17	
5	M5K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.795	732	4.17	
6	M5K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	732	6.65	
6	M5K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	722	6.95	
8	M5K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	733	7.08	
4	M6K	1/4	04G	MegaCrimp	-----	-----	-----	.93	FULL	0.74	731	10.10	
4	M6K	1/4	04G	MegaCrimp	-----	-----	-----	.93	FULL	0.74	721	5.75	
20	MCPB+-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	739 ²	8.04	
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	731	10.48	
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	721	5.75	
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	732	9.08	
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	722	9.08	
8	MCPB+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	733	8.08	
12	MCPB+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	MCPB+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
16	MCPB+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	737 ²	8.83	
16	MCPB+	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	736	8.25	
20	MCPB+	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	739 ²	8.04	
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	721	5.75	
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	731	10.10	
4	MCPB+-MTF	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	731	7.80	
4	MCPB+-MTF	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.640	731	4.84	
6	MCPB+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	722	9.08	
6	MCPB+-MTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	733	8.08	
6	MCPB+-MTF	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	732	6.89	
6	MCPB+-MTF	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	722	7.19	
6	MCPB+-MTF	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	721	6.75	
6	MCPB+-MTF	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	731	11.21	
8	MCPB+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	733	4.00	
8	MCPB+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.970	733	3.25	
12	MCPB+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	735	8.17	
12	MCPB+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	735	3.26	
16	MCPB+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	737 ²	8.83	
16	MCPB+-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	736	8.25	
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	731	3.75	
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	721	7.80	
6	MEGATECH 250	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	722/32	4.99	
8	MEGATECH 250	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	733	3.96	
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	734	5.02	
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.050	733	7.58	
12	MEGATECH 250	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.340	735	5.64	
16	MEGATECH 250	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.730	737 ²	4.14	
20	MEGATECH 250	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	1.980	720 ²	2.60	
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	731	7.80	
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	721	3.75	
6	MEGATECH 1000	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.99	
6	MEGATECH 1000	3/8	06G	MegaCrimp	-----	-----	-----	-----	FULL	0.810	732	4.99	
8	MEGATECH 1000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	733	3.96	
10	MEGATECH 1000	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	734	5.02	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
12	MEGATECH 1000	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	735	7.50	
16	MEGATECH 1000	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.700	737 ²	4.14	
20	MEGATECH 1000	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.020	720 ²	4.56	
8	MEGATECH 3000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	733	7.58	
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	721	4.00	
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	731	8.31	
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	722	6.40	
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	732	6.40	
8	RFS	1/2	08G	MegaCrimp	-----	-----	-----	0.93	FULL	1.010	733	5.57	
12	RFS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	735	5.89	
16	RFS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	737 ²	6.65	
16	RFS	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.650	736	10.43	
16	RFS	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.545	736	5.25	
3	RLA	3/16	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	722	7.30	
3	RLA	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	0.640	731	5.34	
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	721	4.75	
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	731	9.52	
4	RLA	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.660	731	6.36	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.770	721	7.25	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.770	731	11.97	
5	RLA	5/16	05PC	05PC2F-2	80417	-----	-----	-----	FULL	0.765	731	11.71	
5	RLA	5/16	05PC	05PC2F-2	80417	-----	-----	-----	FULL	0.765	721	6.75	
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	722	7.50	
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	732	7.50	
6	RLA	3/8	06PC	06PC2F-2	80418	-----	-----	-----	FULL	0.770	731	11.97	
6	RLA	3/8	06PC	06PC2F-2	80418	-----	-----	-----	FULL	0.770	721	7.25	
8	RLA	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.080	733	9.29	
8	RLA	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	0.995	733	5.01	
10	RLA	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.140	734	4.59	
10	RLA	5/8	10PC	12PC2F-2	80423	-----	-----	-----	FULL	1.150	734	5.08	
12	RLA	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.430	735	10.19	
12	RLA	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	735	4.63	
16	RLA	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.690	737 ²	3.03	
16	RLA	1	16PC	16PC2F-2	80424	-----	-----	-----	FULL	1.570	736	6.63	
8	S/R-XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	733	5.06	
10	S/R-XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.140	733	12.08	
12	S/R-XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	735	7.50	
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	731	6.53	
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	721	3.00	
6	TR500	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	732	4.35	
6	TR500	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	722	4.35	
8	TR500	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	733	4.30	
10	TR500	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.130	734	11.80	
12	TR500	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.300	735	3.60	
16	TR500	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.580	736	6.92	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable. ³ MPLN Couplings Only.



Hydraulic Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

G4H with PC2F Ferrule Crimp Data

1. For hose size and stem type to be crimped to find proper table to use on the right.
2. Measure hose OD with pi tape and match to Hose OD in table to the right and find the proper data for the crimp.
If the measured hose OD doesn't match a number in the Hose OD column, use the crimp data for the closest lower Hose OD.

Hose		Stem		Ferrule	
Dash Size	Hose	Type	Description	Part No.	
12	G4H	PC	12PC2F-4	80422	

Crimp			Crimper		
	Crimp OD			Digital	User's Actual
Hose OD	+/- .010(in)	Crimp Length	Die	Setting	Setting
1.22	1.39	Full	35	8.17	
1.21	1.38	Full	35	7.66	
1.19	1.36	Full	35	6.65	
1.17	1.34	Full	35	5.64	
1.15	1.32	Full	35	4.63	
1.14	1.31	Full	35	4.12	

Hose		Stem		Ferrule	
Dash Size	Hose	Type	Description	Part No.	
16	G4H	PC	16PC2F-4	80425	

Crimp			Crimper		
	Crimp OD			Digital	User's Actual
Hose OD	+/- .010(in)	Crimp Length	Die	Setting	Ring
1.49	1.72	Full	36	14.64	
1.48	1.71	Full	36	14.14	
1.46	1.69	Full	36	13.16	
1.44	1.67	Full	36	12.17	
1.42	1.65	Full	36	11.18	
1.41	1.64	Full	36	10.69	

Hose		Stem		Ferrule	
Dash Size	Hose	Type	Description	Part No.	
20	G4H	PC	20PC2F-2	80427	

Crimp			Crimper		
	Crimp OD			Digital	User's Actual
Hose OD	+/- .010(in)	Crimp Length	Die	Setting	Setting
1.74	2.00	Full	38	405	
1.73	1.99	Full	38	385	
1.71	1.97	Full	38	345	
1.69	1.95	Full	38	310	
1.67	1.93	Full	38	270	
1.66	1.92	Full	38	250	

GLP Coupling Crimping Instructions

Power Crimp® 707

See Figure 1 for proper alignment of coupling in die prior to crimping.

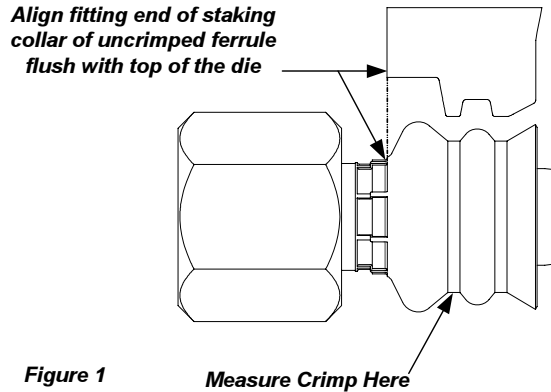


Figure 1 Measure Crimp Here

Dash Size	Hose		Stem Type	Ferrule		Crimp		Crimper		
	Description	Size (in.)		Description	Prod. No.	Insertion Length +/- .03(in)	Crimp OD	Die Set	PC707 Digital Setting	User's Actual Setting
4	LOC	1/4	GLP1	1-pc GLP1	-----	0.66	0.470	771	8.13	
6	LOC	3/8	GLP1	1-pc GLP1	-----	0.77	0.620	772	7.21	
8	LOC	1/2	GLP1	1-pc GLP1	-----	0.72	0.740	773	6.78	
10	LOC	5/8	GLP1	1-pc GLP1	-----	0.75	0.920	774	8.00	
12	LOC	3/4	GLP1	1-pc GLP1	-----	0.75	1.000	775	6.80	
4	LOL	1/4	GLP1	1-pc GLP1	-----	0.66	0.470	771	8.13	
6	LOL	3/8	GLP1	1-pc GLP1	-----	0.77	0.620	772	7.21	
8	LOL	1/2	GLP1	1-pc GLP1	-----	0.72	0.740	773	6.78	
10	LOL	5/8	GLP1	1-pc GLP1	-----	0.75	0.910	774	7.00	
12	LOL	3/4	GLP1	1-pc GLP1	-----	0.98	1.040	775	8.50	
4	M500	1/4	GLP1	1-pc GLP1	-----	0.66	0.47	771	8.13	
6	M500	3/8	GLP1	1-pc GLP1	-----	0.77	0.625	772	7.65	
8	M500	1/2	GLP1	1-pc GLP1	-----	0.72	0.75	773	7.47	
10	M500	5/8	GLP1	1-pc GLP1	-----	0.75	0.91	774	7.00	
12	M500	3/4	GLP1	1-pc GLP1	-----	0.75	1.015	775	6.50	
4	MEGATECH 250	1/4	GLP1	1-pc GLP1	-----	0.66	0.5	771	10.00	
6	MEGATECH 250	3/8	GLP1	1-pc GLP1	-----	0.77	0.64	772	8.52	
8	MEGATECH 250	1/2	GLP1	1-pc GLP1	-----	0.72	0.74	773	6.78	
10	MEGATECH 250	5/8	GLP1	1-pc GLP1	-----	0.75	0.900	774	6.25	
12	MEGATECH 250	3/4	GLP1	1-pc GLP1	-----	0.98	1.020	775	7.65	
4	RLA	1/4	GLP1	1-pc GLP1	-----	0.66	0.5	771	10.00	
6	RLA	3/8	GLP1	1-pc GLP1	-----	0.77	0.66	772	9.83	
8	RLA	1/2	GLP1	1-pc GLP1	-----	0.72	0.74	773	7.38	
10	RLA	5/8	GLP1	1-pc GLP1	-----	0.75	0.92	774	8.00	
12	RLA	3/4	GLP1	1-pc GLP1	-----	0.98	1.04	775	8.50	
8	S/R-XH	1/2	GLP1	1-pc GLP1	-----	0.72	0.76	773	8.68	
10	S/R-XH	5/8	GLP1	1-pc GLP1	-----	0.75	0.92	774	8.00	
12	S/R-XH	3/4	GLP1	1-pc GLP1	-----	0.98	1.08	775	10.50	
4	TR500	1/4	GLP5	1-pc GLP5	-----	0.66	0.47	771	8.13	
6	TR500	3/8	GLP5	1-pc GLP5	-----	0.77	0.61	772	6.55	
8	TR500	1/2	GLP5	1-pc GLP5	-----	0.72	0.72	773	5.50	
10	TR500	5/8	GLP5	1-pc GLP5	-----	0.75	0.88	774	4.25	
12	TR500	3/4	GLP5	1-pc GLP5	-----	0.98	1.02	775	7.65	

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™



GL Coupling Crimping Instructions

Power Crimp® 707

To achieve proper tail length, line up fitting end of ferrule with top of die (see Figure 1) prior to crimping.

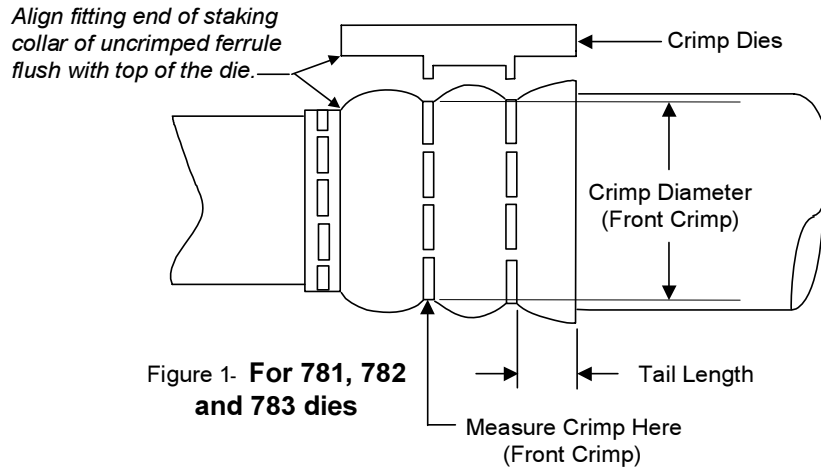


Figure 1- For 781, 782 and 783 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- .10(in.)	Crimp OD	Die Set	PC707 Digital Setting	User's Actual Setting
12	GMV	3/4	12GL	1-pc GL	-----	-----	-----	1.750	0.50	1.12	781	6.70	
16	GMV	1	16GL	1-pc GL	-----	-----	-----	2.125	0.60	1.36	782	7.00	
20	GMV	1 1/4	20GL	1-pc GL	-----	-----	-----	2.250	0.50	1.66	783	7.00	

Clamp Collar Crimping Instructions

Power Crimp® 707

Care must be taken when crimping clamp collars onto a hydraulic hose. If crimp is too tight, hose will be crushed, dramatically reducing its service life. If crimp is too loose, collar could slide along hose's length causing abrasion and eventual hose cover failure.

Remember: Clamp collars must be crimped *before* the hose couplings.

Use the following instructions to determine crimp diameter, which can then be used to find crimping setting in Table 2. The required clamp collar for a specific hydraulic hose is provided in Table 1.

1. Measure hose's outside diameter at the location where clamp collar will be crimped. This can be accomplished by using a pie tape or by using the average hose outside diameter measured with a dial caliper.
2. Obtain crimp diameter by adding hose outside diameter to twice the clamp collar wall thickness (see formula below).

$$\text{Crimp Diameter} = (\text{Hose O.D.}) + [2 \times .065 (\text{Clamp Collar Wall Thickness})]$$

When crimping clamp collar, the crimp die should be located in the center of the collar, which will result in a 1/8" flare on each side of the collar.



Description	Part Number	Product Number	Hydraulic Hose Applications	Length (In.)	PC707 Die
CC1.12	G52000-0210	7334-45805	10M2T, 10G2	2.250	7C3
CC1.25	G52000-0212	7334-45885	12M2T, 12G2, 12M4K	2.000	7C4
CC1.37	G52000-0412	7334-45895	12C12, 12G4K	2.000	7C4

7C3 Die		7C4 Die			
Crimp Diameter	Approx. Setting	Crimp Diameter	Approx. Setting	Crimp Diameter	Approx. Setting
1.050	5.80	1.170	2.65	1.280	7.93
1.055	6.07	1.175	2.89	1.285	8.17
1.060	6.33	1.180	3.13	1.290	8.41
1.065	6.60	1.185	3.37	1.295	8.65
1.070	6.87	1.190	3.61	1.300	8.89
1.075	7.14	1.195	3.85	1.305	9.13
1.080	7.40	1.200	4.09	1.310	9.37
1.085	7.67	1.205	4.33	1.315	9.61
1.090	7.94	1.210	4.57	1.320	9.85
1.095	8.21	1.215	4.81	1.325	10.09
1.100	8.47	1.220	5.05	1.330	10.33
1.105	8.74	1.225	5.29	1.335	10.57
1.110	9.01	1.230	5.53	1.340	10.81
1.115	9.28	1.235	5.77	1.345	11.05
1.120	9.54	1.240	6.01	1.350	11.29
1.125	9.81	1.245	6.25	1.355	11.53
1.130	10.08	1.250	6.49	1.360	11.77
1.135	10.35	1.255	6.73	1.365	12.01
1.140	10.61	1.260	6.97	1.370	12.25
1.145	10.88	1.265	7.21	1.375	12.49
1.150	11.15	1.270	7.45	1.380	12.73
1.155	11.42	1.275	7.69	1.385	12.97
1.160	11.69				
1.165	11.95				



Power Steering Male Flareless Assembly Instructions

Power Crimp® 707

Hose Preparation and Assembly

1. Measure tube O.D.
2. Select proper Male Flareless coupling for application.
3. Determine length of replacement assembly. Measure distance between points where the tubing is to be cut. See Fig. 1.

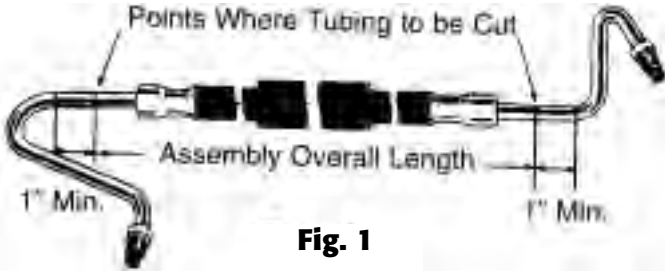


Fig. 1

NOTE: Tubing must be cut at 1" from the start of any bend. Read "Tubing Preparation Assembly" section on next page before cutting.

$$\text{Cut Length} = \text{Assembly Overall Length} - \text{Cutoff Dimension (Coupling 1)} - \text{Cutoff Dimension (Coupling 2)}$$

4. Determine necessary cut length of hose. (Cutoff dimensions are in Table below.)

Cutoff Dimensions For Power Steering Couplings

Part No.	Description	Cutoff (In.)
G50510-0604	6PS-4MFA	.996
G50510-0605	6PS-5MFA	.996
G50510-0606	6PS-6MFA	1.012
G50510-0608	6PS-M8MFA	.934
G50510-0610	6PS-M10MFA	.973
G50510-0612	6PS-M12MFA	.973

5. Cut hose to calculated cut length. End must be square ($\pm 5^\circ$). See Fig. 2.



Fig. 2

6. Mark hose 1-1/4" ($\pm 1/32$ ") from the end of hose with a marker pen. Do not damage hose. See Fig. 3.



Fig. 3

7. Insert a **6PS** coupling into hose until end of ferrule is even with mark. (See Fig. 4.)



Fig. 4

8. Select the proper digital setting for your die set.

P/S Die Setting	744 Die Setting
1.75	4.75

9. Insert properly prepared hose and coupling into crimper. Line up top of die with bottom of stem hex. See Fig. 5 & 6.



Fig. 5

10. Place no-notch cone on die fingers. Press crimp button. When you hear pump shut off, release your finger from crimp button. Crimp is now complete.

Power Steering Male Flareless Assembly Instructions (cont'd)

Power Crimp® 707

11. Measure the crimp O.D. per Fig. 6. Crimp O.D. must be within the specified tolerance.

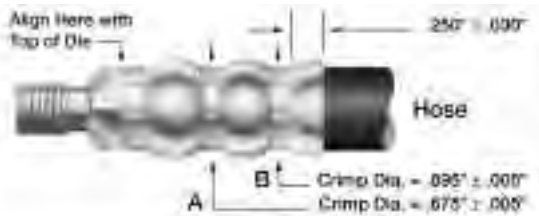


Fig. 6

12. Check assembly to make sure correct overall length has been obtained.
13. Inspect assembly to make sure it has a clean bore and no internal obstructions. Clean if necessary.

Tubing Preparation Assembly

1. Tube End Condition

- Before cutting tube, mark both ends of assembly so it can be properly reassembled. Marks must be made on tubing beyond the point where the tubing will be cut. Use a marker pen to mark the tubing so the surface won't be scratched.
- Tube end must be cut squarely ($\pm 5^\circ$).
- Smooth tube inside and out by removing all burrs and rough edges with steel wool. Clean all metal particles from inside tube.
- Bare end of tube must be long enough for the nut and sleeve to be placed over tube. (1" minimum length before the start of any bend.)
- There must be sufficient tube length for tube end to seat against the shoulder in thread end of stem. (1" minimum length before the start of any bend.)

2. Nut and Sleeve Placement (Tube End)

- Install hex nut over tube, positioned so the shoulder end is placed on tube first. Thread end will then face hose assembly.
- Place sleeve on tube so tapered end will face hose assembly.



3. Connect to Tube End

(Preliminary Connection)

- Insert tube into thread end of hose assembly until it bottoms against shoulder.



- Screw hex nut to thread end until finger tight.
- Using a wrench, tighten approximately 1 turn ($\pm 1/4$ turn) to preset.

4. Inspect

- Disassemble and inspect compression of the sleeve on tube. Sleeve must be compressed sufficiently on tube so it is not easily removed.
- Tube end will be slightly distorted from butting against internal shoulder.

NOTE: Makeup of correct connection is critical for proper use and safety.

5. Final Assembly

- Insert tube into thread end of hose assembly.
 - With a wrench, tighten down until a sudden increase in torque is felt. Turn nut approximately 1/6 turn (but no more than 1/3 turn) to create a seal between sleeve, tube and seat of stem.
- CAUTION:** Overtightening may cause stripped threads and/or collapse of tube.
- Before tightening second end, line up two marks on the tubing to assure proper orientation.



Gates PolarSeal® Hose

G45 Series (ACA) Coupling Crimping Instructions

Power Crimp® 707

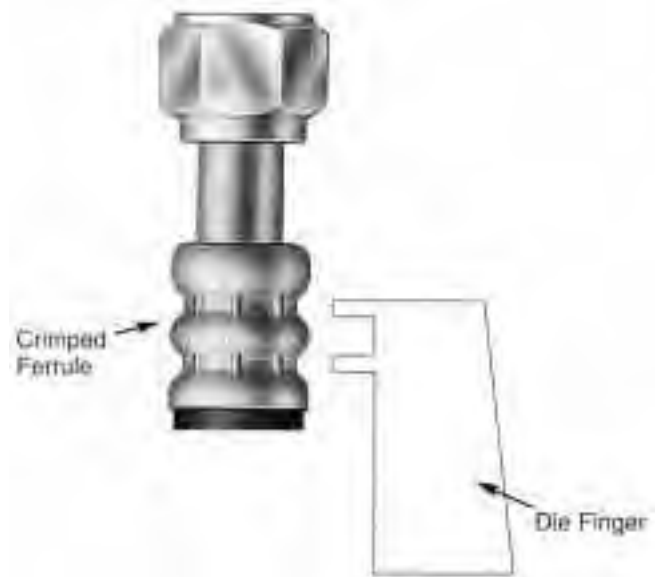
General

Gates recommends only those hose and coupling combinations specified in the Gates Hydraulic Products Catalogs. Gates disclaims any liability for any hose assemblies which have not been produced in conformance with Gates' assembly recommendations.

Swaging

Changing Digital Readout

Rotating the knob on top of switch box clockwise will increase the number; counterclockwise will decrease the number. When changing the setting, always move to a higher number then down to the desired setting. Example: To change from 5.00 to 5.50, move dial up to 6.00 then down to 5.50.



Power Crimp® 707

Crimp Diameter

Should the actual crimp diameter NOT be within the recommended crimp tolerance, check the proper calibration. (See Operator's Manual.) If the calibration is correct, a slight adjustment to the setting or digital readout may be necessary. To obtain a smaller crimp diameter, change setting or digital readout to a larger number.

Changing the digital readout by .05 (Example 5.50 to 5.55) will change the crimp diameter by .001".

MobileCrimp® 4-20

IMPORTANT

To assure a quality assembly, check the FIRST assembly of each run. Measure the crimped O.D. and compare it to the figure listed in the "Crimp Diameter" column.

If ACTUAL crimped dimensions are within specification, you have made a good assembly.

OmniCrimp® 21 / Power Crimp® 3000B

Hose		Fitting Type	Crimp Diameter (±.010")	Ferrule Position	Letter Series		700 Series		Actual Crimper Setting
Type	I.D. (In.)				Die	Setting	Die	Setting	
6AC134a	5/16	6ACA	.690	Centered	W	5.60	740	6.10	
8AC134a	13/32	8ACA	.780	Centered	X	5.90	741	6.55	
10AC134a	1/2	10ACA	.890	Centered	Y	5.50	742	6.25	
12AC134a	5/8	12ACA	1.020	Centered	Z	6.00	743	6.50	

GC32-XD™

Automotive Service Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem	Ferrule		Skive/Buf		Crimp			Crimper		
Dash Size	Description	Size (In.)	Type	Descr.	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	Approx. Digital Readout ¹	User's Actual Setting
4	Charter® Air Hose	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.725	731	9.67	
6	Charter® Air Hose	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.800	732	4.41	
8	Charter® Air Hose	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.025	733	6.52	
4	Multi-Use 1-Braid (19B)	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.648	731	5.74	
6	Multi-Use 1-Braid (19B)	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.770	731	11.97	
8	Multi-Use 1-Braid (19B)	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	0.995	732	13.80	
4	Multi-Use 2-Braid (19B)	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.680	731	7.38	
6	Multi-Use 2-Braid (19B)	3/8	6PC	PC2F-4	80462	-----	-----	-----	FULL	0.885	732	8.50	
5	Multi-Use 2-Braid (19B)	5/16	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.745	731	10.69	
8	Multi-Use 2-Braid (19B)	1/2	8PC	PC2F-4	80463	-----	-----	-----	FULL	1.065	733	8.34	
4	Safety Stripe® Air Hose	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.725	731	9.67	
6	Safety Stripe® Air Hose	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.800	732	4.41	
8	Safety Stripe® Air Hose	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.025	733	6.52	

LP350 Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem	Ferrule		Skive/Buf		Crimp			Crimper		
Dash Size	Type	Size (In.)	Type	Description	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	Appx. Digital Read-out ¹	User's Actual Setting
4	LP350	1/4	PC	4PC2F-2	80416	-	-	-	FULL	0.670	721	2.93	
4	LP350	1/4	PC	4PC2F-2	80416	-	-	-	FULL	0.670	731	6.87	
6	LP350	3/8	PC	6PC2F-2	80418	-	-	-	FULL	0.780	721	8.66	
6	LP350	3/8	PC	6PC2F-2	80418	-	-	-	FULL	0.780	731	12.45	
8	LP350	1/2	PC	8PC2F-2	80419	-	-	-	FULL	0.995	733	5.86	
12	LP350	3/4	PC	12PCBHB-1F	-	-	-	-	FULL	1.315	735	3.72	
16	LP350	1	PC	16PC2F-4	80425	-	-	-	FULL	1.625	736	9.35	
20	LP350	1	PC	20PC2F-4	80426	-	-	-	FULL	2.040	739 ²	3.74	

PowerClean™ Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose				Stem	Ferrule		Skive/Buf		Crimp			Crimper		
Dash Size	Type	Size (In.)	Work. Press. (psi)	Type	Description	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	Appx. Digital Read-out ¹	User's Actual Setting
8	PC2500	1/2	2500	G	MegaCrimp®	-	-	-	1.25	FULL	1.010	733	5.57	
6	PC3000	3/8	3000	G	MegaCrimp®	-	-	-	0.93	FULL	0.845	722/732	6.40	
4	PC3500	1/4	3500	G	MegaCrimp®	-	-	-	0.93	FULL	0.705	721	4.76	
4	PC3500	1/4	3500	G	MegaCrimp®	-	-	-	0.93	FULL	0.705	731	8.31	
6	PC4000	3/8	4000	G	MegaCrimp®	-	-	-	0.93	FULL	0.845	722/732	6.40	
8	PC4000	1/2	4000	G	MegaCrimp®	-	-	-	1.25	FULL	1.050	733	7.58	
6	PC5000	3/8	5000	G	MegaCrimp®	-	-	-	0.93	FULL	0.890	722/732	8.57	
4	PC6000	1/4	6000	G	MegaCrimp®	-	-	-	0.93	FULL	0.740	721	6.59	
4	PC6000	1/4	6000	G	MegaCrimp®	-	-	-	0.93	FULL	0.740	731	10.10	

¹ See Adjustment Procedure at beginning of PC 707 section. ² Must use No-Notch Die Cone, AA and 720 dies are interchangeable.



Industrial Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper		
Size (in)	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.93	732	10.30	
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.93	722	10.30	
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.93	732	10.30	
3/4	1000MP/ Mine Spray	1000	12	PC	12PC2F-2	80423	1.63	WIRE	-	Full	1.19	734	7.02	
3/4	1000MP/ Mine Spray	1000	12	PC	12PC2F-2	80423	1.63	WIRE	-	Full	1.19	734	7.02	
3/4	1000MP/ Mine Spray	1000	12	G	MegaCrimp®	-	-	-	1.50	Full	1.345	735	5.54	
3/4	1000MP/ Mine Spray	1000	12	G	MegaCrimp®	-	-	-	1.50	Full	1.345	735	5.54	
1	1000MP/ Mine Spray	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	1.54	736	4.95	
1	1000MP/ Mine Spray	1000	16	G	MegaCrimp®	-	-	-	1.75	Full	1.745	737	5.73	
1	1000MP/ Mine Spray	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	1.54	736	4.95	
1	1000MP/ Mine Spray	1000	16	G	MegaCrimp®	-	-	-	1.75	Full	1.745	737	5.73	
1 1/4	1000MP/ Mine Spray	1000	20	G	MegaCrimp®	-	-	-	1.75	Full	2.045	739	4.00	
1 1/4	1000MP/ Mine Spray	1000	20	PC	20PC2F-2	80427	1.12	WIRE	-	Full	1.88	737	13.20	
1 1/4	1000MP/ Mine Spray	1000	20	PC	20PC2F-2	80427	1.12	WIRE	-	Full	1.88	737	13.20	
1/4	119B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	731	5.74	
1/4	119B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.76	731	11.46	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	0.85	722	6.82	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	0.85	732	6.82	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	0.88	732	8.26	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	0.88	722	8.26	
1/2	119B	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.99	733	4.76	
1/2	119B	500	8	PC	10PC2F-2B	80476	-	-	-	Full	1.02	733	8.59	
3/4	119B	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.3	734	12.44	
3/4	119B	500	12	PC	12PC2F-4	80422	-	-	-	Full	1.365	735	6.88	
1	119B	250	16	PC	16PC2F-2	80424	-	-	-	Full	1.63	736	9.45	
1	119B	500	16	PC	16PC2F-4	80425	-	-	-	Full	1.675	736	11.58	
3/16	19B	500	3	PC	3PC2F-2	80415	-	-	-	Full	0.635	731	5.08	
1/4	19B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	731	5.74	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.68	721	3.45	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.68	731	7.38	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	0.76	721	7.63	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	0.76	731	11.18	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	0.745	721	6.85	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	0.745	731	10.69	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.77	721	8.15	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.77	731	11.97	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	0.885	722	8.50	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	0.885	732	8.50	
1/2	19B	250	8	PC	8PC2F-2	80419	-	-	-	Full	1.02	733	5.97	
1/2	19B	500	8	PC	8PC2F-4	80463	-	-	-	Full	1.08	733	8.99	
5/8	19B	250	10	PC	10PC2F-2C	80447	-	-	-	Full	1.095	733	10.04	
5/8	19B	500	10	PC	10PC1FA	80436	-	-	-	Full	1.14	734	4.45	
3/4	19B	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.3	734	12.44	
3/4	19B	500	12	PC	12PC1FA	80437	-	-	-	Full	1.365	735	6.88	
1	19B	250	16	PC	16PC2F-2	80424	-	-	-	Full	1.56	736	5.92	
1	19B	500	16	PC	16PC2F-4	80425	-	-	-	Full	1.675	736	11.58	
1 1/4	19B	250	20	PC	20PC2F-4	80426	-	-	-	Full	1.99	7202	3.18	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	721	3.19	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	731	7.12	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.79	722	3.93	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.79	732	3.93	
1/2	20B-HB	350	8	PC	10PC2F-2B	80476	-	-	-	Full	1.065	733	8.54	
3/4	20B-HB	350	12	PC	12PCBHB1F	-	-	-	-	Full	1.355	735	6.40	
1	20B-HB	350	16	PC	16PC2F-4	80425	-	-	-	Full	1.665	736	11.32	
1 1/4	20B-HB	350	20	PC	20PC2F-4	80426	-	-	-	Full	2.04	739	3.74	
1/4	319MB	1000	4	PC	4PC2F-2	80416	0.75	WIRE	-	Full	0.64	731	4.74	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.69	WIRE	-	Full	0.69	721	3.97	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.69	WIRE	-	Full	0.69	731	7.54	
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.94	722	10.60	
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.94	732	10.60	
3/4	319MB	1000	12	PC	12PC2F-4	80422	1.56	WIRE	-	Full	1.315	735	5.20	
1	319MB	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	1.545	736	5.20	

¹ See Adjustment Procedure at beginning of PC 707 section. ² For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper		
Size (in)	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
1 1/4	319MB	1000	20	PC	20PC2F-2	80427	2.19	WIRE	-	Full	1.88	737	13.20	
1/3	3217HP	1000	5	PC	5PC2F-2	80417	-	-	-	Full	0.775	721	8.41	
1/3	3217HP	1000	5	PC	5PC2F-2	80417	-	-	-	Full	0.775	731	12.22	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	721	3.19	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	731	7.12	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.67	721	2.93	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.67	731	6.87	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.77	721	8.15	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.77	731	11.97	
3/8	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.8	722	4.41	
3/8	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.8	732	4.41	
1/2	6B	200	8	PC	8PC2F-2	80419	-	-	-	Full	1	733	5.82	
1/2	6B	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.98	733	4.83	
1/2	6B	315	8	PC	8PC2F-4	80463	-	-	-	Full	1.085	733	9.29	
3/4	6B	250	12	PC	12PC2F-2	80423	-	-	-	Full	1.24	734	9.53	
3/4	6B	315	12	PC	12PC2F-4	80422	-	-	-	Full	1.37	735	7.33	
1	6B	315	16	PC	16PC2F-4	80425	-	-	-	Full	1.71	737	3.97	
1 1/4	6B	200	20	PC	20PC2F-2	80427	-	-	-	Full	1.995	7202	3.29	
1/4	Adapta Flex™	200	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	731	5.74	
1/4	Adapta Flex™	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	731	5.74	
1/4	Adapta Flex™	300	4	PC	4PC2F-2	80416	-	-	-	Full	0.685	731	5.60	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	0.725	721	5.80	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	0.725	731	9.67	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.75	721	7.11	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.75	731	10.95	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.775	721	8.41	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.775	731	12.22	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.8	722	4.41	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.8	732	4.41	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	-	-	-	Full	0.99	732	13.56	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	-	-	-	Full	0.99	722	13.56	
1/2	Adapta Flex™	250	8	PC	8PC2F-2	80419	-	-	-	Full	1	733	5.82	
1/2	Adapta Flex™	300	8	PC	8PC2F-2	80419	-	-	-	Full	1	733	5.82	
5/8	Adapta Flex™	200	10	PC	12PC2F-2	80423	-	-	-	Full	1.125	734	3.82	
5/8	Adapta Flex™	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.125	734	3.82	
3/4	Adapta Flex™	200	12	PC	12PC2F-2	80423	-	-	-	Full	1.32	734	10.52	
3/4	Adapta Flex™	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.35	735	6.41	
3/4	Adapta Flex™	300	12	PC	12PC2F-4	80422	-	-	-	Full	1.35	735	6.41	
1	Adapta Flex™	150	16	PC	16PC2F-2	80424	-	-	-	Full	1.6	736	7.97	
1	Adapta Flex™	200	16	PC	16PC2F-4	80425	-	-	-	Full	1.65	736	10.40	
1	Adapta Flex™	300	16	PC	16PC2F-4	80425	-	-	-	Full	1.655	736	10.70	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	0.785	722	3.68	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	0.785	732	3.68	
1/2	Cyclone™	1000	8	PC	10PC2F-2B	80476	-	-	-	Full	1.04	733	7.08	
3/4	Cyclone™	1000	12	PC	12PC2F-4	80422	-	-	-	Full	1.35	735	6.41	
1/4	Duro Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.655	731	6.10	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	0.72	721	5.54	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	0.72	731	9.42	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.82	722	5.37	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.82	732	5.37	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.845	722	6.57	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.845	732	6.57	
1/2	Duro Flex®	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	733	5.88	
1/2	Duro Flex®	300	8	PC	10PC2F-2B	80476	-	-	-	Full	1.07	733	9.35	
5/8	Duro Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.185	734	6.77	
5/8	Duro Flex®	300	10	PC	12PC2F-2	80423	-	-	-	Full	1.18	734	6.51	
3/4	Duro Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.356	735	6.63	
3/4	Duro Flex®	300	12	PC	12PC2F-4	80422	-	-	-	Full	1.3	734	12.49	
1	Duro Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	1.716	737	4.30	
1 1/4	Duro Flex®	200	20	PC	20PC2F-2	80427	-	-	-	Full	1.995	7202	3.29	
1/2	Heat Master® (Aramid)*	500	8	PC	8PC2F-4	80463	-	-	-	Full	1.115	733	10.75	
3/4	Heat Master® (Aramid)*	500	12	PC	12PCBHB1F	-	-	-	-	Full	1.35	735	6.14	

¹ See Adjustment Procedure at beginning of PC 707 section. ² For aramid-reinforced Heatmaster® hose only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

Omnicrimp® 21 / Power Crimp® 3000B

GC32-XD™

Industrial Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper		
Size (in)	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
1/4	LP350	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.67	721	2.93	
1/4	LP350	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.67	731	6.87	
3/8	LP350	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.78	721	8.66	
3/8	LP350	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.78	731	12.45	
1/2	LP350	350	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	733	5.86	
3/4	LP350	350	12	PC	12PCBHB-1F	-	-	-	-	Full	1.315	735	3.72	
1	LP350	350	16	PC	16PC2F-4	80425	-	-	-	Full	1.625	736	9.35	
1 1/4	LP350	350	20	PC	20PC2F-4	80426	-	-	-	Full	2.04	739	3.74	
1/2	PC2500	2500	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	0.94	722	10.53	
1/2	PC2500	2500	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	0.94	732	10.53	
1/2	PC2500	2500	8	PC	8PC1FA	80435	-	-	-	Full	0.96	733	2.95	
1/2	PC2500	2500	8	PC	8PC1FS	80485	-	-	-	Full	0.96	733	2.95	
1/2	PC2500	2500	8	G	MegaCrimp®	-	-	-	1.25	Full	1.01	733	5.57	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	731	9.68	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	732	5.44	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	732	5.44	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	721	6.33	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	722	5.44	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	722	5.44	
3/8	PC3000	3000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	732	6.40	
3/8	PC3000	3000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	722	6.40	
1/4	PC3500	3500	4	PC	4PC2F-2	80416	0.910	WIRE	-	Full	0.625	731	4.07	
1/4	PC3500	3500	4	G	MegaCrimp®	-	-	-	0.93	Full	0.705	731	8.31	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	0.68	731	6.53	
1/4	PC3500	3500	4	G	MegaCrimp®	-	-	-	0.93	Full	0.705	721	4.76	
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	0.68	721	3.45	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	0.68	721	3.45	
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	0.68	731	6.53	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	722	5.44	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	732	5.44	
3/8	PC4000	4000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	732	6.40	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	732	5.44	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	731	9.68	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	722	5.44	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	721	6.33	
3/8	PC4000	4000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	722	6.40	
1/2	PC4000	4000	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	0.97	733	3.45	
1/2	PC4000	4000	8	PC	8PC1FA	80435	-	-	-	Full	0.98	733	3.96	
1/2	PC4000	4000	8	PC	8PC1FS	80485	-	-	-	Full	0.98	733	3.96	
1/2	PC4000	4000	8	G	MegaCrimp®	-	-	-	1.25	Full	1.05	733	7.58	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	0.88	732	7.61	
3/8	PC5000	5000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.89	732	8.57	
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	0.88	732	7.61	
3/8	PC5000	5000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.89	722	8.57	
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	0.88	722	7.61	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	0.88	722	7.61	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.785	WIRE	-	Full	0.775	721	8.41	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.785	WIRE	-	Full	0.775	731	11.72	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	0.7	721	4.50	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	0.7	721	4.50	
1/4	PC6000	6000	4	G	MegaCrimp®	-	-	-	0.93	Full	0.74	721	6.59	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.785	WIRE	-	Full	0.685	731	5.60	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	0.7	731	7.55	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	0.7	731	7.55	
1/4	PC6000	6000	4	G	MegaCrimp®	-	-	-	0.93	Full	0.74	731	10.10	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.785	WIRE	-	Full	0.685	721	3.71	
3/16	Premo Flex®	250	3	PC	3PC2F-2	80415	-	-	-	Full	0.655	731	6.10	
1/4	Premo Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.645	731	5.59	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	731	7.12	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	721	3.19	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.72	731	9.42	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.72	721	5.54	

¹ See Adjustment Procedure at beginning of PC 707 section. ² For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

PC 707, 700 Series (8 Finger) Dies

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper		
Size (in)	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	0.755	721	7.37	
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	0.755	731	11.20	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.755	721	7.37	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.755	731	11.20	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	0.815	722	5.13	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	0.815	732	5.13	
1/2	Premo Flex®	250	8	PC	8PC1FA	80435	-	-	-	Full	0.98	733	4.83	
1/2	Premo Flex®	315	8	PC	8PC1FA	80435	-	-	-	Full	0.995	733	5.88	
1/2	Premo Flex®	315	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	733	5.88	
5/8	Premo Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.145	734	4.75	
5/8	Premo Flex®	315	10	PC	10PC1FA	80436	-	-	-	Full	1.12	734	3.60	
3/4	Premo Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.35	735	6.41	
3/4	Premo Flex®	315	12	PC	12PC2F-4	80422	-	-	-	Full	1.345	735	6.22	
1	Premo Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	1.675	736	11.58	
1 1/4	Premo Flex®	250	20	PC	20PC2F-4	80426	-	-	-	Full	1.99	7202	3.18	
1/4	Terminator®	501	4	PC	4PC2F-2	80416	-	-	-	Full	0.68	721	3.45	
1/4	Terminator®	501	4	G	MegaCrimp®	-	-	-	0.94	Full	0.74	721	6.59	
1/4	Terminator®	501	4	PC	4PC2F-2	80416	-	-	-	Full	0.68	731	7.90	
1/4	Terminator®	501	4	G	MegaCrimp®	-	-	-	0.94	Full	0.74	731	10.54	
3/8	Terminator®	501	6	PC	6PC2F-4	80462	-	-	-	Full	0.87	722	7.78	
3/8	Terminator®	501	6	G	MegaCrimp®	-	-	-	0.94	Full	0.92	722	10.39	
3/8	Terminator®	501	6	PC	6PC2F-4	80462	-	-	-	Full	0.87	732	7.78	
3/8	Terminator®	501	6	G	MegaCrimp®	-	-	-	0.94	Full	0.92	732	10.39	
1/2	Terminator®	501	8	PC	8PC2F-4	80463	-	-	-	Full	1.045	733	8.09	
1/2	Terminator®	501	8	G	MegaCrimp®	-	-	-	1.25	Full	1.06	733	7.33	
3/4	Terminator®	501	12	PC	12PC2F-4	80422	-	-	-	Full	1.36	734	6.76	
3/4	Terminator®	501	12	G	MegaCrimp®	-	-	-	1.50	Full	1.43	735	9.50	
1	Terminator®	501	16	G	MegaCrimp®	-	-	-	1.75	Full	1.785	737	8.06	
1	Terminator®	501	16	PC	16PC2F-4	80425	-	-	-	Full	1.66	736	10.90	
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	-	-	-	Full	0.75	731	10.65	
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	-	-	-	Full	0.75	721	6.20	
1/2	Thermo AG® 570	570	8	PC	8PC2F-2	80418	-	-	-	Full	0.96	733	2.95	
3/4	Thermo AG® 570	570	12	PC	12PC2F-4	80422	-	-	-	Full	1.29	735	3.35	
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	-	-	-	Full	0.78	722	4.00	
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	-	-	-	Full	0.78	732	4.00	
1/2	Thermo AG® 800	800	8	PC	8PC2F-2	80418	-	-	-	Full	0.96	733	2.95	
3/4	Thermo AG® 800	800	12	PC	12PC2F-4	80422	-	-	-	Full	1.315	735	5.00	

¹ See Adjustment Procedure at beginning of PC 707 section. ² For aramid-reinforced Heatmaster® hose only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

Omnicrimp® 21 / Power Crimp® 3000B

GC32-XD™

MobileCrimp® 4-20

Digital Dial



Positive Stop



Mobile Crimp® 4-20

Calibration Procedures & Adjustment

MobileCrimp® 4-20 Calibration Procedures

NOTE: Calibration required for MobileCrimp® 4-20 Digital Dial crimper model only.
(For more detail, see MobileCrimp® 4-20 Digital Dial Operator's Manual.)



