

NRP-JONES

Crimp Specifications for Steel Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE		CRIMP DIAMETER	DIE NO.		
			MALE STEM PART NO.	FERRULE PART NO.		Diameter	Diameter				
3/16"	100R1 A	A001-03	203-102	203-200	11/16	To Wire	.545				
	100R1 AT	A101-03	"	503-500	-	-	.620				
	100R2 A	A002-03	"	203-200	11/16	To Wire	.580				
	100R2 AT	A102-03	"	503-500	-	-	.635				
	100R3	B003-03	"	203-200	-	-					
	100R5 CC	A005-04	"	503-500	-	-	.620				
	100R5 RC	A055-04	"	503-500	-	-	.620				
										(51)	
1/4"	100R1 A	A001-04	204-104	204-200	11/16	To Wire	.620			(36)	
	100R1 AT	A101-04	"	504-500	-	-	.680				
	100R2 A	A002-04	"	204-200	11/16	To Wire	.645			(36)	
	100R2 AT	A102-04	"	504-500	-	-	.715				
	100R3	B003-04	"	204-200	-	-	.680				
	100R5 CC	A005-05	"	504-500	-	-	.680				
	100R5 RC	A055-05	"	504-500	-	-	.680				
	Powerjack	A320-04	204-LN-106	204-200	11/16	To Wire	.645			(55)(57)	
3-Wire Braid	A003-04	204-104	504-500	11/16	To Wire	.720			(21)		
5/16"	100R1 A	A001-05	205-104	204-200	11/16	To Wire	.660				
	100R1 AT	A101-05	"	505-500	-	-	.770				
	100R2 A	A002-05	"	205-200	11/16	To Wire	.700				
	100R2 AT	A102-05	"	505-500	-	-	.815				
	100R5 CC	A005-06	"	505-500	-	-	.785			(1)	
	100R5 RC	A055-06	"	505-500	-	-	.785			(1)	
3/8" (13/32) (13/32)	100R1 A	A001-06	206-106	206-200	3/4	To Wire	.755			(41)	
	100R1 AT	A101-06	"	506-500	-	-	.850			(23)	
	100R2 A	A002-06	"	206-200	3/4	To Wire	.765			(41)	
	100R2 AT	A102-06	"	506-500	-	-	.860			(20)	
	100R3	B003-06	"	206-200	-	-	.800				
	100R5 CC	A005-08	"	506-500	-	-	.865				
	100R5 RC	A055-08	"	506-500	-	-	.865				
							To Wire**	.875			
	Powerjack	A320-06	206-LN-106	206-200	3/4	To Wire**	.765			60	
	100R12	1212-06	206-106	208-200	13/16	To Wire**	.875				
				406-500	-	-	.900			(16)	
	3-Wire Braid	A003-06	"	506-500	5/8	To Wire**	.890				
			208-200	13/16	To Wire**	.900					

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HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE		CRIMP DIAMETER	DIE NO.
			MALE STEM PART NO.	FERRULE PART NO.		Diameter	Diameter		
1/2"	100R1 A	A001-08	208-108	208-200	13/16	To Wire	.970		
	100R1 AT	A101-08	"	508-500	-	-	.970		
	100R2 A	A002-08	"	208-200	13/16	To Wire	.995		
	100R2 AT	A102-08	"	508-500	-	-	.965		(18)(82)
	100R3	B003-08	"	208-200	13/16	Concentric	.980		
					210-200	-	-		(28)
	100R5 CC	A005-10	208-1P-108	-	-	-	.925	(See	pg 15)
	100R5 RC	A055-10	"	-	-	-	.925		
	100R12	1212-08	208-108	408-400	1-1/8	To Wire	1.070		
				408-500	-	-	1.125		(16)
3 Wire Braid	A003-08	"	408-400	1-1/8	To Wire	1.120			

5/8"	100R1 A	A001-10	210-112	210-200	7/8	To Wire	1.100		
	100R1 AT	A101-10	"	510-500	-	-	1.100		
	100R2 A	A002-10	"	210-200	7/8	To Wire	1.125		
	100R2 AT	A102-10	"	510-500	-	-	1.125		
	100R5 CC	A005-12	"	510-500	-	-	1.100		
	100R5 RC	A055-12	"	510-500	-	-	1.100		
	100R12	1212-10	"	410-400	1-1/16	To Wire**	1.200		

3/4" (7/8) (7/8)	100R1 A	A001-12	212-112	212-200	1-1/16	To Wire	1.200		
	100R1 AT	A101-12	"	512-500	-	-	1.320		(5)
	100R2 A	A002-12	"	212-200	1-1/16	To Wire	1.235		
	100R2 AT	A102-12	"	512-500	-	-	1.330		(7)
	100R3	B003-12	"	312-300	-	-	1.325		
	100R4	2004-12	112-112	612-400	-	-	1.280		(15)
		2014-12	212-112	312-300	-	-	1.325		
	100R5 CC	1005-16	212-112	514-500	-	-	1.290		
	100R5 RC	1055-16	"	514-500	-	-	1.290		
	100R12	1212-12	412-112	412-400	1-5/8	To Wire**	1.290		
				412-500	-	-	1.355		(16)
	3 Wire Braid	A003-12	"	412-400	1-5/8	To Wire**	1.320		
DIN 20023	1214-12SP				To Wire**			(24)	
100R13	1213-12	612-112	612-600	7/8	To Wire**	1.425		(25)	

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HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE		CRIMP DIAMETER	DIE NO.
			MALE PART NO.	STEM FERRULE PART NO.		Diameter	Diameter		
1" (1-1/8") (1-1/8")	100R1 A	A001-16	216-116	216-200	1-1/8	To Wire	1.560		
	100R1 AT	A101-16	"	516-500	-	-	1.650		
	100R2 A	A002-16	"	216-200	1-1/8	To Wire	1.560		
	100R2 AT	A102-16	"	516-500	-	-	1.670		
	100R3	B003-16	"	316-300	-	-	1.600		
	100R4	2004-16	116-116	616-400	-	-	1.560		(14)
		2014-16	216-116	316-300	-	-	1.600		
	100R5 CC	1005-20	216-116	516-500	-	-	1.650		(78)
	100R5 RC	1055-20	"	516-500	-	-	1.650		(78)
	100R12	1212-16	416-116	416-400	1-5/8	To Wire**	1.560		(16)
				416-500	-	-	1.650		
	3 Wire Braid	1003-16	"	416-400	1-5/8	To Wire	1.680		(24)
	DIN 20023	1214-16SP	416-616	416-400	1-5/8	To Wire	1.570		
100R13	1213-16	616-116	616-600	1-3/4	To Wire	1.645		(25)	

