GENERAL CRIMP SPECIFICATIONS
&
SAE CROSS REFERENCE CHART
3/16" - 3-1/2" HOSE

Updated 1/17/20
(Supersedes chart of 12/13/19)

SAE SPEC	DESCRIPTION	NRP/JONES PART NUMBER
100 R1 A	1 Wire Braid Skive	1001
100 R1 AT	1 Wire Braid Non-Skive	1101
100 R17	Hydra-Lite I Hose	A151
100 R2 A	2 Wire Braid Skive	1002
100 R2 AT	2 Wire Braid Non-Skive	1102
100 R16	Hydra-Lite II Hose	A150
100 R3	2 Fiber Braid	2003
100 R4	Suction and Return Spiral Wound	2004
100 R5	1 Wire Braid Cotton Cover	1005
	1 Wire Braid Rubber Cover	1055
100R7	Thermoplastic Hose	3107
100R8	" "	3108
100 R12	4 Wire Braid Spiral Medium CAT	1212
	2 Spiral 1 Braid Heavy	1203
DIN 20023	4 Wire Spiral Heavy DIN	1214 & 1215
100 R13	4&6 Wire Spiral Heavy CAT	1213
100 R14	P.T.F.E. Hose	6014
3 Wire Braid	3 Wire Braid Mine	A003
	Push-on Rubber Cover	2230
	1000# PSI 1 Wire Braid Yellow Mine Hose	1080
	Dual-Lite Pressure Washer/Hydraulic Hose	A184
DIN 20022-2SN	Hydra-Max	A750
	Blue Pressure Washer Hose	A098
	Yellow Flex Wash Down Hose	A096
100 R1 A	1 Wire Grease	A001
	Power Jack Hose	A320

	For Crimp Diameters on Steel Ferrules.....	Page 1
	" " " " Aluminum Ferrules.....	Page 5
	" " " " Stainless Steel Ferrules	Page 7
	" " " " Yellow Mine Hose.....	Page 8
	" " " " Pressure Washer Hose.	Page 8
	" " " " Hydra-Lite Hose.....	Page 9
	" " " " Dual-Lite Hose.....	Page 10
	" " " " Hydra-Max 1/4-2".....	Page 12
	" " " " One Piece Fittings.....	Page 13
	" " " Special Instructions.....	Page 22

NOTE: ALL CRIMP DIMENSIONS ON IMPORTED PRODUCTS MATCH THE CORRESPONDING DOMESTIC PRODUCT CRIMP DIMENSIONS.

NRP JONES, LLC • 302 PHILADELPHIA ST., PO BOX 310 • LA PORTE, IN 46350
(219) 362-9908 or (800) 348-8868

NRP-JONES

Crimp Specifications for Steel Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID STEM PART NO.	MALE FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
	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		
3/16"	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)
	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	-	-	.690		(115)
1/4"	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)
		XF2SNK-04	204-104	504-500	NO SKIVE		.690		
			204-106	204-200	3/4	.450	.632		
	100R1 A	A001-05	205-104	204-200	11/16	To Wire	.660		
	100R1 AT	A101-05	"	505-500	-	-	.770		
5/16"	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)
	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)
3/8"	100R3	B003-06	"	206-200	-	-	.800		
(13/32)	100R5 CC	A005-08	"	506-500	-	-	.865		
(13/32)	100R5 RC	A055-08	"	506-500	-	-	.865		
				506-500		To Wire**	.875		
	Powerjack	A320-06	206-LN-106	206-200	3/4	To Wire**	.765		(56)(57)(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		
		XF2SNK-06	206-106	506-500	NO SKIVE		.840		
			"	206-200	3/4	.620	.755		

NRP-JONES

Crimp Specifications for Steel Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
	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		
1/2"				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		
		XF2SNK-08	208-108	508-500	NO SKIVE		.965		
			208-SPS-108	208-200	15/16	.750	.980		

	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		
5/8"	100R2 AT	A102-10	"	510-500	-	-	1.105		(94)
	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		