Photo 1



Photo 2

1. Before initiating calibration procedure, cycle crimper 5 times. To cycle, dial in a setting of 200 and run crimper down to shutoff with no die set loaded.
2. Place the **MC33** die into the die cone and install pressure plate.
3. Insert an **8G MegaCrimp®** coupling into die set. (See Photo 1.)
4. Turn the knob to a setting of **245**. (Rotating the knob on front of switch box clockwise will increase the number; counterclockwise will decrease the number. When changing the setting, always move to a higher number then down to the desired setting. Example: To change from 200 to 245, move dial up to 300 then down to 245.)
5. Engage pump and complete crimp.
6. Remove coupling and measure crimp diameter, which should measure 1.000"±.003". To properly measure crimp diameter, refer to Hose Assembly Guide instructions, Item #9, at the beginning of this manual.
7. If crimp diameter is within this range, no adjustment is necessary.
8. If the crimp diameter is not within this range, the crimper must be calibrated.
 - a. To get a smaller crimp diameter – change the setting to a smaller number.
 - b. To get a larger crimp diameter – change the setting to a larger number.For every .001" change in crimp diameter, change setting by 002. For example, to increase the crimp diameter by .005", increase your setting by 010.
9. Turn knob to this new setting and crimp a new coupling.
10. After the correct diameter is achieved, pull the plastic cap from the knob. Loosen the two (2) set screws in the brass knob using a .05" Allen wrench approximately 1/4 to 1/2 turn. (See Photo 2.)
11. Turn brass knob either clockwise or counterclockwise to get setting back to **245**.
12. Tighten set screws and replace plastic cap.
13. Crimper is now calibrated.

Adjustment Procedure

Should actual crimp diameter NOT be within tolerance specified in Crimp Data Charts, check crimper calibration. If calibration is correct, a slight adjustment of the digital readout may be necessary. To obtain a smaller crimp diameter, change the digital readout to a smaller number, or vice versa. Changing the digital readout by 002 (Example: 245 to 247) will increase the crimp diameter by .001".

Remember to record your *Actual* adjusted crimp setting in the column provided in the crimp data chart.

Hydraulic Hose Crimp Data
MC4-20 Digital Dial and Piston Stop Crimpers

Hose Size	Part No.	Crimp Type	Crimp Diameter	Crimp Length	Crimp Width	Crimp Height	Crimp Weight	Crimp Volume	Crimp Area	Crimp Perimeter	Crimp Data	
											Actual	Adjusted
1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
3/4"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
1"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
1 1/4"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
1 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
2 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
3"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
3 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
4"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
4 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
5"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
5 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
6"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
6 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
7"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
7 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
8"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
8 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
9"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
9 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
10"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
10 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
11"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
11 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
12"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
12 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
13"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
13 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
14"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
14 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
15"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
15 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
16"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
16 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
17"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
17 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
18"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
18 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
19"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
19 1/2"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		
20"	MC4-20	MC33	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"	1.000"		



Crimper Tooling

MobileCrimp® 4-20 Digital Dial (DD) and Positive Stop (PS)

General

Die Sets

Die Set	MC21/ MC31	MC22/ MC32	MC33	MC34	MC35	MC37	MC39
Part No.	78558/ 78468	78559/ 78469	78470	78471	78472	78474	78476
Product No.	7482-1220/ 7482-1018	7482-1221/ 7482-1019	7482-1020	7482-1021	7482-1022	7482-1024	7482-1026

Swaging

Power Crimp® 707

Specialty and Automotive Dies

Die Set	MC40	MC41	MC42	MC43	MC44	MC45	MC47	MCC3	MCC4
Part No.	78431	78432	78433	78434	78452	78497	78499	78590	78591
Product No.	7482-1140	7482-1141	7482-1142	7482-1143	7482-1002	7482-1145	7482-1273	7482-0981	7482-0982
Use	6AC134a	8AC134a	10AC134a	12AC134a	Power Steering	Grease Fitting	Misc.	Clamp Collars	Clamp Collars

MobileCrimp® 4-20

GL and GLP Dies

Die Set	MC71	MC72	MC73	MC74	MC75	MC81	MC82	MC83
Part No.	78560	78561	78562	78563	78564	78573	78574	78575
Product No.	7482-1344	7482-1345	7482-1356	7482-1357	7482-1358	7482-1227	7482-1228	7482-1229

OmniCrimp® 21 / Power Crimp® 3000B

Die Tooling Supplies

Item	Part No.	Product No.
3oz Jar Molykote G Paste	78755	7482-0311
Digital Caliper	78241	7369-0322

GC32-XD™



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper			
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	User's Actual Setting
16	BOP	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
4	C5C	3/16	03PC	04PC2F-2	80416	-----	-----	-----	FULL	0.620	MC31	195	W5	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.690	MC31	335	R3	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.690	MC21	205	B5	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	-----	FULL	0.765	MC31	485	R1	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	-----	FULL	0.765	MC21	340	B3	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.860	MC22	305	R3	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.860	MC32	305	R3	
10	C5C	1/2	08PC	10PC2F-2B	80476	-----	-----	-----	FULL	1.050	MC33	340	W3	
12	C5C	5/8	10PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.230	MC34	375	R2	
4	C5E	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	0.660	MC31	275	W4	
5	C5E	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.660	MC31	275	W4	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.795	MC22	175	R5	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.795	MC32	175	R5	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.890	MC22	370	B3	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.890	MC32	370	B3	
10	C5E	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	0.990	MC33	225	R4	
12	C5E	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.140	MC34	200	B5	
6	C12M	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	C12M	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
12	C12M	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	C12M	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
20	C12M	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	230160	B5	
6	C12M-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	C12M-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
12	C12M-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	C12M-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
20	C12M-MTF	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	160	B5	
6	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	-----	FULL	0.880	MC22	345	W3	
6	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	-----	FULL	0.880	MC32	345	W3	
8	CM2T	1/2	8G	MegaCrimp	-----	-----	-----	-----	FULL	1.040	MC33	325	R3	
16	CPS	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
16	CPS-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
12	CPSGS	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	MC35	540	W1	
12	CPSGS-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	MC35	540	W1	
20	EFG3K	1 1/4	20MGS	20MGS-4	G20995-0420	-----	-----	-----	FULL	2.050	MC39	160	B5	
20	EFG3K-MTF	1 1/4	20MGS	20MGS-4	G20995-0420	-----	-----	-----	FULL	2.050	MC39	160	B5	
6	EFG4K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	EFG4K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	MC33	374	R2	
10	EFG4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	EFG4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	EFG4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
20	EFG4K	1 1/4	20MGS	20MGS-4	G20995-0420	-----	-----	-----	FULL	2.050	MC39	160	B5	
6	EFG4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	EFG4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	MC33	374	R2	
10	EFG4K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	EFG4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	EFG4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
20	EFG4K-MTF	1 1/4	20MGS	20MGS-4	G20995-0420	-----	-----	-----	FULL	2.050	MC39	160	B5	
6	EFG5K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	EFG5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	MC33	374	R2	
10	EFG5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	EFG5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	EFG5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
6	EFG5K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	EFG5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	MC33	374	R2	
10	EFG5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	EFG5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	EFG5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
6	EFG6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	EFG6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	MC33	374	R2	
10	EFG6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	EFG6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	EFG6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper			
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	User's Actual Setting
6	EFG6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	EFG6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	MC33	374	R2	
10	EFG6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	EFG6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	EFG6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
3	G1	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	0.620	MC31	195	W5	
3	G1	3/16	03PC	03PC2F-2	80415	0.835	WIRE	-----	FULL	0.620	MC31	195	W5	
3	G1	3/16	Grease	03MPG	-----	0.625	WIRE	-----	0.500	0.450	MC45	185	B5	
3	G1	3/16	Grease	03MPGB	-----	0.625	WIRE	-----	0.500	0.450	MC45	185	B5	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	MC21	230	W4	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	MC31	365	B3	
4	G1	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.680	MC31	315	R3	
4	G1	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.680	MC21	185	B5	
4	G1	1/4	04PC	04PC2F-2	80416	0.910	WIRE	-----	FULL	0.625	MC31	205	W5	
5	G1	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC32	145	R5	
5	G1	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC22	145	R5	
5	G1	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.750	MC31	455	B2	
5	G1	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	0.750	MC21	310	W3	
5	G1	5/16	05PC	05PC2F-2	80417	0.835	WIRE	-----	FULL	0.720	MC31	395	R2	
5	G1	5/16	05PC	05PC2F-2	80417	0.835	WIRE	-----	FULL	0.720	MC21	260	B4	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	MC22	275	W4	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	MC32	275	W4	
6	G1	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.835	MC22	255	R4	
6	G1	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.835	MC32	255	R4	
6	G1	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.735	MC21	285	R3	
6	G1	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.735	MC31	425	W2	
8	G1	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.010	MC33	265	W4	
8	G1	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.960	MC33	165	R5	
8	G1	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC32	470	R1	
8	G1	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC22	470	R1	
10	G1	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.135	MC34	190	W5	
10	G1	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.100	MC33	440	B2	
10	G1	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	1.075	MC33	390	R2	
12	G1	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	MC35	270	B4	
12	G1	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.275	MC34	465	R1	
12	G1	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.170	MC34	255	W4	
16	G1	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	MC37	290	R3	
16	G1	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.650	MC36	450	R1	
16	G1	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.545	MC36	235	W4	
20	G1	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.050	MC39	230	R4	
20	G1	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	1.975	MC38	355	B3	
20	G1	1 1/4	20PC	20PC2F-2	80427	2.315	WIRE	-----	FULL	1.920	MC38	250	W4	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	MC21	265	B4	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	MC31	395	R2	
4	G1H	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.685	MC31	325	R3	
4	G1H	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.685	MC21	195	B5	
4	G1H	1/4	04PC	04PC2F-2	80416	0.910	WIRE	-----	FULL	0.620	MC31	195	W5	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	MC32	275	W4	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	MC22	275	W4	
6	G1H	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.845	MC32	275	W4	
6	G1H	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.845	MC22	275	W4	
6	G1H	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.720	MC21	260	B4	
6	G1H	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.720	MC31	395	R2	
8	G1H	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.020	MC33	285	B4	
8	G1H	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.945	MC32	480	R1	
8	G1H	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.945	MC22	480	R1	
8	G1H	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC32	470	R1	
8	G1H	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC22	470	R1	
10	G1H	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.135	MC34	190	W5	
10	G1H	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.085	MC33	410	W2	
10	G1H	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	1.070	MC33	380	R2	
12	G1H	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	MC35	270	B4	
12	G1H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.275	MC34	465	R1	
12	G1H	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.190	MC34	295	R3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper			
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	User's Actual Setting
16	G1H	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	MC37	290	R3	
16	G1H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.635	MC36	420	B2	
16	G1H	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	1.540	MC36	220	W4	
20	G1H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.050	MC39	230	R4	
20	G1H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	1.975	MC38	355	B3	
20	G1H	1 1/4	20PC	20PC2F-2	80427	2.315	WIRE	-----	FULL	1.920	MC38	251	W4	
8	G2AT-HMP	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	MC33	340	W3	
8	G2AT-HMP	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	MC22	530	B1	
8	G2AT-HMP	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	MC32	530	B1	
8	G2AT-HMP	1/2	08PC	08PC2F-2C	80473	0.970	WIRE	-----	FULL	0.970	MC22	530	B1	
8	G2AT-HMP	1/2	08PC	08PC2F-2C	80473	0.970	WIRE	-----	FULL	0.970	MC32	530	B1	
10	G2AT-HMP	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
10	G2AT-HMP	5/8	10PC	10PC2F-2C	80447	1.187	WIRE	-----	FULL	1.085	MC33	410	W2	
12	G2AT-HMP	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	G2AT-HMP	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.205	MC34	325	W3	
16	G2AT-HMP	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	MC37	365	B3	
16	G2AT-HMP	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	1.585	MC36	315	W3	
3	G2	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	0.655	MC31	265	W4	
3	G2	3/16	03PC	03PC2F-2	80415	0.750	WIRE	-----	FULL	0.655	MC31	265	W4	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC31	435	W2	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC21	295	R3	
4	G2	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC31	355	W3	
4	G2	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC21	220	R4	
4	G2	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.655	MC31	265	W4	
5	G2	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
5	G2	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	MC22	370	B3	
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	MC32	370	B3	
6	G2	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.880	MC22	345	W3	
6	G2	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.880	MC32	345	W3	
6	G2	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.775	MC31	505	W1	
6	G2	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.775	MC21	355	R2	
8	G2	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	MC33	340	W3	
8	G2	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	G2	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	MC33	185	W5	
10	G2	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
10	G2	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	MC34	170	W5	
10	G2	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	400	R2	
12	G2	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	G2	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	MC35	195	B5	
12	G2	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	MC34	355	B3	
16	G2	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	MC37	360	B3	
16	G2	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.675	MC36	500	W1	
16	G2	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.585	MC36	315	W3	
20	G2	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	MC39	380	B3	
20	G2	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.065	MC38	530	B1	
20	G2	1 1/4	20PC	20PC2F-2	80427	2.187	WIRE	-----	FULL	2.000	MC38	405	W2	
20	G2H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	MC39	380	B3	
20	G2H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.065	MC38	530	B1	
20	G2H	1 1/4	20PC	20PC2F-2	80427	2.187	WIRE	-----	FULL	2.015	MC38	435	B2	
20	G2H-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	MC39	380	B3	
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.730	MC21	275	R3	
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.730	MC31	415	W2	
6	G2L	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	MC32	345	W3	
6	G2L	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	MC22	345	W3	
8	G2L	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	MC33	333	R3	
10	G2L	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	MC34	246	W4	
12	G2L	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.385	MC35	337	W3	
16	G2L	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	MC37	360	B3	
20	G2L	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	MC39	340	B3	
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC31	435	W2	
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC21	295	R3	
6	G2XH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	MC22	370	B3	
6	G2XH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	MC32	370	B3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper			User's Actual Setting
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	
8	G2XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	MC33	340	W3	
10	G2XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
12	G2XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
16	G2XH	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	MC37	290	R3	
4	G3H	1/4	04PC	04PC2F-2	80416	0.785	0.540	-----	FULL	0.670	MC21	170	W5	
4	G3H	1/4	04PC	04PC2F-2	80416	0.785	0.540	-----	FULL	0.670	MC31	295	B4	
5	G3H	5/16	05PC	05PC2F-2	80417	0.750	0.620	-----	FULL	0.775	MC31	505	W1	
5	G3H	5/16	05PC	05PC2F-2	80417	0.750	0.620	-----	FULL	0.775	MC21	355	R2	
6	G3H	3/8	06PC	06PC2F-2	80418	0.785	0.690	-----	FULL	0.785	MC32	530	W1	
6	G3H	3/8	06PC	06PC2F-2	80418	0.785	0.690	-----	FULL	0.785	MC22	530	W1	
8	G3H	1/2	08PC	10PC2F-2B	80476	0.880	0.900	-----	FULL	1.035	MC33	315	R3	
12	G3H	3/4	12PC	12PC2F-4	80422	1.562	1.200	-----	FULL	1.365	MC35	300	R3	
16	G3H	1	16PC	16PC2F-2	80424	1.500	1.450	-----	FULL	1.615	MC36	375	R2	
20	G3H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.985	MC38	375	R2	
20	G3K	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	160	B5	
20	G3K-MTF	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	160	B5	
12	G4H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.330	MC35	235	R4	
12	G4H	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	MC35	215	R4	
16	G4H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.700	MC36	550	B1	
16	G4H	1	16PC	16PC2F-4	80425	-----	-----	-----	FULL	1.680	MC36	510	B1	
20	G4H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.010	MC38	425	B2	
20	G4H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.960	MC38	330	W3	
10	G4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	G4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	G4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
20	G4K	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	160	B5	
6	G4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	G4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
12	G4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	G4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
20	G4K-MTF	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	160	B5	
8	G5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
10	G5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	G5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	MC35	540	W1	
16	G5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
8	G5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
10	G5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	G5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	MC35	540	W1	
16	G5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
6	G6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	G6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
10	G6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	G6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	MC35	540	W1	
16	G6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
6	G6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	MC33	170	B5	
8	G6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	MC33	425	B2	
10	G6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	MC35	170	R4	
12	G6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	MC35	540	W1	
16	G6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
12	GMV	3/4	12G	MegaCrimp	-----	1.375	1.200	1.50	FULL	1.430	MC35	420	W2	
16	GMV	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	MC37	380	R2	
20	GMV	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.110	MC39	350	W3	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	MC31	365	B3	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	MC21	230	W4	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.755	MC47	166	W2	
6	GT7/GT7NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.865	MC32	315	R3	
6	GT7/GT7NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.865	MC22	315	R3	
8	GT7/GT7NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.020	MC33	285	B4	
12	GT7/GT7NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.330	MC35	235	R4	
16	GT7/GT7NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.680	MC37	130	R5	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	MC21	320	W3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper			
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	User's Actual Setting
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	MC31	445	B2	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.900	MC22	384	R2	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.900	MC32	384	R2	
8	GT8/GT8NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	MC33	309	R3	
12	GT8/GT8NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.360	MC35	290	R3	
16	GT8/GT8NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.680	MC37	130	R5	
3	GTH	3/16	03PC	03PC2F-2	80415	0.687	0.410	-----	FULL	0.635	MC31	225	B5	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	MC31	455	B2	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	MC21	310	W3	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC31	530	W1	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC21	370	B3	
6	GTH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	MC22	285	B4	
8	GTH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
10	GTH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.154	MC34	240	W4	
12	GTH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.390	MC35	346	B3	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC21	295	R3	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC31	435	W2	
4	J2AT ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC31	355	W3	
4	J2AT ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC21	220	R4	
4	J2AT ²	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.640	MC31	235	R4	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC22	380	B3	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC32	380	B3	
6	J2AT ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	MC22	315	R3	
6	J2AT ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	MC32	315	R3	
6	J2AT ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	MC21	340	B3	
6	J2AT ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	MC31	485	R1	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC31	435	W2	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC21	295	R3	
4	J2AT-MTF ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC31	355	W3	
4	J2AT-MTF ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC21	220	R4	
4	J2AT-MTF ²	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.640	MC31	235	R4	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC22	380	B3	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC32	380	B3	
6	J2AT-MTF ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	MC32	315	R3	
6	J2AT-MTF ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	MC22	315	R3	
6	J2AT-MTF ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	MC31	485	R1	
6	J2AT-MTF ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	MC21	340	B3	
12	LW	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	LW	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
12	LW-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	MC35	520	B1	
16	LW-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	MC37	230	W3	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M2T	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	R4	
4	M2T	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M2T	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	MC31	215	B5	
4	M2T	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	MC31	275	W4	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
6	M2T	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	MC32	305	R3	
6	M2T	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	MC22	305	R3	
6	M2T	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC21	285	R3	
6	M2T	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC31	425	W2	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	0.810	MC22	205	B5	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	0.810	MC32	205	B5	
8	M2T	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
8	M2T	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	1.025	MC33	295	B4	
8	M2T	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC32	470	R1	
8	M2T	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC22	470	R1	
8	M2T	1/2	08PC-SS	08PC1F-M2SS	85029	-----	-----	-----	FULL	1.000	MC33	295	B4	
10	M2T	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.155	MC34	230	R4	
10	M2T	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	1.110	MC33	460	R1	
10	M2T	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	1.075	MC33	390	R2	
10	M2T	5/8	10PC-SS	10PC1F-M2SS	85030	-----	-----	-----	FULL	1.110	MC33	480	R1	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper			User's Actual Setting
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	
12	M2T	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	MC35	310	R3	
12	M2T	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	1.330	MC35	235	R4	
12	M2T	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.195	MC34	305	R3	
12	M2T	3/4	12PC-SS	12PC1F-M2SS	85031	-----	-----	-----	FULL	1.330	MC35	235	R4	
16	M2T	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.725	MC37	215	W4	
16	M2T	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	1.680	MC36	510	B1	
16	M2T	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	1.510	MC36	160	R4	
16	M2T	1	16PC-SS	16PC1F-M2SS	85032	-----	-----	-----	FULL	1.655	MC36	485	B1	
10	M2TH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	MC34	210	R4	
10	M2TH-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	MC34	210	R4	
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M2T-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	R4	
4	M2T-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M2T-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	MC31	215	B5	
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
6	M2T-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	MC32	305	R3	
6	M2T-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.860	MC22	305	R3	
6	M2T-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC21	285	R3	
6	M2T-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC31	425	W2	
8	M2T-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
8	M2T-MTF	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	1.025	MC33	295	B4	
8	M2T-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC22	470	R1	
8	M2T-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.940	MC32	470	R1	
10	M2T-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.155	MC34	230	R4	
10	M2T-MTF	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	1.110	MC33	460	R1	
10	M2T-MTF	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	1.075	MC33	390	R2	
12	M2T-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	MC35	310	R3	
12	M2T-MTF	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	1.330	MC35	235	R4	
12	M2T-MTF	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.195	MC34	305	R3	
16	M2T-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.725	MC37	215	W4	
16	M2T-MTF	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	1.680	MC36	510	B1	
16	M2T-MTF	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	1.510	MC36	160	R4	
10	M2TN	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	MC34	210	R4	
8	M2T PLUS	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
10	M2T PLUS	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.125	MC34	170	W5	
12	M2T PLUS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	MC35	310	R3	
16	M2TPLUS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	MC37	180	B5	
16	M21+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	MC37	180	B5	
16	M21+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	MC37	180	B5	
8	M2T PLUS-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
10	M2T PLUS-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.125	MC34	170	W5	
12	M2T PLUS-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	MC35	310	R3	
16	M2TPLUS-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	MC37	180	B5	
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC21	220	R4	
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC31	355	W3	
4	M3K	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	MC21	185	B5	
4	M3K	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	MC31	315	R3	
5	M3K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC22	145	R5	
5	M3K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC32	145	R5	
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
6	M3K	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	MC31	495	R1	
6	M3K	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	MC21	345	B3	
6	M3K	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	MC21	230	W4	
6	M3K	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	MC31	365	B3	
8	M3K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	MC33	245	R4	
8	M3K	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	MC22	550	B5	
8	M3K	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	MC32	550	B5	
8	M3K	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	MC22	450	B2	
8	M3K	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	MC32	450	B2	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper			User's Actual Setting
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	
10	M3K	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
10	M3K	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	MC34	170	W5	
10	M3K	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	400	R2	
12	M3K	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M3K	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
12	M3K	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	MC35	195	B5	
12	M3K	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	MC34	355	B3	
16	M3K	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	MC37	380	R2	
16	M3K	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	MC36	345	B3	
20	M3K	1 1/4	20MGS	20MGS-4	-----	-----	-----	-----	FULL	2.050	MC39	160	B5	
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC21	220	R4	
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC31	355	W3	
6	M3KH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
6	M3KH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
8	M3KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	MC33	245	R4	
10	M3KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
12	M3KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M3KH	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC21	220	R4	
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC31	355	W3	
4	M3K-MTF	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	MC31	315	R3	
4	M3K-MTF	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	0.680	MC21	185	B5	
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
6	M3K-MTF	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	MC21	345	B3	
6	M3K-MTF	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	0.770	MC31	495	R1	
6	M3K-MTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	MC21	230	W4	
6	M3K-MTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	MC31	365	B3	
8	M3K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	MC33	245	R4	
8	M3K-MTF	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	MC22	550	B5	
8	M3K-MTF	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	0.980	MC32	550	B5	
8	M3K-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	MC32	450	B2	
8	M3K-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	MC22	450	B2	
10	M3K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
10	M3K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	MC34	170	W5	
10	M3K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	400	R2	
12	M3K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M3K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
12	M3K-MTF	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	MC35	195	B5	
12	M3K-MTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	MC34	355	B3	
16	M3K-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	MC37	380	R2	
16	M3K-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	MC36	345	B3	
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC31	355	W3	
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC21	220	R4	
5	M3K-XTF	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC32	145	R5	
5	M3K-XTF	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	MC22	145	R5	
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
6	M3K-XTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	MC21	230	W4	
6	M3K-XTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	0.705	MC31	365	B3	
8	M3K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	MC33	245	R4	
8	M3K-XTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	MC32	450	B2	
8	M3K-XTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.930	MC22	450	B2	
10	M3K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	MC34	255	W4	
10	M3K-XTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	255	W4	
12	M3K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M3K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
12	M3K-XTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	MC34	355	B3	
16	M3K-XTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	MC37	355	B3	
16	M3K-XTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	MC36	345	B3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

Omnicrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper			User's Actual Setting
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M4K+	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	R4	
4	M4K+	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M4K+	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	MC31	215	B5	
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M4K+	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	MC32	325	W3	
6	M4K+	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	MC22	325	W3	
6	M4K+	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC31	425	W2	
6	M4K+	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC21	285	R3	
8	M4K+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	MC33	325	R3	
8	M4K+	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	M4K+	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	MC22	510	W1	
8	M4K+	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	MC32	510	W1	
10	M4K+	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	MC34	246	W4	
10	M4K+	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	MC33	450	B2	
10	M4K+	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	400	R2	
12	M4K+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M4K+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M4K+-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M4K+-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	R4	
4	M4K+-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	MC31	215	B5	
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M4K+-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	MC22	325	W3	
6	M4K+-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	MC32	325	W3	
6	M4K+-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC31	425	W2	
6	M4K+-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC21	285	R3	
8	M4K+-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	MC33	362	B3	
8	M4K+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	M4K+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	MC22	510	W1	
8	M4K+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	MC32	510	W1	
10	M4K+-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	MC34	246	W4	
10	M4K+-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	MC33	450	B2	
10	M4K+-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	400	R2	
12	M4K+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M4K+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M4K+-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	R4	
4	M4K+-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
6	M4K+-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M4K+-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
8	M4K+-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
10	M4K+-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	MC34	250	R4	
12	M4K+-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M4K+-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
8	M4KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.025	MC33	295	B4	
10	M4KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.165	MC34	250	R4	
12	M4KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M4KH-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
4	M4K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M4K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M4K-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M4K-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	R4	
4	M4K-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	MC31	215	B5	
6	M4K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M4K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
6	M4K-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	MC32	325	W3	
6	M4K-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	0.870	MC22	325	W3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	User's Actual Setting
6	M4K-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC21	285	R3	
6	M4K-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	0.735	MC31	425	W2	
8	M4K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	MC33	360	B3	
8	M4K-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	M4K-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	MC22	510	W1	
8	M4K-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.960	MC32	510	W1	
10	M4K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.165	MC34	250	R4	
10	M4K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	MC33	450	B2	
10	M4K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	MC33	401	R2	
12	M4K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M4K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
4	M4K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M4K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M4K-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M4K-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	B4	
6	M4K-XTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	315	R3	
6	M4K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC32	325	W3	
6	M4K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	MC22	325	W3	
8	M4K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	MC33	313	R3	
10	M4K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	MC34	246	W4	
12	M4K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	M4K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC31	385	B3	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	MC21	250	W4	
4	M5K	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC21	175	B4	
4	M5K	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	0.675	MC31	305	B4	
4	M5K	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	0.630	MC31	215	B5	
4	M5K	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	MC31	275	W4	
5	M5K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.795	MC32	175	R5	
5	M5K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.795	MC22	175	R5	
6	M5K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	MC22	305	R3	
6	M5K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	MC32	305	R3	
8	M5K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	MC33	325	R3	
4	M6K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.74	MC31	435	W2	
4	M6K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.74	MC21	295	R3	
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC21	295	W2	
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC31	435	W2	
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC22	378	B3	
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC32	378	B3	
8	MCPB+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	MC33	362	B3	
12	MCPB+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	MCPB+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
16	MCPB+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	MC37	389	R2	
16	MCPB+	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	MC36	345	B3	
20	MCPB+	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	MC39	380	B3	
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC31	435	W2	
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	MC21	295	R3	
4	MCPB+-MTF	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	0.700	MC31	355	W3	
4	MCPB+-MTF	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	0.640	MC31	235	R4	
6	MCPB+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	MC22	380	B3	
6	MCPB+-MTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	MC33	360	B3	
6	MCPB+-MTF	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	MC22	315	R3	
6	MCPB+-MTF	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.865	MC32	315	R3	
6	MCPB+-MTF	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	MC21	340	B3	
6	MCPB+-MTF	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	0.765	MC31	485	R1	
8	MCPB+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	MC33	205	B5	
8	MCPB+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.970	MC33	185	W5	
12	MCPB+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	MC35	355	B3	
12	MCPB+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	MC35	150	B5	
16	MCPB+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	MC37	380	R2	
16	MCPB+-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	MC36	345	B3	
20	MCPB+-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	MC39	380	B3	
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	MC21	195	R4	
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	MC31	310	W3	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/-	Die Set	4-20 Digital Setting ¹	4-20 Spacer Ring	User's Actual Setting
6	MEGATECH 250	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	MC32	300	B5	
6	MEGATECH 250	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	MC22	300	B5	
8	MEGATECH 250	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	MC33	170	B5	
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.050	MC33	340	W3	
12	MEGATECH 250	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.340	MC35	250	W4	
16	MEGATECH 250	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.730	MC37	220	W5	
20	MEGATECH 250	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	1.980	MC38	365	R2	
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC21	220	R4	
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	MC31	355	W3	
6	MEGATECH 1000	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
6	MEGATECH 1000	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
8	MEGATECH 1000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	MC33	204	B5	
10	MEGATECH 1000	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	MC34	238	W4	
12	MEGATECH 1000	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	MC35	328	W3	
16	MEGATECH 1000	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.700	MC37	160	W5	
20	MEGATECH 1000	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.020	MC38	445	B2	
8	MEGATECH 3000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	MC33	340	W3	
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	MC21	230	W4	
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	MC31	365	B3	
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	MC22	254	W4	
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	MC32	275	W4	
8	RFS	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.010	MC33	365	W4	
12	RFS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	MC35	270	B4	
16	RFS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	MC37	290	R3	
16	RFS	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.650	MC36	450	R1	
16	RFS	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.545	MC36	235	W4	
3	RLA	3/16	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	MC22	305	R3	
3	RLA	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	0.640	MC31	235	R4	
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	MC31	395	R2	
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	MC21	260	B4	
4	RLA	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	0.660	MC31	275	W4	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.770	MC31	495	R1	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.770	MC21	345	B3	
5	RLA	5/16	05PC	05PC2F-2	80417	-----	-----	-----	FULL	0.765	MC21	340	B3	
5	RLA	5/16	05PC	05PC2F-2	80417	-----	-----	-----	FULL	0.765	MC31	485	R1	
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	MC32	305	R3	
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	MC22	305	R3	
6	RLA	3/8	06PC	06PC2F-2	80418	-----	-----	-----	FULL	0.770	MC21	345	B3	
6	RLA	3/8	06PC	06PC2F-2	80418	-----	-----	-----	FULL	0.770	MC31	495	R1	
8	RLA	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.080	MC33	401	R2	
8	RLA	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	0.995	MC33	235	R4	
10	RLA	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.140	MC34	200	R2	
10	RLA	5/8	10PC	12PC2F-2	80423	-----	-----	-----	FULL	1.150	MC34	220	R4	
12	RLA	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.430	MC35	420	W2	
12	RLA	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	MC35	215	R4	
16	RLA	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.690	MC37	140	W5	
16	RLA	1	16PC	16PC2F-2	80424	-----	-----	-----	FULL	1.570	MC36	285	B4	
8	S/R-XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	MC33	245	R4	
10	S/R-XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.140	MC33	543	-	
12	S/R-XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	MC35	328	W3	
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	MC31	315	R3	
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	MC21	170	B5	
6	TR500	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC22	205	B5	
6	TR500	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	MC32	205	B5	
8	TR500	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	MC33	204	B5	
10	TR500	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.130	MC34	190	W5	
12	TR500	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.300	MC35	156	B5	
16	TR500	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.580	MC36	285	B4	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

MC4-20 Digital Dial and Positive Stop Crimpers

G4H with PC2F Ferrule Crimp Data

- For hose size and stem type to be crimped to find proper table to use on the right.
- Measure hose OD with pi tape and match to Hose OD in table to the right and find the proper data for the crimp.
If the measured hose OD doesn't match a number in the Hose OD column, use the crimp data for the closest lower Hose OD.

Hose		Stem		Ferrule	
Dash Size	Hose	Type	Description	Part No.	
12	G4H	PC	12PC2F-4	80422	

Crimp			Crimper			
Hose OD	Crimp OD +/- .010(in)	Crimp Length	Die	Digital Setting	Spacer Ring	User's Actual Ring
1.22	1.39	Full	35	345	B3	
1.21	1.38	Full	35	325	W3	
1.19	1.36	Full	35	290	B4	
1.17	1.34	Full	35	250	W4	
1.15	1.32	Full	35	215	R4	
1.14	1.31	Full	35	195	B5	

Hose		Stem		Ferrule	
Dash Size	Hose	Type	Description	Part No.	
16	G4H	PC	16PC2F-4	80425	

Crimp			Crimper			
Hose OD	Crimp OD +/- .010(in)	Crimp Length	Die	Digital Setting	Spacer Ring	User's Actual Ring
1.49	1.72	Full	36	595	B1	
1.48	1.71	Full	36	570	B1	
1.46	1.69	Full	36	530	B1	
1.44	1.67	Full	36	490	W1	
1.42	1.65	Full	36	450	B2	
1.41	1.64	Full	36	430	B2	

Hose		Stem		Ferrule	
Dash Size	Hose	Type	Description	Part No.	
20	G4H	PC	20PC2F-2	80427	

Crimp			Crimper			
Hose OD	Crimp OD +/- .010(in)	Crimp Length	Die	Digital Setting	Spacer Ring	User's Actual Ring
1.74	2.00	Full	38	405	W2	
1.73	1.99	Full	38	385	R2	
1.71	1.97	Full	38	345	W3	
1.69	1.95	Full	38	310	R3	
1.67	1.93	Full	38	270	W4	
1.66	1.92	Full	38	250	W4	

¹ See Adjustment Procedure at beginning of MC4-20 section. ² MPLN Couplings Only.



GLP Coupling Crimping Instructions

MobileCrimp® 4-20

IMPORTANT- MC4-20 Digital Dial users- Contact your Gates representative or check www.gates.com and request Fluid Power Technical Note 'Crimping GLP couplings using the MC4-20 Digital Dial crimper'

See Figure 1 for proper alignment of coupling in die prior to crimping.

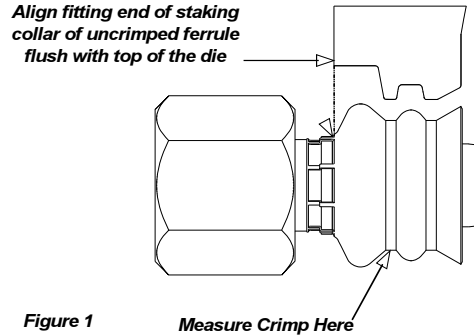


Figure 1 Measure Crimp Here

Dash Size	Hose		Stem Type	Ferrule Description	Crimp		Crimper	
	Description	Size (In.)			Insertion Length +/- .03 (In.)	Crimp O.D.	Die Set	MC4-20 Spacer Ring
4	LOC	1/4	GLP1	1-pc GLP1	0.66	0.470	MC71	R4
6	LOC	3/8	GLP1	1-pc GLP1	0.77	0.620	MC72	R4
8	LOC	1/2	GLP1	1-pc GLP1	0.72	0.740	MC73	R4
10	LOC	5/8	GLP1	1-pc GLP1	0.75	0.920	MC74	R4
12	LOC	3/4	GLP1	1-pc GLP1	0.75	1.000	MC75	R5
4	LOL	1/4	GLP1	1-pc GLP1	0.66	0.470	MC71	R4
6	LOL	3/8	GLP1	1-pc GLP1	0.77	0.620	MC72	R4
8	LOL	1/2	GLP1	1-pc GLP1	0.72	0.740	MC73	R4
10	LOL	5/8	GLP1	1-pc GLP1	0.75	0.910	MC74	R4
12	LOL	3/4	GLP1	1-pc GLP1	0.98	1.040	MC75	B4
4	M500	1/4	GLP1	1-pc GLP1	0.66	0.470	MC71	R4
6	M500	3/8	GLP1	1-pc GLP1	0.77	0.625	MC72	R4
8	M500	1/2	GLP1	1-pc GLP1	0.72	0.750	MC73	W4
10	M500	5/8	GLP1	1-pc GLP1	0.75	0.910	MC74	B5
12	M500	3/4	GLP1	1-pc GLP1	0.75	1.015	MC75	W5
4	M500-XTF	1/4	GLP1	1-pc GLP1	0.66	0.470	MC71	R4
6	M500-XTF	3/8	GLP1	1-pc GLP1	0.77	0.625	MC72	R4
8	M500-XTF	1/2	GLP1	1-pc GLP1	0.72	0.750	MC73	W4
10	M500-XTF	5/8	GLP1	1-pc GLP1	0.75	0.910	MC74	B5
12	M500-XTF	3/4	GLP1	1-pc GLP1	0.75	1.015	MC75	W5
4	MEGATECH250	1/4	GLP1	1-pc GLP1	0.66	0.500	MC71	B4
6	MEGATECH250	3/8	GLP1	1-pc GLP1	0.77	0.640	MC72	W4
8	MEGATECH250	1/2	GLP1	1-pc GLP1	0.72	0.740	MC73	R4
10	MEGATECH250	5/8	GLP1	1-pc GLP1	0.75	0.90	MC74	B5
12	MEGATECH250	3/4	GLP1	1-pc GLP1	0.98	1.020	MC75	R4
4	RLA	1/4	GLP1	1-pc GLP1	0.66	0.500	MC71	B4
6	RLA	3/8	GLP1	1-pc GLP1	0.77	0.660	MC72	B4
8	RLA	1/2	GLP1	1-pc GLP1	0.72	0.740	MC73	R4
10	RLA	5/8	GLP1	1-pc GLP1	0.75	0.920	MC74	R4
12	RLA	3/4	GLP1	1-pc GLP1	0.98	1.040	MC75	B4
8	S/R-XH	1/2	GLP1	1-pc GLP1	0.72	0.760	MC73	W4
10	S/R-XH	5/8	GLP1	1-pc GLP1	0.75	0.920	MC74	R4
12	S/R-XH	3/4	GLP1	1-pc GLP1	0.98	1.080	MC75	B3
4	TR500	1/4	GLP5	1-pc GLP5	0.66	0.470	MC71	R4
6	TR500	3/8	GLP5	1-pc GLP5	0.77	0.610	MC72	B5
8	TR500	1/2	GLP5	1-pc GLP5	0.72	0.720	MC73	B5
10	TR500	5/8	GLP5	1-pc GLP5	0.75	0.880	MC74	R5
12	TR500	3/4	GLP5	1-pc GLP5	0.98	1.020	MC75	R4

GL Coupling Crimping Instructions

MobileCrimp® 4-20

To achieve proper tail length, line up fitting end of ferrule with top of die (see Figure 1) prior to crimping.

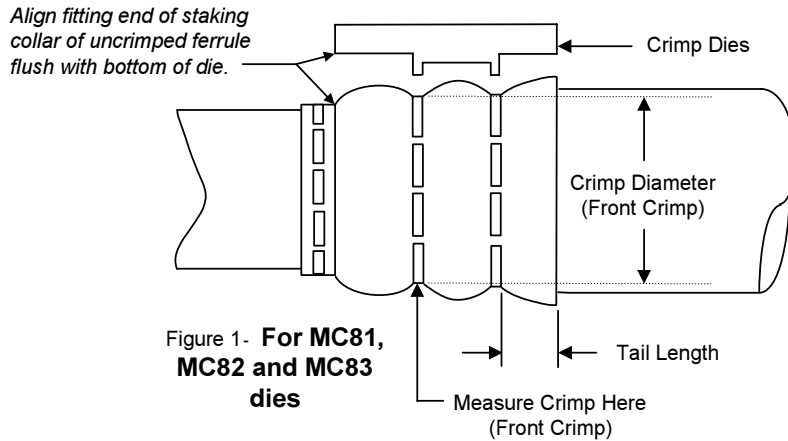


Figure 1- For MC81, MC82 and MC83 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length ±.10(in)	Crimp OD +/- .010(in.)	Die Set	MC4-20 Digital Setting	MC4-20 Spacer Ring	User's Actual Setting
12	GMV	3/4	12GL	1-pc GL	-----	-----	-----	1.750	0.50	1.12	MC81	250	R1	
16	GMV	1	16GL	1-pc GL	-----	-----	-----	2.125	0.60	1.36	MC82	250	R3	
20	GMV	1 1/4	20GL	1-pc GL	-----	-----	-----	2.250	0.50	1.66	MC83	275	W1	

Clamp Collar Crimping Instructions

MobileCrimp® 4-20

Care must be taken when crimping clamp collars onto a hydraulic hose. If crimp is too tight, hose will be crushed, dramatically reducing its service life. If crimp is too loose, collar could slide along hose's length causing abrasion and eventual hose cover failure.

Remember: Clamp collars must be crimped before the hose couplings.

Use the following instructions to determine crimp diameter, which can then be used to find crimping setting in Table 2. The required clamp collar for a specific hydraulic hose is provided in Table 1.

1. Measure hose's outside diameter at the location where clamp collar will be crimped. This can be accomplished by using a pie tape or by using the average hose outside diameter measured with a dial caliper.
2. Obtain crimp diameter by adding hose outside diameter to twice the clamp collar wall thickness (see formula below).

$$\text{Crimp Diameter} = (\text{Hose O.D.}) + [2 \times .065 (\text{Clamp Collar Wall Thickness})]$$

When crimping clamp collar, the crimp die should be located in the center of the collar, which will result in a 1/8" flare on each side of the collar.