1-1/4" (1-3/8")	100R1 A	1001-20	220-120	220-200	1-11/16	To Wire	1.900		(65)
			"	420-400	1-11/16	To Wire	1.900		
	100R1 AT	1101-20	"	520-500	-	-	1.960		
	100R2 A	1002-20	"	220-200	1-11/16	To Wire	1.940		
				420-400	1-11/16	To Wire	1.985		
	100R2 AT	1102-20	"	520-500	-	-	2.060		
	100R3	2003-20	"	220-200	-	-	1.960		
	100R4	2004-20	120-120	620-400	-	-	1.825		(13)
		2014-20	220-120	220-200	-	-	1.960		
	100R5CC	1005-24	220-120	220-200			1.840		(75)(78)
	100R12	1212-20	220-120	420-400	1-11/16	To Wire**	1.930		
				420-500	-	-	2.035		(16)
	3 Wire Braid	1003-20	"	420-400	1-11/16	To Wire**	1.985		
DIN 20023	1215-20SH				To Wire			(24)	
100R13	1213-20	620-120	620-600	2-3/16	To Wire	2.130		50	

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HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
			MALE STEM PART NO.	FERRULE PART NO.					
1-1/2"	100R1 A	1001-24	224-124	424-400	1-7/8	To Wire	2.140		
	100R1 AT	1101-24	"	524-500	-	-	2.260		
	100R2 A	1002-24	"	424-400	1-7/8	To Wire	2.210		
	100R2	1102-24	"	524-500	-	-	2.280		
	100R4	2004-24	124-124	624-400	-	-	2.040		
		2014-24	224-124	424-400	-	-			
	100R12	1212-24		424-400	1-7/8	To Wire**	2.200		
				424-500	-	-	2.360		(16)
	3 Wire Braid	1003-24	"	424-400	1-7/8	To Wire**	2.260		
DIN 20023	1215-24SH				To Wire			(24)	
100R13	1213-24	624-124	624-600	2-3/4	To Wire	2.500		(25)	

2" (1-13/16")	100R1 A	1001-32	232-132	432-400	2-3/8	To Wire	2.750		
	100R1 AT	1101-32	"	532-500	-	-	2.820		
	100R2 A	1002-32	"	432-400	2-3/8	To Wire	2.850		
	100R2	1102-32	"	532-500	-	-	2.875		
	100R4	2004-32	132-132	632-400	-	-	2.480		
		2014-32	232-132	432-400	-	-			
	100R5	1005-32	232-R5-132	524-500	-	-	2.430		(77)
	100R12	1212-32	"	432-400	2-3/8	To Wire**	2.860		(4)
				432-500	-	-	2.950		(16)
3 Wire Braid	1003-32	"	432-400	2-3/8	To Wire**	2.900			
DIN 20023	1215-32SH				To Wire			(24)	
100R13	1213-32	632-132	632-600	2-7/8	To Wire	3.140		(25)	

2-1/2"	100R4	2004-40	140-G40	640-400	-	-	3.015	*74mm	(88)
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3"	100R4	2004-48	148-G48	648-400	-	-	3.530	*88mm	(88)
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3-1/2"	100R4	2004-56	156-G56	656-400	-	-	4.095	*103mm	(88)
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*Recommended Minimum Die Finger Size

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Crimp Data for Aluminum Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
			MALE STEM PART NO.	FERRULE PART NO.						
3/16"	100R1 A	A001-03	103-102	603-100	1/2	To Wire	.545			(10)
	100R1 A	A001-03	203-102	603-200	11/16	To Wire	.560			
	100R1 AT	A101-03	"	503-A-500	-	-	.620			
	100R2 A	A002-03	"	603-200	11/16	To Wire	.580			
	100R2 AT	A102-03	"	503-A-500	-	-	.635			
	100R3	B003-03	"	603-300	-	-				
	100R5 CC	A005-04	"	503-A-500	-	-	.620			
	100R5 RC	A055-04	"	503-A-500	-	-	.620			

1/4"	100R1 A	A001-04	204-104	604-200	11/16	To Wire	.610			
	100R1 AT	A101-04	"	504-A-500	-	-	.680			
	100R2 A	A002-04	"	604-200	11/16	To Wire	.650			
	100R2 AT	A102-04	"	504-A-500	-	-	.715			
	100R3	B003-04	"	604-300	-	-	.690			
	100R5 CC	A005-05	"	504-A-500	-	-	.680			
	100R5 RC	A055-05	"	504-A-500	-	-	.680			

5/16"	100R1 A	A001-05	205-104	604-200	3/4	To Wire	.660			
	100R1 AT	A101-05	"	505-A-500	-	-	.760			
	100R2 A	A002-05	"	605-200	11/16	To Wire				
	100R2 AT	A102-05	"	505-A-500	-	-	.815			
	100R5 CC	A005-06	"	505-A-500	-	-				
	100R5 RC	A055-06	"	505-A-500	-	-				

3/8"	100R1 A	A001-06	206-106	606-200	3/4	To Wire	.760			(42)	
	100R1 AT	A101-06	"	506-A-500	-	-	.850			(23)	
	100R2 A	A002-06	"	606-200	3/4	To Wire	.780			(42)	
	100R2 AT	A102-06	"	506-A-500	-	-	.860			(20)	
	100R3	B003-06	"	606-300	-	-	.800				
	(13/32)	100R5 CC	A005-08	"	506-A-500	-	-	.865			(73)
	(13/32)	100R5 RC	A055-08	"	506-A-500	-	-	.865			(73)

1/2"				608-100	13/16	To Wire	.880			(64)
	100R1 A	A001-08	208-108							
				608-200	13/16	To Wire	.955			
	100R1 AT	A101-08	"	508-A-500			.965			(90)
	100R2 A	A002-08	"	608-200	13/16	To Wire	.980			
	100R2 AT	A102-08	"	508-A-500	-	-	.980			(17)
	100R3	B003-08	"	608-300	13/16	Concentric	1.020			
	100R5 CC	A005-10	"	508-A-500	-	instructions	.970			(71)