	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)
3/4"		2014-12	212-112	312-300	-	-	1.325		
(7/8)	100R5 CC	1005-16	212-112	514-500	-	-	1.290		
(7/8)	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)

NRP-JONES

Crimp Specifications for Steel Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
	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		
1"	100R4	2004-16	116-116	616-400	-	-	1.560		(14)
		2014-16	216-116	316-300	-	-	1.600		
(1-1/8")	100R5 CC	1005-20	216-116	516-500	-	-	1.650		(78)
(1-1/8")	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)

	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		
1-1/4"	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		
(1-3/8")	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

NRP-JONES

Crimp Specifications for Steel Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
	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	-	-			
1-1/2"									
	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)

	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		
2"		2014-32	232-132	432-400	-	-			
(1-13/16")	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)
3"	100R4	2004-48	148-G48	648-400	-	-	3.530	*88mm	(88)
3-1/2"	100R4	2004-56	156-G56	656-400	-	-	4.095	*103mm	(88)

*Recommended Minimum Die Finger Size

NRP-JONES

Crimp Data for Aluminum Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
	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		
3/16"	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		
	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		
1/4"	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		
	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			
5/16"	100R2 AT	A102-05	"	505-A-500	-	-	.815		
	100R5 CC	A005-06	"	505-A-500	-	-			
	100R5 RC	A055-06	"	505-A-500	-	-			
	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)
3/8"	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)
				608-100	13/16	To Wire	.880		(64)
	100R1 A	A001-08	208-108						
				608-200	13/16	To Wire	.955		
1/2"	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)

NRP-JONES

Crimp Data for Aluminum Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
	100R1 A	A001-10	210-112	610-200	7/8	To Wire	1.100		
	100R1 AT	A101-10	"	510-A-500	-	-	1.100		
5/8"	100R2 A	A002-10	"	610-200	7/8	To Wire	1.125		
	100R2 AT	A102-10	"	510-A-500	-	-	1.105		(94)
	100R5 CC	A005-12	"	510-A-500	-	-	1.145		(72)
	100R5 RC	A055-12	"	510-A-500	-	-	1.145		(72)
	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		
3/4"	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		
	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		
1"	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	-	-			
	100R1 A	1001-20	220-120	220-200					(66)
1-1/4"	100R1 AT	1101-20	"	520-A-500	-	-	1.955		
	100R2 AT	1102-20	"	520-A-500	-	-	2.045		
	100R1 AT	1101-24	224-124	524-A-500	-	-			
1-1/2"	100R2 AT	1102-24	"	524-A-500	-	-			
	100R1 AT	1101-32	232-132	532-A-500	-	-			
2"	100R2 AT	1102-32	"	532-A-500	-	-			

NRP-JONES

Crimp Data for Stainless Steel Ferrules and Stems

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE 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

NRP-JONES

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

HOSE SIZE	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE 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)
3/8"	S493-06	206-106	506-500			.825		
	S498-06					.825		
3/8"	S693-06	206-106	506-500			.84		
	S698-06					.84		
					INSERT DEPTH			
3/8 "	S493-06	206-1J				.845		(116)
	S498-06					.845		
3/8"	S693-06	206-1J				.855		(116)
	S698-06					.855		

NRP-JONES

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

HOSE SIZE	HOSE PART NO.	SOLID STEM MALE PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
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	-	-	1.105		(38)
			610-200					
			510-A-500			1.105		(95)
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 MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE 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 STEM MALE PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE 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	-	-	1.105		(22) (95)
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 MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE 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) (105)

HOSE SIZE	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE 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			1.105		(95)
		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			2.280		(39)
2"	1750-32	232-132	532-500			2.875		(39)

Crimp Data for Steel Ferrules for XF2SNK Hose (127)

HOSE SIZE	HOSE PART NO.	SOLID MALE STEM PART NO.	FERRULE PART NO.	SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
1/4"	XF2SNK-04	204-104	504-500	NO SKIVE		.690	15MM	
		204-1J-104		NO SKIVE		.690	15MM	
		204-104	204-200	3/4	.450	.632	15MM	
3/8"	XF2SNK-06	206-106	506-500	NO SKIVE		.840	18MM	
		206-1J-106		NO SKIVE		.850	18MM	
		206-106	206-200	3/4	.620	.755	18MM	
1/2"	XF2SNK-08	208-108	508-500	NO SKIVE		.965	21.60MM	
		208-1J-108		NO SKIVE		.985	21.60MM	
		208-108	208-200	15/16	.750	.980	21.60MM	