Table 1

Description	Part Number	Product Number	Hydraulic Hose Applications	Length (In.)	MC 4-20 Die
CC1.12	G52000-0210	7334-45805	10M2T, 10G2	2.250	MCC3
CC1.25	G52000-0212	7334-45885	12M2T, 12G2, 12M4K	2.000	MCC4
CC1.37	G52000-0412	7334-45895	12C12, 12G4K	2.000	MCC4

Table 2

MCC3 Die		MCC4 Die	
Crimp Diameter	Approx. Setting	Crimp Diameter	Approx. Setting
1.050	260	1.250	260
1.055	270	1.255	270
1.060	282	1.260	282
1.065	293	1.265	293
1.070	303	1.270	303
1.075	315	1.275	315
1.080	325	1.280	325
1.085	335	1.285	335
1.090	347	1.290	347
1.095	358	1.295	358
1.100	370	1.300	370
1.105	380	1.305	380
1.110	390	1.310	390
1.115	400	1.315	400
1.120	412	1.320	412
1.125	423	1.325	423
1.130	435	1.330	435
1.135	445	1.335	445
1.140	455	1.340	455
1.145	465	1.345	465
1.150	477	1.350	477
1.155	488	1.355	488
1.160	500	1.360	500
1.165	510	1.365	510

Power Steering Male Flareless Assembly Instructions

MobileCrimp® 4-20

Hose Preparation and Assembly

1. Measure tube O.D.
2. Select proper Male Flareless coupling for the application.
3. Determine length of replacement assembly. Measure the distance between the points where the tubing is to be cut. See Fig. 1.

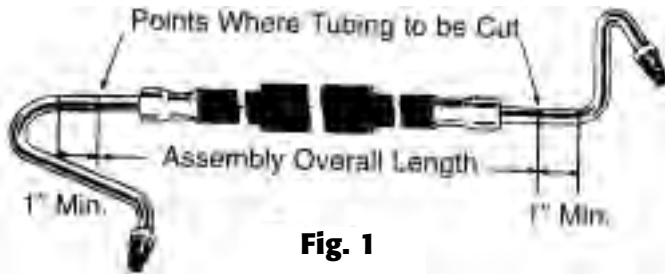


Fig. 1

NOTE: Tubing must be cut at 1" from the start of any bend. Read "Tubing Preparation Assembly" section on next page before cutting.

4. Determine necessary cut length of hose.

$$\text{Cut Length} = \text{Assembly Overall Length} - \text{Cutoff Dimension (Coupling 1)} - \text{Cutoff Dimension (Coupling 2)}$$

(Cutoff dimensions are in Table below.)

Cutoff Dimensions For Power Steering Couplings

Part No.	Description	Cutoff (In.)
G50510-0604	6PS-4MFA	.996
G50510-0605	6PS-5MFA	.996
G50510-0606	6PS-6MFA	1.012
G50510-0608	6PS-M8MFA	.934
G50510-0610	6PS-M10MFA	.973
G50510-0612	6PS-M12MFA	.973

5. Cut hose to calculated cut length. End must be square ($\pm 5^\circ$). See Fig. 2.



Fig. 2

6. Mark hose 1-1/4" ($\pm 1/32$ ") from the end of hose with a marker pen. Do not damage hose. See Fig. 3.



Fig. 3

7. Insert a **6PS** coupling into hose until end of ferrule is even with the mark. (See Fig. 4.)



Fig. 4

8. Place the **MC44** die into crimper. Use setting /spacer ring as shown below:

Digital Dial	Positive Stop Spacer Ring
190	Blue Power Steering

9. Insert properly prepared hose and coupling into crimper. Line up top of die with bottom of the stem hex. (See Fig. 5.)



Fig. 5

10. Place no-notch cone on die fingers. Press crimp button. When you hear pump pressurize or the light and buzzer sound, release your finger from the crimp button. Crimp is now complete.

Power Steering Male Flareless Assembly Instructions (cont'd)

MobileCrimp® 4-20

11. Measure the crimp O.D. per Fig. 6. Crimp O.D. must be within the specified tolerance.

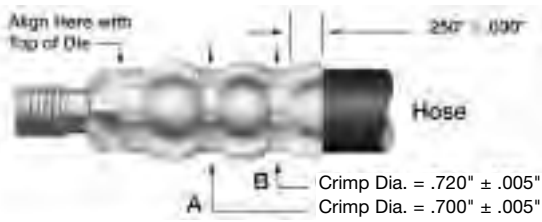


Fig. 6

12. Check assembly to make sure correct overall length has been obtained.
13. Inspect assembly to make sure it has a clean bore and no internal obstructions. Clean if necessary.

Tubing Preparation Assembly

1. Tube End Condition

- Before cutting tube, mark both ends of assembly so that it can be properly reassembled. Marks must be made on tubing beyond the point where the tubing will be cut. Use a marker pen to mark the tubing so the surface won't be scratched.
- Tube end must be cut squarely ($\pm 5^\circ$).
- Smooth tube inside and out by removing all burrs and rough edges with steel wool. Clean all metal particles from inside tube.
- The bare end of the tube must be long enough for the nut and sleeve to be placed over the tube. (1" minimum length before the start of any bend.)
- There must be sufficient tube length for tube end to seat against shoulder in thread end of stem. (1" minimum length before the start of any bend.)

2. Nut and Sleeve Placement (Tube End)

- Install hex nut over tube, positioned so the shoulder end is placed on tube first. Thread end will then face hose assembly.
- Place sleeve on tube so tapered end will face hose assembly.



3. Connect to Tube End

(Preliminary Connection)

- Insert tube into thread end of hose assembly until it bottoms against shoulder.



- Screw hex nut to thread end until finger tight.
- Using a wrench, tighten approximately 1 turn ($\pm 1/4$ turn) to preset.

4. Inspect

- Disassemble and inspect compression of sleeve on tube. Sleeve must be compressed sufficiently on tube so it is not easily removed.
- Tube end will be slightly distorted from butting against internal shoulder.

NOTE: Makeup of the correct connection is critical for proper use and safety.

5. Final Assembly

- Insert tube into thread end of hose assembly.
- With a wrench, tighten down until a sudden increase in torque is felt. Turn nut approximately $1/6$ turn (but no more than $1/3$ turn) to create a seal between sleeve, tube and seat of stem.

CAUTION: Overtightening may cause stripped threads and/or collapse of tube.

- Before tightening second end, line up the two marks on tubing to assure proper orientation.



Gates PolarSeal® Hose

G45 Series (ACA) Coupling Crimping Instructions

MobileCrimp® 4-20

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Gates recommends only those hose and coupling combinations specified in the Gates Hydraulic Products Catalogs. Gates disclaims any liability for any hose assemblies which have not been produced in conformance with Gates' assembly recommendations.

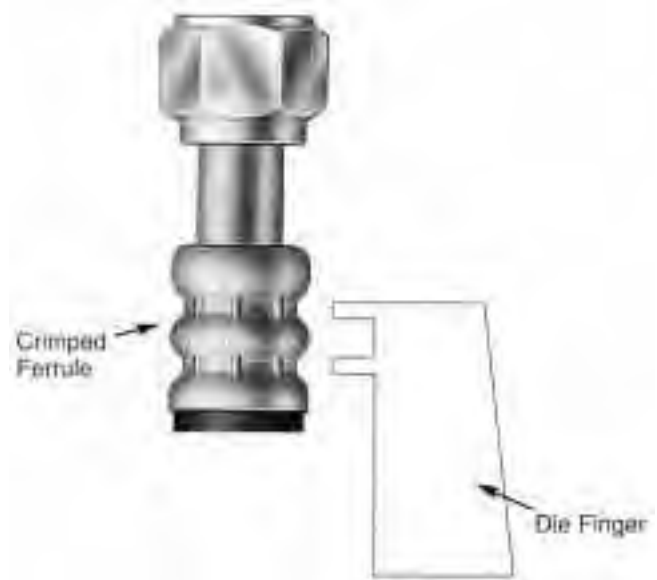
Changing Digital Readout

Rotating knob on front of switch box clockwise will increase number; counterclockwise will decrease number. When changing the setting, always move to a higher number then down to the desired setting. Example: To change from 200 to 245, move dial up to 300 then down to 245.

Crimp Diameter

Should the actual crimp diameter NOT be within the recommended crimp tolerance, check the proper calibration. (See Operator's Manual.) If the calibration is correct, a slight adjustment to the setting or digital readout may be necessary. To obtain a smaller crimp diameter, change setting or digital readout to a larger number.

Changing the digital readout by 002 (Example 245 to 247) will change the crimp diameter by .001".



IMPORTANT

To assure a quality assembly, check the FIRST assembly of each run. Measure the crimped O.D. and compare it to the figure listed in the "Crimp Diameter" column.

If ACTUAL crimped dimensions are within specification, you have made a good assembly.

Hose		Fitting Type	Ferrule Position	Crimp Diameter (±.010")	Die Set	Approximate Digital Setting	Actual Crimper Setting	Positive Stop Spacer
Type	I.D. (In.)							
6AC134a	5/16	6ACA	Centered	.690	MC40	180		W5
8AC134a	13/32	8ACA	Centered	.780	MC41	220		B5
10AC134a	1/2	10ACA	Centered	.890	MC42	190		W5
12AC134a	5/8	12ACA	Centered	1.020	MC43	214		B5



Automotive Service Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Hose			Stem	Ferrule		Skive/Buf		Crimp			Crimper			
Dash Size	Description	Size (In.)	Type	Descr.	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	Digital Setting ¹	User's Actual Setting	Spacer Ring
4	Charter® Air Hose	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.725	31	420		R2
6	Charter® Air Hose	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.800	32	190		W5
8	Charter® Air Hose	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.025	33	315		B4
4	Multi-Use 1-Braid (19B)	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.650	31	255		R4
6	Multi-Use 1-Braid (19B)	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.790	31	540		R5
8	Multi-Use 1-Braid (19B)	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.020	32	635		B1
4	Multi-Use 2-Braid (19B)	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.720	31	395		R2
5	Multi-Use 2-Braid (19B)	5/16	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.770	31	495		R1
6	Multi-Use 2-Braid (19B)	3/8	6PC	PC2F-4	80462	-----	-----	-----	FULL	0.890	32	740		W3
8	Multi-Use 2-Braid (19B)	1/2	8PC	PC2F-4	80463	-----	-----	-----	FULL	1.120	33	160		W5
4	Safety Stripe® Air Hose	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.725	31	420		R2
6	Safety Stripe® Air Hose	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.800	32	190		W5
8	Safety Stripe® Air Hose	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.025	33	315		B4

LP350 Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Hose			Stem	Ferrule		Skive/Buf		Crimp			Crimper			
Dash Size	Type	Size (In.)	Type	Description	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	Digital Setting ¹	User's Actual Setting	Spacer Ring
4	LP350	1/4	PC	4PC2F-2	80416	-----	-----	-----	Full	0.670	21	170		W5
4	LP350	1/4	PC	4PC2F-2	80416	-----	-----	-----	Full	0.670	31	295		B4
6	LP350	3/8	PC	6PC2F-2	80418	-----	-----	-----	Full	0.780	21	365		R2
6	LP350	3/8	PC	6PC2F-2	80418	-----	-----	-----	Full	0.780	31	520		W1
8	LP350	1/2	PC	8PC2F-2	80419	-----	-----	-----	Full	0.995	33	240		R4
12	LP350	3/4	PC	12PCBHB-1F	-----	-----	-----	-----	Full	1.315	35	205		B5
16	LP350	1	PC	16PC2F-4	80425	-----	-----	-----	Full	1.625	36	397		W2
20	LP350	1	PC	20PC2F-4	80426	-----	-----	-----	Full	2.040	39	190		R1

PowerClean™ Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Dash Size	Type	Size (In.)	Work. Press. (psi)	Type	Description	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	Digital Setting ¹	User's Actual Setting	Spacer Ring
8	PC2500	1/2	2500	G	MegaCrimp®	-----	-----	-----	1.25	Full	1.010	33	265		W4
6	PC3000	3/8	3000	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.845	22/32	275		W4
4	PC3500	1/4	3500	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.705	21	230		W4
4	PC3500	1/4	3500	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.705	31	365		B3
6	PC4000	3/8	4000	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.845	22/32	275		W4
8	PC4000	1/2	4000	G	MegaCrimp®	-----	-----	-----	1.25	Full	1.050	33	340		W3
6	PC5000	3/8	5000	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.890	22/32	370		B3
4	PC6000	1/4	6000	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.740	21	295		R3
4	PC6000	1/4	6000	G	MegaCrimp®	-----	-----	-----	0.93	Full	0.740	31	435		W2

¹ See Adjustment Procedure at beginning of MobileCrimp® section.

Industrial Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Size (in)	Hose		Stem		Ferrule		Skive / Buff		Crimp		Crimper				
	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	4-20 Digital Setting	4-20 Spacer Ring	User's Actual Setting
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	0.875	WIRE	-	Full	0.930	22	450	B2	
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	0.875	WIRE	-	Full	0.930	32	450	B2	
3/4	1000MP/ Mine Spray	1000	12	PC	12PC2F-2	80423	1.625	WIRE	-	Full	1.190	34	295	R3	
3/4	1000MP/ Mine Spray	1000	12	PC	MegaCrimp®	-	-	-	1.50	Full	1.345	35	260	B4	
1	1000MP/ Mine Spray	1000	16	PC	MegaCrimp®	-	-	-	1.75	Full	1.745	37	275	B4	
1	1000MP/ Mine Spray	1000	16	PC	16PC2F-2	80424	1.500	WIRE	-	Full	1.620	36	385	R2	
1 1/4	1000MP/ Mine Spray	1000	20	PC	MegaCrimp®	-	-	-	1.75	Full	2.045	39	325	W1	
1 1/4	1000MP/ Mine Spray	1000	20	PC	20PC2F-2	80427	1.118	WIRE	-	Full	1.950	37	705	R1	
1/4	119B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	250	R4	
1/4	119B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.760	31	475	R1	
1/4	119B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.760	21	330	B3	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	0.850	31	660	W4	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	0.850	21	660	W4	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	0.880	22	345	W3	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	0.880	32	345	W3	
1/2	119B	250	8	PC	8PC2F-2	80476	-	-	-	Full	1.020	33	225	R4	
1/2	119B	500	8	PC	10PC2F-2B	80476	-	-	-	Full	1.020	33	285	B4	
3/4	119B	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.290	34	495	W5	
3/4	119B	500	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	35	270	B4	
1	119B	250	16	PC	16PC2F-2	80424	-	-	-	Full	1.630	36	405	W2	
1	119B	500	16	PC	16PC2F-4	80425	-	-	-	Full	1.690	36	530	B1	
3/16	19B	500	3	PC	3PC2F-2	80415	-	-	-	Full	0.630	31	215	B5	
1/4	19B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.650	31	255	R4	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.720	31	395	R2	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.720	21	260	B4	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	0.770	31	495	R1	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	0.770	21	345	B3	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	0.770	31	495	R1	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	0.770	21	345	B3	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.790	31	540	R5	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.790	21	385	W2	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	0.890	32	740	W3	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	0.890	22	740	W3	
1/2	19B	250	8	PC	8PC2F-2	80419	-	-	-	Full	1.020	32	635	B1	
1/2	19B	500	8	PC	8PC2F-4	80463	-	-	-	Full	1.080	33	400	R2	
5/8	19B	250	10	PC	10PC2F-2C	80447	-	-	-	Full	1.090	33	420	W2	
5/8	19B	500	10	PC	10PC1FA	80436	-	-	-	Full	1.120	34	160	W5	
3/4	19B	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.290	34	495	W5	
3/4	19B	500	12	PC	12PC1FA	80437	-	-	-	Full	1.370	35	310	R3	
1	19B	250	16	PC	16PC2F-2	80424	-	-	-	Full	1.540	36	220	W4	
1	19B	500	16	PC	16PC2F-4	80425	-	-	-	Full	1.660	36	470	W1	
1 1/4	19B	250	20	PC	20PC2F-4	80426	-	-	-	Full	2.000	38	405	W2	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	21	175	R4	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	31	305	B4	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.790	22	165	R5	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.790	32	165	R5	
1/2	20B-HB	350	8	PC	10PC2F-2B	80476	-	-	-	Full	1.065	33	370	B3	
3/4	20B-HB	350	12	PC	12PCBHB1F	-	-	-	-	Full	1.355	35	280	B4	
1	20B-HB	350	16	PC	16PC2F-4	80425	-	-	-	Full	1.665	36	480	W1	
1 1/4	20B-HB	350	20	PC	20PC2F-4	80426	-	-	-	Full	2.040	39	190	R1	
1/4	319MB	1000	4	PC	4PC2F-2	80416	0.750	WIRE	-	Full	0.640	31	235	R4	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.688	WIRE	-	Full	0.690	21	205	B5	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.688	WIRE	-	Full	0.690	31	335	R3	
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.875	WIRE	-	Full	0.940	32	470	R1	
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.875	WIRE	-	Full	0.940	22	470	R1	
3/4	319MB	1000	12	PC	12PC2F-4	80422	1.563	WIRE	-	Full	1.315	35	205	R4	
1	319MB	1000	16	PC	16PC2F-2	80424	1.500	WIRE	-	Full	1.545	36	235	W4	
1 1/4	319MB	1000	20	PC	20PC2F-2	80427	2.190	WIRE	-	Full	1.880	37	555	R1	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	31	295	B4	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	21	170	W5	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.780	21	365	R2	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.780	31	520	W1	

¹ See Adjustment Procedure at beginning of MobileCrimp® section. ² For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Size (in)	Hose Type	Working Pressure (psi)	Stem		Ferrule		Skive / Buff		Crimp		Crimper				
			Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	4-20 Digital Setting	4-20 Spacer Ring	User's Actual Setting
5/16	6B	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.720	21	260	B4	
5/16	6B	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.720	31	395	R2	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	21	310	W3	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	31	455	B2	
3/8	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	21	395	B2	
3/8	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	31	560	R5	
1/2	6B	200	8	PC	8PC2F-2	80419	-	-	-	Full	1.000	33	245	R4	
1/2	6B	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.980	33	205	B5	
1/2	6B	315	8	PC	8PC2F-4	80463	-	-	-	Full	1.100	33	440	B2	
3/4	6B	250	12	PC	12PC2F-2	80423	-	-	-	Full	1.240	34	395	R2	
3/4	6B	315	12	PC	12PC2F-4	80422	-	-	-	Full	1.370	35	310	R3	
1	6B	315	16	PC	16PC2F-4	80425	-	-	-	Full	1.710	36	570	B1	
1 1/4	6B	200	20	PC	20PC2F-2	80427	-	-	-	Full	2.020	38	445	B2	
1/4	Adapta Flex™	200	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	250	R4	
1/4	Adapta Flex™	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	250	R4	
1/4	Adapta Flex™	300	4	PC	4PC2F-2	80416	-	-	-	Full	0.685	31	265	W4	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	0.725	21	265	B4	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	0.725	31	405	R2	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	31	455	B2	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	21	310	W3	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.720	31	395	R2	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.720	21	260	B4	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	22	185	B5	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	32	185	B5	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	-	-	-	Full	0.990	32	570	B1	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	-	-	-	Full	0.990	22	570	B1	
1/2	Adapta Flex™	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.990	33	245	R4	
1/2	Adapta Flex™	300	8	PC	8PC2F-2	80419	-	-	-	Full	1.000	33	245	R4	
5/8	Adapta Flex™	200	10	PC	12PC2F-2	80423	-	-	-	Full	1.125	34	170	W5	
5/8	Adapta Flex™	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.125	34	170	W5	
3/4	Adapta Flex™	200	12	PC	12PC2F-2	80423	-	-	-	Full	1.320	34	550	B5	
3/4	Adapta Flex™	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	34	270	B4	
3/4	Adapta Flex™	300	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	35	270	B4	
1	Adapta Flex™	150	16	PC	16PC2F-2	80424	-	-	-	Full	1.600	36	345	B3	
1	Adapta Flex™	200	16	PC	16PC2F-4	80425	-	-	-	Full	1.650	36	450	B2	
1	Adapta Flex™	300	16	PC	16PC2F-4	80425	-	-	-	Full	1.700	36	550	B1	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	0.785	21	375	W2	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	0.785	31	530	R5	
1/2	Cyclone™	1000	8	PC	10PC2F-2B	80476	-	-	-	Full	1.040	33	325	R3	
3/4	Cyclone™	1000	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	35	270	B4	
1/4	Duro Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.650	31	255	R4	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	0.720	21	260	B4	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	0.720	31	395	R2	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.820	32	225	B5	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.820	22	225	B5	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.850	22	285	W4	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.850	32	285	W4	
1/2	Duro Flex®	250	8	PC	8PC2F-2	80419	-	-	-	Full	1.010	33	265	W4	
1/2	Duro Flex®	300	8	PC	10PC2F-2B	80476	-	-	-	Full	1.080	33	400	R2	
5/8	Duro Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.185	34	285	B4	
5/8	Duro Flex®	300	10	PC	12PC2F-2	80423	-	-	-	Full	1.140	34	200	B5	
3/4	Duro Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.330	35	235	R4	
3/4	Duro Flex®	300	12	PC	12PC2F-4	80422	-	-	-	Full	1.310	34	535	B5	
1	Duro Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	1.670	37	115	R5	
1 1/4	Duro Flex®	200	20	PC	20PC2F-2	80427	-	-	-	Full	2.020	37	855	W1	
1/2	Heat Master® (Aramid)	500	8	PC	8PC2F-4	80463	-	-	-	Full	1.115	33	471	R1	
3/4	Heat Master® (Aramid)	500	12	PC	12PCBHB1F	-	-	-	-	Full	1.350	35	270	B4	
1/4	LP350	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	21	170	W5	
1/4	LP350	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	31	295	B4	
3/8	LP350	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	21	365	R2	
3/8	LP350	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	31	520	W1	
1/2	LP350	350	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	33	240	R4	

¹ See Adjustment Procedure at beginning of MobileCrimp® section. ² For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Size (in)	Hose		Stem		Ferrule		Skive / Buff		Crimp		Crimper				
	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	4-20 Digital Setting	4-20 Spacer Ring	User's Actual Setting
3/4	LP350	350	12	PC	12PCBHB-1F	-	-	-	-	Full	1.315	35	205	B5	
1	LP350	350	16	PC	16PC2F-4	80425	-	-	-	Full	1.625	36	397	W2	
1 1/4	LP350	350	20	PC	20PC2F-4	80426	-	-	-	Full	2.040	39	190	R1	
1/2	PC2500	2500	8	PC	8PC1FA	80435	-	-	-	Full	0.960	33	165	R5	
1/2	PC2500	2500	8	PC	8PC1FS	80485	-	-	-	Full	0.960	33	165	R5	
1/2	PC2500	2500	8	G	MegaCrimp®	-	-	-	1.25	Full	1.010	33	265	W4	
1/2	PC2500	2500	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	0.940	32	470	R1	
1/2	PC2500	2500	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	0.940	22	470	R1	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	22	255	R4	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	31	425	W2	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	21	285	R3	
3/8	PC3000	3000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	22	275	W4	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	32	255	R4	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	32	255	R4	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	22	255	R4	
3/8	PC3000	3000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	32	275	W4	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	0.680	21	185	B5	
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	0.680	21	185	B5	
1/4	PC3500	3500	4	PC	4PC2F-2	80416	0.910	WIRE	-	Full	0.625	31	205	W5	
1/4	PC3500	3500	4	G	MegaCrimp®	-	-	-	0.93	Full	0.705	21	230	W4	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	0.680	31	315	R3	
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	0.680	31	315	R3	
1/4	PC3500	3500	4	G	MegaCrimp®	-	-	-	0.93	Full	0.705	31	365	B3	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	32	255	R4	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	31	425	W2	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	0.735	21	285	R3	
3/8	PC4000	4000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	22	275	W4	
3/8	PC4000	4000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	32	275	W4	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	22	255	R4	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	32	255	R4	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	22	255	R4	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	22	255	R4	
1/2	PC4000	4000	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	0.970	33	185	W5	
1/2	PC4000	4000	8	PC	8PC1FA	80435	-	-	-	Full	0.980	33	205	B5	
1/2	PC4000	4000	8	PC	8PC1FS	80485	-	-	-	Full	0.980	33	205	B5	
1/2	PC4000	4000	8	G	MegaCrimp®	-	-	-	1.25	Full	1.050	33	340	W3	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	0.880	22	345	W3	
3/8	PC5000	5000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.890	22	370	B3	
3/8	PC5000	5000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.890	32	370	B3	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.785	WIRE	-	Full	0.775	31	505	W1	
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	0.880	32	345	W3	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	0.880	32	345	W3	
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	0.880	22	345	W3	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.785	WIRE	-	Full	0.775	21	355	R2	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.785	WIRE	-	Full	0.685	21	195	B5	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	0.700	21	220	R4	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	0.700	21	220	R4	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.785	WIRE	-	Full	0.685	31	265	W4	
1/4	PC6000	6000	4	G	MegaCrimp®	-	-	-	0.93	Full	0.740	21	295	R3	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	0.700	31	355	W3	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	0.700	31	355	W3	
1/4	PC6000	6000	4	G	MegaCrimp®	-	-	-	0.93	Full	0.740	31	435	W2	
3/16	Premo Flex®	250	3	PC	3PC2F-2	80415	-	-	-	Full	0.655	31	265	W4	
1/4	Premo Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.645	31	245	R4	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	21	170	W5	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	31	295	B4	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.630	31	215	B5	
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	0.755	21	320	W3	
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	0.755	31	465	R1	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.770	21	345	B3	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.770	31	495	R1	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	0.810	32	205	B5	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	0.810	22	205	B5	

¹ See Adjustment Procedure at beginning of MobileCrimp® section. ² For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

MobileCrimp® 4-20 Digital Dial and Positive Stop Crimpers

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper			
Size (in)	Type	Working Pressure (psi)	Dash Size	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length	Crimp OD +/- .010(in)	Die Set	4-20 Digital Setting	4-20 Spacer Ring	User's Actual Setting
1/2	Premo Flex®	250	8	PC	8PC1FA	80435	-	-	-	Full	0.980	33	205	B5	
1/2	Premo Flex®	315	8	PC	8PC1FA	80435	-	-	-	Full	1.010	33	265	W4	
1/2	Premo Flex®	315	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	33	240	R4	
5/8	Premo Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.145	34	210	B5	
5/8	Premo Flex®	315	10	PC	10PC1FA	80436	-	-	-	Full	1.190	34	295	R3	
5/8	Premo Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.320	35	215	R4	
3/4	Premo Flex®	315	12	PC	12PC2F-4	80422	-	-	-	Full	1.360	35	290	R3	
1	Premo Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	1.670	37	115	R5	
1 1/4	Premo Flex®	250	20	PC	20PC2F-4	80426	-	-	-	Full	1.990	38	385	R2	
1/4	Terminator®	501	4	PC	4PC2F-2	80416	-	-	-	Full	0.680	21	185	B5	
1/4	Terminator®	501	4	G	MegaCrimp®	-	-	-	0.94	Full	0.740	21	295	R3	
1/4	Terminator®	501	4	PC	4PC2F-2	80416	-	-	-	Full	0.680	31	315	R3	
1/4	Terminator®	501	4	G	MegaCrimp®	-	-	-	0.94	Full	0.740	31	435	W2	
3/8	Terminator®	501	6	PC	6PC2F-4	80462	-	-	-	Full	0.870	32	325	R3	
3/8	Terminator®	501	6	PC	6PC2F-4	80462	-	-	-	Full	0.870	22	325	R3	
3/8	Terminator®	501	6	G	MegaCrimp®	-	-	-	0.94	Full	0.920	32	430	R2	
3/8	Terminator®	501	6	G	MegaCrimp®	-	-	-	0.94	Full	0.920	22	430	R2	
1/2	Terminator®	501	8	PC	8PC2F-4	80463	-	-	-	Full	1.060	33	360	B3	
1/2	Terminator®	501	8	G	MegaCrimp®	-	-	-	1.25	Full	1.050	33	340	W3	
3/4	Terminator®	501	12	PC	12PC2F-4	80422	-	-	-	Full	1.360	35	290	R3	
3/4	Terminator®	501	12	G	MegaCrimp®	-	-	-	1.50	Full	1.430	35	420	W2	
1	Terminator®	501	16	G	MegaCrimp®	-	-	-	1.75	Full	1.785	37	355	W3	
1	Terminator®	501	16	PC	16PC2F-4	80425	-	-	-	Full	1.660	36	470	W1	
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	31	455	B2	
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	21	600	W3	
1/2	Thermo AG® 570	570	8	PC	8PC2F-2	80463	-	-	-	Full	0.960	33	162	R5	
3/4	Thermo AG® 570	570	12	PC	12PC2F-4	80422	-	-	-	Full	1.290	35	190	W5	
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	32	143	W1	
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	22	143	W1	
1/2	Thermo AG® 800	800	8	PC	8PC2F-2	80463	-	-	-	Full	0.960	33	162	R5	
3/4	Thermo AG® 800	800	12	PC	12PC2F-4	80422	-	-	-	Full	1.315	35	250	W4	

¹ See Adjustment Procedure at beginning of MobileCrimp® section. ² For aramid-reinforced Heatmaster® hose only.

OmniCrimp® 21 & Power Crimp® 3000B

OmniCrimp® 21



Power Crimp® 3000B



**Also includes
PC2001 data.**



Gates Corporation

Visit www.gates.com/ecrimp for hose crimp specs not listed in this catalog.

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Calibration Procedure

(For more detail, see Crimper Operators' Manual.)

Power Crimp® 3000B

NOTE: Check calibration after every 100 crimps.

The PC3000B Crimper may be calibrated with one of the hose and coupling combinations shown in Table 1.

Hose:	Stem:	Product to Crimp:	Setting:
8G2	MegaCrimp®	8G MegaCrimp coupling	2-1/4
8M2T®	MegaCrimp	8G MegaCrimp coupling	2-1/4

Table 1



Photo 1



Photo 2

1. Install the "33" die set. Ensure die is well lubricated.
 2. Set needle on switch box to **2 1/4** (See Photo 1). (The gauge setting is adjusted by always moving indicator upward to desired setting. Example: Change setting from 2 to 2-1/4, move the indicator to 3, then back up to 2-1/4. To change from 3 to 2, simply move the indicator directly to 2.)
 3. Insert assembly and press crimp switch.
 4. When crimp is complete, pump will automatically shut off and ram will return to start position.
 5. Remove assembly and measure crimp diameter across all four flats. The average of the four dimensions should measure 1.000" (± 0.003 "). To properly measure crimp diameter, refer to the Hose Assembly Guide instructions, Item #9, at the beginning of this manual.
 6. If ferrule is not 1.000" (± 0.003 ") crimp diameter, you must move the control box (See Photo 2).
 - a. To increase crimp O.D. – Loosen the two clamps holding switch box in place and move switch box down. (Moving crimp box by 1/8" changes the crimp O.D. by .033".) Tighten clamps after moving.
 - b. To decrease crimp O.D. – Loosen the two clamps holding switch box in place and move switch box up. (Moving crimp box by 1/8" changes the crimp O.D. by .033".) Tighten clamps after moving.
- CAUTION** – Do not over tighten bolts in clamps.
7. Repeat steps 3 thru 5 to verify correct crimp diameter.

OmniCrimp® 21

The OmniCrimp® 21 crimper is a self-calibrating machine. Each time the machine is turned on a self-calibration sequence is performed automatically. If you are experiencing a consistent problem of adjusting our published approximate settings, contact Gates Product Application at (303) 744-5070. A calibration check procedure is available.

Power Crimp® 2001

See Operators' Manual for details on calibration procedures for the Power Crimp 2001 crimper. This manual can be used for crimp information for the PC 2001 crimper. The crimp O.D. and the die set information in this manual applies to the PC 2001 crimper using the Gates FP dies. **Do not use this manual if using the TF or other non-Gates dies with the PC 2001 crimper.**

Note: Die sets referenced in this manual do not have the FP prefix. (i.e., die set 30 = FP30 for the PC 2001 crimper).

Adjustment Procedures

CAUTION: Digital Readout Settings are Approximate! Machining tolerances exist for each crimper, die set, and supporting piece of equipment which will effect your actual setting. Always check the Crimp Diameter to assure that it is within published limits and record your actual crimper setting to achieve the specified crimp diameter in the user space provided for future use.

Power Crimp® 3000B

Setting Adjustment

The setting is adjusted by always moving the indicator upward to the desired setting. Example: to change the setting from 2 to 3, first lower the indicator to 4, then move it back up to 3. To change from 3 to 2, simply move the indicator directly to 2.

Controller Adjustment

To obtain a smaller crimp diameter (Crimp OD), change the setting to a smaller number, or vice versa. Changing the setting by 1 (Example: 1 to 2) will change crimp diameter by .030".

$$\left(\begin{array}{c} \text{Target} \\ \text{Crimp OD} \end{array} - \begin{array}{c} \text{Measured} \\ \text{Crimp OD} \end{array} \right) \times 30 + \begin{array}{c} \text{Published} \\ \text{Approx.} \\ \text{Setting} \end{array} = \begin{array}{c} \text{Adjusted} \\ \text{Setting} \end{array}$$

OmniCrimp® 21

Digital Readout Adjustment

To obtain a smaller crimp diameter, change the digital readout to a larger number. To obtain a larger crimp diameter, use a smaller number. Changing the digital readout by .005 (Example: 1.000 to 1.005) will change the crimp diameter by .005".

$$\left(\begin{array}{c} \text{Measured} \\ \text{Crimp OD} \end{array} - \begin{array}{c} \text{Target} \\ \text{Crimp OD} \end{array} \right) + \begin{array}{c} \text{Published} \\ \text{Approx.} \\ \text{Setting} \end{array} = \begin{array}{c} \text{Adjusted} \\ \text{Setting} \end{array}$$

Setting Digital Readout

The digital readout is adjusted by pressing the Crimp-Decrease or Crimp-Increase button.

PC 2001

Setting Adjustment

Reference Operator's manual for PC 2001 Adjustment Procedure.

PC 2001 Die Closures for Programming the Minimum Swaging Diameter

To convert the Crimp Outer Diameters listed in this manual to the metric measurements used in many Finn Power machines, multiply the Crimp Outer Diameter value listed for the particular hose/coupling combination by 25.4. Example: For the -6M3K with the -6 MegaCrimp® coupling, the Crimp Outer Diameter is 0.810 inch. When you multiply 0.810 inch by 25.4, this gives a value of 20.574 or 20.6 mm.

DIE SET	Closure (In.)	Closure (mm)
FP 31	0.600	15.2
FP 21	0.660	16.8
FP 32	0.780	19.8
FP 22	0.780	19.8
FP 33	0.950	24.1
FP 34	1.110	28.2
FP 35	1.280	32.5
FP 36	1.490	37.8
FP 37	1.675	42.5
FP 38	1.860	47.2
FP 39	2.020	51.3
FP 310L	2.180	55.3
FP 311	2.320	58.9
FP 312	2.690	68.3
FP 313	2.800	71.1
FP 314	3.000	76.2
FP 301	4.200	10.7

REMEMBER: Record your Actual adjusted crimp setting in the column provided in the crimp data chart.



Crimp Tooling

OmniCrimp® 21 Dies

Die Sets

Die Set	OM21/ OM31	OM22/ OM32	OM33	OM34	OM35	OM37	OM39
Part No.	78263/ 78294	78264/ 78295	78296	78276	78277	78279	78281
Product No.	7482-1222/ 7482-0730	7482-1223/ 7482-0731	7482-0732	7482-0672	7482-0673	7482-0716	7482-0717

Die Set	OM310L ¹	OM311	OM312	OM313	OM314	OM24C4	OM32C4
Part No.	78298	78284	78285	78286	78287	78292	78293
Product No.	7482-1156	7482-0721	7482-0677	7482-0722	7482-0723	7482-0724	7482-0725

¹ 310L supersedes 310 die. (Applies to OmniCrimp 21 / PC 3000B / PC 2001)

Specialty and Automotive Dies

Die Set	OM331	OM301	OM6AC	OM8AC	OM10AC	OM12AC
Part No.	78297	78282	78288	78289	78290	78291
Product No.	7482-0733	7482-0718	7482-0726	7482-0727	7482-0728	7482-0729
Use	Clamp Collars	Grease Fitting	6AC134a	8AC134a	10AC134a	12AC134a

GLP Dies

Die Set	OM71	OM72	OM73	OM74	OM75
Part No.	78671	78672	78673	78674	78675
Product No.	7482-7200	7482-7201	7482-7202	7482-7203	7482-7204

GL Dies

Die Set	OM81	OM82	OM83	OM84	OM85
Part No.	78585	78586	78587	78588	78589
Product No.	7482-1241	7482-1242	7482-1243	7482-1244	7482-1245

Die Tooling Supplies

Item	Part No.	Product No.
3oz Jar Molykote G Paste	78755	7482-0311
Digital Caliper	78241	7369-0322

Crimp Tooling

Power Crimp® 3000B Dies

Die Sets

Die Set	21/ 31	22/ 32	33	34	35	37	39
Part No.	78358/ 78305	78359/ 78306	78307	78308	78309	78311	78313
Product No.	7482-1224/ 7482-6515	7482-1225/ 7482-6516	7482-6517	7482-6518	7482-6519	7482-6582	7482-7011

Die Set	310L ¹	311	312	313	314	24C4	32C4
Part No.	78357	78316	78317	78318	78319	78355	78356
Product No.	7482-1127	7482-7023	7482-7029	7482-6523	7482-0298	7482-6583	7482-6584

¹ 310L supersedes 310 die. (Applies to OmniCrimp 21 / PC 3000B / PC 2001)

Specialty and Automotive Dies

Die Set	301	6AC	8AC	10AC	12AC
Part No.	78334	78300	78301	78302	78303
Product No.	7482-5009	7482-0550	7482-0551	7482-0552	7482-0553
Use	Grease Fitting	6AC134a	8AC134a	10AC134a	12AC134a

GL Dies

Die Set	81	82	83	84	85
Part No.	78582	78583	78584	78592	78593
Product No.	7482-1234	7482-1235	7482-1236	7482-1237	7482-1238

Die Tooling Supplies

Item	Part No.	Product No.
3oz Jar Molykote G Paste	78755	7482-0311
Digital Caliper	78241	7369-0322



Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Hose			Stem	Ferrule		Skive/Buf		Crimp		Crimper				
Dash Size	Description	Size (In.)	Type	Description	Part No.	Length .03 (In.)	Dia. (In.)	Insertion Length .03 (In.)	Crimp Length	Crimp O.D. 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Actual Setting
16	BOP	1	16GS	16GS1F-4	G20995-416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
4	C5C	3/16	3PC	4PC2F-2	80416	-----	-----	-----	FULL	0.620	31	1	1.452	
5	C5C	1/4	4PC	4PC2F-2	80416	-----	-----	-----	FULL	0.690	21	1 1/4	1.453	
5	C5C	1/4	4PC	4PC2F-2	80416	-----	-----	-----	FULL	0.690	31	3 1/4	1.383	
6	C5C	5/16	5PC	6PC2F-2	80418	-----	-----	-----	FULL	0.765	21	3 1/2	1.388	
6	C5C	5/16	5PC	6PC2F-2	80418	-----	-----	-----	FULL	0.765	31	5 1/2	1.309	
8	C5C	13/16	6PC	6PC1FS	80484	-----	-----	-----	FULL	0.860	22/32	3 1/4	1.388	
10	C5C	1/2	8PC	10PC2F-2B	80476	-----	-----	-----	FULL	1.050	33	3 1/2	1.377	
12	C5C	5/8	10PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.230	34	3 3/4	1.359	
4	C5E	3/16	3PC	3PC2F-2	80415	-----	-----	-----	FULL	0.660	31	2 1/4	1.412	
5	C5E	1/4	4PC	4PC2F-2	80416	-----	-----	-----	FULL	0.660	31	2 1/4	1.412	
6	C5E	5/16	5PC	5PC1FS	80483	-----	-----	-----	FULL	0.795	22/32	1 1/4	1.451	
8	C5E	13/16	6PC	6PC1FS	80484	-----	-----	-----	FULL	0.890	22/32	4 1/4	1.359	
10	C5E	1/2	8PC	8PC2F-2	80419	-----	-----	-----	FULL	0.990	33	1 3/4	1.434	
12	C5E	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.140	34	1 1/4	1.447	
6	C12M	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	C12M	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	33	5	1.329	
12	C12M	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	C12M	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	C12M	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
24	C12	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	311	0	1.469	
24	C12	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	310L ³	2 1/2	1.432	
32	C12	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	313	4	1.343	
32	C12	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	312	3	1.398	
6	C12M-MTF	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	C12M-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	33	5	1.329	
12	C12M-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	C12M-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	C12M-MTF	1	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
24	C12-MTF	1	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	311	0	1.469	
24	C12-MTF	1	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	310L ³	2 1/2	1.432	
32	C12-MTF	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	313	4	1.343	
32	C12-MTF	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	312	3	1.398	
6	CM2T	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.880	22/32	3 1/2	1.378	
8	CM2T	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.040	33	3	1.391	
12	CPSSGS	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	35	6 1/4	1.262	
16	CPS	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	CPS	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	310L ³	1 3/4	1.447	
24	CPS	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	311	3	1.350	
32	CPS	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	314	2 3/4	1.395	
12	CPSSGS-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	35	6 1/4	1.262	
16	CPS-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	CPS-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	310L ³	1 3/4	1.447	
24	CPS-MTF	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	311	3	1.350	
32	CPS-MTF	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	314	2 3/4	1.395	
20	EFG3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
20	EFG3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
6	EFG4K	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	EFG4K	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	33	6	1.355	
10	EFG4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	EFG4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	EFG4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	EFG4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
6	EFG4K-MTF	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	EFG4K-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	33	6	1.355	
10	EFG4K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	EFG4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	EFG4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	EFG4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
6	EFG5K	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	EFG5K	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	33	6	1.355	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.

Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Dash Size	Hose		Stem	Ferrule		Skive/Buf		Crimp			Crimper			User's Actual Setting
	Description	Size (In.)		Type	Description	Part No.	Length .03 (In.)	Dia. (In.)	Insertion Length .03 (In.)	Crimp Length	Crimp O.D. 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	
10	EFG5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	EFG5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	EFG5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	EFG5K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.230	310L ³	2	1.420	
6	EFG5K-MTF	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	EFG5K-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	33	6	1.355	
10	EFG5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	EFG5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	EFG5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	EFG5K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.230	310L ³	2	1.420	
6	EFG6K	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	EFG6K	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	33	6	1.355	
10	EFG6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	EFG6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	EFG6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	EFG6K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.230	310L ³	2	1.420	
6	EFG6K-MTF	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
8	EFG6K-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	33	6	1.355	
10	EFG6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	EFG6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	EFG6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	EFG6K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.230	310L ³	2	1.420	
3	G1	3/16	3PC	3PC1FS	80481	-----	-----	-----	FULL	0.620	31	1	1.452	
3	G1	3/16	3PC	3PC2F-2	80415	0.835	WIRE	-----	FULL	0.620	31	1	1.452	
3	G1	3/16	Grease	3MPG	-----	0.625	WIRE	-----	0.500	0.450	301	1 1/2	1.430	
3	G1	3/16	Grease	3MPGB	-----	0.625	WIRE	-----	0.500	0.450	301	1 1/2	1.430	
4	G1	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	21	1 3/4	1.440	
4	G1	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	31	3 3/4	1.368	
5	G1	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.790	22/32	1	1.454	
6	G1	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.845	22/32	2 3/4	1.402	
8	G1	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.010	33	2 1/2	1.413	
10	G1	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.135	34	1	1.452	
12	G1	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.350	35	2	1.407	
16	G1	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.760	37	3 1/2	1.398	
20	G1	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.050	39	3/4	1.450	
24	G1	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.240	310L ³	2 1/2	1.438	
32	G1	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.845	313	3/4	1.455	
4	G1H	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.720	21	2	1.427	
4	G1H	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.720	31	4	1.353	
6	G1H	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.845	22/32	2 3/4	1.402	
8	G1H	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.020	33	2 3/4	1.406	
10	G1H	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.135	34	1	1.452	
12	G1H	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.350	35	2	1.407	
16	G1H	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.760	37	3 1/2	1.398	
20	G1H	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.050	39	3/4	1.450	
24	G1H	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.240	310L ³	2 1/2	1.438	
24	G1H	1 1/2	24PC	24PC2F-4	80428	2.280	WIRE	-----	FULL	2.140	39	3 1/2	1.371	
32	G1H	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.845	313	3/4	1.455	
32	G1H	2	32PC	32PC2F-4	80429	2.750	WIRE	-----	FULL	2.800	313	0	1.503	
3	G2	3/16	3PC	3PC1FS	80481	-----	-----	-----	FULL	0.655	31	2	1.417	
3	G2	3/16	3PC	3PC2F-2	80415	0.750	WIRE	-----	FULL	0.655	31	2	1.417	
4	G2	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	21	3 1/4	1.410	
4	G2	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	31	4 3/4	1.333	
6	G2	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.890	22/32	4 1/4	1.359	
8	G2	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.050	33	3 1/2	1.377	
10	G2	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	
12	G2	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
16	G2	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.790	37	4 1/2	1.368	
20	G2	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.125	39	3	1.384	
24	G2	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	310L ³	5 3/4	1.324	
32	G2	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	313	4 1/4	1.333	
8	G2AT-HMP	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.050	33	3 1/2	1.377	
10	G2AT-HMP	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.



Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Dash Size	Hose		Stem Type	Ferrule		Skive/Buf		Crimp			Crimper			User's Actual Setting
	Description	Size (In.)		Description	Part No.	Length ϕ .03 (In.)	Dia. (In.)	Insertion Length ϕ .03 (In.)	Crimp Length	Crimp O.D. ϕ 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	
12	G2AT-HMP	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
16	G2AT-HMP	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.790	37	4 1/2	1.368	
20	G2H	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.125	39	3	1.384	
24	G2H	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	310L ³	5 3/4	1.324	
24	G2H	1 1/2	24PC	24PC2F-4	80428	2.280	WIRE	-----	FULL	2.255	310L ³	3	1.425	
32	G2H	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	313	4 3/4	1.317	
32	G2H	2	32PC	32PC2F-4	80429	2.750	WIRE	-----	FULL	2.900	313	2 1/2	1.397	
20	G2H-MTF	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.125	39	3	1.384	
24	G2H-MTF	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	310L ³	5 3/4	1.324	
32	G2H-MTF	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	313	4 3/4	1.317	
4	G2L	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.730	21	2 3/4	1.419	
4	G2L	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.730	31	4 3/4	1.343	
6	G2L	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.880	22/32	3 3/4	1.368	
8	G2L	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.040	33	3 1/2	1.393	
10	G2L	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.160	34	1 3/4	1.423	
12	G2L	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.385	35	3	1.373	
16	G2L	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.790	37	4 1/2	1.368	
20	G2L	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.125	39	3	1.384	
24	G2L	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	310L ³	5 3/4	1.324	
32	G2L	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	313	4 3/4	1.317	
4	G2XH	1/4	04G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	31	4 3/4	1.334	
6	G2XH	3/8	06G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.890	32	4 1/4	1.359	
8	G2XH	1/2	08G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.050	33	3 1/2	1.377	
10	G2XH	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	
12	G2XH	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.368	
16	G2XH	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.760	37	3 1/2	1.398	
4	G3H	1/4	4PC	4PC2F-2	80416	0.785	0.540	-----	FULL	0.670	21	1/4	1.471	
4	G3H	1/4	4PC	4PC2F-2	80416	0.785	0.540	-----	FULL	0.670	31	2 1/2	1.402	
5	G3H	5/16	5PC	5PC2F-2	80417	0.750	0.620	-----	FULL	0.775	21	3 3/4	1.379	
5	G3H	5/16	5PC	5PC2F-2	80417	0.750	0.620	-----	FULL	0.775	31	5 3/4	1.299	
6	G3H	3/8	6PC	6PC2F-2	80418	0.785	0.690	-----	FULL	0.785	22/32	1	1.461	
8	G3H	1/2	8PC	10PC2F-2B	80476	0.880	0.900	-----	FULL	1.035	33	3	1.391	
12	G3H	3/4	12PC	12PC2F-4	80422	1.562	1.200	-----	FULL	1.365	35	2 1/4	1.392	
16	G3H	1	16PC	16PC2F-2	80424	1.500	1.450	-----	FULL	1.615	36	4 1/2	1.365	
20	G3H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.985	38	3 1/4	1.360	
20	G3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
24	G3K	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	311	0	1.469	
24	G3K	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	310L ³	2 1/2	1.432	
32	G3K	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	313	4	1.343	
32	G3K	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	312	3	1.398	
20	G3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
24	G3K-MTF	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	311	0	1.469	
24	G3K-MTF	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	310L ³	2 1/2	1.432	
32	G3K-MTF	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	313	4	1.343	
32	G3K-MTF	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	312	3	1.398	
12	G4H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.330	35	1 1/4	1.426	
12	G4H	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	35	1	1.436	
16	G4H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.700	36	7	1.281	
16	G4H	1	16PC	16PC2F-4	80425	-----	-----	-----	FULL	1.680	36	6 1/4	1.301	
20	G4H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	2.010	38	3 3/4	1.335	
20	G4H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.960	38	2 1/2	1.384	
10	G4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	G4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	G4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	G4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
6	G4K-MTF	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	G4K-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.110	33	5	1.329	
12	G4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	G4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	G4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
8	G5K	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	33	5	1.329	
10	G5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.



Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Dash Size	Hose		Stem	Ferrule		Skive/Buf		Crimp			Crimper			User's Actual Setting
	Description	Size (In.)		Description	Part No.	Length .03 (In.)	Dia. (In.)	Insertion Length .03 (In.)	Crimp Length	Crimp O.D. 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	
12	G5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	35	6 1/4	1.262	
16	G5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	G5K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	310L ³	1 3/4	1.447	
24	G5K	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	311	3	1.350	
32	G5K	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	314	2 3/4	1.395	
8	G5K-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	33	5	1.329	
10	G5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	G5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	35	6 1/4	1.262	
16	G5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	G5K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	310L ³	1 3/4	1.447	
24	G5K-MTF	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	311	3	1.350	
32	G5K-MTF	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	314	2 3/4	1.395	
6	G6K	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	G6K	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	33	5	1.329	
10	G6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	G6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	35	6 1/4	1.262	
16	G6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	G6K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	310L ³	1 3/4	1.447	
24	G6K	1 1/2	24PCM	24PCM2F-G6	-----	2.750	WIRE	-----	FULL	2.470	311	2 3/4	1.360	
6	G6K-MTF	3/8	6GS	6GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	33	1 1/2	1.455	
8	G6K-MTF	1/2	8GS	8GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	33	5	1.329	
10	G6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	35	1	1.436	
12	G6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	35	6 1/4	1.262	
16	G6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
20	G6K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	310L ³	1 3/4	1.447	
12	GMV	3/4	12G	MegaCrimp®	-----	1.375	1.200	1.50	FULL	1.430	35	4 1/4	1.329	
16	GMV	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.800	37	4 3/4	1.358	
20	GMV	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.110	39	2 1/2	1.397	
24	GMV	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.320	310L ³	5	1.351	
24	GMV	1 1/2	24PC	24PC2F-4	80428	-----	-----	-----	FULL	2.240	310L ³	2 1/2	1.438	
32	GMV	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.910	313	2 3/4	1.386	
32	GMV	2	32PC	32PC2F-4	80429	-----	-----	-----	FULL	2.860	312	5 3/4	1.318	
4	GT7	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	21	1 3/4	1.440	
4	GT7	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	31	3 3/4	1.368	
5	GT7	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.755	21	3 1/4	1.396	
5	GT7	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.755	31	5 1/4	1.319	
6	GT7	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.865	22/32	3 1/2	1.383	
8	GT7	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.020	33	2 3/4	1.406	
12	GT7	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.330	35	1 1/4	1.426	
4	GT8	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.750	21	3 1/4	1.401	
4	GT8	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.750	31	5 1/4	1.324	
6	GT8	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.900	22/32	4 1/4	1.355	
8	GT8	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.040	33	3 1/2	1.393	
12	GT8	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.360	35	2	1.400	
3	GTH	3/16	3PC	3PC2F-2	80415	0.687	0.410	-----	FULL	0.635	31	1 1/2	1.437	
4	GTH	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.750	21	3 1/4	1.401	
4	GTH	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.750	31	5 1/4	1.324	
5	GTH	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.790	21	4	1.353	
5	GTH	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.790	31	6	1.284	
6	GTH	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.850	22/32	3	1.397	
8	GTH	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.035	33	3	1.391	
10	GTH	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.154	34	1 1/2	1.425	
12	GTH	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.390	35	3	1.368	
24	HO	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	310L ³	5 3/4	1.324	
4	J2AT	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	21	3	1.410	
4	J2AT	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	31	4 3/4	1.334	
6	J2AT	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.895	22/32	4 1/4	1.354	
4	J2AT-MTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	21	3	1.410	
4	J2AT-MTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	31	4 3/4	1.334	
6	J2AT-MTF	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.895	22/32	4 1/4	1.354	
12	LW	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	
16	LW	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
12	LW-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	35	5 1/2	1.294	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.



Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Dash Size	Hose		Stem	Ferrule		Skive/Buf		Crimp			Crimper			
	Description	Size (In.)	Type	Description	Part No.	Length ϕ .03 (In.)	Dia. (In.)	Insertion Length ϕ .03 (In.)	Crimp Length	Crimp O.D. ϕ 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Actual Setting
16	LW-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	37	3 1/4	1.408	
4	M2T [®]	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.715	21	2	1.432	
4	M2T [®]	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
4	M2T [®]	1/4	4PC-SS	4PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	31	2 1/4	1.412	
6	M2T [®]	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.870	22/32	3 1/2	1.378	
6	M2T [®]	3/8	6PC-SS	6PC1F-M2SS	85028	-----	-----	-----	FULL	0.810	22/32	1 3/4	1.436	
8	M2T [®]	1/2	8G	MegaCrimp [®]	-----	-----	-----	1.25	FULL	1.035	33	3	1.391	
8	M2T [®]	1/2	8PC-SS	8PC1F-M2SS	85029	-----	-----	-----	FULL	1.000	33	2	1.425	
10	M2T [®]	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.155	34	1 1/2	1.432	
10	M2T [®]	5/8	10PC-SS	10PC1F-M2SS	85030	-----	-----	-----	FULL	1.110	33	5 1/4	1.320	
12	M2T [®]	3/4	12G	MegaCrimp [®]	-----	-----	-----	1.50	FULL	1.370	35	2 1/2	1.387	
12	M2T [®]	3/4	12PC-SS	12PC1F-M2SS	85031	-----	-----	-----	FULL	1.330	35	1 1/4	1.426	
16	M2T [®]	1	16G	MegaCrimp [®]	-----	-----	-----	1.75	FULL	1.725	37	2 1/2	1.433	
16	M2T [®]	1	16PC-SS	16PC1F-M2SS	85032	-----	-----	-----	FULL	1.655	36	5 1/2	1.326	
4	M2T [®] -MTF	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.715	21	2	1.432	
4	M2T [®] -MTF	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
6	M2T [®] -MTF	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.870	22/32	3 1/2	1.378	
8	M2T [®] -MTF	1/2	8G	MegaCrimp [®]	-----	-----	-----	1.25	FULL	1.035	33	3	1.391	
10	M2T [®] -MTF	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.155	34	1 1/2	1.432	
12	M2T [®] -MTF	3/4	12G	MegaCrimp [®]	-----	-----	-----	1.50	FULL	1.370	35	2 1/2	1.387	
16	M2T [®] -MTF	1	16G	MegaCrimp [®]	-----	-----	-----	1.75	FULL	1.725	37	2 1/2	1.433	
10	M2TH	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.145	34	1 1/4	1.444	
4	M3K	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	21	1 3/4	1.445	
4	M3K	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	31	3 1/2	1.373	
5	M3K	5/16	5G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.790	22/32	1	1.454	
6	M3K	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.810	22/32	1 3/4	1.436	
8	M3K	1/2	8G	MegaCrimp [®]	-----	-----	-----	1.25	FULL	1.000	33	2	1.425	
10	M3K	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	
12	M3K	3/4	12G	MegaCrimp [®]	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M3K	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
16	M3K	1	16G	MegaCrimp [®]	-----	-----	-----	1.75	FULL	1.800	37	4 3/4	1.358	
16	M3K	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	36	4 1/4	1.373	
20	M3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.060	39	1	1.455	
4	M3K-MTF	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	21	1 3/4	1.445	
4	M3K-MTF	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	31	3 1/2	1.373	
6	M3K-MTF	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.810	22/32	1 3/4	1.436	
8	M3K-MTF	1/2	8G	MegaCrimp [®]	-----	-----	-----	1.25	FULL	1.000	33	2	1.425	
10	M3K-MTF	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	
12	M3K-MTF	3/4	12G	MegaCrimp [®]	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M3K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
16	M3K-MTF	1	16G	MegaCrimp [®]	-----	-----	-----	1.75	FULL	1.800	37	4 3/4	1.358	
16	M3K-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	36	4 1/4	1.373	
4	M3K-XTF	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	21	1 3/4	1.445	
4	M3K-XTF	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	31	3 1/2	1.373	
5	M3K-XTF	5/16	5G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.790	22/32	1	1.454	
6	M3K-XTF	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.810	22/32	1 3/4	1.436	
8	M3K-XTF	1/2	8G	MegaCrimp [®]	-----	-----	-----	1.25	FULL	1.000	33	2	1.425	
10	M3K-XTF	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	
12	M3K-XTF	3/4	12G	MegaCrimp [®]	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M3K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
16	M3K-XTF	1	16G	MegaCrimp [®]	-----	-----	-----	1.75	FULL	1.800	37	4 3/4	1.358	
16	M3K-XTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	36	4 1/4	1.373	
4	M3KH	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	21	1 3/4	1.445	
4	M3KH	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	31	3 1/2	1.373	
6	M3KH	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	21	1 3/4	1.445	
6	M3KH	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.700	31	3 1/2	1.373	
8	M3KH	1/2	8G	MegaCrimp [®]	-----	-----	-----	1.25	FULL	1.040	33	2	1.425	
10	M3KH	5/8	10G	MegaCrimp [®]	-----	-----	-----	1.12	FULL	1.170	34	2	1.418	
12	M3KH	3/4	12G	MegaCrimp [®]	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M3KH	3/4	12GS	12GX1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
4	M4K+	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.715	21	2	1.432	
4	M4K+	1/4	4G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
6	M4K+	3/8	6G	MegaCrimp [®]	-----	-----	-----	0.93	FULL	0.870	22/32	3 1/2	1.378	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

OmniCrimp® 21, PC 3000B, PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive/Buf		Crimp			Crimper			
	Description	Size (In.)	Type	Description	Part No.	Length ϕ .03 (In.)	Dia. (In.)	Insertion Length ϕ .03 (In.)	Crimp Length	Crimp O.D. ϕ 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Act. Setting
8	M4K+	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.040	33	3 1/2	1.393	
10	M4K+	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.160	34	1 3/4	1.423	
12	M4K+	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M4K+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
4	M4K+-MTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	21	2	1.432	
4	M4K+-MTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
6	M4K+-MTF	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.870	22/32	3 1/2	1.378	
8	M4K+-MTF	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.060	33	3 3/4	1.367	
10	M4K+-MTF	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.160	34	1 3/4	1.423	
12	M4K+-MTF	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M4K+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
4	M4K+-XTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	21	2	1.432	
4	M4K+-XTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
6	M4K+-XTF	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.870	22/32	3 1/2	1.378	
8	M4K+-XTF	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.035	33	3	1.391	
10	M4K+-XTF	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.160	34	1 3/4	1.423	
12	M4K+-XTF	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M4K+-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
4	M4KH	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
6	M4KH	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.025	33	2 3/4	1.401	
8	M4KH	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.165	34	1 3/4	1.418	
10	M4KH	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.365	35	3 1/4	1.363	
12	M4KH	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M4KH	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
12	M4KH-MTF	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	M4KH-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
4	M5K	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	21	2	1.432	
4	M5K	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.715	31	4	1.358	
4	M5K	1/4	4PC-SS	4PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	31	2 1/4	1.412	
5	M5K	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.795	32	1.25	1.451	
6	M5K	3/8	6G	MegaCrimp®	-----	-----	-----	-----	FULL	0.860	22/32	3 1/4	1.388	
8	M5K-XTF													
4	M6K	1/4	4G	MegaCrimp®	-----	-----	-----	-----	FULL	0.740	21	3	1.410	
4	M6K	1/4	4G	MegaCrimp®	-----	-----	-----	-----	FULL	0.740	31	4 3/4	1.333	
4	MCPB+	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	21	3	1.410	
4	MCPB+	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	31	4 3/4	1.334	
6	MCPB+	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.895	22/32	4 1/4	1.354	
8	MCPB+	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.060	33	3 3/4	1.367	
12	MCPB+	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	MCPB+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
16	MCPB+	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.800	37	4 3/4	1.358	
16	MCPB+	1	16GS	16GS1F-2	G20995-0216	-----	-----	-----	FULL	1.610	36	4 1/4	1.373	
20	MCPB+	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.125	39	3	1.384	
4	MCPB+-MTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	21	3	1.410	
4	MCPB+-MTF	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.740	31	4 3/4	1.334	
6	MCPB+-MTF	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.895	22/32	4 1/4	1.354	
8	MCPB+-MTF	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.060	33	3 3/4	1.367	
12	MCPB+-MTF	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.395	35	3 1/4	1.363	
12	MCPB+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	35	1/2	1.455	
16	MCPB+-MTF	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.800	37	4 3/4	1.358	
16	MCPB+-MTF	1	16GS	16GS1F-2	G20995-0216	-----	-----	-----	FULL	1.610	36	4 1/4	1.373	
20	MCPB+-MTF	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.125	39	3	1.384	
4	MegaTech™ 250	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.680	21	1 3/4	1.461	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.



Hydraulic Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Dash Size	Hose		Stem	Ferrule		Skive/Buf		Crimp			Crimper			
	Description	Size (In.)	Type	Description	Part No.	Length .03 (In.)	Dia. (In.)	Insertion Length .03 (In.)	Crimp Length	Crimp O.D. 0.10 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Actual Setting
24	MegaTech™ 500	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.240	39	6 1/4	1.370	
32	MegaTech™ 500	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.845	313	3/4	1.455	
4	MegaTech™ 1000	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.700	21	1 3/4	1.445	
4	MegaTech™ 1000	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.700	31	3 1/2	1.373	
6	MegaTech™ 1000	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.810	22/32	1 3/4	1.436	
8	MegaTech™ 1000	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	0.980	33	1 1/2	1.444	
10	MegaTech™ 1000	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.160	34	1 3/4	1.423	
12	MegaTech™ 1000	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.380	35	2 3/4	1.377	
16	MegaTech™ 1000	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.700	37	1 1/2	1.458	
20	MegaTech™ 1000	1 1/4	20G	MegaCrimp®	-----	-----	-----	1.75	FULL	2.020	38	4 1/4	1.325	
8	MegaTech™ 3000	1/2	08G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.050	33	3 1/2	1.377	
24	MegaTech™ II ACP	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.330	310L ³	6	1.340	
32	MegaTech™ II ACP	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.950	313	4	1.343	
4	RFS	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	21	1 3/4	1.440	
4	RFS	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	31	3 3/4	1.368	
6	RFS	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.705	21	3 3/4	1.368	
6	RFS	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.845	22/32	2 3/4	1.402	
8	RFS	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.010	33	2 1/2	1.415	
12	RFS	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.350	35	2	1.407	
16	RFS	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.760	37	3 1/2	1.398	
4	GTH	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.750	31	5 1/4	1.324	
4	GTH	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.750	21	3 1/4	1.400	
6	GTH	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.850	22	3	1.400	
8	GTH	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.035	33	3	1.391	
10	GTH	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.154	34	1 1/2	1.425	
12	GTH	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.390	35	3	1.368	
3	RLA	3/16	3PC	3PC2F-2	80415	-----	-----	-----	FULL	0.640	31	1 3/4	1.432	
4	RLA	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.720	21	2	1.427	
4	RLA	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.720	31	4	1.353	
5	RLA	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.770	21	3 3/4	1.384	
5	RLA	5/16	5G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.770	31	5 3/4	1.304	
6	RLA	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.860	22/32	3 1/4	1.388	
8	RLA	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	1.080	33	4 1/2	1.348	
10	RLA	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.140	34	1 1/4	1.447	
12	RLA	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.430	35	4 1/4	1.329	
16	RLA	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.690	37	1 1/4	1.468	
32	SHR	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	313	4	1.343	
32	SHR	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	312	3	1.398	
4	TR500	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.680	31	3	1.393	
4	TR500	1/4	4G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.680	21	3/4	1.460	
6	TR500	3/8	6G	MegaCrimp®	-----	-----	-----	0.93	FULL	0.810	22	1 3/4	1.440	
6	TR500	3/8	6G	MegaCrimp®	-----	-----	-----	-----	FULL	0.810	32	1 3/4	1.436	
8	TR500	1/2	8G	MegaCrimp®	-----	-----	-----	1.25	FULL	0.980	33	1 1/2	1.444	
10	TR500	5/8	10G	MegaCrimp®	-----	-----	-----	1.12	FULL	1.130	34	1	1.457	
12	TR500	3/4	12G	MegaCrimp®	-----	-----	-----	1.50	FULL	1.300	35	1/2	1.462	
16	TR500	1	16G	MegaCrimp®	-----	-----	-----	1.75	FULL	1.580	36	3 1/4	1.403	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² MPLN Couplings Only. ³ The 310L die supersedes the 310 die.

GLP Coupling Crimping Instructions

OmniCrimp® 21

Crimping Instructions for the GLP coupling on the Omni21

See Figure 1 for proper alignment of coupling in die prior to crimping.

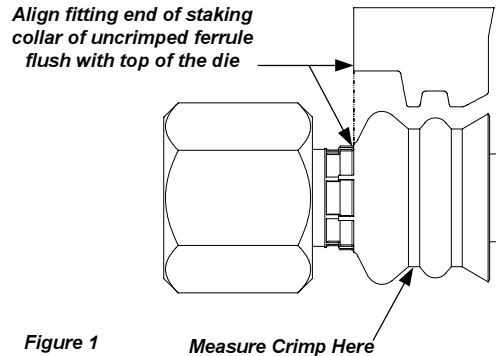


Figure 1 Measure Crimp Here

Dash Size	Hose		Stem Type	Ferrule		Crimp		Crimper		
	Description	Size (in.)		Description	Prod. No.	Insertion Length +/- .03(in)	Crimp OD	Die Set	Omni Digital Setting	User's Actual Setting
4	LOC	1/4	GLP1	1-pc GLP1	-----	0.66	0.470	OM71		
6	LOC	3/8	GLP1	1-pc GLP1	-----	0.77	0.620	OM72		
8	LOC	1/2	GLP5	1-pc GLP1	-----	0.72	0.740	OM73		
10	LOC	5/8	GLP1	1-pc GLP1	-----	0.75	0.920	OM74		
12	LOC	3/4	GLP1	1-pc GLP1	-----	0.75	1.000	OM75		
4	LOL	1/4	GLP1	1-pc GLP1	-----	0.66	0.470	OM71		
6	LOL	3/8	GLP1	1-pc GLP1	-----	0.77	0.620	OM72		
8	LOL	1/2	GLP1	1-pc GLP1	-----	0.72	0.740	OM73		
10	LOL	5/8	GLP1	1-pc GLP1	-----	0.75	0.910	OM74		
12	LOL	3/4	GLP1	1-pc GLP1	-----	0.98	1.040	OM75		

GLP Crimp data for the OmniCrimp® 21 will be appearing shortly in Ecrimp 3.91.

GL Coupling Crimping Instructions

OmniCrimp® 21

To achieve proper tail length, line up hose end of ferrule with “locating step” on die inside diameter (I.D.) prior to crimping (See Figure 1 or 2 depending on die). Be sure die fingers are all the way forward and locked in place in die shoes.

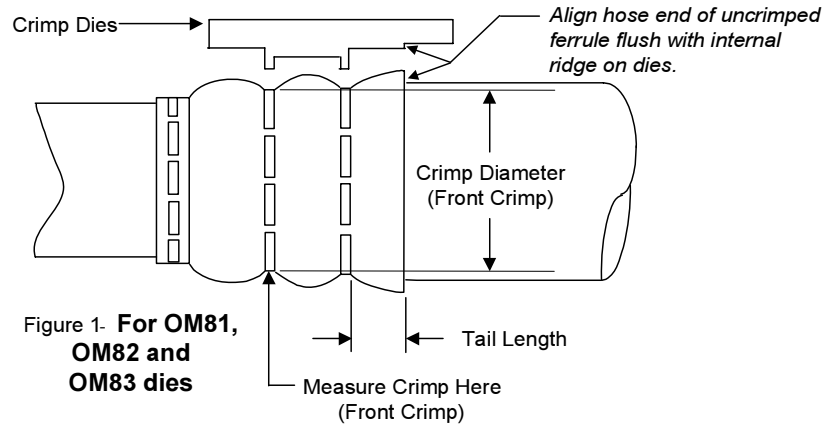


Figure 1- For OM81, OM82 and OM83 dies

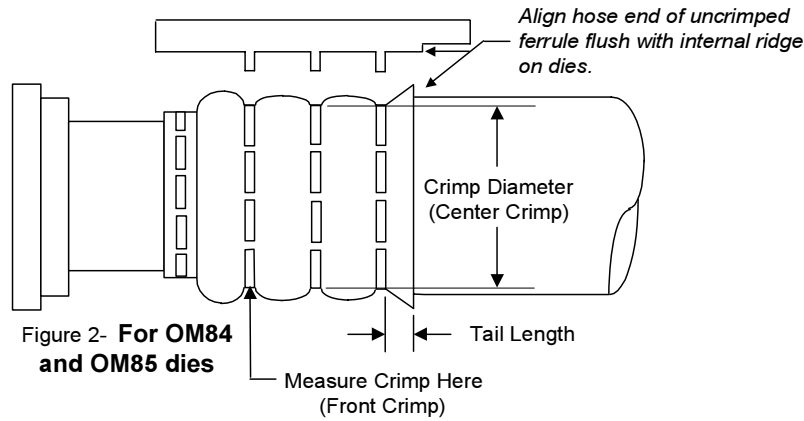


Figure 2- For OM84 and OM85 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- .10(in)	Crimp OD +/- .010(in.)	Die Set	OMNI Digital Setting	User's Actual Setting
12	GMV	3/4	12GL	1-pc GL	-----	-----	-----	1.750	0.50	1.120	OM81	1.430	
16	GMV	1	16GL	1-pc GL	-----	-----	-----	2.125	0.60	1.360	OM82	1.425	
20	GMV	1 1/4	20GL	1-pc GL	-----	-----	-----	2.250	0.50	1.660	OM83	1.420	
24	GMV	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	OM84	1.400	
32	GMV	2	32GL	1-pc GL	-----	-----	-----	2.750	0.50	2.430	OM85	1.400	
24	MEGATECH ACR	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	OM84	1.400	
32	MEGATECH ACR	2	32GL	1-pc GL	-----	-----	-----	2.750	0.50	2.410	OM85	1.390	

GL Coupling Crimping Instructions

Power Crimp® 3000B

To achieve proper tail length, line up hose end of ferrule with "locating step" on die inside diameter (I.D.) for -12, -16 and -20GMV (see Figure 1) prior to crimping. See below for -24 and -32 (see Figure 2).

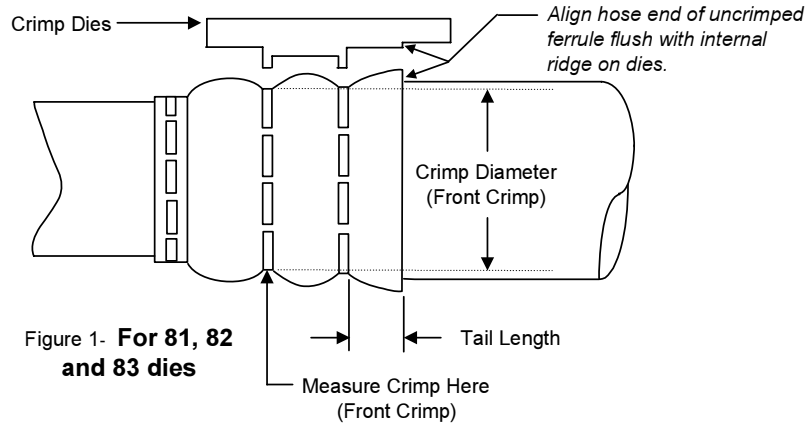


Figure 1- For 81, 82 and 83 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- .10(in.)	Crimp OD +/- .010(in.)	Die Set	PC3000B Digital Setting	User's Actual Setting
12	GMV	3/4	12GL	1-pc GL	-----	-----	-----	1.75	0.50	1.12	81	1 3/4	
16	GMV	1	16GL	1-pc GL	-----	-----	-----	2.125	0.60	1.36	82	1 3/4	
20	GMV	1 1/4	20GL	1-pc GL	-----	-----	-----	2.25	0.50	1.66	83	2 1/4	

To achieve proper tail length, line up hose end of ferrule with top of die (see Figure 2) prior to crimping. This is for sizes -24 and -32.

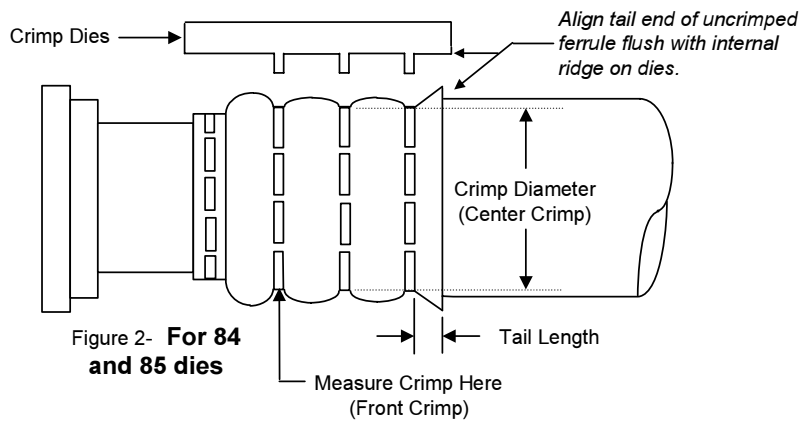


Figure 2- For 84 and 85 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.10(in.)	Crimp OD +/- .010(in.)	Die Set	PC3000B Digital Setting	User's Actual Setting
24	GMV	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	84	2 3/4	
32	GMV	2	32GL	1-pc GL	-----	-----	-----	2.75	0.50	2.430	85	2 1/4	

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.020(in.)	Crimp OD +/- .010(in.)	Die Set	PC3000B Digital Setting	User's Actual Setting
24	MEGATECH ACR	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	84	2 3/4	
32	MEGATECH ACR	2	32GL	1-pc GL	-----	-----	-----	2.75	0.50	2.410	85	2 1/4	



Clamp Collar Crimping Instructions

OmniCrimp® 21

Care must be taken when crimping clamp collars onto a hydraulic hose. If crimp is too tight, hose will be crushed, dramatically reducing its service life. If crimp is too loose, collar could slide along hose's length causing abrasion and eventual hose cover failure.

Remember: Clamp collars must be crimped before the hose couplings.

Use the following instructions to determine crimp diameter, which can then be used to find crimping setting in Table 2. The required clamp collar for a specific hydraulic hose is provided in Table 1.

1. Measure hose's outside diameter at the location where clamp collar will be crimped. This can be accomplished by using a pie tape or by using the average hose outside diameter measured with a dial caliper.
2. Obtain crimp diameter by adding hose outside diameter to twice the clamp collar wall thickness (see formula below).

Crimp Diameter = (Hose O.D.) + [2 x .065 (Clamp Collar Wall Thickness)]

When crimping clamp collar, the crimp die should be located in the center of the collar, which will result in a 1/8" flare on each side of the collar.



Table 1

Description	Part Number	Product Number	Hydraulic Hose Applications	Length (In.)	OmniCrimp® Die
CC1.12	G52000-0210	7334-45805	10M2T, 10G2	2.250	OM331
CC1.25	G52000-0212	7334-45885	12M2T, 12G2, 12M4K	2.000	OM331
CC1.37	G52000-0412	7334-45895	12C12, 12G4K	2.000	OM331

Table 2

OM331 Die							
Crimp Diameter	Approx. Setting		Crimp Diameter	Approx. Setting		Crimp Diameter	Approx. Setting
1.050	1.320		1.170	1.200		1.290	1.085
1.055	1.315		1.175	1.195		1.295	1.080
1.060	1.310		1.180	1.190		1.300	1.075
1.065	1.305		1.185	1.185		1.305	1.070
1.070	1.300		1.190	1.180		1.310	1.065
1.075	1.295		1.195	1.175		1.315	1.060
1.080	1.290		1.200	1.170		1.320	1.055
1.085	1.285		1.205	1.165		1.325	1.050
1.090	1.280		1.210	1.160		1.330	1.045
1.095	1.275		1.215	1.155		1.335	1.040
1.100	1.270		1.220	1.150		1.340	1.035
1.105	1.265		1.225	1.145		1.345	1.030
1.110	1.260		1.230	1.140		1.350	1.025
1.115	1.255		1.235	1.135		1.355	1.020
1.120	1.250		1.240	1.130		1.360	1.015
1.125	1.245		1.245	1.127		1.365	1.010
1.130	1.240		1.250	1.123		1.370	1.005
1.135	1.235		1.255	1.118		1.375	1.000
1.140	1.230		1.260	1.115		1.380	0.995
1.145	1.225		1.265	1.110		1.385	0.990
1.150	1.220		1.270	1.105		1.390	0.985
1.155	1.215		1.275	1.100		1.395	0.980
1.160	1.210		1.280	1.095		1.400	0.975
1.165	1.205		1.285	1.090		1.405	0.970

Power Steering Male Flareless Assembly Instructions

OmniCrimp® 21

Hose Preparation and Assembly

1. Measure tube O.D.
2. Select proper Male Flareless coupling for application.
3. Determine length of replacement assembly. Measure distance between points where tubing is to be cut. See Fig. 1.

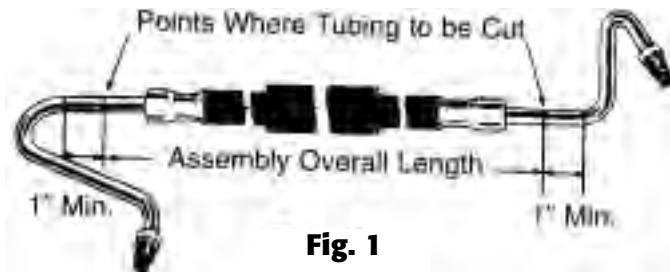


Fig. 1

NOTE: Tubing must be cut at 1" from the start of any bend. Read "Tubing Preparation Assembly" section on next page before cutting.

4. Determine necessary cut length of hose.

$$\text{Cut Length} = \text{Assembly Overall Length} - \text{Cutoff Dimension (Coupling 1)} - \text{Cutoff Dimension (Coupling 2)}$$

(Cutoff dimensions are in Table below.)

Cutoff Dimensions For Power Steering Couplings

Part No.	Description	Cutoff (In.)
G50510-0604	6PS-4MFA	.996
G50510-0605	6PS-5MFA	.996
G50510-0606	6PS-6MFA	1.012
G50510-0608	6PS-M8MFA	.934
G50510-0610	6PS-M10MFA	.973
G50510-0612	6PS-M12MFA	.973

5. Cut hose to calculated cut length. End must be square ($\pm 5^\circ$). See Fig. 2.



Fig. 2

6. Mark hose 1-1/4" ($\pm 1/32$ ") from end of hose with a marker pen. Do not damage hose. See Fig. 3.



Fig. 3

7. Insert a 6PS coupling into hose until end of ferrule is even with the mark. (See Fig. 4.)



Fig. 4

8. Place power steering die in crimper. Use setting as shown below:

Die Set	Setting
Power Steering	1.452

9. Insert properly prepared hose and coupling into crimper. Line up top of die with bottom of stem hex. (See Fig. 5.)



Fig. 5

10. Place no-notch cone on die fingers. Press crimp button. When you hear pump pressurize or the light and buzzer sound, release your finger from crimp button. Crimp is now complete.

Power Steering Male Flareless Assembly Instructions (cont'd)

OmniCrimp® 21

11. Measure crimp O.D. per Fig. 6. Crimp O.D. must be within the specified tolerance.

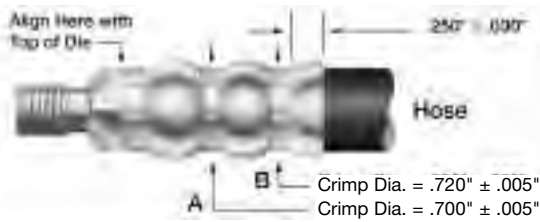


Fig. 6

12. Check assembly to make sure correct overall length has been obtained.
13. Inspect assembly to make sure it has a clean bore and no internal obstructions. Clean if necessary.

Tubing Preparation Assembly

1. Tube End Condition

- Before cutting tube, mark both ends of assembly so that it can be properly reassembled. These marks must be made on the tubing beyond the point where tubing will be cut. Use a marke pen to mark tubing so the surface won't be scratched.
- Tube end must be cut squarely ($\pm 5^\circ$).
- Smooth tube inside and out by removing all burrs and rough edges with steel wool. Clean all metal particles from inside tube.
- The bare end of the tube must be long enough for the nut and sleeve to be placed over the tube. (1" minimum length before the start of any bend.)
- There also must be sufficient tube length for tube end to seat against shoulder in thread end of stem. (1" minimum length before the start of any bend.)

2. Nut and Sleeve Placement (Tube End)

- Install hex nut over tube, positioned so shoulder end is placed on tube first. Thread end will then face hose assembly.
- Place sleeve on tube so tapered end will face hose assembly.



3. Connect to Tube End

(Preliminary Connection)

- Insert tube into thread end of hose assembly until it bottoms against the shoulder.



- Screw hex nut to thread end until finger tight.
- Using a wrench, tighten approximately 1 turn ($\pm 1/4$ turn) to preset.

4. Inspect

- Disassemble and inspect compression of sleeve on tube. Sleeve must be compressed sufficiently on tube so it is not easily removed.
 - Tube end will be slightly distorted from butting against internal shoulder.
- NOTE: Makeup of the correct connection is critical for proper use and safety.

5. Final Assembly

- Insert tube into thread end of hose assembly.
 - With a wrench, tighten down until a sudden increase in torque is felt. Turn nut approximately 1/6 turn (but no more than 1/3 turn) to create a seal between the sleeve, tube and seat of the stem.
- CAUTION: Overtightening may cause stripped threads and/or collapse of the tube.
- Before tightening second end, line up two marks on tubing to assure proper orientation.



Gates PolarSeal® Hose

G45 Series (ACA) Coupling Crimping Instructions

OmniCrimp® 21

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 30008

GC32-XD™

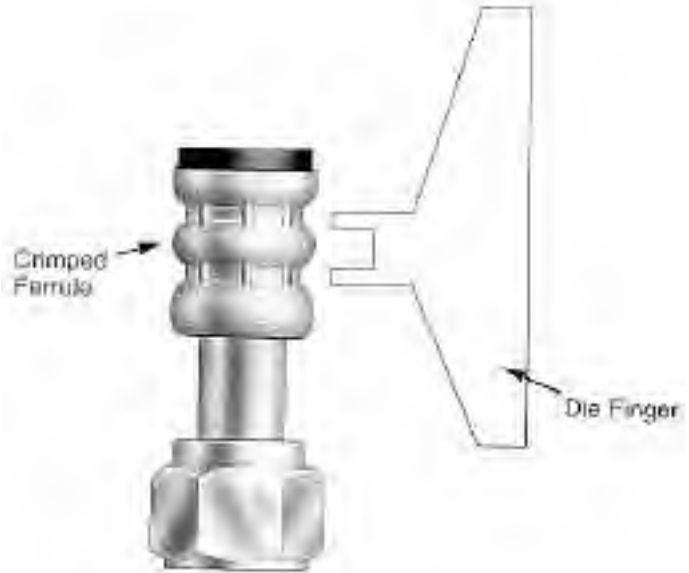
Gates recommends only those hose and coupling combinations specified in the Gates Hydraulic Products Catalogs. Gates disclaims any liability for any hose assemblies which have not been produced in conformance with Gates' assembly recommendations.

Changing Digital Readout

To set the RETRACT position, hold the hose assembly to be crimped in front of the die fingers. Twist the JOG switch in the direction of the RETRACT arrow and hold it until the die fingers open enough to allow easy insertion of the assembly.

Release the switch. This position can be changed by pressing the INCREASE or DECREASE buttons beneath the RETRACT display.

Use the INCREASE or DECREASE buttons beneath the start crimp display to change crimp settings.



Crimp Diameter

Should the actual crimp diameter NOT be within the recommended crimp tolerance, a slight adjustment to the "Approximate Setting" or digital readout may be necessary.

Changing the CRIMP setting by one number will change crimp diameter by approximately .001". After nominal crimp diameter is obtained, check at least every tenth crimp to ensure that it is within recommended tolerances.

IMPORTANT

To assure a quality assembly, check the FIRST assembly of each run. Measure the crimped O.D. and compare it to the figure listed in the "Crimp Diameter" column.

If ACTUAL crimped dimensions are within specification, you have made a good assembly.