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Crimp Data for Aluminum Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE		CRIMP DIAMETER	DIE NO.	
			MALE STEM PART NO.	FERRULE PART NO.		Diameter	DIAMETER			
5/8"	100R1 A	A001-10	210-112	610-200	7/8	To Wire	1.100			
	100R1 AT	A101-10	"	510-A-500	-	-	1.100			
	100R2 A	A002-10	"	610-200	7/8	To Wire	1.125			
	100R2 AT	A102-10	"	510-A-500	-	-	1.125			
	100R5 CC	A005-12	"	510-A-500	-	-	1.145		(72)	
	100R5 RC	A055-12	"	510-A-500	-	-	1.145		(72)	
3/4"	100R1 A	A001-12	212-112	612-200	1-1/16	To Wire	1.200			
	100R1 AT	A101-12	"	512-A-500	-	-	1.320		(6)	
	100R2 A	A002-12	"	612-200	1-1/16	To Wire	1.235			
	100R2 AT	A102-12	"	512-A-500	-	-	1.330		(7)	
	100R3	B003-12	"	612-300	-	-	1.400			
	100R4	2004-12	"	612-300	-	-	1.400			
	(7/8)	100R5 CC	1005-16	"	514-A-500	-	-	1.290		
	(7/8)	100R5 RC	1055-16	"	514-A-500	-	-	1.290		
1"	100R1 A	A001-16	216-116	616-200	1-1/8	To Wire	1.560			
	100R1 AT	A101-16	"	516-A-500	-	-	1.650			
	100R2 A	A002-16	"	616-200	1-1/8	To Wire	1.580			
	100R2 AT	A102-16	"	516-A-500	-	-	1.670			
	100R3	B003-16	"	616-300	-	-	1.570			
	100R4	2004-16	"	616-300	-	-	1.580			
	(1-1/8)	100R5 CC	1005-20	"	516-A-500	-	-			
	(1-1/8)	100R5 RC	1055-20	"	516-A-500	-	-			
1-1/4"	100R1 A	1001-20	220-120	220-200					(66)	
	100R1 AT	1101-20	"	520-A-500	-	-	1.955			
	100R2 AT	1102-20	"	520-A-500	-	-	2.045			
1-1/2"	100R1 AT	1101-24	224-124	524-A-500	-	-				
	100R2 AT	1102-24	"	524-A-500	-	-				
2"	100R1 AT	1101-32	232-132	532-A-500	-	-				
	100R2 AT	1102-32	"	532-A-500	-	-				

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Crimp Data for Stainless Steel Ferrules and Stems

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
			MALE PART NO.	STEM FERRULE PART NO.						
1/4"	100R1 A	A001-04	704-SS-104	204-SS-200	11/16	To Wire	.602			
	100R1 AT	A101-04	"	504-SS-500	-	-	.652			
	100R2 A	A002-04	"	204-SS-200	11/16	To Wire	.637			
	100R2 AT	A102-04	"	504-SS-500	-	-	.687			
	100R3	B003-04	"	204-SS-200	-	-	.662			
	100R5 CC	A005-05	"	504-SS-500	-	-	.652			(30)
	100R5 RC	A055-05	"	504-SS-500	-	-	.652			(30)
3/8"	100R1 A	A001-06	706-SS-106	206-SS-200	3/4	To Wire	.733			(67)
	100R1 AT	A101-06	"	506-SS-500	-	-	.828			
	100R2 A	A002-06	"	206-SS-200	3/4	To Wire	.753			
	100R2 AT	A102-06	"	506-SS-500	-	-	.863			
	100R3	B003-06	"	206-SS-200	-	-	.773			
	100R5 CC	A005-08	"	506-SS-500	-	-	.828			(81)
	100R5RC	A055-06	"	506-SS-500	-	-	.828			
100R12	1212-06		208-SS-200	13/16	To Wire*	.883				
1/2"	100R1 A	A001-08	708-SS-108	208-SS-200	13/16	To Wire	.928			
	100R1 AT	A101-08	"	508-SS-500	-	-	.933			
	100R2 A	A002-08	"	208-SS-200	13/16	To Wire	.958			
	100R2 AT	A102-08	"	508-SS-500	-	-	.973			
	100R3	B003-08	"	208-SS-200	13/16	Concentric	.983			
	100R5 CC	A005-10	"	508-SS-500	-	-	.933			(81)
	100RC	A055-08	"	508-SS-500	-	-	.933			
	100R12	1212-08	"	408-SS-400	1-1/8	To Wire*	1.033			
3/4"	100R1 A	A001-12	412-SS-112	212-SS-200	1-1/16	To Wire	1.164			
	100R1 AT	A101-12	"	512-SS-500	-	-	1.284			
	100R2 A	A002-12	"	212-SS-200	1-1/16	To Wire	1.199			
	100R2 AT	A102-12	"	512-SS-500	-	-	1.334			
	100R12	1212-12	"	412-SS-400	1-5/8	To Wire*	1.295			
1"	100R1 A	A001-16	416-SS-116	216-SS-200	1-1/8	To Wire	1.523			
	100R1 AT	A101-16	"	516-SS-500	-	-	1.613			(61)
	100R2 A	A002-16	"	216-SS-200	1-1/8	To Wire	1.543			
	100R2 AT	A101-16	"	516-SS-500	-	-	1.638			(61)
	100R12	1212-16	"	416-SS-400	1-5/8	To Wire*	1.560			
1-1/4"	100R1 A	1001-20	220-SS-120	420-SS-400	1-11/16	To Wire	1.900			
	100R2 A	1101-20	"	420-SS-400	1-11/16	To Wire	1.985			(61)
	100R12	1212-20	"	420-SS-400	1-11/16	To Wire	1.965			(61)

Note: For sizes over 1-1/4" refer to crimp data on page 4

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Crimp Data for 1000# PSI 1-Wire Braid Yellow Mine Hose