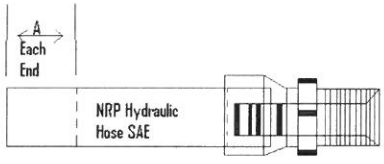
NRP-JONES

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 MALE STEM PART NO.	SPACER RING COLOR	SIDE	"A" INSERT DEPTH	NOMINAL CRIMP DIAMETER		
1/4"	1 Wire	A101-04	204-1P-104	Black	DN	7/8	.560		
3/8"	1 Wire	A101-06	206-1P-106	Black	DN	13/16	.740		
1/2"	1 Wire	A101-08	208-1P-108	Black	DN	1-1/16	.865		
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		
1"	1 Wire	A101-16	216-1P-116	Black	DN	1-1/4	1.445		

*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 with Newly Designed Ferrule 2016

HOSE SIZE	SAE SPEC	HOSE PART NO.		INSERT DEPTH	CRIMP DIAMETER		
1/4"	1 WIRE	A101-04	204-1J-104	.845	.650		
	2 WIRE	A102-04	204-1J-104	.845	.690		
	100R3	B003-04	204-1J-104	.845	.700		(53)
	100R5	A005-05	204-1J-104	.845	.650		(53)
	100R16	A150-04	204-1J-104	.845	.690		(58)
	100R17	A151-04	204-1J-104	.845	.655		(58)
	Power Jack	A320-04	204-1J-104	.845	.690		(99)
3/8" (13/32")	1 WIRE	A101-06	206-1J-106	.845	.845		(45)
	2 WIRE	A102-06	206-1J-106	.845	.870		
	100R3	B003-06	206-1J-106	.845	.880		(53)
	100R5	A005-08	206-1J-106	.845	.860		(53)
	100R12	1212-06	206-1J-106	.845 skive if needed	.915		(53)
	100R16	A150-06	206-1J-106	.845	.850		(58)
	100R17	A151-06	206-1J-106	.845	.835		(58 & 122)
	Power Jack	A320-06	206-1J-106	.845	.870		(99)
1/2"	1 WIRE	A101-08	208-1J-108	1.100	.950		
	2 WIRE	A102-08	208-1J-108	1.100	.990		
	100R3	B003-08	208-1J-108	1.100	1.020		(53)
	100R5	A005-10	208-1J-108	1.100	.950		(53)
	100R16	A150-08	208-1J-108	1.100	.985		(58)
	100R17	A151-08	208-1J-108	1.100	.935		(58)
5/8"	1 WIRE	A101-10	210-1J-112	1.100	1.065		
	2 WIRE	A102-10	210-1J-112	1.100	1.105		(35)
	100R5	A005-12	210-1J-112	1.100	1.105		(53)
	100R16	A150-10	210-1J-112	1.100	1.105		(58)
	100R17	A151-10	210-1J-112	1.100	1.105		(58)
3/4" (7/8")	1 WIRE	A101-12	212-1J-112	1.140	1.250		
	2 WIRE	A102-12	212-1J-112	1.140	1.290		
	100R3	B003-12	212-1J-112	1.140	1.320		(53)
	100R4	2014-12	212-1J-112	1.140	1.290		(53)
	100R5	1005-16	212-1J-112	1.140	1.290		(53)
	100R16	A150-12	212-1J-112	1.140	1.250		(58)
	100R17	A151-12	212-1J-112	1.140	1.290		(58 & 122)
		A840-12	212-1J-112		1.320		(119)