Hose		Fitting Type	Crimp Diameter (±.010")	Ferrule Position	Die Set	Approx. Digital Readout (±.05")	Actual Crimper Setting
Type	I.D. (In.)						
6AC134a	5/16	6ACA	.690	Centered	OM6AC	1.455	
8AC134a	13/32	8ACA	.780	Centered	OM8AC	1.435	
10AC134a	1/2	10ACA	.890	Centered	OM10AC	1.450	
12AC134a	5/8	12ACA	1.020	Centered	OM12AC	1.440	



Gates PolarSeal® Hose

G45 Series (ACA) Coupling Crimping Instructions

Power Crimp® 3000B

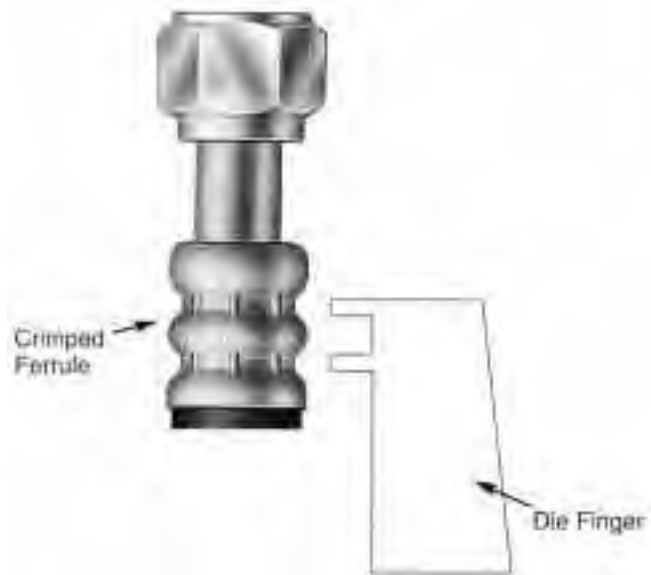
Gates recommends only those hose and coupling combinations specified in the Gates Hydraulic Products Catalogs. Gates disclaims any liability for any hose assemblies which have not been produced in conformance with Gates' assembly recommendations.

Gauge Setting

The gauge setting is adjusted by always moving indicator upward to desired setting. Example: to change setting from 2 to 3, move the indicator to 4, then back up to 3. To change from 3 to 2, simply move the indicator directly up to 2.

Crimp Diameter

The crimp diameter must be within the tolerance specified below. If not, check calibration of crimper (see Operator's Manual). If calibration is correct, a slight adjustment of the gauge setting may be necessary. To obtain a smaller crimp diameter, move indicator upward to a smaller number. Changing setting by one whole number will change crimp diameter by 0.30". Record any gauge setting adjustment in the "Actual Crimper Setting" column in the chart below.



IMPORTANT

To assure a quality assembly, check the FIRST assembly of each run. Measure the crimped O.D. and compare it to the figure listed in the "Crimp Diameter" column.

If ACTUAL crimped dimensions are within specification, you have made a good assembly.

Hose		Fitting Type	Crimp Diameter (±.010")	Ferrule Position	Die Fingers	Approx. Gauge Setting	Actual Crimper Setting
Type	I.D. (In.)						
6AC134a	5/16	6ACA	.690	Centered	6AC	2	
8AC134a	13/32	8ACA	.780	Centered	8AC	2-3/4	
10AC134a	1/2	10ACA	.890	Centered	10AC	2	
12AC134a	5/8	12ACA	1.020	Centered	12AC	2-1/4	

Automotive Service Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Hose			Stem	Ferrule		Skive/Buf		Crimp			Crimper			
Dash Size	Description	Size (In.)	Type	Descr.	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Actual Setting
4	Charter® Air Hose	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.725	31	4 1/4	1.348	
6	Charter® Air Hose	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.800	32	1 1/2	1.446	
8	Charter® Air Hose	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.025	33	2 3/4	1.401	
4	Multi-Use 1-Braid (19B)	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.648	31	2	1.424	
6	Multi-Use 1-Braid (19B)	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.770	31	5 3/4	1.304	
8	Multi-Use 1-Braid (19B)	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	0.995	32	7 1/4	1.257	
4	Multi-Use 2-Braid (19B)	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.680	31	3	1.393	
5	Multi-Use 2-Braid (19B)	5/16	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.745	31	5	1.329	
6	Multi-Use 2-Braid (19B)	3/8	6PC	PC2F-4	80462	-----	-----	-----	FULL	0.885	32	4	1.364	
8	Multi-Use 2-Braid (19B)	1/2	8PC	PC2F-4	80463	-----	-----	-----	FULL	1.065	33	3	1.363	
4	Safety Stripe® Air Hose	1/4	4PC	PC2F-2	80416	-----	-----	-----	FULL	0.725	31	4 1/4	1.348	
6	Safety Stripe® Air Hose	3/8	6PC	PC2F-2	80418	-----	-----	-----	FULL	0.800	32	1 1/2	1.446	
8	Safety Stripe® Air Hose	1/2	8PC	PC2F-2	80419	-----	-----	-----	FULL	1.025	33	2 3/4	1.401	

LP350 Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Hose			Stem	Ferrule		Skive/Buf		Crimp			Crimper			
Dash Size	Type	Size (In.)	Type	Description	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Actual Setting
4	LP350	1/4	PC	4PC2F-2	80416	-	-	-	FULL	0.670	21	1/4	1.471	
4	LP350	1/4	PC	4PC2F-2	80416	-	-	-	FULL	0.670	31	2 1/2	1.409	
6	LP350	3/8	PC	6PC2F-2	80418	-	-	-	FULL	0.780	21	5 3/4	1.374	
6	LP350	3/8	PC	6PC2F-2	80418	-	-	-	FULL	0.780	31	5 1/4	1.300	
8	LP350	1/2	PC	8PC2F-2	80419	-	-	-	FULL	0.995	33	2 1/4	1.427	
12	LP350	3/4	PC	12PCBHB-1	-	-	-	-	FULL	1.315	35	3/4	1.441	
16	LP350	1	PC	16PC2F-4	80425	-	-	-	FULL	1.625	36	4 3/4	1.355	
20	LP350	1 1/4	PC	20PC2F-4	80426	-	-	-	FULL	2.040	39	3/4	1.465	
24	LP350	1 1/2	PC	24PCBHB1	-	-	-	-	FULL	2.450	311	4	1.350	
32	LP350	2	PC	32PCBHB1F	-	-	-	-	FULL	3.110	314	2 3/4	1.395	

PowerClean™ Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Hose				Stem	Ferrule		Skive/Buf		Crimp			Crimper			
Dash Size	Type	Size (In.)	Work. Press. (psi)	Type	Description	Part No.	Length ± .03 (In.)	Dia. (In.)	Hose Insertion Length ± .03 (In.)	Length ± .03 (In.)	Crimp OD ± .010 (In.)	Die Set	PC 3000B Approx. Setting ¹	Omni21 Approx. Setting ¹	User's Actual Setting
8	PC2500	1/2	2500	G	MegaCrimp	-	-	-	1.25	FULL	1.010	33	2 1/2	1.415	
6	PC3000	3/8	3000	G	MegaCrimp	-	-	-	0.93	FULL	0.845	22/32	2 3/4	1.402	
4	PC3500	1/4	3500	G	MegaCrimp	-	-	-	0.93	FULL	0.705	21	2	1.440	
4	PC3500	1/4	3500	G	MegaCrimp	-	-	-	0.93	FULL	0.705	31	3 3/4	1.368	
6	PC4000	3/8	4000	G	MegaCrimp	-	-	-	0.93	FULL	0.845	22/32	2 3/4	1.402	
8	PC4000	1/2	4000	G	MegaCrimp	-	-	-	1.25	FULL	1.050	33	3 1/2	1.377	
6	PC5000	3/8	5000	G	MegaCrimp	-	-	-	0.93	FULL	0.890	22/32	4 1/4	1.359	
4	PC6000	1/4	6000	G	MegaCrimp	-	-	-	0.93	FULL	0.740	21	3 3/4	1.410	
4	PC6000	1/4	6000	G	MegaCrimp	-	-	-	0.93	FULL	0.740	31	4 3/4	1.334	

¹ See Adjustment Procedures at beginning of Omni/3000B section.



Industrial Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Size	Description	Working Pressure (psi)	Stem		Ferrule Description	Auto Part No.	Skive / Buff		Crimp			Crimper			
			Dash Size	Type			Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/-	Crimp OD +/- .010(in)	Die Set	PC3000B Approx. Setting ¹	OMNI21 Approx. Setting ¹	User's Actual Setting
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.930	32	5 1/4	1.320	
3/4	1000MP/ Mine Spray	1000	12	G	MegaCrimp®	-	-	-	1.50	Full	1.345	35	1 3/4	1.411	
3/4	1000MP/ Mine Spray	1000	12	PC	12PC2F-2	80423	1.63	WIRE	-	Full	1.190	34	2 1/2	0.933	
1	1000MP/ Mine Spray	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	1.540	36	2	1.439	
1	1000MP/ Mine Spray	1000	16	G	MegaCrimp®	-	-	-	1.75	Full	1.745	37	3	1.413	
1 1/2	1000MP/ Mine Spray	1000	24	PC	24PC2F-4	-	2.28	WIRE	-	Full	2.200	310L2	1 1/4	1.460	
1 1/4	1000MP/ Mine Spray	1000	20	G	MegaCrimp®	-	-	-	1.75	Full	2.045	39	3/4	0.250	
1 1/4	1000MP/ Mine Spray	1000	20	PC	20PC2F-2	80427	1.12	WIRE	-	Full	1.880	37	7 1/4	1.278	
2	1000MP/ Mine Spray	1000	32	PC	32PC2F-4	-	2.75	WIRE	-	Full	2.800	312	3 1/4	1.375	
1/2	119B	250	8	PC	8PC2F-2	80476	-	-	-	Full	1.065	33	1 3/4	1.434	
1/2	119B	500	8	PC	10PC2F-2B	80476	-	-	-	Full	1.065	33	4	1.367	
1/4	119B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	2	1.424	
1/4	119B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.705	21	2	1.440	
1/4	119B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.705	31	3 1/4	1.380	
3/4	119B	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.300	34	5 3/4	1.290	
3/4	119B	500	12	PC	12PC2F-4	80422	-	-	-	Full	1.365	35	2 1/2	1.390	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	0.770	21	5 1/4	1.384	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	0.770	31	5 1/2	1.304	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	0.885	22	4	1.364	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	0.885	32	4	1.364	
1	119B	250	16	PC	16PC2F-2	80424	-	-	-	Full	1.630	36	5	1.350	
1	119B	500	16	PC	16PC2F-4	80425	-	-	-	Full	1.675	36	6 1/4	1.280	
1/2	19B	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	32	7 1/4	1.257	
1/2	19B	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	22	7 1/4	1.257	
1/2	19B	500	8	PC	8PC2F-4	80463	-	-	-	Full	1.065	33	3	1.363	
1/4	19B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	2	1.424	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.680	21	3/4	1.462	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	0.680	31	3	1.393	
3/16	19B	500	3	PC	3PC2F-2	80415	-	-	-	Full	0.635	31	1 1/2	1.437	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	0.760	31	5 1/4	1.314	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	0.760	21	4 3/4	1.392	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	0.745	21	4	1.405	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	0.745	31	5	1.329	
3/4	19B	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.300	34	5 3/4	1.290	
3/4	19B	500	12	PC	12PC1FA	80437	-	-	-	Full	1.365	35	2 1/2	1.390	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.770	31	5 3/4	1.304	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.770	21	5 1/4	1.384	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	0.885	22	4	1.364	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	0.885	32	4	1.364	
5/8	19B	250	10	PC	10PC2F-2C	80447	-	-	-	Full	1.095	33	4 3/4	1.341	
5/8	19B	500	10	PC	10PC1FA	80436	-	-	-	Full	1.140	34	1 1/4	1.447	
1	19B	250	16	PC	16PC2F-2	80424	-	-	-	Full	1.560	36	2 3/4	1.420	
1	19B	500	16	PC	16PC2F-4	80425	-	-	-	Full	1.675	36	6 1/4	1.280	
1 1/4	19B	250	20	PC	20PC2F-4	80426	-	-	-	Full	1.990	38	3 1/4	1.355	
1/2	20B-HB	350	8	PC	10PC2F-2B	80476	-	-	-	Full	1.065	33	3 1/2	1.355	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	31	2 1/4	1.400	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	21	1/2	1.466	
3/4	20B-HB	350	12	PC	12PCBHB1F	-	-	-	-	Full	1.355	35	2 1/4	1.400	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.790	32	3/4	1.400	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.790	22	3/4	1.400	
1	20B-HB	350	16	PC	16PC2F-4	80425	-	-	-	Full	1.665	36	5 1/4	1.295	
1 1/2	20B-HB	350	24	PC	24PCBHB1F	-	-	-	-	Full	2.450	311	4	1.350	
1 1/4	20B-HB	350	20	PC	20PC2F-4	80426	-	-	-	Full	2.040	39	3/4	1.465	
2	20B-HB	350	32	PC	32PCBHB1F	-	-	-	-	Full	3.030	313	6 3/4	1.260	
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.940	22	5 3/4	1.310	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² The 310L die supersedes the 310 die. ³ For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Size	Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper			
	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/-	Crimp OD +/- .010(in)	Die Set	PC3000B Approx. Setting ¹	OMNI21 Approx. Setting ¹	User's Actual Setting
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	0.940	32	5 3/4	1.310	
1/4	319MB	1000	4	PC	4PC2F-2	80416	0.75	WIRE	-	Full	0.640	31	1 1/2	1.432	
3/4	319MB	1000	12	PC	12PC2F-4	80422	1.56	WIRE	-	Full	1.315	35	1	1.441	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.69	WIRE	-	Full	0.690	21	1 1/4	1.453	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.69	WIRE	-	Full	0.690	31	3	1.383	
1	319MB	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	1.545	36	2 1/4	1.435	
1 1/2	319MB	1000	24	PC	24PC2F-4	-	2.28	WIRE	-	Full	2.200	310L2	1 1/4	1.460	
1 1/4	319MB	1000	20	PC	20PC2F-2	80427	2.19	WIRE	-	Full	1.880	37	7 1/4	1.278	
2	319MB	1000	32	PC	32PC2F-4	-	2.75	WIRE	-	Full	2.800	312	3 1/2	1.375	
1/2	6B	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.980	33	1 1/2	1.444	
1/2	6B	315	8	PC	8PC2F-4	80463	-	-	-	Full	1.085	33	4	1.350	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	21	1/2	1.466	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	31	2 1/4	1.400	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	21	1/4	1.471	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	31	2 1/2	1.409	
3/4	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	31	6 1/4	1.275	
3/4	6B	250	12	PC	12PC2F-2	80423	-	-	-	Full	1.240	34	4	1.349	
3/4	6B	315	12	PC	12PC2F-4	80422	-	-	-	Full	1.370	35	2 1/2	1.385	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.770	31	5 1/2	1.304	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.770	21	5 1/4	1.384	
3/8	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	21	6 1/4	1.369	
1	6B	315	16	PC	16PC2F-4	80425	-	-	-	Full	1.710	36	6 3/4	1.270	
1 1/4	6B	200	20	PC	20PC2F-2	80427	-	-	-	Full	1.995	38	3 3/4	1.360	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	-	-	-	Full	0.990	32	1	1.275	
1/2	Adapta Flex™	250	8	PC	8PC2F-2	80419	-	-	-	Full	1.000	33	1 1/2	1.430	
1/2	Adapta Flex™	300	8	PC	8PC2F-2	80419	-	-	-	Full	1.000	33	1 1/2	1.444	
1/4	Adapta Flex™	200	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	2	1.424	
1/4	Adapta Flex™	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.648	31	2	1.424	
1/4	Adapta Flex™	300	4	PC	4PC2F-2	80416	-	-	-	Full	0.685	31	2	1.417	
3/4	Adapta Flex™	200	12	PC	12PC2F-2	80423	-	-	-	Full	1.320	34	4	1.274	
3/4	Adapta Flex™	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	34	2	1.410	
3/4	Adapta Flex™	300	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	35	2	1.410	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	31	4 3/4	1.325	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	21	4 1/4	1.401	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.775	31	5 1/4	1.305	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.775	21	5 1/2	1.379	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	32	1 1/2	1.410	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.800	22	1 1/2	1.410	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	0.725	21	3	1.423	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	0.725	31	3 3/4	1.350	
5/8	Adapta Flex™	200	10	PC	12PC2F-2	80423	-	-	-	Full	1.125	34	1/2	1.462	
5/8	Adapta Flex™	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.125	34	1/2	1.462	
1	Adapta Flex™	150	16	PC	16PC2F-2	80424	-	-	-	Full	1.600	36	4	1.380	
1	Adapta Flex™	200	16	PC	16PC2F-4	80425	-	-	-	Full	1.650	36	5 1/2	1.331	
1	Adapta Flex™	300	16	PC	16PC2F-4	80425	-	-	-	Full	1.655	36	5 1/4	1.320	
1/2	Cyclone™	1000	8	PC	10PC2F-2B	80476	-	-	-	Full	1.040	33	2 3/4	1.380	
3/4	Cyclone™	1000	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	35	2	1.410	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	0.785	21	6	1.374	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	0.785	31	5 3/4	1.290	
1/2	Duro Flex®	250	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	33	1 3/4	1.430	
1/2	Duro Flex®	300	8	PC	10PC2F-2B	80476	-	-	-	Full	1.070	33	3 1/4	1.360	
1/4	Duro Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.655	31	1 1/2	1.420	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	0.720	21	4	1.360	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	0.720	31	4	1.360	
3/4	Duro Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.356	35	2 3/4	1.405	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² The 310L die supersedes the 310 die. ³ For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Size	Hose		Stem		Ferrule	Skive / Buff		Crimp			Crimper				
	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/-	Crimp OD +/- .010(in)	Die Set	PC3000B Approx. Setting ¹	OMNI21 Approx. Setting ¹	User's Actual Setting
3/4	Duro Flex®	300	12	PC	12PC2F-4	80422	-	-	-	Full	1.300	34	5 3/4	1.290	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.820	32	1	1.430	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.820	22	1	1.430	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.845	22	1 3/4	1.405	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	0.845	32	1 3/4	1.405	
5/8	Duro Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.185	34	2 1/2	1.403	
5/8	Duro Flex®	300	10	PC	12PC2F-2	80423	-	-	-	Full	1.180	34	2 1/2	1.408	
1	Duro Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	1.716	37	1 1/2	1.445	
1 1/4	Duro Flex®	200	20	PC	20PC2F-2	80427	-	-	-	Full	1.995	37	3 3/4	1.175	
1/2	Heat Master® (Aramid) ¹	500	8	PC	8PC2F-4	80463	-	-	-	Full	1.115	33	5 1/2	1.315	
3/4	Heat Master® (Aramid) ¹	500	12	PC	12PCBHB1F	-	-	-	-	Full	1.350	35	2	1.407	
1/2	LP350	350	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	33	2 1/4	1.427	
1/4	LP350	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	21	1/4	1.471	
1/4	LP350	350	4	PC	4PC2F-2	80416	-	-	-	Full	0.670	31	2 1/2	1.409	
3/4	LP350	350	12	PC	12PCBHB-1	-	-	-	-	Full	1.315	35	3/4	1.441	
3/8	LP350	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	31	5 1/4	1.300	
3/8	LP350	350	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	21	5 3/4	1.374	
1	LP350	350	16	PC	16PC2F-4	80425	-	-	-	Full	1.625	36	4 3/4	1.355	
1 1/2	LP350	350	24	PC	24PCBHB1F	-	-	-	-	Full	2.450	311	4	1.350	
1 1/4	LP350	350	20	PC	20PC2F-4	80426	-	-	-	Full	2.040	39	3/4	1.465	
2	LP350	350	32	PC	32PCBHB1F	-	-	-	-	Full	3.110	314	2.75	1.395	
1/2	PC2500	2500	8	G	MegaCrimp®	-	-	-	1.25	Full	1.010	33	2 1/2	1.415	
1/2	PC2500	2500	8	PC	8PC1FS	80485	-	-	-	Full	0.960	33	1	1.463	
1/2	PC2500	2500	8	PC	8PC2F-2	80419	0.97	WIRE	-	Full	0.940	32	5 1/2	1.310	
1/2	PC2500	2500	8	PC	8PC1FA	80435	-	-	-	Full	0.960	33	1	1.463	
3/8	PC3000	3000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	32	2 3/4	1.402	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	32	2 1/2	1.412	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.84	WIRE	-	Full	0.735	31	4 1/2	1.339	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	32	2 1/2	1.412	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	22	2 1/2	1.412	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.84	WIRE	-	Full	0.735	21	3 1/2	1.414	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	22	2 1/2	1.412	
3/8	PC3000	3000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	22	2 3/4	1.402	
1/4	PC3500	3500	4	PC	4PC2F-2	80416	0.91	WIRE	-	Full	0.625	31	1 1/4	1.447	
1/4	PC3500	3500	4	G	MegaCrimp®	-	-	-	0.93	Full	0.705	31	3 3/4	1.368	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	0.680	31	3	1.393	
1/4	PC3500	3500	4	G	MegaCrimp®	-	-	-	0.93	Full	0.705	21	2	1.440	
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	0.680	21	3/4	1.462	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	0.680	21	3/4	1.462	
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	0.680	31	3	1.393	
1/2	PC4000	4000	8	PC	8PC1FA	80435	-	-	-	Full	0.980	33	1 1/2	1.444	
1/2	PC4000	4000	8	PC	8PC2F-2	80419	0.97	WIRE	-	Full	0.970	33	1 1/4	1.453	
1/2	PC4000	4000	8	PC	8PC1FS	80485	-	-	-	Full	0.980	33	1 1/2	1.444	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	22	2 1/2	1.412	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	32	2 1/2	1.412	
3/8	PC4000	4000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	32	2 3/4	1.402	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	0.835	32	2 1/2	1.412	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.84	WIRE	-	Full	0.735	31	4 1/2	1.339	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	0.835	22	2 1/2	1.412	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.84	WIRE	-	Full	0.735	21	3 1/2	1.414	
3/8	PC4000	4000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.845	22	2 3/4	1.402	
1/2	PC4000	4000	8	G	MegaCrimp®	-	-	-	1.25	Full	1.050	33	3 1/2	1.377	
3/8	PC5000	5000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.890	22	4 1/4	1.359	
3/8	PC5000	5000	6	G	MegaCrimp®	-	-	-	0.93	Full	0.890	32	4 1/4	1.359	
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	0.880	32	3 3/4	1.368	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² The 310L die supersedes the 310 die. ³ For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Size	Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper			
	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/-	Crimp OD +/- .010(in)	Die Set	PC3000B Approx. Setting ¹	OMNI21 Approx. Setting ¹	User's Actual Setting
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	0.880	22	3 3/4	1.368	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	0.880	22	3 3/4	1.368	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.79	WIRE	-	Full	0.775	21	5 1/2	1.379	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	0.880	32	3 3/4	1.368	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.79	WIRE	-	Full	0.775	31	5 3/4	1.299	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.79	WIRE	-	Full	0.685	31	2	1.417	
1/4	PC6000	6000	4	G	MegaCrimp®	-	-	-	0.93	Full	0.740	31	4 3/4	1.334	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	0.700	31	3 1/2	1.373	
1/4	PC6000	6000	4	G	MegaCrimp®	-	-	-	0.93	Full	0.740	21	3 3/4	1.410	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	0.700	21	1 3/4	1.445	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	0.700	21	1 3/4	1.445	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.79	WIRE	-	Full	0.685	21	1	1.458	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	0.700	31	3 1/2	1.373	
1/2	Premo Flex®	250	8	PC	8PC1FA	80435	-	-	-	Full	0.980	33	1 1/4	1.445	
1/2	Premo Flex®	315	8	PC	8PC2F-2	80419	-	-	-	Full	0.995	33	2 1/4	1.427	
1/2	Premo Flex®	315	8	PC	8PC1FA	80435	-	-	-	Full	0.995	33	1 1/2	1.435	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.720	21	4	1.360	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	-	-	-	Full	0.720	31	4	1.360	
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	0.755	31	5 1/4	1.319	
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	0.755	21	4 1/2	1.396	
1/4	Premo Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	0.645	31	1 3/4	1.430	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	21	1/2	1.466	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	0.675	31	2 3/4	1.400	
5/16	Premo Flex®	250	3	PC	3PC2F-2	80415	-	-	-	Full	0.655	31	2	1.417	
3/4	Premo Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	1.350	35	2	1.410	
3/4	Premo Flex®	315	12	PC	12PC2F-4	80422	-	-	-	Full	1.345	35	1 3/4	1.415	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.755	21	4 1/2	1.396	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	0.755	31	5 1/4	1.319	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	0.815	22	1 1/4	1.430	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	0.815	32	1 1/4	1.430	
5/8	Premo Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	1.145	34	1 1/2	1.246	
5/8	Premo Flex®	315	10	PC	10PC1FA	80436	-	-	-	Full	1.120	34	1/2	1.467	
1	Premo Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	1.675	37	1/4	1.490	
1 1/4	Premo Flex®	250	20	PC	20PC2F-4	80426	-	-	-	Full	1.990	38	3 1/4	1.355	
1/2	Terminator®	501	8	G	MegaCrimp®	-	-	-	1.25	Full	1.050	33	3 1/2	1.377	
1/2	Terminator®	501	8	PC	8PC2F-4	80463	-	-	-	Full	1.060	33	3 3/4	1.367	
1/4	Terminator®	501	4	G	MegaCrimp®	-	-	-	0.94	Full	0.740	31	5 1/2	1.300	
1/4	Terminator®	501	4	PC	4PC2F-2	80416	-	-	-	Full	0.680	21	3/4	1.462	
1/4	Terminator®	501	4	PC	4PC2F-2	80416	-	-	-	Full	0.680	31	2 3/4	1.395	
1/4	Terminator®	501	4	G	MegaCrimp®	-	-	-	0.94	Full	0.740	21	3 3/4	1.410	
3/4	Terminator®	501	12	PC	12PC2F-4	80422	-	-	-	Full	1.360	35	5 1/4	1.300	
3/4	Terminator®	501	12	G	MegaCrimp®	-	-	-	-	Full	1.430	35	2 1/2	1.329	
3/8	Terminator®	501	6	PC	6PC2F-4	80462	-	-	-	Full	0.870	22	2 3/4	1.410	
3/8	Terminator®	501	6	G	MegaCrimp®	-	-	-	0.94	Full	0.920	22	5 1/4	1.300	
3/8	Terminator®	501	6	PC	6PC2F-4	80462	-	-	-	Full	0.870	32	2 3/4	1.410	
3/8	Terminator®	501	6	G	MegaCrimp®	-	-	-	0.94	Full	0.920	32	5 1/4	1.300	
1	Terminator®	501	16	G	MegaCrimp®	-	-	-	1.75	Full	1.785	37	3 1/2	1.365	
1	Terminator®	501	16	PC	16PC2F-4	80425	-	-	-	Full	1.660	36	5 1/4	1.300	
1 1/2	Terminator®	501	24	PC	24PC2F-4	80428	-	-	-	Full	2.260	39	7 1/4	1.260	
1 1/4	Terminator®	501	20	PC	20PC2F-2	80427	-	-	-	Full	1.970	38	3 1/4	1.380	
1 1/4	Terminator®	501	20	G	MegaCrimp®	-	-	-	1.75	Full	2.080	38	6 3/4	1.265	
2	Terminator®	501	32	PC	32PC2F-4	80429	-	-	-	Full	2.910	313	3 1/4	1.390	
1/2	Thermo AG® 570	570	8	PC	8PC2F-2	80463	-	-	-	Full	0.960	33	2	1.463	
3/4	Thermo AG® 570	570	12	PC	12PC2F-4	80422	-	-	-	Full	1.290	35	1/4	1.465	
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	21	5	1.434	

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² The 310L die supersedes the 310 die. ³ For aramid-reinforced Heatmaster® hose only.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Industrial Hose Crimp Data

OmniCrimp® 21 and PC 3000B Crimpers

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper			
Size	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/-	Crimp OD +/- .010(in)	Die Set	PC3000B Approx. Setting ¹	OMNI21 Approx. Setting ¹	User's Actual Setting
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	-	-	-	Full	0.750	31	6 1/4	1.324	
1/2	Thermo AG® 800	800	8	PC	8PC2F-2	80463	-	-	-	Full	0.960	33	2	1.463	
3/4	Thermo AG® 800	800	12	PC	12PC2F-4	80422	-	-	-	Full	1.315	35	1	1.436	
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	22	1	1.465	
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	-	-	-	Full	0.780	32	1	1.465	

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

¹ See Adjustment Procedures at beginning of Omni/3000B section. ² The 310L die supersedes the 310 die. ³ For aramid-reinforced Heatmaster® hose only.

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp		Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
16	BOP	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
4	C5C	3/16	03PC	04PC2F-2	80416	-----	-----	-----	FULL	15.748	FP31	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	17.526	FP21	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	17.526	FP31	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	-----	FULL	19.431	FP21	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	-----	FULL	19.431	FP31	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.844	FP22	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.844	FP32	
10	C5C	1/2	08PC	10PC2F-2B	80476	-----	-----	-----	FULL	26.67	FP33	
12	C5C	5/8	10PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	31.242	FP34	
4	C5E	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	16.764	FP31	
5	C5E	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	16.764	FP31	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	20.193	FP21	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	20.193	FP32	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	22.606	FP22	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	22.606	FP32	
10	C5E	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	25.146	FP33	
12	C5E	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	28.956	FP34	
24	C12	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	59.69	FP311	
24	C12	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	57.023	FP310L	
32	C12	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	74.93	FP313	
32	C12	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	70.739	FP312	
6	C12M	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	C12M	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
12	C12M	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
16	C12M	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	C12M	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
6	C12M-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	C12M-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
12	C12M-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
16	C12M-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	C12M-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
24	C12-MTF	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	59.69	FP311	
24	C12-MTF	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	57.023	FP310L	
32	C12-MTF	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	74.93	FP313	
32	C12-MTF	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	70.739	FP312	
6	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	0.93	FULL	22.352	FP22	
6	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	0.93	FULL	22.352	FP32	
8	CM2T	1/2	8G	MegaCrimp	-----	-----	-----	1.25	FULL	26.416	FP33	
16	CPS	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	CPS	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.388	FP310L	
24	CPS	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	62.738	FP311	
32	CPS	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	78.994	FP314	
12	CPSGS	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	38.1	FP35	
12	CPSGS-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	38.1	FP35	
20	EFG3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
20	EFG3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
6	EFG4K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	EFG4K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.432	FP33	
10	EFG4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
12	EFG4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
16	EFG4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
20	EFG4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
6	EFG4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	EFG4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.432	FP33	
10	EFG4K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.53	FP35	
12	EFG4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
16	EFG4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	EFG4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
6	EFG5K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	EFG5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.432	FP33	
10	EFG5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
12	EFG5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.59	FP35	
16	EFG5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	EFG5K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.642	FP310L	
6	EFG5K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	EFG5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.432	FP33	
10	EFG5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.53	FP35	
12	EFG5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.59	FP35	
16	EFG5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	EFG5K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.642	FP310L	
6	EFG6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	EFG6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.432	FP33	
10	EFG6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
12	EFG6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.59	FP35	
16	EFG6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	EFG6K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.642	FP310L	
6	EFG6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
8	EFG6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.432	FP33	
10	EFG6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.53	FP35	
12	EFG6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.59	FP35	
16	EFG6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	EFG6K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.642	FP310L	
3	G1	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	15.748	FP31	
3	G1	3/16	03PC	03PC2F-2	80415	0.835	WIRE	-----	FULL	15.748	FP31	
3	G1	3/16	Grease	03MPG	-----	0.625	WIRE	-----	0.500	11.43	FP301	
3	G1	3/16	Grease	03MPGB	-----	0.625	WIRE	-----	0.500	11.43	FP301	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.907	FP21	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.907	FP31	
4	G1	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.272	FP21	
4	G1	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.272	FP31	
4	G1	1/4	04PC	04PC2F-2	80416	0.910	WIRE	-----	FULL	15.875	FP31	
5	G1	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.066	FP32	
5	G1	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	19.05	FP21	
5	G1	5/16	05PC	05PC1FS	80483	-----	-----	-----	FULL	19.05	FP31	
5	G1	5/16	05PC	05PC2F-2	80417	0.835	WIRE	-----	FULL	18.288	FP21	
5	G1	5/16	05PC	05PC2F-2	80417	0.835	WIRE	-----	FULL	18.288	FP31	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.463	FP22	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.463	FP32	
6	G1	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.209	FP22	
6	G1	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.209	FP32	
6	G1	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	18.669	FP21	
6	G1	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	18.669	FP31	
8	G1	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.654	FP33	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose			Stem	Ferrule		Skive / Buff		Crimp			Crimper	
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
8	G1	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.384	FP33	
8	G1	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP22	
8	G1	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP32	
10	G1	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.829	FP34	
10	G1	5/8	10PC	10PC1FA-M3K	80436	-----	-----	-----	FULL	27.94	FP33	
10	G1	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	27.94	FP33	
10	G1	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	27.305	FP33	
12	G1	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.29	FP35	
12	G1	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	32.385	FP34	
12	G1	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	29.718	FP34	
16	G1	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	44.704	FP37	
16	G1	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	41.91	FP36	
16	G1	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	39.243	FP36	
20	G1	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	52.07	FP39	
20	G1	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	50.165	FP38	
20	G1	1 1/4	20PC	20PC2F-2	80427	2.315	WIRE	-----	FULL	48.768	FP38	
24	G1	1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	56.896	FP310L	
32	G1	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	72.263	FP313	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.288	FP31	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.288	FP21	
4	G1H	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.399	FP31	
4	G1H	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.399	FP21	
4	G1H	1/4	04PC	04PC2F-2	80416	0.910	WIRE	-----	FULL	15.748	FP31	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.463	FP32	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.463	FP22	
6	G1H	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.463	FP22	
6	G1H	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.463	FP32	
6	G1H	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	18.288	FP21	
6	G1H	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	18.288	FP31	
8	G1H	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.908	FP33	
8	G1H	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.003	FP32	
8	G1H	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.003	FP22	
8	G1H	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP32	
8	G1H	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP22	
10	G1H	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.829	FP34	
10	G1H	5/8	10PC	10PC1FA-M3K	80436	-----	-----	-----	FULL	27.559	FP33	
10	G1H	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	27.559	FP33	
10	G1H	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	27.178	FP33	
12	G1H	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.29	FP35	
12	G1H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	32.385	FP34	
12	G1H	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	30.226	FP34	
16	G1H	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	44.704	FP37	
16	G1H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	41.529	FP36	
16	G1H	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	39.116	FP36	
20	G1H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	52.07	FP39	
20	G1H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	50.165	FP38	
20	G1H	1 1/4	20PC	20PC2F-2	80427	2.315	WIRE	-----	FULL	48.768	FP38	
24	G1H	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	56.896	FP310L	
24	G1H	1 1/2	24PC	24PC2F-4	80428	2.280	WIRE	-----	FULL	54.356	FP39	
24	G1H	1 1/2	24PC	24PC2F-4	80428	2.280	WIRE	-----	FULL	54.36	FP39	
32	G1H	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	72.263	FP313	
32	G1H	2	32PC	32PC2F-4	80429	2.750	WIRE	-----	FULL	71.12	FP313	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 30008

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
8	G2AT-HMP	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.67	FP33	
8	G2AT-HMP	1/2	08PC	08PC2F-2C	80473	0.970	WIRE	-----	FULL	24.638	FP32	
8	G2AT-HMP	1/2	08PC	08PC2F-2C	80473	0.970	WIRE	-----	FULL	24.638	FP22	
10	G2AT-HMP	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.718	FP34	
10	G2AT-HMP	5/8	10PC	10PC2F-2C	80447	1.187	WIRE	-----	FULL	27.559	FP33	
12	G2AT-HMP	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	G2AT-HMP	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	30.607	FP34	
16	G2AT-HMP	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.466	FP37	
16	G2AT-HMP	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	40.259	FP36	
3	G2	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	16.637	FP31	
3	G2	3/16	03PC	03PC2F-2	80415	0.750	WIRE	-----	FULL	16.637	FP31	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP21	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP31	
4	G2	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP31	
4	G2	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP21	
4	G2	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	16.637	FP31	
5	G2	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.57	FP32	
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.606	FP32	
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.606	FP22	
6	G2	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	22.352	FP22	
6	G2	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	22.352	FP32	
6	G2	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	19.685	FP21	
6	G2	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	19.685	FP31	
8	G2	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.67	FP33	
8	G2	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.892	FP33	
8	G2	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	24.638	FP33	
10	G2	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.718	FP34	
10	G2	5/8	10PC	10PC1FA-M3K	80436	-----	-----	-----	FULL	28.575	FP34	
10	G2	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	28.575	FP34	
10	G2	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	27.432	FP33	
12	G2	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	G2	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	33.274	FP35	
12	G2	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	30.988	FP34	
12	G2	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	31.75	FP34	
16	G2	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.466	FP37	
16	G2	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	42.545	FP36	
16	G2	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	40.259	FP36	
20	G2	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.975	FP39	
20	G2	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	52.451	FP38	
20	G2	1 1/4	20PC	20PC2F-2	80427	2.187	WIRE	-----	FULL	50.8	FP38	
24	G2	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	59.563	FP310L	
32	G2	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	75.184	FP313	
20	G2H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.975	FP39	
20	G2H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	52.451	FP38	
20	G2H	1 1/4	20PC	20PC2F-2	80427	2.187	WIRE	-----	FULL	51.181	FP38	
24	G2H	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	59.563	FP310L	
24	G2H	1 1/2	24PC	24PC2F-4	80428	2.280	WIRE	-----	FULL	57.277	FP310L	
32	G2H	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	75.184	FP313	
32	G2H	2	32PC	32PC2F-4	80429	2.750	WIRE	-----	FULL	73.66	FP313	
20	G2H-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.975	FP39	
24	G2H-MTF	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	59.563	FP310L	
32	G2H-MTF	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	75.184	FP313	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose			Stem	Ferrule		Skive / Buff		Crimp			Crimper	
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	22.352	FP31	
6	G2L	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.352	FP32	
8	G2L	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.416	FP33	
10	G2L	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.464	FP34	
12	G2L	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.179	FP35	
16	G2L	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.466	FP37	
20	G2L	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.975	FP39	
24	G2L	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	59.563	FP310L	
32	G2L	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	75.184	FP313	
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.8	FP21	
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.8	FP31	
6	G2XH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.61	FP32	
8	G2XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.67	FP33	
10	G2XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.72	FP34	
12	G2XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.43	FP35	
16	G2XH	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	44.704	FP37	
4	G3H	1/4	04PC	04PC2F-2	80416	0.785	0.540	-----	FULL	17.018	FP31	
4	G3H	1/4	04PC	04PC2F-2	80416	0.785	0.540	-----	FULL	17.018	FP21	
5	G3H	5/16	05PC	05PC2F-2	80417	0.750	0.620	-----	FULL	19.685	FP21	
5	G3H	5/16	05PC	05PC2F-2	80417	0.750	0.620	-----	FULL	19.685	FP31	
8	G3H	1/2	06PC	06PC2F-2	80418	0.785	0.690	-----	FULL	19.939	FP22	
10	G3H	5/8	08PC	10PC2F-2B	80476	0.880	0.900	-----	FULL	26.289	FP33	
12	G3H	3/4	12PC	12PC2F-4	80422	1.562	1.200	-----	FULL	34.671	FP35	
16	G3H	1	16PC	16PC2F-2	80424	1.500	1.450	-----	FULL	41.021	FP36	
20	G3H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	50.419	FP38	
20	G3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
20	G3K	1 1/4	20PCS	20PCS1F-M3K	81394	-----	-----	-----	FULL	51.562	FP38	
20	G3K	1 1/4	20PCS	20PCS2F	80756	2.187	WIRE	-----	FULL	51.054	FP38	
24	G3K	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	59.69	FP311	
24	G3K	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	57.023	FP310L	
32	G3K	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	74.93	FP313	
32	G3K	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	70.739	FP312	
20	G3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
20	G3K-MTF	1 1/4	20PCS	20PCS1F-M3K	81394	-----	-----	-----	FULL	51.562	FP38	
20	G3K-MTF	1 1/4	20PCS	20PCS2F	80756	2.187	WIRE	-----	FULL	51.054	FP38	
24	G3K-MTF	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	59.69	FP311	
24	G3K-MTF	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	57.023	FP310L	
32	G3K-MTF	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	74.93	FP313	
32	G3K-MTF	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	70.739	FP312	
12	G4H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	33.782	FP35	
12	G4H	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	33.528	FP35	
16	G4H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	43.18	FP36	
16	G4H	1	16PC	16PC2F-4	80425	-----	-----	-----	FULL	42.672	FP36	
20	G4H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	51.054	FP38	
20	G4H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	49.784	FP38	
10	G4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
12	G4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
12	G4K	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	34.163	FP35	
12	G4K	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	32.131	FP34	
16	G4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	G4K	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	G4K	1	16PCS	16PCS2F	80755	1.595	WIRE	-----	FULL	39.624	FP36	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



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Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 30008