HOSE SIZE	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
		MALE STEM PART NO.	FERRULE PART NO.						
1/2"			208-200	13/16	To Wire	.960			(9)
	1080-08	208-108	508-500	-	-	Cannot be	used		
			608-200	13/16	To Wire				
			508-A-500	-	-				
3/4"			212-200	1-1/16	To Wire	1.201			
	1080-12	212-112	512-500	-	-	1.320			
			612-200	1-1/16	To Wire	1.201			
			512-A-500	-	-	1.319			
1"			216-200	1-1/16	To Wire	1.545			
	1080-16	216-116	516-500	-	-	1.650			
			616-200	1-1/8	To Wire	1.530			
			516-A-500	-	-	1.645			
1-1/4"			220-200	1-11/16	To Wire	1.870			
			520-500	-	-				
	1080-20	220-120	*620-100	2-1/4	To Wire	1.890			
			520-A-500	-	-				
* Requires special stem: 220-SP-120 or 220-SP-620									
1-1/2"			424-400	1-7/8	To Wire	2.110			
	1080-24	224-124	524-500	-	-				
			524-A-500	-	-				
2"			432-400	2-3/8	To Wire	2.780			
	1080-32	232-132	532-500	-	-				
			532-A-500	-	-				

Crimp Data For Pressure Wash Hose

1/4"	A096-04	204-104	204-200	11/16	To Wire	.680			
	A098-04		504-500	-	-	.680			(68)
3/8"	A096-06	206-106	206-200	3/4	To Wire	.740			(3)
	A098-06		506-500	-	-	.830			
1/2"	A096-08	208-108	208-200	13/16	To Wire	.905			
	A098-08		508-500	-	-	.970			
3/4"	A096-12	212-112	212-200	1-1/16	To Wire	1.180			
	A096-12		512-500	-	-	1.280			(11)

Crimp Data for Steel & Aluminum Ferrules for Hydra-Lite I Hose

HOSE SIZE	HOSE PART NO.	SOLID		Length	SKIVE		CRIMP DIAMETER	DIE NO.	
		MALE STEM PART NO.	FERRULE PART NO.		Diameter				
1/4"	A151-04	204-104	204-200	11/16	To Wire	.620			
			504-500	-	-	.690			
			604-200	11/16	To Wire	.610			
			504-A-500	-	-	.670			
3/8"	A151-06	206-106	206-200	3/4	To Wire	.745			
			506-500	-	-	.840			
			606-200	3/4	To Wire	.755			(43)
			506-A-500	-	-	.840			
1/2"	A151-08	208-108	208-200	13/16	To Wire	.945			
			508-500	-	-	.950			
			608-200	13/16	To Wire	.935			
			508-A-500	-	-	.970			
5/8"	A151-10	210-112	210-200						
			510-500	-	-	1.125			(38)
			610-200						
			510-A-500						
3/4"	A151-12	212-112	212-200						
			512-500		-	1.330			(38)
			612-200						
			512-A-500						
1"	A151-16	216-116	216-200						
			516-500		-	1.670			(38)
			616-200						
			516-A-500						

NRP-JONES

Crimp Data for Dual-Lite Pressure Washer/Hydraulic Hose(26)

HOSE SIZE	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
		MALE STEM PART NO.	FERRULE PART NO.						
1/4"	A184-04	204-104	204-200	11/16	To Wire	.620			
			504-500	-	-	.690			
			604-200	11/16	To Wire	.610			
			504-A-500	-	-	.670			
3/8"	A184-06	206-106	206-200	3/4	To Wire	.745			
			506-500	-	-	.840			
			606-200	3/4	To Wire	.760			
			506-A-500	-	-	.840			
1/2"	A184-08	208-108	208-200	13/16	To Wire	.945			
			508-500	-	-	.950			
			608-200	13/16	To Wire	.935			
			508-A-500	-	-	.970			

NRP-JONES

Crimp Data for Steel & Aluminum Ferrules for Hydra-Lite II Hose

HOSE SIZE	HOSE PART NO.	SOLID		SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
		MALE STEM PART NO.	FERRULE PART NO.						
1/4"	A150-04	204-104	204-200	11/16	To Wire	.645			
			504-500	-	-	.690			
			604-200	11/16	To Wire	.645			
			504-A-500	-	-	.690			
3/8"	A150-06	206-106	206-200	3/4	To Wire	.765			(44)
			506-500	-	-	.840			
			606-200	3/4	To Wire	.765			(44)
			506-A-500	-	-	.840			
1/2"	A150-08	208-108	208-200	13/16	To Wire	.970			
			508-500	-	-	.965			(83)
			608-200	13/16	To Wire	.970			
			508-A-500	-	-	.980			(40)
5/8"	A150-10	210-112	510-500	-	-	1.125			(22)
3/4"	A150-12	212-112	212-200	1-1/16	To Wire	1.225			
			512-500	-	-	1.320			(52)
			612-200	1-1/16	To Wire	1.225			
			512-A-500	-	-	1.320			(52)
1"	A150-16	216-116	216-200	1-1/8	To Wire	1.550			
			516-500	-	-	1.650			
			616-200	1-1/8	To Wire	1.550			
			516-A-500	-	-	1.650			

NRP-JONES

Crimp Data for Steel Ferrules for IMPULSE PLUS Hose(12)

HOSE SIZE	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
		MALE STEM PART NO.	FERRULE PART NO.				
1/4"	A054-04	204-104	504-500	-	-	.690	
3/8"	A054-06	206-106	506-500	-	-	.840	
1/2"	A054-08	208-108	508-500	-	-	.985	

Crimp Data for Steel Ferrules for HYDRA-MAX Hose(27)

HOSE SIZE	HOSE PART NO.	SOLID		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
		MALE STEM PART NO.	FERRULE PART NO.				
1/4"	A750-04	204-104	504-500			.715	
		204-1J-104				.690	(49)
3/8"	A750-06	206-106	506-500			.860	
		206-1J-106				.850	(49)
1/2"	A750-08	208-108	508-500			.980	
		208-1J-108				.985	(49)
5/8"	A750-10	210-112	510-500			1.125	
		210-1J-112				1.105	(49)
3/4"	A750-12	212-112	512-500			1.330	
		212-1J-112				1.250	(49)
1"	A750-16	216-116	516-500			1.670	
		216-1J-116				1.620	(49)
1-1/4"	1750-20	220-120	520-500			2.060	(39)
1-1/2"	1750-24	224-124	524-500				(39)
2"	1750-32	232-132	532-500				(39)

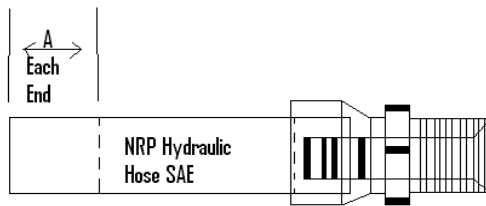
NRP-JONES

Crimp Data for One-Piece Couplings(31)