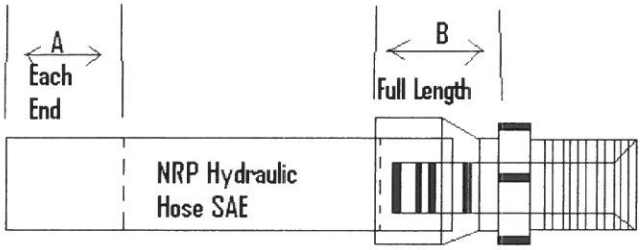
1" (1-1/8")	1 WIRE	A101-16	216-1J-116	1.350	1.600		
	2 WIRE	A102-16	216-1J-116	1.350	1.635		
	100R3	B003-16	216-1J-116	1.350	1.645		(53)
	100R4	2014-16	216-1J-116	1.350	1.635		(53)
	100R5	1005-20	216-1J-116	1.350	1.635		(53)
	100R16	A150-16	216-1J-116	1.350	1.620		(58)
	100R17	A151-16	216-1J-116	1.350	1.635		(58)

1" SS (1-1/8")	1 WIRE	A101-16	216-1JSS-116	1.350	1.575		
	2 WIRE	A102-16	216-1JSS-116	1.350	1.610		
	100R3	B003-16	216-1JSS-116	1.350	1.620		(121)
	100R4	2014-16	216-1JSS-116	1.350	1.610		(121)
	100R5	1005-20	216-1JSS-116	1.350	1.610		(121)
	100R16	A150-16	216-1JSS-116	1.350	1.595		(121)
	100R17	A151-16	216-1JSS-116	1.350	1.610		(121)

1-1/4"	1 WIRE	1101-20	220-1J-120	1.750	1.975		(62)
	2 WIRE	1102-20	220-1J-120	1.750	2.015		(62)
	100R3	2003-20	220-1J-120	1.750	2.030		
	100R4	2014-20	220-1J-120	1.750	2.015		(53)

See Diagram on the Following Page

Crimp 1J Stainless fitting using these same instructions



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 SIZE	SAE SPEC	HOSE PART	STEM SERIES	FERRULE	CRIMP	
3/16"	100R5	A005-04	203-	503-R5-500	.620	
(-4)	100R5	A055-04	203-	503-R5-500	.620	
1/4"	100R5	A005-05	204-	504-500	.680	
(-5)	100R5	A055-05	204-	504-500	.680	
5/16"	100R5	A005-06	205-	505-500	.785	
(-6)	100R5	A055-06	205-	505-500	.785	
13/32"	100R5	A005-08	206-	506-500	.865	
(-8)	100R5	A055-08	206-	506-500	.865	
1/2"	100R5	A005-10	208-	508-R5-500	.965	
(-10)	100R5	A055-10	208-	508-R5-500	.965	
5/8"	100R5	A005-12	210-	510-500	1.100	
(-12)	100R5	A055-12	210-	510-500	1.100	
7/8"	100R5	1005-16	214-	514-500	1.330	
(-16)	100R5	1055-16	214-	514-500	1.330	
1-1/8"	100R5	1005-20	220-R5-	516-500	1.740	
(-20)	100R5	1055-20	220-R5-	516-500	1.740	
1-3/8"	100R5	1005-24	224-R5-	220-200	1.910	
(-24)	100R5	1055-24	224-R5-	220-200	1.910	
1-13/16"	100R5	1005-32	232-R5-	524-500	2.430	
(-32)	100R5	1055-32	232-R5-	524-500	2.430	
2-3/8"	100R5	1005-40	240-R5-	532-R5-500	3.120	(92)
(-40)	100R5	1055-40	240-R5-			

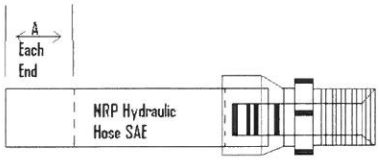
NOTE: Crimping information is for all stems with the above series

NRP-JONES

Crimp Data for 1 Pc Crimp Fittings for 100R5 Hose (91) (106)