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
20	G4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
20	G4K	1 1/4	20PCS	20PCS1F-M3K	81394	-----	-----	-----	FULL	51.562	FP38	
20	G4K	1 1/4	20PCS	20PCS2F	80756	2.187	WIRE	-----	FULL	51.054	FP38	
6	G4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
6	G4K-MTF	3/8	06PCS	06PCS1F	81390	-----	-----	-----	FULL	24.638	FP33	
6	G4K-MTF	3/8	06PCS	06PCS2F	83398	0.785	WIRE	-----	FULL	21.336	FP32	
8	G4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
8	G4K-MTF	1/2	08PCS	08PCS1F	81391	-----	-----	-----	FULL	28.575	FP33	
8	G4K-MTF	1/2	08PCS	08PCS2F	83399	1.170	WIRE	-----	FULL	26.035	FP33	
12	G4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
12	G4K-MTF	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	34.163	FP35	
12	G4K-MTF	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	32.131	FP34	
16	G4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	G4K-MTF	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	G4K-MTF	1	16PCS	16PCS2F	80755	1.595	WIRE	-----	FULL	39.624	FP36	
20	G4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
20	G4K-MTF	1 1/4	20PCS	20PCS1F-M3K	81394	-----	-----	-----	FULL	51.562	FP38	
8	G5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
10	G5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
12	G5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	38.1	FP35	
16	G5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
20	G5K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.388	FP310L	
24	G5K	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	62.738	FP311	
32	G5K	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	78.994	FP314	
8	G5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
8	G5K-MTF	1/2	08PCS	08PCS2F	83399	1.170	WIRE	-----	FULL	26.035	FP33	
10	G5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
10	G5K-MTF	5/8	10PCM	10PCM-2F	83419	1.010	WIRE	-----	FULL	31.115	FP34	
12	G5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	38.1	FP35	
12	G5K-MTF	3/4	12PCM	12PCM-2F	83404	1.095	WIRE	-----	FULL	36.322	FP35	
16	G5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	G5K-MTF	1	16PCM	16PCM-2F	83400	1.785	WIRE	-----	FULL	42.037	FP36	
20	G5K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.388	FP310L	
20	G5K-MTF	1 1/4	20PCM	20PCM-2F	83405	2.220	WIRE	-----	FULL	53.594	FP39	
24	G5K-MTF	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	62.738	FP311	
32	G5K-MTF	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	78.994	FP314	
6	G6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
6	G6K	3/8	06PCS	06PCS1F	81390	-----	-----	-----	FULL	24.638	FP33	
6	G6K	3/8	06PCS	06PCS2F	83398	0.785	WIRE	-----	FULL	21.336	FP32	
6	G6K	3/8	06PCS	06PCS2F	83398	0.785	WIRE	-----	FULL	21.336	FP22	
8	G6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
8	G6K	1/2	08PCS	08PCS2F	83399	1.170	WIRE	-----	FULL	26.035	FP33	
10	G6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
12	G6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	38.1	FP35	
16	G6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	G6K	1	16PCM	16PCM-2F	83400	1.785	WIRE	-----	FULL	42.037	FP36	
20	G6K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.388	FP310L	
20	G6K	1 1/4	20PCM	20PCM-2F	83405	2.220	WIRE	-----	FULL	53.594	FP39	
20	G6K	1 1/4	20PCM	20PCM-2F	83405	2.220	WIRE	-----	FULL	53.59	FP39	
24	G6K	1 1/2	24PCM	24PCM2F-G6K	-----	2.750	WIRE	-----	FULL	62.738	FP311	
6	G6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	24.892	FP33	
6	G6K-MTF	3/8	06PCS	06PCS1F	81390	-----	-----	-----	FULL	24.638	FP33	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
6	G6K-MTF	3/8	06PCS	06PCS2F	83398	0.785	WIRE	-----	FULL	21.336	FP22	
6	G6K-MTF	3/8	06PCS	06PCS2F	83398	0.785	WIRE	-----	FULL	21.336	FP32	
8	G6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	27.94	FP33	
8	G6K-MTF	1/2	08PCS	08PCS2F	83399	1.170	WIRE	-----	FULL	26.035	FP33	
10	G6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.528	FP35	
10	G6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	33.53	FP35	
12	G6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	38.1	FP35	
16	G6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	G6K-MTF	1	16PCM	16PCM-2F	83400	1.785	WIRE	-----	FULL	42.037	FP36	
20	G6K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	56.388	FP310L	
20	G6K-MTF	1 1/4	20PCM	20PCM-2F	83405	2.220	WIRE	-----	FULL	53.59	FP39	
20	G6K-MTF	1 1/4	20PCM	20PCM-2F	83405	2.220	WIRE	-----	FULL	53.594	FP39	
12	GMV	3/4	12G	MegaCrimp	-----	1.375	1.200	1.50	FULL	36.322	FP35	
16	GMV	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.72	FP37	
20	GMV	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.594	FP39	
24	GMV	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	58.928	FP310L	
24	GMV	1 1/2	24PC	24PC2F-4	80428	-----	-----	-----	FULL	56.896	FP310L	
32	GMV	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	73.914	FP313	
32	GMV	2	32PC	32PC2F-4	80429	-----	-----	-----	FULL	72.644	FP312	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.907	FP21	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.907	FP31	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	19.177	FP31	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	19.177	FP21	
6	GT7/GT7NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.971	FP22	
6	GT7/GT7NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.971	FP32	
8	GT7/GT7NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.908	FP33	
12	GT7/GT7NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	33.782	FP35	
16	GT7/GT7NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	42.672	FP37	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	19.05	FP31	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	19.05	FP21	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.86	FP32	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.86	FP22	
8	GT8/GT8NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.416	FP33	
12	GT8/GT8NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.544	FP35	
16	GT8/GT8NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	42.672	FP37	
3	GTH	3/16	03PC	03PC2F-2	80415	0.687	0.410	-----	FULL	16.129	FP31	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	19.05	FP31	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	19.05	FP21	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.066	FP31	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.066	FP21	
6	GTH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.59	FP22	
8	GTH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.289	FP33	
10	GTH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.3116	FP34	
12	GTH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.306	FP35	
24	HO	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	59.563	FP310L	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP31	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP21	
4	J2AT ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP31	
4	J2AT ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP21	
4	J2AT ²	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	16.256	FP31	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP32	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP22	
6	J2AT ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.971	FP32	
6	J2AT ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.971	FP22	
6	J2AT ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	19.431	FP21	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 30008

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
6	J2AT ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	19.431	FP31	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP21	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP31	
4	J2AT-MTF ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP31	
4	J2AT-MTF ²	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP21	
4	J2AT-MTF ²	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	16.256	FP31	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP32	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP22	
6	J2AT-MTF ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.971	FP22	
6	J2AT-MTF ²	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.971	FP32	
6	J2AT-MTF ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	19.431	FP21	
6	J2AT-MTF ²	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	19.431	FP31	
12	LW	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
12	LW	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	34.163	FP35	
12	LW	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	32.131	FP34	
16	LW	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	LW	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	LW	1	16PCS	16PCS2F	80755	1.595	WIRE	-----	FULL	39.624	FP36	
12	LW-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	37.592	FP35	
12	LW-MTF	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	34.163	FP35	
12	LW-MTF	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	32.131	FP34	
16	LW-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	44.45	FP37	
16	LW-MTF	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	LW-MTF	1	16PCS	16PCS2F	80755	1.595	WIRE	-----	FULL	39.624	FP36	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP21	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP31	
4	M2T	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP31	
4	M2T	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP21	
4	M2T	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	16.002	FP31	
4	M2T	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	16.764	FP31	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP22	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP32	
6	M2T	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	21.844	FP22	
6	M2T	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	21.844	FP32	
6	M2T	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP21	
6	M2T	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP31	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	20.574	FP22	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	20.574	FP32	
8	M2T	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.289	FP33	
8	M2T	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	26.035	FP33	
8	M2T	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP32	
8	M2T	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP22	
8	M2T	1/2	08PC-SS	08PC1F-M2SS	85029	-----	-----	-----	FULL	25.4	FP33	
10	M2T	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.337	FP34	
10	M2T	5/8	10PC	10PC1F-M2A	80443	-----	-----	-----	FULL	28.702	FP33	
10	M2T	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	28.194	FP33	
10	M2T	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	27.305	FP33	
10	M2T	5/8	10PC-SS	10PC1F-M2SS	85030	-----	-----	-----	FULL	28.194	FP33	
12	M2T	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.798	FP35	
12	M2T	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	33.782	FP35	
12	M2T	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	30.353	FP34	
12	M2T	3/4	12PC-SS	12PC1F-M2SS	85031	-----	-----	-----	FULL	33.782	FP35	
16	M2T	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	43.815	FP37	
16	M2T	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	42.672	FP36	
16	M2T	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	38.354	FP36	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
16	M2T	1	16PC-SS	16PC1F-M2SS	85032	-----	-----	-----	FULL	42.037	FP36	
10	M2TH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.083	FP34	
10	M2TH-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.08	FP34	
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP31	
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP21	
4	M2T-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP31	
4	M2T-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP21	
4	M2T-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	16.002	FP31	
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP32	
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP22	
6	M2T-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	21.844	FP22	
6	M2T-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	21.844	FP32	
6	M2T-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP31	
6	M2T-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP21	
8	M2T-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.289	FP33	
8	M2T-MTF	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	26.035	FP33	
8	M2T-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP22	
8	M2T-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.876	FP32	
10	M2T-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.337	FP34	
10	M2T-MTF	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	28.194	FP33	
10	M2T-MTF	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	27.305	FP33	
12	M2T-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.798	FP35	
12	M2T-MTF	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	33.782	FP35	
12	M2T-MTF	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	30.353	FP34	
16	M2T-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	43.815	FP37	
16	M2T-MTF	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	42.672	FP36	
16	M2T-MTF	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	38.354	FP36	
10	M2TN	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.08	FP34	
8	M2T PLUS	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.29	FP33	
10	M2T PLUS	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.58	FP34	
12	M2T PLUS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.8	FP35	
16	M2T+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	43.434	FP37	
16	M2T+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	43.434	FP37	
8	M2T PLUS-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.29	FP33	
10	M2T PLUS-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.58	FP34	
12	M2T PLUS-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.8	FP35	
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP21	
4	M3K	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	17.272	FP31	
4	M3K	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	17.272	FP21	
5	M3K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.066	FP32	
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP32	
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP22	
6	M3K	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	19.558	FP21	
6	M3K	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	19.558	FP31	
6	M3K	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	17.907	FP31	
6	M3K	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	17.907	FP21	
8	M3K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.4	FP33	
8	M3K	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	24.892	FP22	
8	M3K	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	24.892	FP32	
8	M3K	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.622	FP32	
8	M3K	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.622	FP22	
10	M3K	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.718	FP34	
10	M3K	5/8	10PC	10PC1FA-M3K	80436	-----	-----	-----	FULL	28.575	FP34	
10	M3K	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	28.575	FP34	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 30008

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
10	M3K	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	27.432	FP33	
12	M3K	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	M3K	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	M3K	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	33.274	FP35	
12	M3K	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	30.988	FP34	
16	M3K	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.72	FP37	
16	M3K	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	40.894	FP36	
16	M3K	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	M3K	1	16PCS	16PCS2F	80755	1.559	WIRE	-----	FULL	40.386	FP36	
20	M3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	52.07	FP39	
20	M3K	1 1/4	20PCS	20PCS1F-M3K	81394	-----	-----	-----	FULL	51.562	FP38	
20	M3K	1 1/4	20PCS	20PCS2F	80756	2.187	WIRE	-----	FULL	51.054	FP38	
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP21	
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
4	M3K-MTF	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	17.272	FP21	
4	M3K-MTF	1/4	04PC	04M3KPC	80584	-----	-----	-----	FULL	17.272	FP31	
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP32	
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP22	
6	M3K-MTF	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	19.558	FP21	
6	M3K-MTF	3/8	06PC	06M3KPC	80585	-----	-----	-----	FULL	19.558	FP31	
6	M3K-MTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	17.907	FP21	
6	M3K-MTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	17.907	FP31	
8	M3K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.4	FP33	
8	M3K-MTF	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	24.892	FP32	
8	M3K-MTF	1/2	08PC	08M3KPC	80586	-----	-----	-----	FULL	24.892	FP22	
8	M3K-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.622	FP32	
8	M3K-MTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.622	FP22	
10	M3K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.718	FP34	
10	M3K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	28.575	FP34	
10	M3K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	27.432	FP33	
12	M3K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	M3K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	M3K-MTF	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	33.274	FP35	
12	M3K-MTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	30.988	FP34	
12	M3K-MTF	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	31.75	FP34	
16	M3K-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.72	FP37	
16	M3K-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	40.894	FP36	
16	M3K-MTF	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	M3K-MTF	1	16PCS	16PCS2F	80755	1.559	WIRE	-----	FULL	40.259	FP36	
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP21	
5	M3K-XTF	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.066	FP22	
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP32	
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP22	
6	M3K-XTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	17.907	FP21	
6	M3K-XTF	3/8	06PC	06PC2F-2	80418	0.835	WIRE	-----	FULL	17.907	FP31	
8	M3K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.4	FP33	
8	M3K-XTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.622	FP22	
8	M3K-XTF	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	23.622	FP32	
10	M3K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.718	FP34	
10	M3K-XTF	5/8	10PC	10PC1FA-M3K	80436	-----	-----	-----	FULL	28.575	FP34	
10	M3K-XTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	27.432	FP33	
12	M3K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	M3K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	M3K-XTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	30.988	FP34	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
16	M3K-XTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.72	FP37	
16	M3K-XTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	40.894	FP36	
16	M3K-XTF	1	16PCS	16PCS2F	80755	1.560	WIRE	-----	FULL	40.386	FP36	
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP21	
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
6	M3KH	3/8	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP21	
6	M3KH	3/8	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
6	M3KH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.57	FP32	
8	M3KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.4	FP33	
10	M3KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.72	FP34	
12	M3KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.43	FP35	
12	M3KH	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
5	M4K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.19	FP32	
10	M4K	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.46	FP34	
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP21	
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP31	
4	M4K+	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP31	
4	M4K+	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP21	
4	M4K+	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	16.002	FP31	
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP32	
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP22	
6	M4K+	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	22.098	FP22	
6	M4K+	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	22.098	FP32	
6	M4K+	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP31	
6	M4K+	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP21	
8	M4K+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.924	FP33	
8	M4K+	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.892	FP33	
8	M4K+	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	24.384	FP22	
8	M4K+	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	24.384	FP32	
10	M4K+	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.591	FP34	
10	M4K+	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	28.067	FP33	
10	M4K+	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	27.432	FP33	
12	M4K+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	M4K+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	M4K+	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	33.782	FP35	
12	M4K+	3/4	12PCS	12PCS2F	80754	1.600	WIRE	-----	FULL	32.004	FP34	
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP21	
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP31	
4	M4K+-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP21	
4	M4K+-MTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP31	
4	M4K+-MTF	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	16.002	FP31	
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP22	
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP32	
6	M4K+-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	22.098	FP32	
6	M4K+-MTF	3/8	06PC	06PC1F-M2S	81512	-----	-----	-----	FULL	22.098	FP22	
6	M4K+-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP21	
6	M4K+-MTF	3/8	06PC	06PC2F-2	80418	0.785	WIRE	-----	FULL	18.669	FP31	
8	M4K+-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.924	FP33	
8	M4K+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.892	FP33	
8	M4K+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	24.384	FP22	
8	M4K+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	24.384	FP32	
10	M4K+-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.591	FP34	
10	M4K+-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	28.067	FP33	
10	M4K+-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	27.432	FP33	
12	M4K+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
12	M4K+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	M4K+-MTF	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	33.782	FP35	
12	M4K+-MTF	3/4	12PCS	12PCS2F	80754	1.600	WIRE	-----	FULL	32.004	FP34	
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP31	
4	M4K+-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP31	
4	M4K+-XTF	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP21	
6	M4K+-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.098	FP32	
8	M4K+-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.289	FP33	
10	M4K+-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.591	FP34	
12	M4K+-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	M4K+-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.16	FP21	
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.16	FP31	
12	M4KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	M4KH-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP31	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.161	FP21	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.16	FP31	
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.16	FP21	
4	M5K	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP31	
4	M5K	1/4	04PC	04PC1F-M2S	80468	-----	-----	-----	FULL	17.145	FP21	
4	M5K	1/4	04PC	04PC2F-2	80416	0.835	WIRE	-----	FULL	16.002	FP31	
4	M5K	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	16.764	FP31	
5	M5K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	20.19	FP32	
6	M5K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.84	FP32	
8	M5K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.416	FP33	
8	M5K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.42	FP33	
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP21	
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP31	
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP32	
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP22	
8	MCPB+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.924	FP33	
12	MCPB+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	MCPB+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	MCPB+	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	33.782	FP35	
12	MCPB+	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	32.004	FP34	
16	MCPB+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.72	FP37	
16	MCPB+	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	40.894	FP36	
20	MCPB+	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.975	FP39	
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP31	
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.796	FP21	
4	MCPB+-MTF	1/4	04PC	04PC1FS	80482	-----	-----	-----	FULL	17.78	FP31	
4	MCPB+-MTF	1/4	04PC	04PC2F-2	80416	0.785	WIRE	-----	FULL	16.256	FP31	
6	MCPB+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	22.733	FP22	
6	MCPB+-MTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.924	FP33	
6	MCPB+-MTF	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.971	FP22	
6	MCPB+-MTF	3/8	06PC	06PC1FS	80484	-----	-----	-----	FULL	21.971	FP32	
6	MCPB+-MTF	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	19.431	FP31	
6	MCPB+-MTF	3/8	06PC	06PC2F-2	80418	0.800	WIRE	-----	FULL	19.431	FP21	
8	MCPB+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	24.892	FP33	
8	MCPB+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	24.638	FP33	
12	MCPB+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.433	FP35	
12	MCPB+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	33.02	FP35	
12	MCPB+-MTF	3/4	12PCS	12PCS1F	81392	-----	-----	-----	FULL	33.782	FP35	
12	MCPB+-MTF	3/4	12PCS	12PCS2F	80754	1.595	WIRE	-----	FULL	32.004	FP34	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



Hydraulic Hose Crimp Data

PC 2001 Crimpers

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
16	MCPB+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	45.72	FP37	
16	MCPB+-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	40.894	FP36	
16	MCPB+-MTF	1	16PCS	16PCS1F-M3K	81393	-----	-----	-----	FULL	42.164	FP36	
16	MCPB+-MTF	1	16PCS	16PCS2F	80755	1.560	WIRE	-----	FULL	40.259	FP36	
20	MCPB+-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	53.975	FP39	
20	MCPB+-MTF	1 1/4	20PCS	20PCS2F	80756	2.187	WIRE	-----	FULL	50.8	FP38	
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP21	
6	MEGATECH 250	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP22	
8	MEGATECH 250	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	24.892	FP33	
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.464	FP34	
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	26.67	FP33	
12	MEGATECH 250	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.036	FP35	
16	MEGATECH 250	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	43.18	FP37	
20	MEGATECH 250	1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	50.292	FP38	
24	MEGATECH 500	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	56.896	FP39	
32	MEGATECH 500	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	72.263	FP313	
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.78	FP31	
6	MEGATECH 1000	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP22	
8	MEGATECH 1000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	24.892	FP33	
10	MEGATECH 1000	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	29.464	FP34	
12	MEGATECH 1000	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.052	FP35	
16	MEGATECH 1000	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	43.18	FP37	
20	MEGATECH 1000	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	51.308	FP38	
8	MEGATECH 3000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	26.67	FP33	
24	MEGATECH II ACP	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	59.182	FP310L	
32	MEGATECH II ACP	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	74.93	FP313	
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.907	FP31	
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.907	FP21	
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.5	FP32	
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.5	FP22	
8	RFS	1/2	08G	MegaCrimp	-----	-----	-----	0.93	FULL	25.6	FP33	
12	RFS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	34.3	FP35	
16	RFS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	44.704	FP37	
16	RFS	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	41.91	FP36	
16	RFS	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	39.243	FP36	
3	RLA	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	16.256	FP31	
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.288	FP31	
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	18.288	FP21	
4	RLA	1/4	04PC	04PC2F-2	80416	-----	-----	-----	FULL	16.764	FP31	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	19.558	FP31	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	19.558	FP21	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	19.56	FP21	
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	19.56	FP31	
5	RLA	5/16	05PC	05PC2F-2	80417	-----	-----	-----	FULL	19.431	FP21	
5	RLA	5/16	05PC	05PC2F-2	80417	-----	-----	-----	FULL	19.431	FP31	
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.844	FP32	
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	21.844	FP22	
6	RLA	3/8	06PC	06PC2F-2	80418	-----	-----	-----	FULL	19.558	FP31	
6	RLA	3/8	06PC	06PC2F-2	80418	-----	-----	-----	FULL	19.558	FP21	
8	RLA	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	27.432	FP33	
8	RLA	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	25.273	FP33	
10	RLA	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.956	FP34	
10	RLA	5/8	10PC	12PC2F-2	80423	-----	-----	-----	FULL	29.21	FP34	
12	RLA	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	36.322	FP35	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



Hydraulic Hose Crimp Data

PC 2001 Crimpers

Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
Dash Size	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
12	RLA	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	33.528	FP35	
16	RLA	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	42.926	FP37	
16	RLA	1	16PC	16PC2F-2	80424	-----	-----	-----	FULL	39.878	FP36	
8	S/R-XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	25.4	FP33	
10	S/R-XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.96	FP33	
12	S/R-XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	35.05	FP35	
32	SHR	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	74.93	FP313	
32	SHR	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	70.739	FP312	
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.272	FP21	
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	17.272	FP31	
6	TR500	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	20.574	FP22	
8	TR500	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	24.892	FP33	
10	TR500	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	28.702	FP34	
12	TR500	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	33.02	FP35	
16	TR500	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	40.13	FP36	
16	TR500	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	40.132	FP36	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.

Industrial Hose Crimp Data

PC 2001 Crimpers

Hose			Stem		Ferrule	Skive / Buff		Crimp			Crimper		
Size	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/- .03(in)	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
1	119B	250	16	PC	16PC2F-2	80424	-	-	-	Full	41.402	36	
1	119B	500	16	PC	16PC2F-4	80425	-	-	-	Full	42.545	36	
1/2	119B	500	8	PC	10PC2F-2B	80476	-	-	-	Full	27.051	33	
1/4	119B	250	4	PC	4PC2F-2	80416	-	-	-	Full	16.459	31	
1/4	119B	500	4	PC	4PC2F-2	80416	-	-	-	Full	17.907	31	
3/4	119B	250	12	PC	12PC2F-4	80422	-	-	-	Full	33.020	34	
3/4	119B	500	12	PC	12PC2F-4	80422	-	-	-	Full	34.671	35	
3/8	119B	250	6	PC	6PC2F-4	80462	-	-	-	Full	19.558	31	
3/8	119B	500	6	PC	6PC1FA	80434	-	-	-	Full	22.479	32	
1	19B	250	16	PC	16PC2F-2	80424	-	-	-	Full	39.624	36	
1	19B	500	16	PC	16PC2F-4	80425	-	-	-	Full	42.545	36	
1/2	19B	250	8	PC	8PC2F-2	80419	-	-	-	Full	25.273	32	
1/2	19B	500	8	PC	8PC2F-4	80463	-	-	-	Full	27.051	33	
1/4	19B	250	4	PC	4PC2F-2	80416	-	-	-	Full	16.459	31	
1/4	19B	500	4	PC	4PC2F-2	80416	-	-	-	Full	17.272	31	
1-1/4	19B	250	20	PC	20PC2F-4	80426	-	-	-	Full	50.546	38	
3/16	19B	500	3	PC	3PC2F-2	80415	-	-	-	Full	16.129	31	
3/4	19B	250	12	PC	12PC2F-4	80422	-	-	-	Full	33.020	34	
3/4	19B	500	12	PC	12PC1FA	80437	-	-	-	Full	34.671	35	
3/8	19B	250	6	PC	6PC2F-2	80418	-	-	-	Full	19.558	31	
3/8	19B	500	6	PC	6PC2F-4	80462	-	-	-	Full	22.479	32	
5/16	19B	250	5	PC	5PC1FA	80433	-	-	-	Full	19.304	31	
5/16	19B	500	5	PC	6PC2F-2	80418	-	-	-	Full	18.923	31	
5/8	19B	250	10	PC	10PC2F-2C	80447	-	-	-	Full	27.813	33	
5/8	19B	500	10	PC	10PC1FA	80436	-	-	-	Full	28.956	34	
1	20B-HB	350	16	PC	16PC2F-4	80425	-	-	-	Full	42.291	36	
1/2	20B-HB	350	8	PC	10PC2F-2B	80476	-	-	-	Full	27.051	33	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	-	-	-	Full	17.145	31	
1-1/2	20B-HB	350	24	PC	24PCBHB1F	-	-	-	-	Full	62.230	311	
1-1/4	20B-HB	350	20	PC	20PC2F-4	80426	-	-	-	Full	51.816	39	
2	20B-HB	350	32	PC	32PCBHB1F	-	-	-	-	Full	76.962	313	
3/4	20B-HB	350	12	PC	12PCBHB1F	-	-	-	-	Full	34.417	35	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	-	-	-	Full	20.066	32	
1	319MB	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	39.243	36	
1/2	319MB	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	23.876	32	
1/4	319MB	1000	4	PC	4PC2F-2	80416	0.75	WIRE	-	Full	16.256	31	
1-1/2	319MB	1000	24	PC	24PC2F-4	-	2.28	WIRE	-	Full	55.880	310L ²	
1-1/4	319MB	1000	20	PC	20PC2F-2	80427	2.19	WIRE	-	Full	47.752	37	
2	319MB	1000	32	PC	32PC2F-4	-	2.75	WIRE	-	Full	71.120	312	
3/4	319MB	1000	12	PC	12PC2F-4	80422	1.56	WIRE	-	Full	33.401	35	
3/8	319MB	1000	6	PC	6PC2F-2	80418	0.69	WIRE	-	Full	17.526	31	
1	3619M	1000	16	PC	16PC2F-2	80424	1.50	WIRE	-	Full	39.116	36	
1	3619M	1000	16	G	MegaCrimp	-	-	-	1.75	Full	44.323	37	
1.2	3619M	1000	8	PC	8PC2F-2	80419	0.88	WIRE	-	Full	23.622	32	
1-1/2	3619M	1000	24	PC	24PC2F-4	-	2.28	WIRE	-	Full	55.880	310L ²	
1-1/4	3619M	1000	20	PC	20PC2F-2	80427	1.12	WIRE	-	Full	47.752	37	
1-1/4	3619M	1000	20	G	MegaCrimp	-	-	-	1.75	Full	51.943	39	
2	3619M	1000	32	PC	32PC2F-4	-	2.75	WIRE	-	Full	71.120	312	
3/4	3619M	1000	12	PC	12PC2F-2	80423	1.63	WIRE	-	Full	30.226	34	
3/4	3619M	1000	12	G	MegaCrimp	-	-	-	1.50	Full	34.163	35	
1	6B	315	16	PC	16PC2F-4	80425	-	-	-	Full	43.434	36	
1/2	6B	200	8	PC	8PC2F-2	80419	-	-	-	Full	25.400	33	

¹ Adjustment Procedures on page 5. ² MPLN Couplings only. ³ The 310L die supersedes the 310 die. ⁴ Required if hose OD prohibits insertions.



Industrial Hose Crimp Data

PC 2001 Crimpers

Hose			Stem		Ferrule		Skive / Buff		Crimp			Crimper	
Size	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/- .03(in)	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
1/2	6B	250	8	PC	8PC2F-2	80419	-	-	-	Full	24.892	33	
1/2	6B	315	8	PC	8PC2F-4	80463	-	-	-	Full	27.559	33	
1/4	6B	250	4	PC	4PC2F-2	80416	-	-	-	Full	17.145	31	
1/4	6B	315	4	PC	4PC2F-2	80416	-	-	-	Full	17.018	31	
1-1/4	6B	200	20	PC	20PC2F-2	80427	-	-	-	Full	50.673	38	
3/4	6B	250	12	PC	12PC2F-2	80423	-	-	-	Full	31.496	34	
3/4	6B	315	12	PC	12PC2F-4	80422	-	-	-	Full	34.798	35	
3/8	6B	200	6	PC	6PC2F-2	80418	-	-	-	Full	19.558	31	
3/8	6B	250	6	PC	6PC2F-2	80418	-	-	-	Full	20.320	31	
1	Adapta Flex™	150	16	PC	16PC2F-2	80424	-	-	-	Full	40.640	36	
1	Adapta Flex™	200	16	PC	16PC2F-4	80425	-	-	-	Full	41.910	36	
1	Adapta Flex™	300	16	PC	16PC2F-4	80425	-	-	-	Full	42.037	36	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	-	-	-	Full	25.146	32	
1/2	Adapta Flex™	250	8	PC	8PC2F-2	80419	-	-	-	Full	25.400	33	
1/2	Adapta Flex™	300	8	PC	8PC2F-2	80419	-	-	-	Full	25.400	33	
1/4	Adapta Flex™	200	4	PC	4PC2F-2	80416	-	-	-	Full	16.460	31	
1/4	Adapta Flex™	250	4	PC	4PC2F-2	80416	-	-	-	Full	16.460	31	
1/4	Adapta Flex™	300	4	PC	4PC2F-2	80416	-	-	-	Full	17.400	31	
3/4	Adapta Flex™	200	12	PC	12PC2F-2	80423	-	-	-	Full	33.530	34	
3/4	Adapta Flex™	250	12	PC	12PC2F-4	80422	-	-	-	Full	34.290	34	
3/4	Adapta Flex™	300	12	PC	12PC2F-4	80422	-	-	-	Full	34.290	35	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	-	-	-	Full	19.050	31	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	-	-	-	Full	19.690	31	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	-	-	-	Full	20.320	31	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	-	-	-	Full	18.415	31	
5/8	Adapta Flex™	200	10	PC	12PC2F-2	80423	-	-	-	Full	28.580	34	
5/8	Adapta Flex™	250	10	PC	12PC2F-2	80423	-	-	-	Full	28.580	34	
1/2	Cyclone™	1000	8	PC	10PC2F-2B	80476	-	-	-	Full	26.416	33	
3/4	Cyclone™	1000	12	PC	12PC2F-4	80422	-	-	-	Full	34.290	35	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	-	-	-	Full	19.939	31	
1	Duro Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	43.586	37	
1/2	Duro Flex®	250	8	PC	8PC2F-2	80419	-	-	-	Full	25.273	33	
1/2	Duro Flex®	300	8	PC	10PC2F-2B	80476	-	-	-	Full	27.178	33	
1/4	Duro Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	16.637	31	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	-	-	-	Full	18.288	31	
1-1/4	Duro Flex®	200	20	PC	20PC2F-2	80427	-	-	-	Full	50.673	37	
3/4	Duro Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	34.442	35	
3/4	Duro Flex®	300	12	PC	12PC2F-4	80422	-	-	-	Full	33.020	34	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	20.828	32	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	-	-	-	Full	21.463	32	
5/8	Duro Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	30.099	34	
5/8	Duro Flex®	300	10	PC	12PC2F-2	80423	-	-	-	Full	29.972	34	
3/4	Heat Master® (Aramid) ¹	500	12	PC	12PCBHB1F	-	-	-	-	Full	34.290	35	
1/2	PC2500	2500	8	G	MegaCrimp	-	-	-	1.25	Full	25.654	33	
1/2	PC2500	2500	8	PC	8PC1FS	80485	-	-	-	Full	24.384	33	
1/2	PC2500	2500	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	23.876	32	
1/2	PC2500	2500	8	PC	8PC1FA	80435	-	-	-	Full	24.384	33	
3/8	PC3000	3000	6	PC	6PC1FA	80434	-	-	-	Full	21.209	32	
3/8	PC3000	3000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	18.669	31	
3/8	PC3000	3000	6	PC	6PC1FS	80484	-	-	-	Full	21.209	32	
3/8	PC3000	3000	6	G	MegaCrimp	-	-	-	0.93	Full	21.463	32	
1/4	PC3500	3500	4	PC	4PC2F-2	80416	0.910	WIRE	-	Full	15.875	31	

¹ Crimp data is only for aramid-reinforced Heatmaster® hose. ² The 310L die supersedes the 310 die.



Industrial Hose Crimp Data

PC 2001 Crimpers

Hose			Stem		Ferrule	Skive / Buff			Crimp			Crimper	
Size	Description	Working Pressure (psi)	Dash Size	Type	Description	Auto Part No.	Length +/- .03(in)	Diameter (in)	Hose Insertion Length +/- .03(in)	Length +/- .03(in)	Crimp OD +/- .254(mm)	Die Set	User's Actual Setting
1/4	PC3500	3500	4	PC	4PC1FS	80482	-	-	-	Full	17.272	31	
1/4	PC3500	3500	4	PC	4PC1FA	80432	-	-	-	Full	17.272	31	
1/4	PC3500	3500	4	G	MegaCrimp	-	-	-	0.93	Full	17.907	31	
1/2	PC4000	4000	8	G	MegaCrimp	-	-	-	1.25	Full	26.670	33	
1/2	PC4000	4000	8	PC	8PC1FA	80435	-	-	-	Full	24.892	33	
1/2	PC4000	4000	8	PC	8PC1FS	80485	-	-	-	Full	24.892	33	
1/2	PC4000	4000	8	PC	8PC2F-2	80419	0.970	WIRE	-	Full	24.638	33	
3/8	PC4000	4000	6	PC	6PC2F-2	80418	0.835	WIRE	-	Full	18.669	31	
3/8	PC4000	4000	6	G	MegaCrimp	-	-	-	0.93	Full	21.463	32	
3/8	PC4000	4000	6	PC	6PC1FA	80434	-	-	-	Full	21.209	32	
3/8	PC4000	4000	6	PC	6PC1FS	80484	-	-	-	Full	21.209	32	
3/8	PC5000	5000	6	PC	6PC1FA	80434	-	-	-	Full	22.352	32	
3/8	PC5000	5000	6	PC	6PC1FS	80484	-	-	-	Full	22.352	32	
3/8	PC5000	5000	6	G	MegaCrimp	-	-	-	0.93	Full	22.606	32	
3/8	PC5000	5000	6	PC	6PC2F-2	80418	0.785	WIRE	-	Full	19.685	31	
1/4	PC6000	6000	4	PC	4PC2F-2	80416	0.785	WIRE	-	Full	17.399	31	
1/4	PC6000	6000	4	PC	4PC1FS	80482	-	-	-	Full	17.780	31	
1/4	PC6000	6000	4	G	MegaCrimp	-	-	-	0.93	Full	18.796	31	
1/4	PC6000	6000	4	PC	4PC1FA	80432	-	-	-	Full	17.780	31	
1	Premo Flex®	250	16	PC	16PC2F-4	80425	-	-	-	Full	42.545	37	
1/2	Premo Flex®	250	8	PC	8PC1FA	80435	-	-	-	Full	24.892	33	
1/2	Premo Flex®	315	8	PC	8PC1FA	80435	-	-	-	Full	25.273	33	
1/4	Premo Flex®	250	4	PC	4PC2F-2	80416	-	-	-	Full	16.383	31	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	-	-	-	Full	17.145	31	
1-1/4	Premo Flex®	250	20	PC	20PC2F-4	80426	-	-	-	Full	50.546	38	
3/16	Premo Flex®	250	3	PC	3PC2F-2	80415	-	-	-	Full	16.637	31	
3/4	Premo Flex®	250	12	PC	12PC2F-4	80422	-	-	-	Full	34.290	35	
3/4	Premo Flex®	315	12	PC	12PC2F-4	80422	-	-	-	Full	34.163	35	
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	-	-	-	Full	19.177	31	
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	-	-	-	Full	20.701	32	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	-	-	-	Full	18.288	31	
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	-	-	-	Full	19.177	31	
5/8	Premo Flex®	250	10	PC	12PC2F-2	80423	-	-	-	Full	29.083	34	
5/8	Premo Flex®	315	10	PC	10PC1FA	80436	-	-	-	Full	28.448	34	
1	Terminator®	400	16	G	MegaCrimp	-	-	-	1.75	Full	45.339	37	
1	Terminator®	400	16	PC	16PC2F-4	80425	-	-	-	Full	42.164	36	
1/2	Terminator®	400	8	G	MegaCrimp	-	-	-	1.25	Full	26.670	33	
1/2	Terminator®	400	8	PC	8PC2F-4	80463	-	-	-	Full	26.924	33	
1/4	Terminator®	400	4	PC	4PC2F-2	80416	-	-	-	Full	17.272	31	
1/4	Terminator®	400	4	G	MegaCrimp	-	-	-	0.94	Full	18.796	31	
1-1/2	Terminator®	400	24	PC	24PC2F-4	80428	-	-	-	Full	57.404	39	
1-1/4	Terminator®	400	20	PC	20PC2F-2	80427	-	-	-	Full	50.038	38	
1-1/4	Terminator®	400	20	G	MegaCrimp	-	-	-	1.75	Full	52.832	38	
2	Terminator®	400	32	PC	32PC2F-4	80429	-	-	-	Full	73.914	313	
3/4	Terminator®	400	12	G	MegaCrimp	-	-	-	1.50	Full	36.322	35	
3/4	Terminator®	400	12	PC	12PC2F-4	80422	-	-	-	Full	34.544	35	
3/8	Terminator®	400	6	PC	6PC2F-4	80462	-	-	-	Full	22.098	32	
3/8	Terminator®	400	6	G	MegaCrimp	-	-	-	0.94	Full	23.368	32	

¹ Crimp data is only for aramid-reinforced Heatmaster® hose. ² The 310L die supersedes the 310 die.



GLP Coupling Crimping Instructions

Power Crimp® 2001 (FP-120)

See Figure 1 for proper alignment of coupling in die prior to crimping.

Align fitting end of staking collar of uncrimped ferrule flush with top of the die

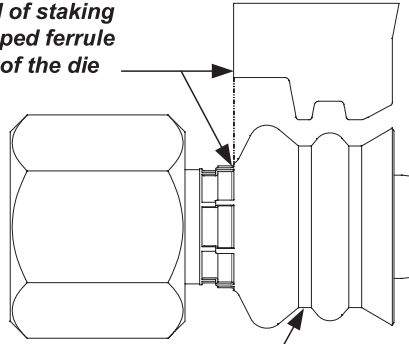


Figure 1 *Measure Crimp Here*

Hose Dash Size	Description	Size (in.)	Stem Type	Ferrule Description	Prod. No.	Crimp Insertion Length +/- .03(in)	Crimp OD (mm)	Crimper Die Set	User's Actual Setting
4	LOC	1/4	GLP1	1-pc GLP1	-----	0.66	11.94	FP71	
6	LOC	3/8	GLP1	1-pc GLP1	-----	0.77	15.75	FP72	
8	LOC	1/2	GLP1	1-pc GLP1	-----	0.72	18.80	FP73	
10	LOC	5/8	GLP1	1-pc GLP1	-----	0.75	23.37	FP74	
12	LOC	3/4	GLP1	1-pc GLP1	-----	0.75	25.40	FP75	
4	LOL	1/4	GLP1	1-pc GLP1	-----	0.66	11.94	FP71	
6	LOL	3/8	GLP1	1-pc GLP1	-----	0.77	15.75	FP72	
8	LOL	1/2	GLP1	1-pc GLP1	-----	0.72	18.80	FP73	
10	LOL	5/8	GLP1	1-pc GLP1	-----	0.75	23.11	FP74	
12	LOL	3/4	GLP1	1-pc GLP1	-----	0.98	26.42	FP75	
4	M500	1/4	GLP1	1-pc GLP1	-----	0.46	11.68	FP71	
6	M500	3/8	GLP1	1-pc GLP1	-----	0.62	15.62	FP72	
8	M500	1/2	GLP1	1-pc GLP1	-----	0.75	19.05	FP73	
10	M500	5/8	GLP1	1-pc GLP1	-----	0.91	23.11	FP74	
12	M500	3/4	GLP1	1-pc GLP1	-----	0.75	25.78	FP75	
4	MEGATECH 250	1/4	GLP1	1-pc GLP1	-----	0.66	12.70	FP71	
6	MEGATECH 250	3/8	GLP1	1-pc GLP1	-----	0.77	16.26	FP72	
8	MEGATECH 250	1/2	GLP1	1-pc GLP1	-----	0.72	18.80	FP73	
10	MEGATECH 250	5/8	GLP1	1-pc GLP1	-----	0.75	22.86	FP74	
12	MEGATECH 250	3/4	GLP1	1-pc GLP1	-----	0.98	25.91	FP75	
4	RLA	1/4	GLP1	1-pc GLP1	-----	0.66	12.70	FP71	
6	RLA	3/8	GLP1	1-pc GLP1	-----	0.77	16.76	FP72	
8	RLA	1/2	GLP1	1-pc GLP1	-----	0.72	18.80	FP73	
10	RLA	5/8	GLP1	1-pc GLP1	-----	0.75	23.37	FP74	
12	RLA	3/4	GLP1	1-pc GLP1	-----	0.98	26.42	FP75	
8	S/R-XH	1/2	GLP1	1-pc GLP1	-----	0.72	19.30	FP73	
10	S/R-XH	5/8	GLP1	1-pc GLP1	-----	0.75	23.37	FP74	
12	S/R-XH	3/4	GLP1	1-pc GLP1	-----	0.98	27.43	FP75	
4	TR500	1/4	GLP5	1-pc GLP5	-----	0.66	11.94	FP71	
6	TR500	3/8	GLP5	1-pc GLP5	-----	0.77	15.49	FP72	
8	TR500	1/2	GLP5	1-pc GLP5	-----	0.72	18.29	FP73	
10	TR500	5/8	GLP5	1-pc GLP5	-----	0.75	22.35	FP74	
12	TR500	3/4	GLP5	1-pc GLP5	-----	0.98	25.91	FP75	

GL Coupling Crimping Instructions

Power Crimp® 2001

To achieve proper tail length, line up hose end of ferrule with “locating step” on die inside diameter (I.D.) prior to crimping (See Figure 1 or 2 depending on die). Be sure die fingers are all the way forward and locked in place in die shoes.

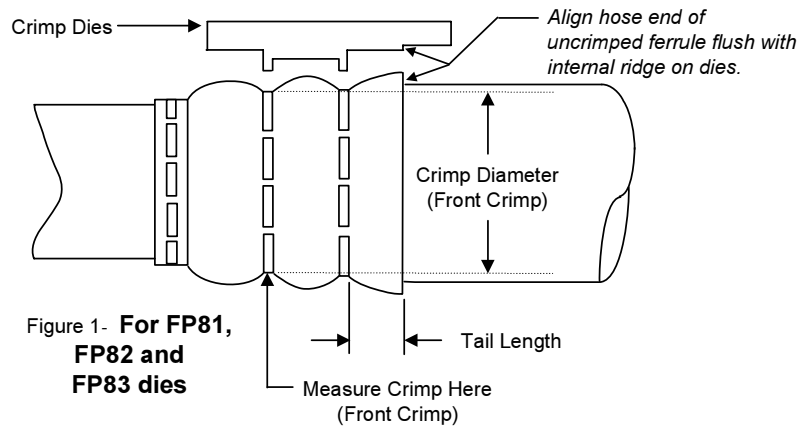


Figure 1- For FP81, FP82 and FP83 dies

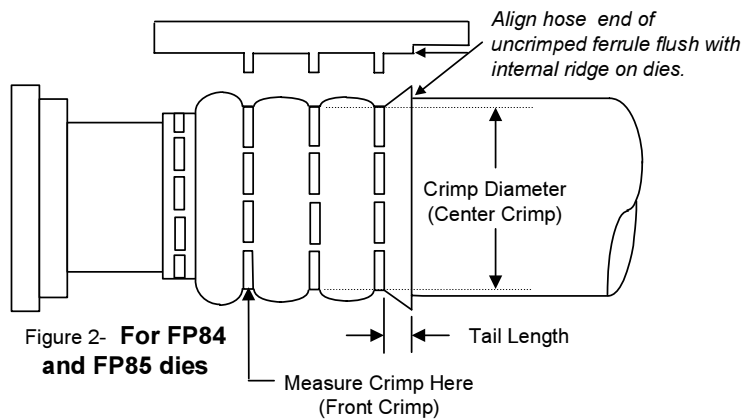


Figure 2- For FP84 and FP85 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.10(in)	Crimp OD +/- 0.010(in.)	Die Set	User's Actual Setting
12	GMV	3/4	12GL	1-pc GL	-----	-----	-----	1.75	0.50	1.12	FP81	
16	GMV	1	16GL	1-pc GL	-----	-----	-----	2.125	0.60	1.36	FP82	
20	GMV	1 1/4	20GL	1-pc GL	-----	-----	-----	2.25	0.50	1.66	FP83	
24	GMV	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	FP84	
32	GMV	2	32GL	1-pc GL	-----	-----	-----	2.75	0.50	2.43	FP85	

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.020(in)	Crimp OD +/- .010(in.)	Die Set	User's Actual Setting
24	MEGATECH ACR	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	FP84	
32	MEGATECH ACR	2	32GL	1-pc GL	-----	-----	-----	2.75	0.50	2.41	FP85	

Note: The Tail Length Tolerance for the MEGATECH ACR HOSE IS +/- 0.020(in.)!