One-Piece Couplings for Weatherhead and Imperial-Eastman Crimp Machines

HOSE SIZE	SAE SPEC	HOSE PART NO.	SOLID	SPACER RING		"A" INSERT DEPTH	NOMINAL CRIMP DIAMETER		
			MALE STEM PART NO.	COLOR	SIDE				
1/4"	1 Wire	A101-04	204-1P-104	Black	DN	7/8	.560		
	2 Wire	A102-04	204-1P-104	Black	UP	7/8	.620		
3/8"	1 Wire	A101-06	206-1P-106	Black	DN	13/16	.740		
	2 Wire	A102-06	206-1P-106	Yellow	UP	13/16	.765		
1/2"	1 Wire	A101-08	208-1P-108	Black	DN	1-1/16	.865		
	2 Wire	A102-08	208-1P-108	Black	UP	1-1/16	.925		
5/8"									
	NA	NA	NA	NA	NA	NA	NA	NA	
3/4"	1 Wire	A101-12	212-1P-112	Black	DN	1-1/4	1.160		
	2 Wire	A102-12	212-1P-112	Black	UP	1-1/4	1.215		
1"	1 Wire	A101-16	216-1P-116	Black	DN	1-1/4	1.445		
	2 Wire	A102-16	216-1P-116	Silver	UP	1-1/4	1.525		

*When correct, your insert depth line & front of fitting are equal



MEASURING THE CRIMP DIAMETER

- 1) Measure the diameter in the middle of the crimped portion of the fitting.
- 2) Measure halfway between the ridges across the flat portion of the crimp.
- 3) Consult crimp diameters on the above chart.
- 4) Crimp only to the location line on ferrule.

1/2009 NOTE: THIS FITTING CAN NO LONGER BE USED ON TWO WIRE HOSE IF THE HOSE WAS MADE AFTER JANUARY 2009

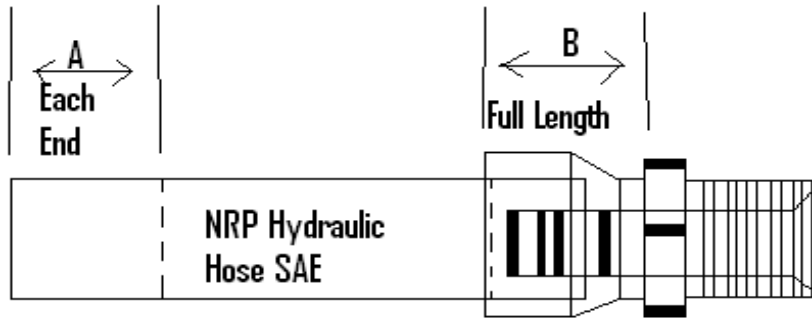
NRP-JONES

Crimp Data for 1J One-Piece Couplings

HOSE SIZE	SAE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	"A" INSERT DEPTH	NOMINAL CRIMP DIAMETER			
1/4"	1 WIRE	A101-04	204-1J-104	11/16	.650			
	2 WIRE	A102-04	204-1J-104	11/16	.690			
	100R3	B003-04	204-1J-104	11/16	.700			(53)
	100R5	A005-05	204-1J-104	11/16	.650			(53)
	100R16	A150-04	204-1J-104	11/16	.690			(58)
	100R17	A151-04	204-1J-104	11/16	.655			(58)
3/8" (13/32")	1 WIRE	A101-06	206-1J-106	11/16	.845			(45)
	2 WIRE	A102-06	206-1J-106	11/16	.870			
	100R3	B003-06	206-1J-106	11/16	.880			(53)
	100R5	A005-08	206-1J-106	11/16	.860			(53)
	100R12	1212-06	206-1J-106	11/16 Skive if needed	.915			(53)
	100R16	A150-06	206-1J-106	11/16	.850			(58)
	100R17	A151-06	206-1J-106	11/16	.850			(58)
1/2"	1 WIRE	A101-08	208-1J-108	15/16	.950			
	2 WIRE	A102-08	208-1J-108	15/16	.990			
	100R3	B003-08	208-1J-108	15/16	1.020			(53)
	100R5	A005-10	208-1J-108	15/16	.950			(53)
	100R16	A150-08	208-1J-108	15/16	.985			(58)
	100R17	A151-08	208-1J-108	15/16	.935			(58)
5/8"	1 WIRE	A101-10	210-1J-112	15/16	1.065			
	2 WIRE	A102-10	210-1J-112	15/16	1.105			(35)
	100R5	A005-12	210-1J-112	15/16	1.105			(53)
	100R16	A150-10	210-1J-112	15/16	1.105			(58)
	100R17	A151-10	210-1J-112	15/16	1.105			(58)
3/4" (7/8")	1 WIRE	A101-12	212-1J-112	1-7/64	1.250			
	2 WIRE	A102-12	212-1J-112	1-7/64	1.290			
	100R3	B003-12	212-1J-112	1-7/64	1.320			(53)
	100R4	2014-12	212-1J-112	1-7/64	1.290			(53)
	100R5	1005-16	212-1J-112	1-7/64	1.290			(53)
	100R16	A150-12	212-1J-112	1-7/64	1.250			(58)
	100R17	A151-12	212-1J-112	1-7/64	1.290			(58)
	1" (1-1/8")	1 WIRE	A101-16	216-1J-116	1-5/32	1.600		
2 WIRE		A102-16	216-1J-116	1-5/32	1.635			
100R3		B003-16	216-1J-116	1-5/32	1.645			(53)
100R4		2014-16	216-1J-116	1-5/32	1.635			(53)
100R5		1005-20	216-1J-116	1-5/32	1.635			(53)
100R16		A150-16	216-1J-116	1-5/32	1.620			(58)
100R17		A151-16	216-1J-116	1-5/32	1.635			(58)
1-1/4"	1 WIRE	1101-20	220-1J-120	1-3/4	1.975			(62)
	2 WIRE	1102-20	220-1J-120	1-3/4	2.015			(62)
	100R3	2003-20	220-1J-120	1-3/4	2.030			
	100R4	2014-20	220-1J-120	1-3/4	2.015			(53)

See Diagram on the Following Page

*When correct, your insert depth line & front of fitting are equal



MEASURING THE CRIMP DIAMETER

- 1) Measure the diameter in the middle of the crimped portion of the fitting.
- 2) Measure halfway between the ridges across the flat portion of the crimp.
- 3) Crimp full length- see (B) on the illustration.
- 4) Consult crimp diameters on the above chart.
- 5) Note on 3/8" 100R12 & hoses 2014 & 100R4 skiving may be required. Use insert depth as skive length.