HOSE SIZE	SAE SPEC	HOSE PART NO.	P/N		CRIMP	INSERT DEPTH	
3/16"	100R5	A005-04	204-1PR5-		.560	.875	
(-4)	100R5	A803-04	204-1PR5-		.560	.875	
	100R5		204-1PR5B-		.560	.875	(117)
1/4"	100R5	A005-05	205-1PR5-		.600	.850	
(-5)	100R5	A803-05	205-1PR5-		.600	.850	
		A360-05	205-1PR5-		.600		(114)
	100R5		205-1PR5B-		.600		(117)
5/16"	100R5	A005-06	206-1PR5-		.700	.875	
(-6)	100R5	A803-05	206-1PR5-		.700	.875	
		A360-06	206-1PR5-		.720		(114)
	100R5		206-1PR5B-		.700	.875	(117)
13/32"	100R5	A005-08	208-1PR5-		.840	1.050	
(-8)	100R5	A803-08	208-1PR5-		.840	1.050	
		A360-08	208-1PR5-		.830		
	100R5		208-1PR5B-		.840	1.05	(117)
1/2"	100R5	A005-10	210-1PR5-		.960	1.100	
(-10)	100R5	A803-10	210-1PR5-		.960	1.100	
		A360-10	210-1PR5-		.985		(114)
	100R5		210-1PR5B-		.960	1.10	(117)
5/8"	100R5	A005-12	212-1PR5-		1.080	1.150	
(-12)	100R5	A803-12	212-1PR5-		1.080	1.150	
		A360-12	212-1PR5-		1.10		(114)
	100R5		212-1PR5B-		1.080	1.15	(117)
7/8"	100R5	1005-16	216-1PR5-		1.260	1.200	
(-16)	100R5	1803-16	216-1PR5-		1.260	1.200	
1-1/8"	100R5	1005-20	220-1PR5-		1.520	1.450	
(-20)	100R5	1803-20	220-1PR5-		1.520	1.450	
1-3/8"	100R5	1005-24	224-1PR5-		1.725	1.650	
(-24)	100R5	1803-24	224-1PR5-		1.725	1.650	
1-13/16"	100R5	1005-32	232-1PR5-		2.200	2.000	
(-32)	100R5	1803-32	232-1PR5-		2.200	2.000	

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



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 **1W Crimp Specifications**