GL Coupling Crimping Instructions

Power Crimp® 2001

To achieve proper tail length, line up the hose end of ferrule with top of die (See Figure 1) prior to crimping.

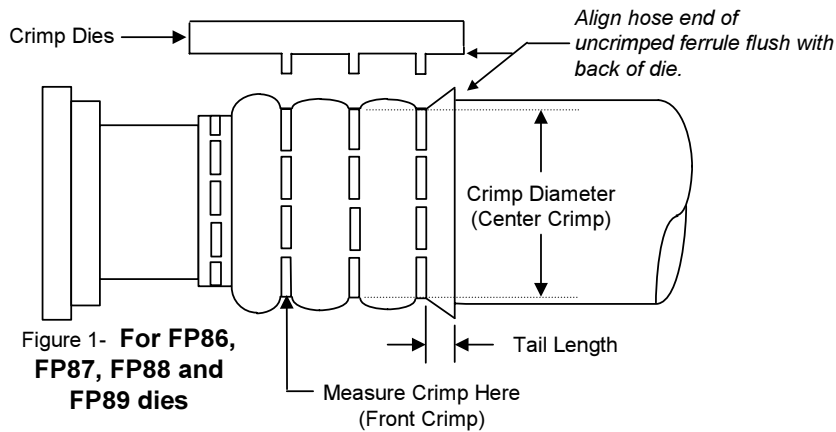


Figure 1- For FP86, FP87, FP88 and FP89 dies

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.10(in.)	Crimp OD +/- .010(in.)	Die Set	User's Actual Setting
40	GMV	2 1/2	40G4H	1-pc GL/G4H	-----	-----	-----	2.375	0.425	2.900	FP86	
48	GMV	3	48G4H	1-pc GL/G4H	-----	-----	-----	2.750	0.460	3.470	FP87	
56	GMV	3 1/2	56G4H	1-pc GL/G4H	-----	-----	-----	3.64	0.625	4.000	FP88	
64	GMV	4	64G4H	1-pc GL/G4H	-----	-----	-----	4.04	0.550	4.500	FP89	

Dash Size	Description	Size (in.)	Type	Description	No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.020(in.)	Crimp OD +/- .010(in.)	Die Set	User's Actual Setting
40	MEGATECHACR	2 1/2	40G4H	1-pc GL/G4H	-----	-----	-----	2.375	0.400	2.800	FP86	
48	MEGATECHACR	3	48G4H	1-pc GL/G4H	-----	-----	-----	2.750	0.420	3.410	FP87	

Note: The Tail Length Tolerance for the MEGATECH ACR HOSE IS +/- 0.020(in.)!

GC32-XD™



GC32-XD™

Gates Corporation

Visit www.gates.com/ecrimp for hose crimp specs not listed in this catalog.

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

Omnicrimp® 21 / Power Crimp® 3000B

GC32-XD™

Calibration & Adjustment Procedure

GC32-XD™

Check calibration every 100 crimps. (See operator's manual for more details.)

Calibration Procedure

Before crimping a hose assembly, check calibration. Calibration is the proper relationship between a setting and the crimp diameter. It should be checked at least monthly, weekly or daily, if crimper has been used heavily or abused.

1. Retract die shoes to fully open position.
2. Load the **GC32-33** die set into crimper for calibration. Press the Quick Change Tool (QCT) down until you feel it bottom out on the die shoe surface. Twist the QCT clockwise until it engages the die fingers,



then pull out of crimper head, aligning red with red decal on the QCT.

3. Set the dial vernier to **1.23** to calibrate.
4. While holding the thread end of an **8G MegaCrimp®** coupling, insert coupling into crimper so that ferrule is 1/8" from front edge of die shoe.
5. Press and hold top blue CRIMP button. Crimper will close down to position set on dial vernier. Once it reaches that position, crimper will automatically shut off.

NOTE: CRIMP button and foot pedal operate on a "dead man" control. It only operates as long as you depress the CRIMP button or hold foot pedal down. It stops immediately when switch is released.



WARNING:

To prevent serious injury:

- Keep away from all moving parts! If bodily contact should occur with a moving part, immediately release CRIMP button, foot pedal or press emergency stop.
 - Do not operate crimper with hand, fingers, or any body part in crimper mouth.
 - Keep additional personnel away from crimper while operating.
6. Remove coupling and measure crimp diameter. Crimp diameter must measure 1.000" +/- .003". To properly measure crimp diameter, refer to Hose Assembly Guide, #9, at the beginning of this manual.
 - If the crimp diameter is acceptable, no adjustment is necessary.
 - If crimp diameter is not acceptable, crimper must be calibrated. Proceed as follows:
 - a. Lock setting to 1.23 by using black locking lever on top of dial vernier.



Calibration & Adjustment Procedure

GC32-XD™

Calibration Procedure - Continued

b. Use Calibration equation to determine approximate new setting.

$$\left(\frac{\text{Actual COD} - \text{Target COD}}{\text{COD}} \right) \times 22 + \text{Published Setting} = \text{Adjusted Setting}$$

Example:

$$(1.010 - 1.000) \times 22 + 1.23 = 1.45$$

Changing the dial vernier number by approximately .02 will change crimp diameter .001".

c. Using the Allen head wrench included in the Accessory Kit, remove the dial vernier by loosening the set screw located at bottom on black knob of dial vernier.



- If crimp was too tight, unlock dial vernier and lower setting according to above calibration equation. Lock in place.
- If crimp was too loose, unlock and raise setting. Lock in place.



d. Reinstall dial vernier and tighten set screw using Allen wrench.



e. Unlock and reset dial vernier to 1.23.

7. Repeat calibration steps until published crimp diameter is achieved. Crimper is now calibrated.

Adjustment Procedure

Should the actual crimp diameter NOT be within the tolerance specified in the Crimp Data Charts, check the calibration of the crimper. If the calibration is correct, a slight adjustment of the digital readout may be necessary. To obtain a smaller crimp diameter, change the digital readout to a smaller number, or vice versa. Changing the digital readout by .05 (Example: 5.50 to 5.55) will change the crimp diameter by .001".

$$\left(\frac{\text{Actual COD} - \text{Target COD}}{\text{COD}} \right) \times 22 + \text{Published Setting} = \text{Adjusted Setting}$$

Remember to record your *Actual* adjusted crimp setting in the column provided in the crimp data chart.

Hydraulic Hose Crimp Data

Line	Size	Material	Length	Pressure	Temp	Actual Crimp Diameter	Published Crimp Diameter
1	1/2"	304	10'	3000	100		
2	3/4"	304	10'	3000	100		
3	1"	304	10'	3000	100		
4	1 1/4"	304	10'	3000	100		
5	1 1/2"	304	10'	3000	100		
6	2"	304	10'	3000	100		
7	2 1/2"	304	10'	3000	100		
8	3"	304	10'	3000	100		
9	3 1/2"	304	10'	3000	100		
10	4"	304	10'	3000	100		
11	4 1/2"	304	10'	3000	100		
12	5"	304	10'	3000	100		
13	5 1/2"	304	10'	3000	100		
14	6"	304	10'	3000	100		
15	6 1/2"	304	10'	3000	100		
16	7"	304	10'	3000	100		
17	7 1/2"	304	10'	3000	100		
18	8"	304	10'	3000	100		
19	8 1/2"	304	10'	3000	100		
20	9"	304	10'	3000	100		
21	9 1/2"	304	10'	3000	100		
22	10"	304	10'	3000	100		

Crimp Tooling

GC32-XD™ Dies Die Sets

Die Set	32-21	32-22	32-31	32-33	32-34	32-35	32-36	32-37
Part No.	78860	78861	78862 78890*	78863 78891*	78864 78892*	78865 78893*	78866 78894*	78867 78895*
Product No.	7482-7128	7482-7129	7482-7130 7482-7158*	7482-7131 7482-7159*	7482-7132 7482-7160*	7482-7133 7482-7161*	7482-7134 7482-7162*	7482-7135 7482-7163*

Die Set	32-38	32-39	32-310L	32-311	32-312	32-313	32-314
Part No.	78868 78896*	78869 78897*	78870 78898*	78871 78899*	78872 78900*	78873 78901*	78874 78902*
Product No.	7482-7136 7482-7164*	7482-7137 7482-7165*	7482-7138 7482-7166*	7482-7139 7482-7167*	7482-7140 7482-7168*	7482-7141 7482-7169*	7482-7142 7482-7170*

* ID Slug Die Finger

Specialty and Automotive Dies

Die Set	32-40	32-41	32-42	32-43	32-44	32-45	32-46	32-301
Part No.	78875	78876	78877	78878	78879	78888	78880 78904*	78889 78906*
Product No.	7482-7143	7482-7144	7482-7145	7482-7146	7482-7147	7482-7156	7482-7148 7482-7172*	7482-7157 7482-7174*
Use	Air Conditioning	Air Conditioning	Air Conditioning	Air Conditioning	Power Steering	Grease	Battery Cable	Clamp Collar

GLP Dies

Die Set	32-71	32-72	32-73	32-74	32-75
Part No.	78666	78667	78668	78669	78670
Product No.	7482-1372	7482-1373	7482-1374	7482-1375	7482-1376

GL Dies

Die Set	32-81	32-82	32-83	32-84	32-85	32-86
Part No.	78881	78882	78883	78884	78885	78886
Product No.	7482-7149	7482-7150	7482-7151	7482-7152	7482-7153	7482-7154

Die Tooling Supplies

Item	Part No.	Product No.
3oz Jar Molykote G Paste	78755	7482-0311
Digital Caliper	78241	7369-0322

Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
16	BOP	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
4	C5C	3/16	03PC	04PC2F-2	80416	-----	-----	-----	FULL	0.620	32-31	0.28	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	0.93	FULL	0.690	32-21	0.51	
5	C5C	1/4	04PC	04PC2F-2	80416	-----	-----	0.93	FULL	0.690	32-31	1.88	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	0.93	FULL	0.765	32-21	2.22	
6	C5C	5/16	05PC	06PC2F-2	80418	-----	-----	0.93	FULL	0.765	32-31	3.59	
8	C5C	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.860	32-22	1.95	
10	C5C	1/2	08PC	10PC2F-2B	80476	-----	-----	-----	FULL	1.050	32-33	2.22	
12	C5C	5/8	10PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.230	32-34	2.61	
4	C5E	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	0.660	32-31	1.19	
5	C5E	1/4	04PC	04PC2F-2	80416	-----	-----	0.93	FULL	0.660	32-31	1.19	
6	C5E	5/16	05PC	05PC1FS	80483	-----	-----	0.93	FULL	0.795	32-22	0.49	
8	C5E	13/32	06PC	06PC1FS	80484	-----	-----	-----	FULL	0.890	32-22	2.62	
10	C5E	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	0.990	32-33	0.84	
12	C5E	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.140	32-34	0.58	
24	C12	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	32-311	0.41	
24	C12	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	32-310L	1.31	
32	C12	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	32-313	3.21	
32	C12	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	32-312	1.95	
6	C12M	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	C12M	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
12	C12M	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	C12M	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	C12M	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
6	C12M-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	C12M-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
12	C12M-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	C12M-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	C12M-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
24	C12-MTF	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	32-311	0.41	
24	C12-MTF	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	32-310L	1.31	
32	C12-MTF	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	32-313	3.21	
32	C12-MTF	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	32-312	1.95	
6	CM2T	3/8	6G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	32-22	2.40	
8	CM2T	1/2	8G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	32-33	1.99	
16	CPS	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	CPS	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
24	CPS	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	32-311	3.08	
32	CPS	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	32-314	1.91	
12	CPSGS	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	32-35	4.76	
12	CPSGS-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	32-35	4.76	
16	CPS-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
16	CPS-MTF	1	16PCM	16PCM-2F	83400	1.785	WIRE	-----	FULL	1.655	32-36	3.64	
20	CPS-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
20	CPS-MTF	1 1/4	20PCM	20PCM-2F	83405	2.220	WIRE	-----	FULL	2.110	32-39	1.76	
24	CPS-MTF	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	32-311	3.08	
32	CPS-MTF	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	32-314	1.91	
20	EFG3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
20	EFG3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
6	EFG4K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	EFG4K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	32-33	2.92	
10	EFG4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	EFG4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	EFG4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	EFG4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
6	EFG4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	EFG4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	32-33	2.92	
10	EFG4K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	EFG4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	EFG4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	EFG4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
6	EFG5K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	EFG5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	32-33	2.92	
10	EFG5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	EFG5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
16	EFG5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	EFG5K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
6	EFG5K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	EFG5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	32-33	2.92	
10	EFG5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	EFG5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	EFG5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	EFG5K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
6	EFG6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	EFG6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	32-33	2.92	
10	EFG6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	EFG6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	EFG6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	EFG6K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
6	EFG6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	EFG6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.080	32-33	2.92	
10	EFG6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	EFG6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	EFG6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	EFG6K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
3	G1	3/16	03PC	03PC1FS	80481	-----	-----	-----	FULL	0.620	32-31	0.28	
3	G1	3/16	03PC	03PC2F-2	80415	0.835	WIRE	-----	FULL	0.620	32-31	0.28	
3	G1	3/16	Grease	03MPG	-----	0.625	WIRE	-----	0.500	0.450	32-301	0.93	
3	G1	3/16	Grease	03MPGB	-----	0.625	WIRE	-----	0.500	0.450	32-301	0.93	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	32-31	2.22	
4	G1	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	32-21	0.85	
5	G1	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-22	0.38	
6	G1	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	32-22	1.61	
8	G1	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.010	32-33	1.30	
8	G1	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.960	32-33	0.20	
10	G1	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.135	32-34	0.47	
10	G1	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.100	32-33	3.38	
10	G1	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	1.075	32-33	2.79	
12	G1	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	32-35	1.39	
12	G1	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.275	32-34	2.59	
12	G1	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.170	32-34	1.26	
16	G1	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	32-37	1.77	
16	G1	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.650	32-36	3.28	
16	G1	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.545	32-36	1.38	
20	G1	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.050	32-39	0.46	
20	G1	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	1.975	32-38	2.47	
20	G1	1 1/4	20PC	20PC2F-2	80427	2.315	WIRE	-----	FULL	1.920	32-38	1.26	
24	G1	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.240	32-310L	1.19	
32	G1	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.845	32-313	0.85	
3	G1H	3/16	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	32-22	1.61	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	32-31	2.56	
4	G1H	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	32-21	1.19	
6	G1H	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	32-22	1.61	
8	G1H	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.020	32-33	1.53	
10	G1H	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.135	32-34	0.47	
10	G1H	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.085	32-33	2.92	
10	G1H	5/8	10PC	10PC2F-2B	80476	0.970	WIRE	-----	FULL	1.070	32-33	2.68	
12	G1H	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	32-35	1.39	
12	G1H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.275	32-34	2.59	
12	G1H	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.190	32-34	1.75	
16	G1H	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	32-37	1.77	
16	G1H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.635	32-36	2.95	
16	G1H	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	1.540	32-36	1.32	
20	G1H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.050	32-39	0.46	
20	G1H	1 1/4	20PC	20PC1FS	80489	-----	-----	-----	FULL	1.975	32-38	2.47	
20	G1H	1 1/4	20PC	20PC2F-2	80427	2.315	WIRE	-----	FULL	1.920	32-38	1.26	
24	G1H	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.240	32-310L	1.19	
24	G1H	1 1/2	24PC	24PC2F-4	80428	2.280	WIRE	-----	FULL	2.140	32-39	2.41	
32	G1H	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.845	32-313	0.85	
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02	

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout
4	G2	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65
4	G2	1/4	04PC	04PC1FS	80481	-----	-----	-----	FULL	0.655	32-31	1.08
6	G2	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	32-22	2.62
8	G2	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	32-33	2.22
10	G2	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26
12	G2	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
16	G2	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	32-37	2.46
20	G2	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
24	G2	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	32-310L	3.67
32	G2	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	32-313	3.44
8	G2AT-HMP	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	32-33	2.22
10	G2AT-HMP	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26
10	G2AT-HMP	5/8	10PC	10PC2F-2C	80447	1.187	WIRE	-----	FULL	1.085	32-33	2.92
12	G2AT-HMP	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	G2AT-HMP	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.205	32-34	2.04
16	G2AT-HMP	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	32-37	2.46
16	G2AT-HMP	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	1.585	32-36	2.05
5	G2	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83
8	G2	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	32-33	0.61
8	G2	1/2	08PC	08PC2F-2	80419	0.970	WIRE	-----	FULL	0.970	32-33	0.41
10	G2	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	32-34	0.25
10	G2	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92
12	G2	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	32-35	0.50
12	G2	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	32-34	2.37
16	G2	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.675	32-36	4.08
16	G2	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.585	32-36	2.05
20	G2H	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
24	G2H	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	32-310L	3.67
32	G2H	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	32-313	3.44
20	G2H-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
24	G2H-MTF	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	32-310L	3.67
32	G2H-MTF	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	32-313	3.44
3	G2L	3/16	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	32-22	2.40
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.730	32-21	1.42
4	G2L	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.730	32-31	2.79
6	G2L	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.880	32-22	2.40
8	G2L	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	32-33	1.99
10	G2L	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	32-34	1.03
12	G2L	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.385	32-35	2.18
16	G2L	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.790	32-37	2.46
20	G2L	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
24	G2L	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	32-310L	3.67
32	G2L	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.960	32-313	3.44
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65
4	G2XH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02
6	G2XH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.890	32-22	2.62
8	G2XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	32-33	2.22
10	G2XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26
12	G2XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
16	G2XH	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	32-37	1.77
8	G3H	1/2	08PC	10PC2F-2B	80476	0.880	0.900	-----	FULL	1.035	32-33	1.88
12	G3H	3/4	12PC	12PC2F-4	80422	1.562	1.200	-----	FULL	1.365	32-35	1.73
16	G3H	1	16PC	16PC2F-2	80424	1.500	1.450	-----	FULL	1.615	32-36	2.73
20	G3H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.985	32-38	2.69
4	G3H (C3H)	1/4	04PC	04PC2F-2	80416	0.785	0.540	0.93	FULL	0.670	32-21	0.05
4	G3H (C3H)	1/4	04PC	04PC2F-2	80416	0.785	0.540	0.93	FULL	0.670	32-31	1.42
5	G3H (C3H)	5/16	05PC	05PC2F-2	80417	0.750	0.620	0.93	FULL	0.775	32-21	2.45
5	G3H (C3H)	5/16	05PC	05PC2F-2	80417	0.750	0.620	0.93	FULL	0.775	32-31	3.82
8	G3H (C3H)	1/2	06PC	06PC2F-2	80418	0.785	0.690	-----	FULL	0.785	32-22	0.27
10	G3H (C3H)	5/8	08PC	10PC2F-2B	80476	0.880	0.900	-----	FULL	1.035	32-33	1.88
12	G3H (C3H)	3/4	12PC	12PC2F-4	80422	1.562	1.200	-----	FULL	1.365	32-35	1.73
16	G3H (C3H)	1	16PC	16PC2F-2	80424	1.500	1.450	-----	FULL	1.615	32-36	2.73
20	G3H (C3H)	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.985	32-38	2.69
20	G3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46
24	G3K	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	32-311	0.41

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
24	G3K	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	32-310L	1.31	
32	G3K	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	32-313	3.21	
32	G3K	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	32-312	1.95	
20	G3K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
24	G3K-MTF	1 1/2	24PCS	24PCS1F	81395	-----	-----	-----	FULL	2.350	32-311	0.41	
24	G3K-MTF	1 1/2	24PCS	24PCS2F	80757	2.093	WIRE	-----	FULL	2.245	32-310L	1.31	
32	G3K-MTF	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	32-313	3.21	
32	G3K-MTF	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	32-312	1.95	
12	G4H	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.330	32-35	0.94	
12	G4H	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	32-35	0.72	
16	G4H	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.700	32-36	4.66	
16	G4H	1	16PC	16PC2F-4	80425	-----	-----	-----	FULL	1.680	32-36	4.20	
20	G4H	1 1/4	20PC	20PC2F-2	80427	-----	-----	-----	FULL	1.960	32-38	2.14	
10	G4K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	G4K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	G4K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	G4K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
6	G4K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	G4K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
12	G4K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	G4K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	G4K-MTF	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46	
8	G5K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
10	G5K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	G5K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	32-35	4.76	
16	G5K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	G5K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
24	G5K	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	32-311	3.08	
32	G5K	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	32-314	1.91	
8	G5K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
10	G5K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	G5K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	32-35	4.76	
16	G5K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	G5K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
24	G5K-MTF	1 1/2	24PCM	24PCM-2F	83402	2.750	WIRE	-----	FULL	2.470	32-311	3.08	
32	G5K-MTF	2	32PCM	32PCM-2F	83403	2.875	WIRE	-----	FULL	3.110	32-314	1.91	
6	G6K	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	G6K	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
10	G6K	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	G6K	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	32-35	4.76	
16	G6K	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	G6K	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
24	G6K	1 1/2	24PCM	24PCM2F-G6K	-----	2.750	WIRE	-----	FULL	2.470	32-311	3.08	
6	G6K-MTF	3/8	06GS	06GS1F-4	G20995-0406	-----	-----	-----	FULL	0.980	32-33	0.61	
8	G6K-MTF	1/2	08GS	08GS1F-4	G20995-0408	-----	-----	-----	FULL	1.100	32-33	3.38	
10	G6K-MTF	5/8	10GS	10GS1F-4	G20995-0410	-----	-----	-----	FULL	1.320	32-35	0.72	
12	G6K-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.500	32-35	4.76	
16	G6K-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
20	G6K-MTF	1 1/4	20GS	20GS1F-6	G20995-0620	-----	-----	-----	FULL	2.220	32-310L	0.71	
12	GMV	3/4	12G	MegaCrimp	-----	1.375	1.200	1.50	FULL	1.430	32-35	3.19	
16	GMV	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69	
20	GMV	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.110	32-39	1.76	
24	GMV	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.320	32-310L	3.08	
32	GMV	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.910	32-313	2.31	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	32-31	2.22	
4	GT7/GT7NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	32-21	0.85	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.755	32-21	1.99	
5	GT7/GT7NC	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.755	32-31	3.36	
6	GT7/GT7NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.865	32-22	2.06	

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper		
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting
8	GT7/GT7NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.020	32-33	1.53	
12	GT7/GT7NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.330	32-35	0.94	
16	GT7/GT7NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.680	32-37	0.05	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	32-21	1.88	
4	GT8/GT8NC	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	32-31	3.25	
6	GT8/GT8NC	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.900	32-22	2.84	
8	GT8/GT8NC	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	32-33	1.99	
12	GT8/GT8NC	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.360	32-35	1.61	
16	GT8/GT8NC	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.680	32-37	0.05	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	32-21	1.88	
4	GTH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	32-31	3.25	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-31	4.16	
5	GTH	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-21	2.79	
6	GTH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	32-22	1.72	
8	GTH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88	
10	GTH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.154	32-34	0.90	
12	GTH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.390	32-35	2.29	
3	GTH (C6H)	3/16	03PC	03PC2F-2	80415	0.687	0.410	-----	FULL	0.635	32-31	0.62	
4	GTH (C6H)	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	32-21	1.88	
4	GTH (C6H)	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.750	32-31	3.25	
5	GTH (C6H)	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-31	4.16	
5	GTH (C6H)	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-21	2.79	
6	GTH (C6H)	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	32-22	1.72	
8	GTH (C6H)	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88	
10	GTH (C6H)	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.154	32-34	0.90	
12	GTH (C6H)	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.390	32-35	2.29	
24	HO	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.345	32-310L	3.67	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02	
4	J2AT ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65	
6	J2AT ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	32-22	2.73	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65	
4	J2AT-MTF ²	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02	
6	J2AT-MTF ²	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	32-22	2.73	
12	LW	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	LW	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
12	LW-MTF	3/4	12GS	12GS1F-4	G20995-0412	-----	-----	-----	FULL	1.480	32-35	4.31	
16	LW-MTF	1	16GS	16GS1F-4	G20995-0416	-----	-----	-----	FULL	1.750	32-37	1.54	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45	
4	M2T	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08	
4	M2T	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	-----	FULL	0.660	32-31	1.19	
6	M2T	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17	
6	M2T	3/8	06PC-SS	06PC1F-M2SS	85028	-----	-----	-----	FULL	0.810	32-22	0.83	
8	M2T	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88	
8	M2T	1/2	08PC-SS	08PC1F-M2SS	85029	-----	-----	-----	FULL	1.000	32-33	1.07	
8	M2T	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	1.025	32-33	1.65	
10	M2T	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.155	32-34	0.92	
10	M2T	5/8	10PC-SS	10PC1F-M2SS	85030	-----	-----	-----	FULL	1.110	32-33	3.61	
10	M2T	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	1.110	32-33	3.61	
10	M2T	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	1.075	32-33	2.79	
12	M2T	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	32-35	1.84	
12	M2T	3/4	12PC-SS	12PC1F-M2SS	85031	-----	-----	-----	FULL	1.330	32-35	0.94	
12	M2T	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	1.330	32-35	0.94	
12	M2T	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.195	32-34	1.85	
16	M2T	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.725	32-37	0.96	
16	M2T	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	1.680	32-36	4.20	

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem			Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)	Type	Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout	User's Actual Setting	
16	M2T	1	16PC	16PC2F-2	80424	1.595	WIRE	-----	FULL	1.510	32-36	0.60		
16	M2T	1	16PC-SS	16PC1F-M2SS	85032	-----	-----	-----	FULL	1.655	32-36	3.64		
10	M2TH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	32-34	0.70		
10	M2TH-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	32-34	0.70		
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45		
4	M2T-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08		
6	M2T-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17		
8	M2T-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88		
8	M2T-MTF	1/2	08PC	08PC1F-M2S	80474	-----	-----	-----	FULL	1.025	32-33	1.65		
10	M2T-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.155	32-34	0.92		
10	M2T-MTF	5/8	10PC	10PC1F-M2S	80477	-----	-----	-----	FULL	1.110	32-33	3.61		
10	M2T-MTF	5/8	10PC	10PC2F-2B	80476	0.940	WIRE	-----	FULL	1.075	32-33	2.79		
12	M2T-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	32-35	1.84		
12	M2T-MTF	3/4	12PC	12PC1F-M2S	80475	-----	-----	-----	FULL	1.330	32-35	0.94		
12	M2T-MTF	3/4	12PC	12PC2F-2	80423	1.095	WIRE	-----	FULL	1.195	32-34	1.85		
16	M2T-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.725	32-37	0.96		
16	M2T-MTF	1	16PC	16PC1F-M2S	80480	-----	-----	-----	FULL	1.680	32-36	4.20		
16	M2T-MTF	1	16PC	16PC2F-2	80424	1.500	WIRE	-----	FULL	1.510	32-36	0.60		
10	M2TN	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.145	32-34	0.70		
8	M2T PLUS	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88		
10	M2T PLUS	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.125	32-34	0.25		
12	M2T PLUS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	32-35	1.84		
16	M2TPLUS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	32-37	0.63		
16	M2T+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	32-37	0.63		
16	M2T+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	32-37	0.63		
8	M2T PLUS-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88		
10	M2T PLUS-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.125	32-34	0.25		
12	M2T PLUS-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.370	32-35	1.84		
16	M2TPLUS-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.710	32-37	0.63		
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-21	0.73		
4	M3K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-31	2.10		
5	M3K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-22	0.38		
6	M3K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83		
8	M3K	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	32-33	1.07		
10	M3K	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26		
12	M3K	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40		
12	M3K	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27		
16	M3K	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69		
16	M3K	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	32-36	2.62		
20	M3K	1 1/4	20GS	20GS1F-4	G20995-0420	-----	-----	-----	FULL	2.050	32-39	0.46		
10	M3K	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	32-34	0.25		
10	M3K	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92		
12	M3K	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	32-35	0.50		
12	M3K	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	32-34	2.37		
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-31	2.10		
4	M3KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-21	0.73		
6	M3KH	3/8	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-31	2.10		
6	M3KH	3/8	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-21	0.73		
6	M3KH	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83		
8	M3KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	32-33	1.07		
10	M3KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26		
12	M3KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40		
12	M3KH	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27		
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-31	2.10		
4	M3K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-21	0.73		
6	M3K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83		
8	M3K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	32-33	1.07		
10	M3K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26		
10	M3K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.125	32-34	0.25		
10	M3K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92		
12	M3K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40		
12	M3K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27		
12	M3K-MTF	3/4	12PC	12PC1FS-M3K	80487	-----	-----	-----	FULL	1.310	32-35	0.50		
12	M3K-MTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	32-34	2.37		
16	M3K-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69		

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout
16	M3K-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	32-36	2.62
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-31	2.10
4	M3K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-21	0.73
5	M3K-XTF	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.790	32-22	0.38
6	M3K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83
8	M3K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	32-33	1.07
10	M3K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.170	32-34	1.26
10	M3K-XTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92
12	M3K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M3K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
12	M3K-XTF	3/4	12PC	12PC2F-2	80423	1.062	WIRE	-----	FULL	1.220	32-34	2.37
16	M3K-XTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69
16	M3K-XTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	32-36	2.62
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
4	M4K+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
6	M4K+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17
8	M4K+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.040	32-33	1.99
8	M4K+	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	32-33	0.61
10	M4K+	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	32-34	1.03
10	M4K+	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	32-33	3.49
10	M4K+	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92
12	M4K+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M4K+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
4	M4K+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
6	M4K+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17
8	M4K+-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	32-33	2.46
8	M4K+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	32-33	0.61
10	M4K+-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	32-34	1.03
10	M4K+-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	32-33	3.49
10	M4K+-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92
12	M4K+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M4K+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
4	M4K+-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
6	M4K+-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17
8	M4K+-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88
10	M4K+-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.165	32-34	1.14
12	M4K+-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M4K+-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
4	M4KH	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
8	M4KH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.065	32-33	1.65
10	M4KH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.165	32-34	1.14
12	M4KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	35	1.363
12	M4KH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M4KH-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
4	M4K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
4	M4K-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
6	M4K-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17
8	M4K-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	32-33	2.46
8	M4K-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	32-33	0.61
10	M4K-MTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.165	32-34	1.14
10	M4K-MTF	5/8	10PC	10PC1FS-M3K	80486	-----	-----	-----	FULL	1.105	32-33	3.49

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout
10	M4K-MTF	5/8	10PC	10PC2F-2C	80447	1.220	WIRE	-----	FULL	1.080	32-33	2.92
12	M4K-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M4K-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
8	M4K-XTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88
4	M4K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
4	M4K-XTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
6	M4K-XTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.870	32-22	2.17
6	M4K-XTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.035	32-33	1.88
10	M4K-XTF	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	32-34	1.03
12	M4K-XTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	M4K-XTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-21	1.08
4	M5K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.715	32-31	2.45
4	M5K	1/4	04PC-SS	04PC1F-M2SS	85027	-----	-----	0.93	FULL	0.660	32-31	1.19
5	M5K	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.795	32-22	0.49
6	M5K	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	32-22	1.95
4	M6K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.74	32-31	3.02
4	M6K	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.74	32-21	1.65
4	MCPB PLUS-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65
4	MCPB PLUS-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02
6	MCPB PLUS-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	32-22	2.73
8	MCPB PLUS-MTF	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	32-33	2.46
8	MCPB PLUS-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	32-33	0.61
8	MCPB PLUS-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.970	32-33	0.41
12	MCPB PLUS-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	MCPB PLUS-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
16	MCPB PLUS-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69
16	MCPB PLUS-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	32-36	2.62
20	MCPB PLUS-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65
4	MCPB+	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02
6	MCPB+	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	32-22	2.73
8	MCPB+	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	32-33	2.46
12	MCPB+	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	MCPB+	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
16	MCPB+	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69
16	MCPB+	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	32-36	2.62
20	MCPB+	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-31	3.02
4	MCPB+-MTF	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.740	32-21	1.65
6	MCPB+-MTF	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.895	32-22	2.73
6	MCPB+-MTF	3/8	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.060	32-33	2.46
8	MCPB+-MTF	1/2	08PC	08PC1FS	80485	-----	-----	-----	FULL	0.980	32-33	0.61
8	MCPB+-MTF	1/2	08PC	08PC2F-2	80419	0.880	WIRE	-----	FULL	0.970	32-33	0.41
12	MCPB+-MTF	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.395	32-35	2.40
12	MCPB+-MTF	3/4	12GS	12GS1F-2	G20995-0212	-----	-----	-----	FULL	1.300	32-35	0.27
16	MCPB+-MTF	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.800	32-37	2.69
16	MCPB+-MTF	1	16GS	16GS1F-2	-----	-----	-----	-----	FULL	1.610	32-36	2.62
20	MCPB+-MTF	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.125	32-39	2.08
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-31	2.10
4	MEGATECH 1000	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.700	32-21	0.73
6	MEGATECH 1000	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83
8	MEGATECH 1000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	32-33	0.61
10	MEGATECH 1000	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	32-34	1.03
12	MEGATECH 1000	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	32-35	2.00
16	MEGATECH 1000	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.700	32-37	0.39
20	MEGATECH 1000	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.020	32-38	0.13
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	32-21	0.73
4	MEGATECH 250	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	32-31	2.10

¹ See Adjustment Procedure at beginning of GC32-XD™ section.



General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hydraulic Hose Crimp Data

GC32-XD™

Dash Size	Hose		Stem Type	Ferrule		Skive / Buff		Crimp			Crimper	
	Description	Size (in)		Description	Part No.	Length +/- .03(in)	Diameter (in)	Insertion Length +/- .03(in)	Crimp Length	Crimp OD +/- .010(in)	Die Set	Approx. Digital Readout
6	MEGATECH 250	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.850	32-22	0.83
8	MEGATECH 250	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	32-33	0.61
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.160	32-34	1.03
12	MEGATECH 250	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.340	32-35	1.16
16	MEGATECH 250	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.730	32-37	0.39
20	MEGATECH 250	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	1.700	32-37	0.39
20	MEGATECH 250	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	1.980	32-38	2.58
24	MEGATECH 500	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.240	32-39	4.56
32	MEGATECH 500	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.845	32-313	0.85
10	MEGATECH 250	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.050	32-33	2.22
12	MEGATECH 1000(A)	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	32-35	2.00
16	MEGATECH 1000(A)	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.700	32-37	0.39
20	MEGATECH 1000(A)	1 1/4	20G	MegaCrimp	-----	-----	-----	1.75	FULL	2.020	32-38	0.13
8	MEGATECH 3000	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.050	32-33	2.22
24	MEGATECH II ACP	1 1/2	24PC	24PC1FS	80491	-----	-----	-----	FULL	2.330	32-310L	3.32
32	MEGATECH II ACP	2	32PC	32PC1FS	80492	-----	-----	-----	FULL	2.950	32-313	3.21
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	32-31	2.22
4	RFS	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.705	32-21	0.85
6	RFS	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.845	32-22	1.61
8	RFS	1/2	08G	MegaCrimp	-----	-----	-----	1.50	FULL	1.010	32-33	1.30
12	RFS	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.350	32-35	1.39
16	RFS	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.760	32-37	1.77
16	RFS	1	16PC	16PC1FS	80488	-----	-----	-----	FULL	1.650	32-36	3.28
16	RFS	1	16PC	16PC2F-2	80424	1.535	WIRE	-----	FULL	1.545	32-36	1.38
3	RLA	3/16	03PC	03PC2F-2	80415	-----	-----	-----	FULL	0.640	32-31	0.73
3	RLA	3/16	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	32-22	1.95
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	32-21	1.19
4	RLA	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.720	32-31	2.56
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.770	32-21	2.34
5	RLA	5/16	05G	MegaCrimp	-----	-----	-----	0.93	FULL	0.770	32-31	3.71
6	RLA	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.860	32-22	1.95
8	RLA	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.080	32-33	2.92
8	RLA	1/2	08PC	08PC2F-2	80419	-----	-----	-----	FULL	0.995	32-33	0.95
10	RLA	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.140	32-34	0.58
10	RLA	5/8	10PC	12PC2F-2	80423	-----	-----	-----	FULL	1.150	32-34	0.81
12	RLA	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.430	32-35	3.19
12	RLA	3/4	12PC	12PC2F-4	80422	-----	-----	-----	FULL	1.320	32-35	0.72
16	RLA	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.690	32-37	0.16
16	RLA	1	16PC	16PC2F-2	80424	-----	-----	-----	FULL	1.570	32-36	1.83
8	S/R-XH	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	1.000	32-33	1.07
10	S/R-XH	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.140	32-33	4.25
12	S/R-XH	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.380	32-35	2.00
32	SHR	2	32PCS	32PCS1F-G3K	81282	-----	-----	-----	FULL	2.950	32-313	3.21
32	SHR	2	32PCS	32PCS2F	80758	2.875	WIRE	-----	FULL	2.785	32-312	1.95
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	32-21	0.28
4	TR500	1/4	04G	MegaCrimp	-----	-----	-----	0.93	FULL	0.680	32-31	1.65
6	TR500	3/8	06G	MegaCrimp	-----	-----	-----	0.93	FULL	0.810	32-22	0.83
8	TR500	1/2	08G	MegaCrimp	-----	-----	-----	1.25	FULL	0.980	32-33	0.61
10	TR500	5/8	10G	MegaCrimp	-----	-----	-----	1.12	FULL	1.130	32-34	0.36
12	TR500	3/4	12G	MegaCrimp	-----	-----	-----	1.50	FULL	1.300	32-35	0.27
16	TR500	1	16G	MegaCrimp	-----	-----	-----	1.75	FULL	1.580	32-36	1.94

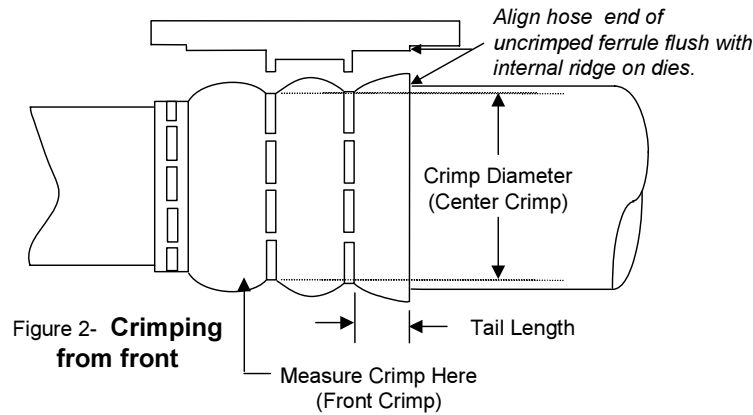
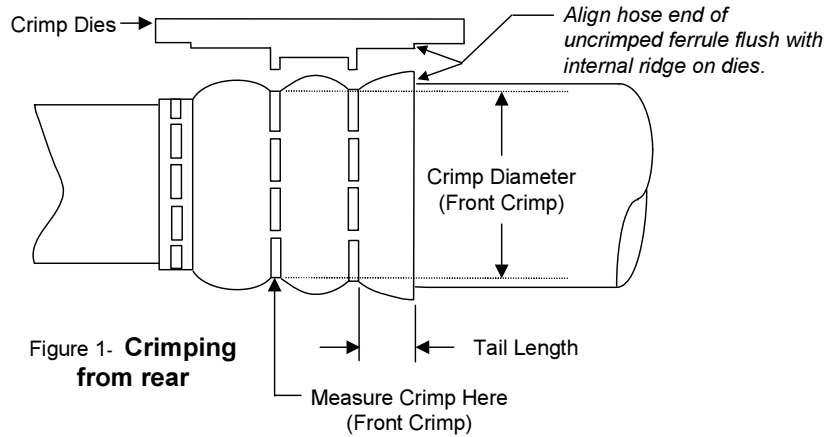
¹ See Adjustment Procedure at beginning of GC32-XD™ section.



GLP Coupling Crimping Instructions

GC32-XD™

To achieve proper tail length, line up hose end of ferrule with “locating step” on die inside diameter (I.D.) prior to crimping (See Figure 1 or 2 depending on die). Be sure die fingers are all the way forward and locked in place in die shoes.



Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.10(in)	Crimp OD +/- 0.010(in.)	Die Set	GC32 Setting	User's Actual Setting
12	GMV	3/4	12GL	1-pc GL	-----	-----	-----	1.750	0.50	1.120	GC81	1.21	
16	GMV	1	16GL	1-pc GL	-----	-----	-----	2.125	0.60	1.360	GC82	0.84	
20	GMV	1 1/4	20GL	1-pc GL	-----	-----	-----	2.250	0.50	1.660	GC83	1.27	
24	GMV	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	GC84	1.71	
32	GMV	2	32GL	1-pc GL	-----	-----	-----	2.750	0.50	2.430	GC85	1.75	

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.020(in)	Crimp OD +/- .010(in.)	Die Set	GC32 Setting	User's Actual Setting
24	MEGATECH 500 (ACR)	1 1/2	24GL	1-pc GL	-----	-----	-----	2.375	0.50	1.915	GC84	1.71	
32	MEGATECH 500 (ACR)	2	32GL	1-pc GL	-----	-----	-----	2.750	0.50	2.410	GC85	0.78	

Note: The Tail Length Tolerance for the MEGATECH ACR HOSE IS +/- 0.020(in.)!

GLP Coupling Crimping Instructions

GC32-XD™

See Figure 1 for proper alignment of coupling in die prior to crimping.