NRP-JONES

Crimp Data for 2 Pc Crimp Fittings for 100R5 Hose(79)

HOSE	SAE SPEC	HOSE PART	STEM	FERRULE	CRIMP	
3/16" (-4)	100R5	A005-04	203-	503-R5-500	.620	
	100R5	A055-04	203-	503-R5-500	.620	
1/4" (-5)	100R5	A005-05	204-	504-500	.680	
	100R5	A055-05	204-	504-500	.680	
5/16" (-6)	100R5	A005-06	205-	505-500	.785	
	100R5	A055-06	205-	505-500	.785	
13/32" (-8)	100R5	A005-08	206-	506-500	.865	
	100R5	A055-08	206-	506-500	.865	
1/2" (-10)	100R5	A005-10	208-	508-R5-500	.965	
	100R5	A055-10	208-	508-R5-500	.965	
5/8" (-12)	100R5	A005-12	210-	510-500	1.100	
	100R5	A055-12	210-	510-500	1.100	
7/8" (-16)	100R5	1005-16	214-	514-500	1.330	
	100R5	1055-16	214-	514-500	1.330	
1-1/8" (-20)	100R5	1005-20	220-R5-	516-500	1.740	
	100R5	1055-20	220-R5-	516-500	1.740	
1-3/8" (-24)	100R5	1005-24	224-R5-	220-200	1.910	
	100R5	1055-24	224-R5-	220-200	1.910	
1-13/16" (-32)	100R5	1005-32	232-R5-	524-500	2.430	
	100R5	1055-32	232-R5-	524-500	2.430	
2-3/8" (-40)	100R5	1005-40	240-R5-			
	100R5	1055-40	240-R5-			

NOTE: Crimping information is for all stems with the above series

NRP-JONES

Crimp Data for 1 Pc Crimp Fittings for 100R5 Hose (91)

HOSE	SAE SPEC	HOSE PART	P/N	CRIMP
3/16" (-4)	100R5	A005-04	204-1PR5-	.525
	100R5	A803-04	204-1PR5-	.525
1/4" (-5)	100R5	A005-05	205-1PR5-	.585
	100R5	A803-05	205-1PR5-	.585
5/16" (-6)	100R5	A005-06	206-1PR5-	.680
	100R5	A803-05	206-1PR5-	.680
13/32" (-8)	100R5	A005-08	208-1PR5-	.765
	100R5	A803-08	208-1PR5-	.765
1/2" (-10)	100R5	A005-10	210-1PR5-	.910
	100R5	A803-10	210-1PR5-	.910
5/8" (-12)	100R5	A005-12	212-1PR5-	1.080
	100R5	A803-12	212-1PR5-	1.080
7/8" (-16)	100R5	1005-16	216-1PR5-	1.260
	100R5	1803-16	216-1PR5-	1.260
1-1/8" (-20)	100R5	1005-20	220-1PR5-	1.520
	100R5	1803-20	220-1PR5-	1.520

NOTE: Crimping information is for all stems with the above series

1W Crimp Specifications

Hose Size	SAE Spec	NRP-Jones Hose Part No.	Solid Male 1pc Part No.	Skive Length	Skive Diameter	Full Length Crimp Diameter
1/2"	100R2AT	A102-08	608-1W-108	NO	NO	1.100 (70)
	100R16	A150-08	"	NO	NO	1.100 (70)
	100R12	1212-08	"	NO	NO	1.120
	Hydra-Max	A750-08	"	NO	NO	1.100 (70)
	DIN 20023	1214-08SP	"	1-3/16	TO WIRE	1.120
	100R15	1211-08	"	1-3/16	TO WIRE	1.170
3/4"	100R2AT	A102-12	612-1W-112	NO	NO	1.340
	100R16	A150-12	"	NO	NO	1.340
	100R17	A151-12	"	NO	NO	1.340
	Hydra-Max	A750-12	"	NO	NO	1.340
	100R12	1212-12	"	NO	NO	1.375
	DIN 20023	1214-12SP	"	1.445	TO WIRE	1.375
100R13	1213-12	"	1.445	TO WIRE	1.400	
1"	100R2AT	A102-16	616-1W-116	NO	NO	1.680
	100R16	A150-16	"	NO	NO	1.680
	Hydra-Max	A750-16	"	NO	NO	1.680
	100R17	A151-16	"	NO	NO	1.680
	100R12	1212-16	"	NO	NO	1.700
	DIN 20023	1214-16SP	"	1.785	TO WIRE	1.700
100R13	1213-16	"	1.785	TO WIRE	1.725	
1-1/4"	100R2AT	1102-20	620-1W-120	NO	NO	2.095
	DIN20022	1750-20	"	NO	NO	2.095
	100R12	1212-20	"	NO	NO	2.075
	DIN 20023	1214-20SH	"	NO	NO	-
	100R13	1213-20	"	1.850	TO WIRE	2.125
1-1/2"	100R2AT	1102-24	624-1W-124	NO	NO	2.380
	DIN20022	1750-24	"	NO	NO	2.380
	100R12	1212-24	"	NO	NO	2.365
	DIN 20023	1214-24SH	"	NO	NO	-
	100R13	1213-24	"	2.140	TO WIRE	2.465
2"	100R2AT	1102-32	632-1W-132	NO	NO	2.760
	DIN20022	1750-32	"	NO	NO	2.760
	100R12	1212-32	"	NO	NO	2.780
	DIN 20023	1214-32SH	"	NO	NO	-
	100R13	1213-32	"	2.500	TO WIRE	2.960

- Double Angle Dies

- Note correction to 1-1/4" 100R13 skive length 7/16/03

NRP-JONES

Crimp Data for One-Piece Couplings

For NRP-Jones 100R7 and 100R8 Thermoplastic Hose(76)

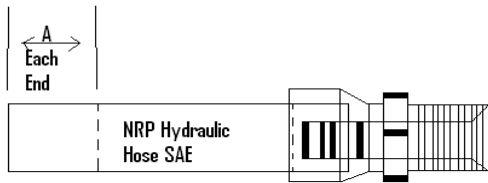
(85)