HOSE SIZ	SAE SPEC	NRP/JONES HOSE PART NO	SOLID MALE 1PC PART NO.	SKIVE LENGTH	SKIVE DIAMETER	FULL LENGTH CRIMP DIAMETER	INSERT DEPTH	
		(97) (107)					(70) (101)	
	100R2AT	A102-08	608-1W-108	NO	NO	1.100	1-1/2	
	100R16	A150-08	"	NO	NO	1.100	1-1/2	
1/2"	100R12	1212-08	"	NO	NO	1.120	1-1/2	
	Hydra-Max	A750-08	"	NO	NO	1.100	1-1/2	
	DIN 20023	1214-08SP	"	1-3/16	TO WIRE	1.120	1-1/2	
	100R15	1211-08	"	1-3/16	TO WIRE	1.170	1-1/2	
	4SH	1312-08SH	"	NO	NO	1.120	1-1/2	
	100R2AT	A102-10	610-1W-108	NO	NO	1.18	1.42	
	100R16	A150-10	"	NO	NO	1.18	1.42	
5/8"	Hydra-Max	A750-10	"	NO	NO	1.18	1.42	
	100R17	A151-10	"	NO	NO	1.18	1.42	
	100R12	1212-10	"	NO	NO	1.23	1.42	
	100R2AT	A102-12	612-1W-112	NO	NO	1.340	1-9/16	
	100R16	A150-12	"	NO	NO	1.340	1-9/16	
	100R17	A151-12	"	NO	NO	1.340	1-9/16	
3/4"	Hydra-Max	A750-12	"	NO	NO	1.340	1-9/16	
	100R12	1212-12	"	NO	NO	1.375	1-9/16	
	DIN 20023	1214-12SP	"	1.445	TO WIRE	1.375	1-9/16	
	100R13	1213-12	"	1.445	TO WIRE	1.400	1-9/16	
	4SH	1312-12SH	"	NO	NO	1.375	1-9/16	
	100R2AT	A102-16	616-1W-116	NO	NO	1.680	1-3/4	
	100R16	A150-16	"	NO	NO	1.680	1-3/4	
	Hydra-Max	A750-16	"	NO	NO	1.680	1-3/4	
1"	100R17	A151-16	"	NO	NO	1.680	1-3/4	
	100R12	1212-16	"	NO	NO	1.700	1-3/4	
	DIN 20023	1214-16SP	"	1.785	TO WIRE	1.700	1-3/4	
	100R13	1213-16	"	1.785	TO WIRE	1.725	1-3/4	
	4SH	1312-16SH	"	NO	NO	1.700	1-3/4	
		9XF5000	"	NO	NO	1.70		
	100R1AT	1101-20	620-1W-120	NO	NO	2.055	2	
	100R2AT	1102-20	"	NO	NO	2.095	2	
	DIN20022	1750-20	"	NO	NO	2.095	2	
1-1/4"	100R12	1212-20	"	NO	NO	2.075	2	
	DIN 20023	1214-20SH	"	NO	NO	-	2	
	100R13	1213-20	"	1.850	TO WIRE	2.125	2	
	4SH	1312-20SH	"	NO	NO	2.010	2	(125)
	100R1AT	1101-24	624-1W-124	NO	NO	2.340	2-1/4	
	100R2AT	1102-24	"	NO	NO	2.380	2-1/4	
	DIN20022	1750-24	"	NO	NO	2.380	2-1/4	
1-1/2"	100R12	1212-24	"	NO	NO	2.365	2-1/4	
	DIN 20023	1214-24SH	"	NO	NO	-	2-1/4	
	100R13	1213-24	"	2.140	TO WIRE	2.465	2-1/4	
	4SH	1312-24SH	"	NO	NO	2.365	2-1/4	
	100R1AT	1101-32	632-1W-132	NO	NO	2.760	2-3/4	
	100R2AT	1102-32	"	NO	NO	2.760	2-3/4	
	DIN20022	1750-32	"	NO	NO	2.760	2-3/4	
2"	100R12	1212-32	"	NO	NO	2.780	2-3/4	
	DIN 20023	1214-32SH	"	NO	NO	-	2-3/4	
	100R13	1213-32	"	2.500	TO WIRE	2.960	2-3/4	
	4SH	1312-32SH	"	NO	NO	2.780	2-3/4	
	MUDD DOG	MD5000-32	"	NO	NO	2.740	2-3/4	(123)

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

NRP-JONES

Crimp Data for One-Piece Couplings

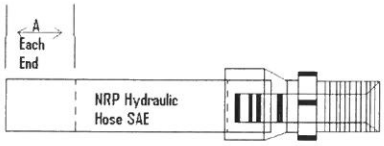
For NRP-Jones 100R7 and 100R8 Thermoplastic Hose(76) (85)

Hose Size	SAE Spec	Hose Part No.	Solid Male Stem Part No.	"A" Insert Depth	Nominal Crimp Diameter	
	100R7	3107-04	204-1P-104	7/8	.530/.550	(89)
	100R7NC	3207-04	204-1P-104	7/8	.530/.550	
	100R7TW	3307-04	204-1P-104	7/8	.530/.550	
1/4"	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	
	100R7	3107-05	205-1P-105			
	100R7NC	3207-05	205-1P-105			
	100R7TW	3307-05	205-1P-105			
5/16"	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			
	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	
3/8"	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	
	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	
1/2"	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	
	100R87TW	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

Crimp Data for 1Y Fittings (80)
For 100R13 & 100R15 Non-Skive Hose (87)
(100)
(102)
(103)