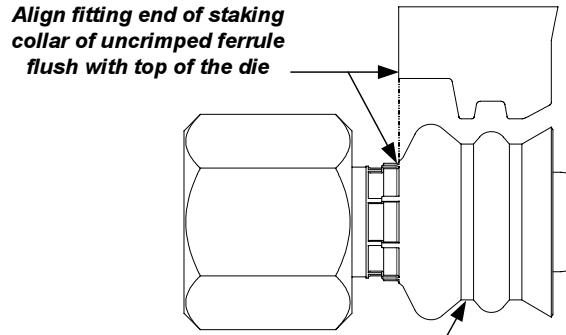


Figure 1 Measure Crimp Here

Dash Size	Hose		Stem Type	Ferrule		Crimp		Crimper		
	Description	Size (in.)		Description	Prod. No.	Insertion Length +/- .03(in)	Crimp OD	Die Set	GC32-XD Digital Setting	User's Actual Setting
4	LOC	1/4	GLP1	1-pc GLP1	-----	0.66	0.470	GC32-71	1.24	
6	LOC	3/8	GLP1	1-pc GLP1	-----	0.77	0.620	GC32-72	0.85	
8	LOC	1/2	GLP5	1-pc GLP1	-----	0.72	0.740	GC32-73	1.25	
10	LOC	5/8	GLP1	1-pc GLP1	-----	0.75	0.920	GC32-74	0.59	
12	LOC	3/4	GLP1	1-pc GLP1	-----	0.75	1.000	GC32-75	1.02	
4	LOL	1/4	GLP1	1-pc GLP1	-----	0.66	0.470	GC32-71	1.24	
6	LOL	3/8	GLP1	1-pc GLP1	-----	0.77	0.620	GC32-72	0.85	
8	LOL	1/2	GLP1	1-pc GLP1	-----	0.72	0.740	GC32-73	1.25	
10	LOL	5/8	GLP1	1-pc GLP1	-----	0.75	0.910	GC32-74	0.59	
12	LOL	3/4	GLP1	1-pc GLP1	-----	0.98	1.040	GC32-75	1.80	
4	M500	1/4	GLP1	1-pc GLP1	-----	0.66	0.460	GC32-71	1.10	
6	M500	3/8	GLP1	1-pc GLP1	-----	0.77	0.615	GC32-72	1.10	
8	M500	1/2	GLP5	1-pc GLP1	-----	0.72	0.750	GC32-73	1.60	
10	M500	5/8	GLP1	1-pc GLP1	-----	0.75	0.910	GC32-74	1.08	
12	M500	3/4	GLP1	1-pc GLP1	-----	0.75	1.015	GC32-75	1.20	
4	MEGATECH 250	1/4	GLP1	1-pc GLP1	-----	0.66	0.500	GC32-71	1.96	
6	MEGATECH 250	3/8	GLP1	1-pc GLP1	-----	0.77	0.640	GC32-72	1.48	
8	MEGATECH 250	1/2	GLP1	1-pc GLP1	-----	0.72	0.740	GC32-73	1.25	
10	MEGATECH 250	5/8	GLP1	1-pc GLP1	-----	0.75	0.900	GC32-74	0.88	
12	MEGATECH 250	3/4	GLP1	1-pc GLP1	-----	0.98	1.020	GC32-75	1.41	
4	RLA	1/4	GLP1	1-pc GLP1	-----	0.66	0.500	GC32-71	1.96	
6	RLA	3/8	GLP1	1-pc GLP1	-----	0.77	0.660	GC32-72	1.95	
8	RLA	1/2	GLP1	1-pc GLP1	-----	0.72	0.740	GC32-73	1.25	
10	RLA	5/8	GLP1	1-pc GLP1	-----	0.75	0.920	GC32-74	1.32	
12	RLA	3/4	GLP1	1-pc GLP1	-----	0.98	1.040	GC32-75	1.80	
8	S/R-XH	1/2	GLP1	1-pc GLP1	-----	0.72	0.760	GC32-73	1.18	
10	S/R-XH	5/8	GLP1	1-pc GLP1	-----	0.75	0.920	GC32-74	0.82	
12	S/R-XH	3/4	GLP1	1-pc GLP1	-----	0.98	1.080	GC32-75	2.74	
4	TR500	1/4	GLP5	1-pc GLP5	-----	0.66	0.470	GC32-71	1.24	
6	TR500	3/8	GLP5	1-pc GLP5	-----	0.77	0.610	GC32-72	0.71	
8	TR500	1/2	GLP5	1-pc GLP5	-----	0.72	0.720	GC32-73	0.71	
10	TR500	5/8	GLP5	1-pc GLP5	-----	0.75	0.880	GC32-74	0.36	
12	TR500	3/4	GLP5	1-pc GLP5	-----	0.98	1.020	GC32-75	1.41	

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

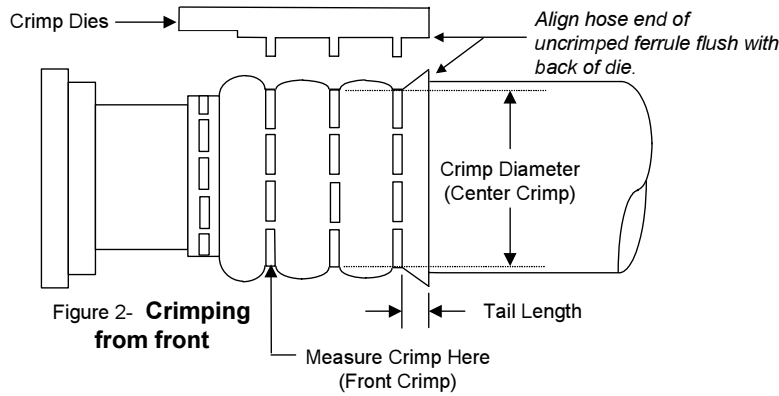
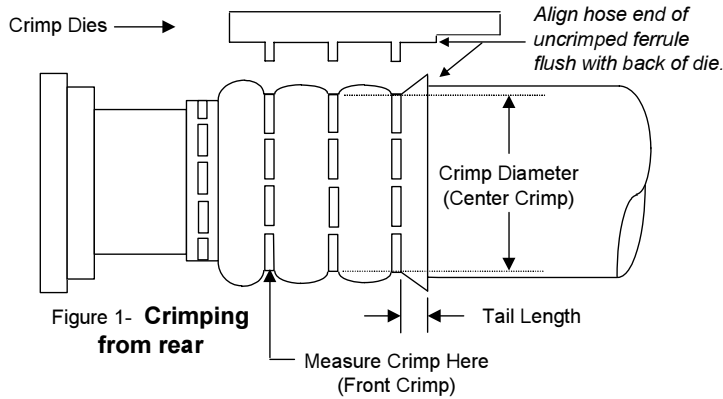
GC32-XD™



GL Coupling Crimping Instructions

GC32-XD™

To achieve proper tail length, line up hose end of ferrule with “locating step” on die inside diameter (I.D.) prior to crimping (See Figure 1 or 2 depending on die). Be sure die fingers are all the way forward and locked in place in die shoes.



Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.10(in.)	Crimp OD +/- .010(in.)	Die Set	GC32 Setting	User's Actual Setting
40	GMV	2 1/2	40G4H	1-pc GL/G4H	-----	-----	-----	2.375	0.425	2.900	FP86	2.94	

Dash Size	Description	Size (in.)	Type	Description	Part No.	Length +/- .03(in.)	Diameter (in.)	Insertion Length +/- .03(in)	Tail Length +/- 0.020(in.)	Crimp OD +/- .010(in.)	Die Set	GC32 Setting	User's Actual Setting
40	MEGATECH 500 (ACR)	2 1/2	40G4H	1-pc GL/G4H	-----	-----	-----	2.375	0.425	2.800	FP86	0.55	

Note: The Tail Length Tolerance for the MEGATECH ACR HOSE IS +/- 0.020(in.)!

Clamping Collars

Clamp Collar Crimping Instructions

GC32-XD™

Care must be taken when crimping clamp collars onto a hydraulic hose. If crimp is too tight, hose will be crushed, dramatically reducing its service life. If crimp is too loose, collar could slide along hose's length causing abrasion and eventual hose cover failure.

Remember: Clamp collars must be crimped before the hose couplings.

Use the following instructions to determine crimp diameter, which can then be used to find crimping setting in Table 2. The required clamp collar for a specific hydraulic hose is provided in Table 1.

1. Measure hose's outside diameter at the location where clamp collar will be crimped. This can be accomplished by using a pie tape or by using the average hose outside diameter measured with a dial caliper.
2. Measure wall thickness of clamp collar with a dial caliper.
3. Obtain crimp diameter by adding hose outside diameter to twice the clamp collar wall thickness (see formula below).

$$\text{Crimp Diameter} = (\text{Hose O.D.}) + [2 \times .065 (\text{Clamp Collar Wall Thickness})]$$

When crimping clamp collar, the crimp die should be located in the collar center, which will result in a 1/8" flare on each side of the collar.



Table 1

Description	Part Number	Product Number	Hydraulic Hose Applications	GC32-XD Die
CC1.12	80276	7334-45805	10M2T, 10G2	32-331
CC1.25	80277	7334-45885	12M2T, 12G2, 12M4K	32-331
CC1.37	80278	7334-45895	12C12, 12G4K	32-331

Table 2

32-331 Die					
Crimp Diameter	Approx. Setting	Crimp Diameter	Approx. Setting	Crimp Diameter	Approx. Setting
1.050	3.30	1.165	5.60	1.385	7.90
1.055	3.40	1.170	5.70	1.390	8.00
1.060	3.50	1.175	5.80	1.395	8.10
1.065	3.60	1.180	5.90	1.400	8.20
1.070	3.70	1.185	6.00	1.405	8.30
1.075	3.80	1.190	6.10	1.410	8.40
1.080	3.90	1.200	6.20	1.415	8.50
1.085	4.00	1.205	6.30	1.420	8.60
1.090	4.10	1.210	6.40	1.425	8.70
1.095	4.20	1.215	6.50	1.430	8.80
1.100	4.30	1.220	6.60	1.435	8.90
1.105	4.40	1.225	6.70	1.440	9.00
1.110	4.50	1.230	6.80	1.445	9.10
1.115	4.60	1.235	6.90	1.450	9.20
1.120	4.70	1.240	7.00	1.455	9.30
1.125	4.80	1.245	7.10	1.460	9.40
1.130	4.90	1.250	7.20	1.465	9.50
1.135	5.00	1.255	7.30	1.470	9.60
1.140	5.10	1.360	7.40	1.475	9.70
1.145	5.20	1.365	7.50	1.480	9.80
1.150	5.30	1.370	7.60	1.485	9.90
1.155	5.40	1.375	7.70	1.490	10.00
1.160	5.50	1.380	7.80		

Power Steering Male Flareless Assembly Instructions

GC32-XD™

General

Swaging

Power Crimp® 707

MobileCrimp® 4-20

OmniCrimp® 21 / Power Crimp® 3000B

GC32-XD™

Hose Preparation and Assembly

1. Measure Tube O.D.
2. Select the proper Male Flareless coupling for the application.
3. Determine the length of the replacement assembly. Measure the distance between the points where the tubing is to be cut. See Fig. 1.

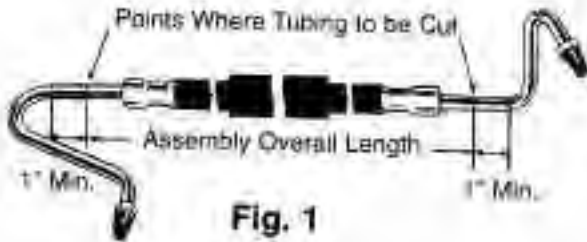


Fig. 1

NOTE: Tubing must be cut at 1" from the start of any bend. Read "Tubing Preparation Assembly" section before cutting.

4. Determine the necessary cut length of hose.

$$\text{Cut Length} = \text{Assembly Overall Length} - \text{Cutoff Dimension (Coupling 1)} - \text{Cutoff Dimension (Coupling 2)}$$

(Cutoff dimensions are in Table below.)

Cutoff Dimensions For Power Steering Couplings

Part No.	Description	Cutoff (In.)
G50510-0604	6PS-4MFA	.996
G50510-0605	6PS-5MFA	.996
G50510-0606	6PS-6MFA	1.012
G50510-0608	6PS-M8MFA	.934
G50510-0610	6PS-M10MFA	.973
G50510-0612	6PS-M12MFA	.973

5. Cut hose to the calculated cut length. End must be square ($\pm 5^\circ$). See Fig. 2.

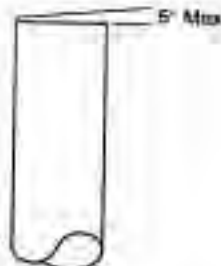


Fig. 2

6. Mark the hose 1-1/4" ($\pm 1/32"$) from the end of the hose with a marker pen. Do not damage hose. See Fig. 3.

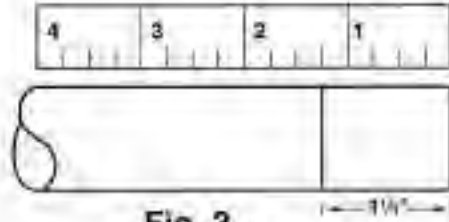


Fig. 3

7. Insert a 6PS coupling into the hose until the end of the ferrule is even with the mark. (See Fig. 4.)



Fig. 4

8. Use the provided digital setting to complete the crimp.

Die Set	GC32-XD Setting
32-44	1.17

9. Insert the properly prepared hose and coupling into the crimper. Line up the front of the die with the bottom of the stem hex. See Fig. 5 & 6.

Fig. 5



Power Steering Male Flareless Assembly Instructions

GC32-XD™

10. Measure the Crimp O.D. per Fig. 6. Crimp O.D. must be within the specified tolerance.

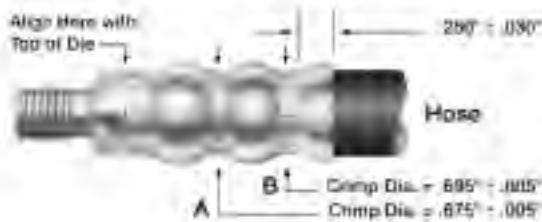


Fig. 6

11. Check the assembly to make sure the correct overall length has been obtained.
12. Inspect the assembly to make sure it has a clean bore and no internal obstructions. Clean if necessary.

Tubing Preparation Assembly

1. Tube End Condition

- Before cutting tube, mark both ends of the assembly so that it can be properly reassembled. These marks must be made on the tubing beyond the point where the tubing will be cut. Use a marker pen to mark the tubing so the surface won't be scratched.
- Tube end must be cut squarely ($\pm 5^\circ$).
- Smooth the tube inside and out by removing all the burrs and rough edges with steel wool. Clean all metal particles from inside the tube.
- The bare end of the tube must be long enough for the nut and sleeve to be placed over the tube. (1" minimum length before the start of any bend.)
- There also must be sufficient tube length for the tube end to seat against the shoulder in the thread end of the stem. (1" minimum length before the start of any bend.)

2. Nut and Sleeve Placement (Tube End)

- Install the hex nut over the tube, positioned so the shoulder end is placed on the tube first. The thread end will then face the hose assembly.
- Place the sleeve on the tube so the tapered end will face the hose assembly.



3. Connect to the Tube End (Preliminary Connection)

- Insert the tube into the thread end of the hose assembly until it bottoms against the shoulder.



- Screw the hex nut to the thread end until finger tight.
- Using a wrench, tighten approximately 1 turn ($\pm 1/4$ turn) to preset.

4. Inspect

- Disassemble and inspect compression of the sleeve on the tube. The sleeve must be compressed sufficiently on the tube so it is not easily removed.
- The tube end will be slightly distorted from butting against the internal shoulder. NOTE: Makeup of the correct connection is critical for proper use and safety.

5. Final Assembly

- Insert the tube into the thread end of the hose assembly.
- With a wrench, tighten down until a sudden increase in torque is felt. Turn nut approximately $1/6$ turn (but no more than $1/3$ turn) to create a seal between the sleeve, tube and seat of the stem.
- CAUTION: Overtightening may cause stripped threads and/or collapse of the tube.
- Before tightening the second end, line up the two marks on the tubing to assure proper orientation.



Gates PolarSeal® Hose

G45 Series (ACA) Coupling Crimping Instructions

GC32-XD™

Gates recommends only those hose and coupling combinations specified in the Gates Hydraulic Products Catalogs. Gates disclaims any liability for any hose assemblies which have not been produced in conformance with Gates' assembly recommendations.

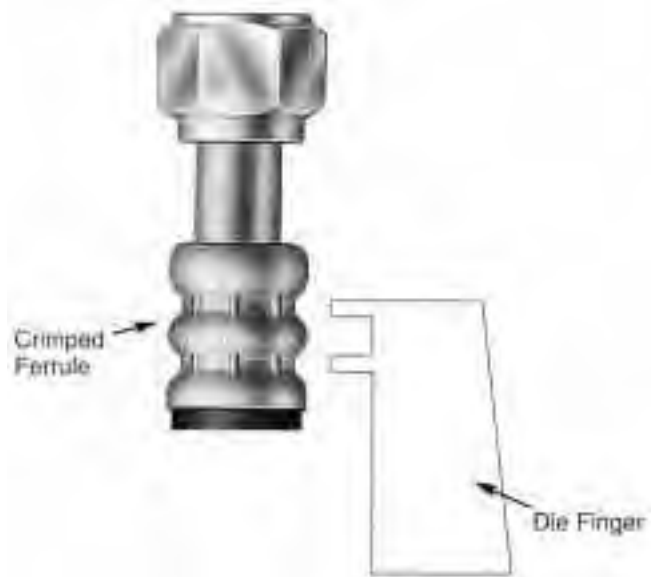
Changing Digital Readout

Rotating the knob on front of the dial vernier clockwise will increase the number; counterclockwise will decrease the number. When changing the setting, always move to a higher number then down to the desired setting. Example: To change from 1.00 to 1.50, move dial up to 2.00 then down to 1.50.

Crimp Diameter

Should the actual crimp diameter NOT be within the recommended crimp tolerance, check the proper calibration. (See Operator's Manual.) If the calibration is correct, a slight adjustment to the setting or digital readout may be necessary. To obtain a smaller crimp diameter, change setting or digital readout to a larger number.

Changing the vernier readout by .05 (Example 1.50 to 1.55) will change the crimp diameter by .002".



IMPORTANT

To assure a quality assembly, check the FIRST assembly of each run. Measure the crimped O.D. and compare it to the figure listed in the "Crimp Diameter" column.

If ACTUAL crimped dimensions are within specification, you have made a good assembly.

Hose		Fitting Type	Crimp Diameter (±.010")	Ferrule Position	Die Set	Setting	Actual Crimper Setting
Type	I.D. (in.)						
6AC134a	5/16	6ACA	.690	Centered	32-40	0.80	
8AC134a	13/32	8ACA	.780	Centered	32-41	0.96	
10AC134a	1/2	10ACA	.890	Centered	32-42	0.63	
12AC134a	5/8	12ACA	1.020	Centered	32-43	0.87	

Automotive Service Hose Crimp Data

GC32-XD™

Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper		
Size (In.)	Type	Dash Size	Type	Description	Part No.	Length +/- .03 (In.)	Dia. (In.)	Hose Insertion	Length +/- .03 (In.)	Crimp OD +/- .010 (In.)	Die Set	Approx. Digital Readout ¹	User's Actual Setting
								Length +/- .03 (In.)					
1/4	Charter® Air Hose	4	PC	4PC2F-2	80416	---	---	---	Full	0.725	32-31	2.96	
1/4	Charter® Air Hose	4	PC	4PC2F-2	80416	---	---	---	Full	0.725	32-21	1.58	
3/8	Charter® Air Hose	6	PC	6PC2F-2	80418	---	---	---	Full	0.800	32-32	0.54	
3/8	Charter® Air Hose	6	PC	6PC2F-2	80418	---	---	---	Full	0.800	32-22	0.54	
1/2	Charter® Air Hose	8	PC	8PC2F-2	80419	---	---	---	Full	1.025	32-33	1.80	
1/4	Multi-Use 1-Braid (19B)	4	PC	4PC2F-2	80416	---	---	---	Full	0.648	32-31	3.16	
5/16	Multi-Use 1-Braid (19B)	5	PC	5PC1FA	80433	---	---	---	Full	0.760	32-31	3.73	
5/16	Multi-Use 1-Braid (19B)	5	PC	5PC1FA	80433	---	---	---	Full	0.760	32-21	2.37	
3/8	Multi-Use 1-Braid (19B)	6	PC	6PC2F-2	80418	---	---	---	Full	0.770	32-31	3.96	
3/8	Multi-Use 1-Braid (19B)	6	PC	6PC2F-2	80418	---	---	---	Full	0.770	32-21	2.60	
1/2	Multi-Use 1-Braid (19B)	8	PC	8PC2F-2	80419	---	---	---	Full	1.020	32-33	1.69	
1/4	Multi-Use 2-Braid (19B)	4	PC	4PC2F-2	80416	---	---	---	Full	0.680	32-31	1.92	
1/4	Multi-Use 2-Braid (19B)	4	PC	4PC2F-2	80416	---	---	---	Full	0.680	32-21	0.56	
5/16	Multi-Use 2-Braid (19B)	5	PC	6PC2F-2	80418	---	---	---	Full	0.745	32-31	3.40	
5/16	Multi-Use 2-Braid (19B)	5	PC	6PC2F-2	80418	---	---	---	Full	0.745	32-21	2.04	
3/8	Multi-Use 2-Braid (19B)	6	PC	6PC2F-4	80462	---	---	---	Full	0.885	32-32	2.30	
3/8	Multi-Use 2-Braid (19B)	6	PC	6PC2F-4	80462	---	---	---	Full	0.885	32-22	2.30	
1/2	Multi-Use 2-Braid (19B)	8	PC	8PC2F-4	80463	---	---	---	Full	1.065	32-33	2.71	
1/4	Safety Stripe® Air Hose	4	PC	4PC2F-2	80416	---	---	---	Full	0.725	32-31	2.96	
3/8	Safety Stripe® Air Hose	6	PC	6PC2-2	80418	---	---	---	Full	0.800	32-32	0.54	
1/2	Safety Stripe® Air Hose	8	PC	8PC2F-2	80419	---	---	---	Full	1.025	32-33	1.80	

LP350 Hose Crimp Data

GC32-XD™

Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper				
Size (In.)	Type	Work Press. (psi)	Dash Size	Type	Description	Part No.	Product No.	Length ±0.03 (In.)	Dia. (In.)	Hose Insertion	Length ±0.03 (In.)	Crimp OD ±0.010 (In.)	Die Set	Approx. Setting	User Actual Setting
										Length ±0.03 (In.)					
1/4	LP350	350	4	PC	4PC2F-2	80416	7266-0034	---	---	---	Full	0.670	32-21	0.62	
1/4	LP350	350	4	PC	4PC2F-2	80416	7266-0034	---	---	---	Full	0.670	32-31	1.99	
3/8	LP350	350	6	PC	6PC2F-2	80418	7266-0033	---	---	---	Full	0.800	32-22	0.60	
3/8	LP350	350	6	PC	6PC2F-2	80418	7266-0033	---	---	---	Full	0.800	32-32	0.60	
1/2	LP350	350	8	PC	8PC2F-2	80419	7266-0002	---	---	---	Full	0.995	32-33	0.95	
3/4	LP350	350	12	PC	12PCBHB-1F	---	---	---	---	---	Full	1.315	32-35	0.60	
1	LP350	350	16	PC	16PC2F-4	80425	7266-0017	---	---	---	Full	1.625	32-36	2.97	
1 1/4	LP350	350	20	PC	20PC2F-4	80426	7266-0021	---	---	---	Full	2.040	32-39	0.24	
1 1/2	LP350	350	24	PC	24PCBHB1F	---	---	---	---	---	Full	2.450	31-311	2.64	
2	LP350	350	32	PC	32PCBHB1F	---	---	---	---	---	Full	3.110	32-314	2.15	

PowerClean™ Hose Crimp Data

GC32-XD™

Hose		Stem		Ferrule		Skive / Buff		Crimp			Crimper				
Size (In.)	Type	Work Press. (psi)	Dash Size	Type	Description	Part No.	Product No.	Length ±0.03 (In.)	Dia. (In.)	Hose Insertion	Length ±0.03 (In.)	Crimp OD ±0.010 (In.)	Die Set	Approx. Setting	User Actual Setting
										Length ±0.03 (In.)					
1/2	PC2500	2500	8	G	MegaCrimp®	---	---	---	---	1.25	Full	1.010	32-33	1.34	
3/8	PC3000	3000	6	G	MegaCrimp®	---	---	---	---	0.93	Full	0.845	32-22	1.61	
3/8	PC3000	3000	6	G	MegaCrimp®	---	---	---	---	0.93	Full	0.845	32-32	1.61	
1/4	PC3500	3500	4	G	MegaCrimp®	---	---	---	---	0.93	Full	0.705	32-21	0.85	
1/4	PC3500	3500	4	G	MegaCrimp®	---	---	---	---	0.93	Full	0.705	32-31	2.22	
3/8	PC4000	4000	6	G	MegaCrimp®	---	---	---	---	0.93	Full	0.845	32-22	1.61	
3/8	PC4000	4000	6	G	MegaCrimp®	---	---	---	---	0.93	Full	0.845	32-32	1.61	
1/2	PC4000	4000	8	G	MegaCrimp®	---	---	---	---	1.25	Full	1.050	32-33	2.24	
3/8	PC5000	5000	6	G	MegaCrimp®	---	---	---	---	0.93	Full	0.890	32-22	2.62	
3/8	PC5000	5000	6	G	MegaCrimp®	---	---	---	---	0.93	Full	0.890	32-32	2.62	
1/4	PC6000	6000	4	G	MegaCrimp®	---	---	---	---	0.93	Full	0.740	32-21	1.65	
1/4	PC6000	6000	4	G	MegaCrimp®	---	---	---	---	0.93	Full	0.740	32-31	3.02	

¹ See Adjustment Procedures at beginning of GC32-XD section.



Industrial Hose Crimp Data

GC32-XD™

Size (In.)	Hose		Stem		Ferrule			Skive / Buff		Crimp			Crimper		
	Type	Work Press. (psi)	Dash Size	Type	Description	Part No.	Product No.	Length ±0.03 (In.)	Dia. (In.)	Hose Insertion Length ±0.03 (In.)	Length ±0.03 (In.)	Crimp OD ±0.010 (In.)	Die Set	Approx. Setting ¹	User Actual Setting
1/2	1000MP/ Mine Spray	1000	8	PC	8PC2F-2	80419	7266-0002	0.88	WIRE	-----	Full	0.930	32-32	3.52	
3/4	1000MP/ Mine Spray	1000	12	PC	12PC2F-2	80423	7266-0018	1.63	WIRE	-----	Full	1.190	32-34	1.71	
3/4	1000MP/ Mine Spray	1000	12	G	MegaCrimp®	-----	-----	-----	-----	1.50	Full	1.345	32-35	1.28	
1	1000MP/ Mine Spray	1000	16	PC	16PC2F-2	80424	7266-0013	1.50	WIRE	-----	Full	1.540	32-36	0.97	
1	1000MP/ Mine Spray	1000	16	G	MegaCrimp®	-----	-----	-----	-----	1.75	Full	1.745	32-37	1.38	
1 1/2	1000MP/ Mine Spray	1000	24	PC	24PC2F-2	80428	7266-0035	2.28	WIRE	-----	Full	2.200	32-310L ²	0.29	
1 1/4	1000MP/ Mine Spray	1000	20	PC	20PC2F-2	80427	7266-0022	1.12	WIRE	-----	Full	1.880	32-37	4.68	
1 1/4	1000MP/ Mine Spray	1000	20	G	MegaCrimp®	-----	-----	-----	-----	1.75	Full	2.045	32-39	0.35	
2	1000MP/ Mine Spray	1000	32	PC	32PC2F-4	80429	7266-0037	2.75	WIRE	-----	Full	2.800	32-312	2.31	
1/2	119B	250	8	PC	8PC2F-2	80476	7266-0046	-----	-----	-----	Full	1.065	32-33	2.59	
1/2	119B	500	8	PC	10PC2F-2B	80476	7266-0046	-----	-----	-----	Full	1.065	32-33	2.59	
1/4	119B	250	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.648	32-31	0.92	
1/4	119B	500	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.705	32-21	0.85	
1/4	119B	500	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.705	32-31	2.22	
3/4	119B	250	12	PC	12PC2F-4	80422	7266-0014	-----	-----	-----	Full	1.300	32-34	4.19	
3/4	119B	500	12	PC	12PC2F-4	80422	7266-0014	-----	-----	-----	Full	1.365	32-35	1.73	
3/8	119B	250	6	PC	6PC2F-4	80462	7266-0040	-----	-----	-----	Full	0.770	32-21	2.34	
3/8	119B	250	6	PC	6PC2F-4	80462	7266-0040	-----	-----	-----	Full	0.770	32-31	3.71	
1	119B	250	16	PC	16PC2F-2	80424	7266-0013	-----	-----	-----	Full	1.630	32-36	3.09	
1	119B	500	16	PC	16PC2F-4	80425	7266-0017	-----	-----	-----	Full	1.675	32-36	4.15	
3/16	19B	500	3	PC	3PC2F-2	80415	7266-0007	-----	-----	-----	Full	0.635	32-31	0.62	
1/4	19B	250	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.648	32-31	0.92	
1/4	19B	500	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.680	32-21	0.28	
1/4	19B	500	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.680	32-31	1.65	
5/16	19B	500	5	PC	6PC2F-2	80418	7266-0033	-----	-----	-----	Full	0.745	32-21	1.76	
5/16	19B	500	5	PC	6PC2F-2	80418	7266-0033	-----	-----	-----	Full	0.745	32-31	3.13	
1/2	19B	250	8	PC	8PC2F-2	80419	7266-0002	-----	-----	-----	Full	0.995	32-22	4.97	
1/2	19B	250	8	PC	8PC2F-2	80419	7266-0002	-----	-----	-----	Full	0.995	32-32	4.97	
1/2	19B	500	8	PC	8PC2F-4	80463	7266-0041	-----	-----	-----	Full	1.065	32-33	2.59	
3/4	19B	250	12	PC	12PC2F-4	80422	7266-0014	-----	-----	-----	Full	1.300	32-34	4.19	
3/8	19B	250	6	PC	6PC2F-2	80418	7266-0033	-----	-----	-----	Full	0.770	32-21	2.34	
3/8	19B	250	6	PC	6PC2F-2	80418	7266-0033	-----	-----	-----	Full	0.770	32-31	3.71	
3/8	19B	500	6	PC	6PC2F-4	80462	7266-0040	-----	-----	-----	Full	0.885	32-22	2.51	
3/8	19B	500	6	PC	6PC2F-4	80462	7266-0040	-----	-----	-----	Full	0.885	32-32	2.51	
5/8	19B	250	10	PC	10PC2F-2C	80447	7266-0810	-----	-----	-----	Full	1.095	32-33	3.27	
1	19B	250	16	PC	16PC2F-2	80424	7266-0013	-----	-----	-----	Full	1.560	32-36	1.44	
1	19B	500	16	PC	16PC2F-4	80425	7266-0017	-----	-----	-----	Full	1.675	32-36	4.15	
1 1/4	19B	250	20	PC	20PC2F-4	80426	7266-0021	-----	-----	-----	Full	1.990	32-38	2.90	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.675	32-21	0.16	
1/4	20B-HB	350	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.675	32-31	1.53	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	7266-0033	-----	-----	-----	Full	0.790	32-22	0.38	
3/8	20B-HB	350	6	PC	6PC2F-2	80418	7266-0033	-----	-----	-----	Full	0.790	32-32	0.38	
1/2	20B-HB	350	8	PC	10PC2F-2B	80476	7266-0046	-----	-----	-----	Full	1.065	32-33	2.59	
3/4	20B-HB	350	12	PC	12PCBHB1F	-----	-----	-----	-----	-----	Full	1.355	32-35	1.50	
1	20B-HB	350	16	PC	16PC2F-4	80425	7266-0017	-----	-----	-----	Full	1.665	32-36	3.91	
1 1/2	20B-HB	350	24	PC	24PCBHB1F	-----	-----	-----	-----	-----	Full	2.450	32-311	2.64	
1 1/4	20B-HB	350	20	PC	20PC2F-4	80426	7266-0021	-----	-----	-----	Full	2.040	32-39	0.24	
2	20B-HB	350	32	PC	32PCBHB1F	-----	-----	-----	-----	-----	Full	3.030	32-313	5.01	
1/4	319MB	1000	4	PC	4PC2F-2	80416	7266-0034	0.75	WIRE	-----	Full	0.640	32-31	0.73	
3/8	319MB	1000	6	PC	6PC2F-2	80418	7266-0033	0.69	WIRE	-----	Full	0.690	32-21	0.51	
3/8	319MB	1000	6	PC	6PC2F-2	80418	7266-0033	0.69	WIRE	-----	Full	0.690	32-31	1.88	
1/2	319MB	1000	8	PC	8PC2F-2	80419	7266-0002	0.88	WIRE	-----	Full	0.940	32-22	3.74	
1/2	319MB	1000	8	PC	8PC2F-2	80419	7266-0002	0.88	WIRE	-----	Full	0.940	32-32	3.74	
3/4	319MB	1000	12	PC	12PC2F-4	80422	7266-0014	1.56	WIRE	-----	Full	1.315	32-35	0.60	
1	319MB	1000	16	PC	16PC2F-2	80424	7266-0013	1.50	WIRE	-----	Full	1.545	32-36	1.08	
1 1/4	319MB	1000	20	PC	20PC2F-2	80427	7266-0022	2.19	WIRE	-----	Full	1.880	32-37	4.68	
1 1/2	319MB	1000	24	PC	24PC2F-4	80428	7266-0035	2.28	WIRE	-----	Full	2.200	32-310L ²	0.29	
2	319MB	1000	32	PC	32PC2F-4	80429	7266-0037	2.75	WIRE	-----	Full	2.800	32-312	2.31	
1/4	6B	315	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.670	32-21	0.05	
1/4	6B	315	4	PC	4PC2F-2	80416	7266-0034	-----	-----	-----	Full	0.670	32-31	1.42	

¹ See Adjustment Procedures at beginning of GC32-XD section. ² For aramid-reinforced Heatmaster® hose only.



Industrial Hose Crimp Data

GC32-XD™

Size (In.)	Hose		Stem		Ferrule		Skive / Buff		Crimp		Crimper				
	Type	Work Press. (psi)	Dash Size	Type	Description	Part No.	Product No.	Length ±0.03 (In.)	Dia. (In.)	Hose Insertion Length ±0.03 (In.)	Length ±0.03 (In.)	Crimp OD ±0.010 (In.)	Die Set	Approx. Setting ¹	User Actual Setting
1/4	6B	250	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.675	32-21	0.16	
1/4	6B	250	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.675	32-31	1.53	
3/8	6B	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.800	32-31	4.39	
3/8	6B	200	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.770	32-21	2.34	
3/8	6B	200	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.770	32-31	3.71	
3/8	6B	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.800	32-21	0.60	
1/2	6B	250	8	PC	8PC2F-2	80419	7266-0002	----	----	----	Full	0.980	32-33	0.65	
1/2	6B	315	8	PC	8PC2F-4	80463	7266-0041	----	----	----	Full	1.085	32-33	3.04	
3/4	6B	250	12	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.240	32-34	2.84	
3/4	6B	315	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.370	32-35	1.84	
1	6B	315	16	PC	16PC2F-4	80425	7266-0017	----	----	----	Full	1.710	32-36	4.97	
1 1/4	6B	200	20	PC	20PC2F-2	80427	7266-0022	----	----	----	Full	1.995	32-38	3.02	
1/4	Adapta Flex™	250	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.630	32-31	0.50	
1/4	Adapta Flex™	200	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.635	32-31	0.62	
1/4	Adapta Flex™	300	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.645	32-31	0.85	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	7266-0038	----	----	----	Full	0.725	32-21	1.31	
5/16	Adapta Flex™	200	5	PC	5PC2F-2	80417	7266-0038	----	----	----	Full	0.725	32-31	2.68	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.750	32-21	1.88	
3/8	Adapta Flex™	200	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.750	32-31	3.25	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.775	32-21	2.45	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.775	32-21	2.45	
3/8	Adapta Flex™	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.775	32-31	3.82	
3/8	Adapta Flex™	300	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.775	32-31	3.82	
1/2	Adapta Flex™	300	8	PC	8PC2F-2	80419	7266-0002	----	----	----	Full	0.980	32-33	0.65	
1/2	Adapta Flex™	200	8	PC	8PC2F-2	80419	7266-0002	----	----	----	Full	0.990	32-32	4.86	
1/2	Adapta Flex™	250	8	PC	8PC2F-2	80419	7266-0002	----	----	----	Full	1.000	32-33	1.11	
5/8	Adapta Flex™	200	10	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.120	32-34	0.13	
5/8	Adapta Flex™	250	10	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.125	32-34	0.24	
3/4	Adapta Flex™	200	12	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.285	32-34	3.85	
3/4	Adapta Flex™	300	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.335	32-35	1.05	
3/4	Adapta Flex™	250	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.345	32-34	5.21	
1	Adapta Flex™	150	16	PC	16PC2F-2	80424	7266-0013	----	----	----	Full	1.600	32-36	2.38	
1	Adapta Flex™	200	16	PC	16PC2F-4	80425	7266-0017	----	----	----	Full	1.650	32-36	3.56	
1	Adapta Flex™	300	16	PC	16PC2F-4	80425	7266-0017	----	----	----	Full	1.655	32-36	3.68	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.785	32-21	2.68	
3/8	Cyclone™	1000	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.785	32-31	4.05	
3/4	Cyclone™	1000	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.350	32-35	1.39	
1/2	Cyclone™	1000	8	PC	10PC2F-2B	80476	7266-0046	----	----	----	Full	1.040	32-33	2.02	
1/4	Duro Flex®	250	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.655	32-31	1.08	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	7266-0039	----	----	----	Full	0.720	32-21	1.19	
1/4	Duro Flex®	300	4	PC	4PC2F-4	80461	7266-0039	----	----	----	Full	0.720	32-31	2.56	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.820	32-22	1.05	
3/8	Duro Flex®	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.820	32-32	1.05	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.845	32-22	1.61	
3/8	Duro Flex®	300	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.845	32-32	1.61	
1/2	Duro Flex®	250	8	PC	8PC2F-2	80419	7266-0002	----	----	----	Full	0.995	32-33	0.99	
1/2	Duro Flex®	300	8	PC	10PC2F-2B	80476	7266-0046	----	----	----	Full	1.070	32-33	2.70	
5/8	Duro Flex®	300	10	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.180	32-34	1.49	
5/8	Duro Flex®	250	10	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.185	32-34	1.60	
3/4	Duro Flex®	300	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.300	32-34	4.19	
3/4	Duro Flex®	250	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.356	32-35	1.52	
1	Duro Flex®	250	16	PC	16PC2F-4	80425	7266-0017	----	----	----	Full	1.716	32-37	0.68	
1 1/4	Duro Flex®	200	20	PC	20PC2F-2	80427	7266-0022	----	----	----	Full	1.995	32-37	7.49	
1/2	Heat Master® (Aramid)2	500	8	PC	8PC2F-4	80463	7266-0041	----	----	----	Full	1.115	32-33	3.72	
3/4	Heat Master® (Aramid)2	500	12	PC	12PCBHB1F	-----	-----	----	----	----	Full	1.350	32-35	1.39	
3/16	Premo Flex®	250	3	PC	3PC2F-2	80415	7266-0007	----	----	----	Full	0.655	32-31	1.08	
1/4	Premo Flex®	250	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.645	32-31	0.85	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.675	32-21	0.16	
1/4	Premo Flex®	315	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.675	32-31	1.53	
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	7266-0038	----	----	----	Full	0.720	32-21	1.19	

¹ See Adjustment Procedures at beginning of GC32-XD section. ² For aramid-reinforced Heatmaster® hose only.



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GC32-XD™

Industrial Hose Crimp Data

GC32-XD™

Size (In.)	Hose Type	Work Press. (psi)	Stem		Ferrule		Skive / Buff		Crimp			Crimper		
			Dash Size	Type	Description	Part No.	Product No.	Length ±0.03 (In.)	Dia. (In.)	Hose Insertion Length ±0.03 (In.)	Length ±0.03 (In.)	Crimp OD ±0.010 (In.)	Die Set	Approx. Setting ¹
5/16	Premo Flex®	250	5	PC	5PC2F-2	80417	7266-0038	----	----	----	Full	0.720	32-31	2.56
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.755	32-21	1.99
5/16	Premo Flex®	315	5	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.755	32-31	3.36
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.755	32-21	1.99
3/8	Premo Flex®	250	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.755	32-31	3.36
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.815	32-22	0.94
3/8	Premo Flex®	315	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.815	32-32	0.94
1/2	Premo Flex®	315	8	PC	8PC2F-2	80419	7266-0002	----	----	----	Full	0.995	32-33	0.99
5/8	Premo Flex®	250	10	PC	12PC2F-2	80423	7266-0018	----	----	----	Full	1.145	32-34	0.70
3/4	Premo Flex®	315	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.345	32-35	1.28
3/4	Premo Flex®	250	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.350	32-35	1.39
1	Premo Flex®	250	16	PC	16PC2F-4	80425	7266-0017	----	----	----	Full	1.675	32-37	-0.33
1 1/4	Premo Flex®	250	20	PC	20PC2F-4	80426	7266-0021	----	----	----	Full	1.990	32-38	2.90
1/4	Terminator®	501	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.680	32-21	0.28
1/4	Terminator®	501	4	PC	4PC2F-2	80416	7266-0034	----	----	----	Full	0.680	32-31	1.65
1/4	Terminator®	501	4	G	MegaCrimp®	----	----	----	----	0.94	Full	0.740	32-21	1.65
1/4	Terminator®	501	4	G	MegaCrimp®	----	----	----	----	0.94	Full	0.740	32-31	3.02
3/8	Terminator®	501	6	PC	6PC2F-4	80462	7266-0040	----	----	----	Full	0.870	32-22	2.17
3/8	Terminator®	501	6	PC	6PC2F-4	80462	7266-0040	----	----	----	Full	0.870	32-32	2.17
3/8	Terminator®	501	6	G	MegaCrimp®	----	----	----	----	0.94	Full	0.920	32-22	3.29
3/8	Terminator®	501	6	G	MegaCrimp®	----	----	----	----	0.94	Full	0.920	32-32	3.29
1/2	Terminator®	501	8	G	MegaCrimp®	----	----	----	----	1.25	Full	1.050	32-33	2.24
1/2	Terminator®	501	8	PC	8PC2F-4	80463	7266-0041	----	----	----	Full	1.060	32-33	2.47
3/4	Terminator®	501	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.360	32-35	1.61
3/4	Terminator®	501	12	G	MegaCrimp®	----	----	----	----	----	Full	1.430	32-35	3.19
1	Terminator®	501	16	PC	16PC2F-4	80425	7266-0017	----	----	----	Full	1.660	32-36	3.79
1	Terminator®	501	16	G	MegaCrimp®	----	----	----	----	1.75	Full	1.785	32-37	2.36
1 1/4	Terminator®	501	20	PC	20PC2F-2	80427	7266-0022	----	----	----	Full	1.970	32-38	2.42
1 1/4	Terminator®	501	20	G	MegaCrimp®	----	----	----	----	1.75	Full	2.080	32-38	5.07
1 1/2	Terminator®	501	24	PC	24PC2F-4	80428	7266-0035	----	----	----	Full	2.260	32-39	5.00
2	Terminator®	501	32	PC	32PC2F-4	80429	7266-0037	----	----	----	Full	2.910	32-313	2.31
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.750	32-21	1.88
3/8	Thermo AG® 570	570	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.750	32-31	3.25
1/2	Thermo AG® 570	570	8	PC	8PC2F-2	80463	7266-0041	----	----	----	Full	0.960	32-33	0.20
3/4	Thermo AG® 570	570	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.290	32-35	0.04
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.780	32-22	0.15
3/8	Thermo AG® 800	800	6	PC	6PC2F-2	80418	7266-0033	----	----	----	Full	0.780	32-32	0.15
1/2	Thermo AG® 800	800	8	PC	8PC2F-2	80463	7266-0041	----	----	----	Full	0.960	32-33	0.20
3/4	Thermo AG® 800	800	12	PC	12PC2F-4	80422	7266-0014	----	----	----	Full	1.315	32-35	0.60

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Notes



Notes