Hose Size	SAE Spec	Hose Part No.	Solid Male Stem Part No.	"A" Insert Depth	Nominal Crimp Diameter
1/4"	100R7	3107-04	204-1P-104	7/8	.530/.550
	100R7NC	3207-04	204-1P-104	7/8	.530/.550
	100R7TW	3307-04	204-1P-104	7/8	.530/.550
	100R7TWNC	3407-04	204-1P-104	7/8	.530/.550
	100R8	3108-04	204-1P-104	7/8	.530/.550
	100R8NC	3208-04	204-1P-104	7/8	.530/.550
	100R8TW	3308-04	204-1P-104	7/8	.530/.550
	100R8TWNC	3408-04	204-1P-104	7/8	.530/.550
5/16"	100R7	3107-05	205-1P-105		
	100R7NC	3207-05	205-1P-105		
	100R7TW	3307-05	205-1P-105		
	100R7TWNC	3407-05	205-1P-105		
	100R8	3108-05	205-1P-105		
	100R8NC	3208-05	205-1P-105		
	100R8TW	3308-05	205-1P-105		
	100R8TWNC	3408-05	205-1P-105		
3/8"	100R7	3107-06	206-1P-106	13/16	.700
	100R7NC	3207-06	206-1P-106	13/16	.700
	100R7TW	3307-06	206-1P-106	13/16	.700
	100R7TWNC	3407-06	206-1P-106	13/16	.700
	100R8	3108-06	206-1P-106	13/16	.700
	100R8NC	3208-06	206-1P-106	13/16	.700
	100R8TW	3308-06	206-1P-106	13/16	.700
	100R8TWNC	3408-06	206-1P-106	13/16	.700
1/2"	100R7	3107-08	208-1P-108	1-1/16	.850
	100R7NC	3207-08	208-1P-108	1-1/16	.850
	100R7TW	3307-08	208-1P-108	1-1/16	.850
	100R7TWNC	3407-08	208-1P-108	1-1/16	.850
	100R8	3108-08	208-1P-108	1-1/16	.860
	100R8NC	3208-08	208-1P-108	1-1/16	.860
	100R8TW	3308-08	208-1P-108	1-1/16	.860
	100R8TWNC	3408-08	208-1P-108	1-1/16	.860
3/4"					
1"					

NC=Non-Conductive
TW=Twin Line

See Crimp Instructions on Next Page

***When correct, your insert depth line & front of fitting are equal.**



MEASURING THE CRIMP DIAMETER

- 1) Measure the diameter in the middle of the crimped portion of the fitting.
- 2) Measure halfway between the ridges across the flat portion of the crimp.
- 3) Consult crimp diameters on the above chart.
- 4) Crimp only to the location line on ferrule.

NRP- JONES

9/16/2009

Crimp Data for 1Y Fittings

(80)

For 100R13 & 100R15 Non-Skive Hose

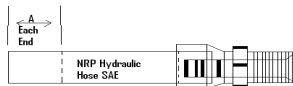
Hose Type	Fitting	No. Wire Lays		Crimp Dim
-12 100R13	612-Y	4		1.445
-12 100R15	612-Y	4		1.445
-16 100R13	616-Y	4		1.787
-16 100R15	616-Y	4		1.787
-20 100R13	620-Y	6		2.248
-20 100R15	620-Y	6		2.213
-24 100R13	624-Y	6		2.524
-24 100R15	624-Y	6		2.531
-32 100R13	632-Y	6		3.114
-32 100R15	632-Y	6		

(87)

NOTE: Full length crimp including pre-crimp area.
Must be used with NRP-Jones hose only.

HOSE SIZE	SAE SPEC	HOSE PART HOSE PART	STEM SERIES	INSERT DEPTH	CRIMP DIAMETER	
3/16" (-4)	100R14	6014-04	204-1PTF	7/8	.355 to .365	
1/4" (-5)	100R14	6014-05	205-1PTF	7/8	.405	
5/16" (-6)	100R14	6014-06	206-1PTF	7/8	.475	
3/8" (-7)	100R14	6014-07	207-1PTF	13/16	.545	
13/32" (-8)	100R14	6014-08	208-1PTF	13/16	.575	
1/2" (-10)	100R14	6014-10	210-1PTF	15/16	.695	
5/8" (-12)	100R14	6014-12	212-1PTF	15/16	.810	
3/4" (-14)	100R14	6014-14	214-1PTF	1-7/64	.978	
7/8" (-16)	100R14	6014-16	216-1PTF	1-7/64	1.100	
1" (-18)	100R14	6014-18	218-1PTF	1-5/32	1.225	
1-1/8" (-20)	100R14	6014-20	220-1PTF	1-3/4	1.385	

***When correct, your insert depth line & front of fitting are equal.**



MEASURING THE CRIMP DIAMETER

- 1) Measure the diameter in the middle of the crimped portion of the fitting.
- 2) Measure halfway between the ridges across the flat portion of the crimp.
- 3) Consult crimp diameters on the above chart.
- 4) Crimp only to the location line on ferrule.

** Leave 1/8" long ring of rubber on end of hose to prevent wire from fraying.

**Furnished pre-crimped- Attach to hose using special step die (print available upon request).

IMPORTANT:

The crimp diameters listed are accurate in most applications but not conclusive because of the wide tolerance on hose specifications in the SAE standards. The crimp dimensions listed were developed by extensive testing of finished assemblies made with hose manufactured by Nephi Rubber Products. If you are using hose other than that supplied by NRP the crimp diameter may have to be adjusted up or down depending on the manufacturer of the hose.