Hose Type	Fitting	No. Wire Lays	Fitting Insertion D	Crimp Dim	(104)
-12 100R2	612-Y	2	1.770	1.380	
-12 100R16	612-Y	2	1.770	1.380	
-12 100R17	612-Y	2	1.770	1.380	
-12 A750	612-Y	2	1.770	1.380	
-12 100R12	612-Y	4	1.770	1.425	
-12 100R13	612-Y	4	1.770	1.445	
-12 100R15	612-Y	4	1.770	1.445	
-12 4SH	612-Y	4	1.770	1.425	
-16 100R2	616-Y	2	2.560	1.850	
-16 100R16	616-Y	2	2.560	1.850	
-16 100R17	616-Y	2	2.560	1.850	
-16 A750	616-Y	2	2.560	1.850	
-16 100R12	616-Y	4	2.560	1.768	
-16 100R13	616-Y	4	2.560	1.787	
-16 100R15	616-Y	4	2.560	1.787	
-16 4SH	616-Y	4	2.560	1.768	
-20 100R2	620-Y	2	2.950	2.06	(126)
-20 100R12	620-Y	4	2.950	2.106	
-20 100R13	620-Y	6	2.950	2.248	
-20 100R15	620-Y	6	2.950	2.213	
-20 4SH	620-Y	4	2.950	2.106	
-24 100R2	624-Y	2	3.070	2.390	
-24 100R12	624-Y	4	3.070	2.378	
-24 100R13	624-Y	6	3.070	2.524	
-24 100R15	624-Y	6	3.070	2.531	
-24 4SH	624-Y	4	3.070	2.378	
MUDD DOG	1502-*24Y			2.378	(124)
-32 100R2	632-Y	2	3.070	2.930	
-32 100R12	632-Y	4	3.070	2.898	
-32 100R13	632-Y	6	3.070	3.114	
-32 100R15	632-Y	6	3.070	3.114	
-32 4SH	632-Y	4	3.070	2.898	

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

NRP Jones **BOP CRIMP DIMENSIONS**

HOSE SIZE	HOSE SPEC	NRP/JONES HOSE PART NO.	FITTING/FERRU	SKIVE LENGTH	FULL LENGTH CRIMP DIAMETER
3/8	BOP	A822-06	206-200	0.75"	0.76
1/2	BOP	A822-08	208-200	0.81"	0.975
3/4	BOP	A822-12	212-200	1.06"	1.235
1	BOP	A822-16	216-200	1.13"	1.56
1-1/4	BOP	1822-20	620-1W-120	1.85"	2.125
3/8	BOP	A825-06	206-200	0.75"	0.76
1/2	BOP	A825-08	208-200	0.81"	0.975
3/4	BOP	1825-12	612-1W-112	1.45"	1.4
1	BOP	1825-16	616-1W-116	1.79"	1.725
1-1/4	BOP	1825-20	620-1W-120	1.85"	2.125
1-1/2	BOP	1825-24	624-1W-124	2.14"	2.465
2	BOP	1825-32	632-1W-132	2.50"	2.96

NOTE: SKIVING OF COVER IS REQUIRED FOR ATTACHMENT OF FITTINGS

NRP-JONES

Crimp Data for 1 Pc Fittings for 100R14 P.T.F.E. Hose (84) (96)

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	.420-.425	
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.

SPECIAL INSTRUCTIONS

** 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.

NRP-JONES

AQUA BLAST (112)

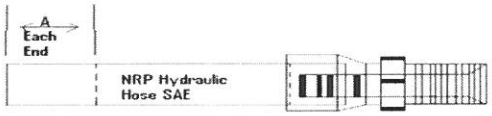
Aquablast Hose	Inner Skive	External Skive	Crimp Spec	Dies
12,500 PSI				
AB-08	0.687	1.5	1.112	26mm
1/2" 12,500psi Hose				
AB-12				
3/4" 12,500psi Hose	0.546	2.437	1.519	38mm
AB-16				
1" 12,500psi Hose	0.687	2.312	1.763	39mm
16,000 PSI				
ABP-08	0.5	1.625	1.173	26mm
1/2" 16,000psi Hose				
ABP-12				
3/4" 16,000 psi Hose	.539 to .578"	2.461 to 2.500"	1.516 to 1.524"	38mm

HYDRO CARBON DRAIN HOSE (118)