(86)

Changes:

- (1) Page 1 9/15/01 (was .690)
- (2) Page 7 10/22/91 (was 1.640)
- (3) Page 8 4/7/92 (was .755)
- (4) Page 4 6/23/92 (was 2.660)
- (5) Page 2 6/23/92 (was 1.370)
- (6) Page 6 6/23/92 (was 1.370)
- (7) Page 2 & 6 8/25/93 (was 1.370)
- (8) Page 12 3/8/94 (addition -deleted 8/30/96)
- (9) Page 8 3/8/94 (addition)
- (10) Page 5 1/20/95 (addition)
- (110) Page 8 2/1/95 (addition)
- (12) Page 12 2/15/95 (addition)
- (13) Page 3 4/13/95 (stem P/N correction)
- (14) Page 3 4/13/95 (addition)
- (15) Page 2 4/13/95 (addition)
- (16) Page 1-4 8/30/96 (addition)
- (17) Page 5 8/30/96 (was 1.000)
- (18) Page 2 8/30/96 (was 1.010)
- (19) Page 15 8/30/96 (addition)
- (20) Page 1 & 5 9/25/96 (was .900)
- (21) Page 1 9/30/96 (was .740)
- (22) Page 11 10/17/97 (addition)
- (23) Page 1 & 5 4/9/98 (was .865)
- (24) Page 2-4 1/13/00 (addition)
- (25) Page 2-4 1/13/00 (addition)
- (26) Page 10 1/13/00 (addition)
- (27) Page 12 1/13/00 (addition)
- (28) Page 2 1/13/00 (changed from 2-piece)
- (29) Page 14 3/3/00 (addition)
- (30) Page 7 5/31/00 (hose part number correction)
- (31) Page 13 9/25/00 (delete 1PC couplings & correct heading for 1P couplings)
- (32) Page 9-11 11/17/00 (addition of 1J crimping specs)
- (33) Page 2 1/22/01 (delete obsolete crimping data for 100R11)
- (34) Page 14 3/20/01 (correct all "A" Insert Depths)

(35)	Page 11 Page 14	5/24/02	(addition of specs for 5/8" & add 1-1/4" w/specs) (add 210-1J-112 on 5/8")
(36)	Page 1	6/6/02	(changed crimp diameter for A001-04 & A002-04)
(37)	Page 2-4	10/18/02	(added 2014)
(38)	Page 9-11	10/18/02	(Add A151-10, A151-12 & A151-16 Changed pg # to 12a & 12b)
(39)	Page 12	10/18/02	(Add 1-1/4, 1-1/2 & 2")
(40)	Page 11	12/13/02	(changed crimp dia from 1.000 to .980 on 1/2")
(41)	Page 1	1/2/03	(changed crimp dia on 3/8")
(42)	Page 5	1/2/03	(changed crimp dia on 3/8")
(43)	Page 9-11	1/2/03	(changed crimp dia on 3/8")
(44)	Page 11	1/2/03	(changed crimp dia on 3/8")
(45)	Page 14	1/2/03	(changed crimp dia on 3/8")
(46)	Page 14	1/15/03	(added illustration B)
(47)	Page 9-11	1/27/03	(added crimp diameter on 3/4" & 1")
(48)	Page 12	2/14/03	(added instruction #4)
(49)	Page 12	2/17/03	(added 1J's and crimp diameters)
(50)	Page 1	2/17/03	(added 206-1J-106)
(51)	Page 1-4	3/4/03	(Deleted <u>all</u> 100R11)
(52)	Page 11	3/4/03	(Changed crimp dia A150-12, 512-500 & 512A500 to 1.320)
(53)	Page 14	4/24/03	(Added 100R3, 100R4, and 100R5)
(54)	Page 9	5/20/03	(added crimp diameter for 5/8" 210-1J-112)
(55)	Page 1	7/23/03	(added A320-04)
(56)	Page 1	7/23/03	(added A320-06)
(57)	Page 1	10/5/04	(added Powerjack)
(58)	Page 14	12/15/04	(added A150 & A151)
(59)	Page 9 & 11 ALL PAGES	12/15/04 6/20/05	(added 1J's) Converted all charts to Excel format
(60)	Page 1	7/12/05	(corrected p/n 206-LN-206 to 206-LN-106)
(61)	Page 7	10/11/05	(corrected ferrule p/n on 1" and 1-1/4")
(62)	Page 14	1/5/06	(corrected p/n for 1-1/4" 1&2 Wire)
(63)	Page 4	1/31/06	(corrected p/n for 2" 100R10)
(64)	Page 5	2/1/06	(corrected p/n's 1/2")
(65)	Page 3	2/1/06	(corrected ferrule p/n 1-1/4")
(66)	Page 6	2/1/06	(corrected ferrule p/n 1-1/4")
(67)	Page 7	2/1/06	(corrected missing hose p/n 3/8,1/2,3/4,1,1-1/4)
(68)	Page 8	2/1/06	(corrected ferrule p/n)
(69)	Page 16	5/18/06	(added 1W crimp specs)
(70)	Page 16	4/16/08	(corrected 1/2" crimp diameters)
(71)	Page 5	12/9/08	(removed 100R5RC and made corrections on 100R5CC)
(72)	Page 6	12/9/08	(changed crimp diameter for 5/8" 100R5CC & 100R5RC)
(73)	Page 5	12/9/08	(corrected hose part number for 13/32 A005 and A055)
(74)	1,2,3,4,7	3/25/09	(Removed 100R9 & 100R10)
(75)	Page 3	3/25/09	(Added 100R5CC for 1-1/4")
(76)	Page 17&18	4/10/09	(Added 100R7 & 100R8 Thermoplastic hose)
(77)	Page 4	4/10/09	(Added 100R5 1-13/16")
(78)	Page 3	4/10/09	(Changed 100R5 hose size 1-1/8" & 1-3/8")
(79)	Page 16	5/6/09	(Added 2 Pc Crimp Fittings for 100R5 Hose)
(80)	Page 20	9/16/09	(Added Crimp Specs for 1Y Fittings)
(81)	Page 7	1/14/10	(Corrected hose part number for 3/8" and 1/2" 100R5)
(82)	Page 2	2/17/10	(Changed crimp diameter for 1/2" to .965)
(83)	Page 11	2/17/10	(Changed crimp diameter for 1/2" to .965)
(84)	Page 21	4/9/10	(Added crimp specs for 100R14 PTFE hose)
(85)	Page 18	4/15/10	(Corrected crimp diameter for 1/4")
(86)	Page 22	12/3/10	(Deleted info regarding pin gages)
(87)	Page 20	4/6/11	(Corrected Crimp Diameter for 100R13 -24)
(88)	Page 4	4/12/11	(Added 2-1/2",3" & 3-1/2")
(89)	Page 18	5/16/11	(Corrected Crimp Diameter on 1/4")
(90)	Page 5	11/16/11	(Corrected mistakes from excel conversion in 2005)
(91)	Page 17	11/16/11	(Added 1 Pc fittings for 100R5)