HOSE	FITTINGS	SKIVE	CRIMP
1324-12	212-1PHC-112	NA	1.275
1324-16	216-1J-116	NA	1.645

Crimp Data for KT One-Piece Couplings

HOSE SIZE	SAE SPEC	HOSE PART NO.	SOLID MALE STEM PART NO.	"A" INSERT DEPTH	NOMINAL CRIMP DIAMETER	DIE SIZE	
1/4"	1 WIRE	A101-04	204-KT	1.280	.585	14 MM	
	2 WIRE	A102-04	204-KT	1.280	.645	14 MM	
	100R7	3107-04	204-KT	1.280	.570	14 MM	
	100R8	3108-04	204-KT	1.280	.570	14 MM	
	100R16	A150-04	204-KT	1.280	.615	14 MM	
	100R17	A151-04	204-KT	1.280	.565	14 MM	
3/8"	1 WIRE	A101-06	206-KT	1.430	.750	17 MM	
	2 WIRE	A102-06	206-KT	1.430	.800	17 MM	
	100R7	3104-06	206-KT	1.430	.720	17 MM	
	100R8	3108-06	206-KT	1.430	.710	17 MM	
	100R16	A150-06	206-KT	1.430	.760	17 MM	
	100R17	A151-06	206-KT	1.430	.725	17 MM	
1/2"	1 WIRE	A101-08	208-KT	1.500	.860	20 MM	
	2 WIRE	A102-08	208-KT	1.500	.910	20 MM	
	100R7	3107-08	208-KT	1.500	.870	20 MM	
	100R8	3108-08	208-KT	1.500	.860	20 MM	
	100R16	A150-08	208-KT	1.500	.880	20 MM	
	100R17	A151-08	208-KT	1.500	.840	20 MM	
5/8"	1 WIRE	A101-10	210-KT	1.500	1.000	24 MM	
	2 WIRE	A102-10	210-KT	1.500	1.050	24 MM	
	100R16	A150-10	210-KT	1.500	1.010	24 MM	
	100R17	A151-10	210-KT	1.500	.995	24 MM	
3/4"	1 WIRE	A101-12	212-KT	1.540	1.150	27 MM	
	2 WIRE	A102-12	212-KT	1.540	1.190	27 MM	
	100R16	A150-12	212-KT	1.540	1.150	27 MM	
	100R17	A151-12	212-KT	1.540	1.160	27 MM	
1"	1 WIRE	A101-16	216-KT	1.660	1.430	35 MM	
	2 WIRE	A102-16	216-KT	1.660	1.480	35 MM	
	100R16	A150-16	216-KT	1.660	1.425	35 MM	
	100R17	A151-16	216-KT	1.660			
1-1/4"	1 WIRE	1101-20	220-KT	2.030	1.830	45 MM	
	2 WIRE	1102-20	220-KT	2.030	1.920	45 MM	



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.

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

(45)	Page 14	01/02/03	on 3/8")
(46)	Page 14	01/15/03	(added illustration B)
(47)	Page 9-11	01/27/03	diameter on 3/4" &
(48)	Page 12	02/14/03	#4)
(49)	Page 12	02/17/03	crimp diameters)
(50)	Page 1	02/17/03	(added 206-1J-106)
(51)	Page 1-4	03/04/03	(Deleted all 100R11)
(52)	Page 11	03/04/03	A150-12, 512-500 &
(53)	Page 14	04/24/03	100R4, and 100R5)
(54)	Page 9	05/20/03	diameter for 5/8" 210-
(55)	Page 1	07/23/03	(added A320-04)
(56)	Page 1	07/23/03	(added A320-06)
(57)	Page 1	10/05/04	(added Powerjack)
(58)	Page 14	12/15/04	A151)
(59)	Page 9 & 11	12/15/04	(added 1J's)
	ALL PAGES	06/20/05	Converted all charts to Excel format
(60)	Page 1	07/12/05	(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	01/05/06	(corrected p/n for 1-1/4" 1&2 Wire)
(63)	Page 4	01/31/06	(corrected p/n for 2" 100R10)
(64)	Page 5	02/01/06	(corrected p/n's 1/2")
(65)	Page 3	02/01/06	(corrected ferrule p/n 1-1/4")
(66)	Page 6	02/01/06	(corrected ferrule p/n 1-1/4")
(67)	Page 7	02/01/06	(corrected missing hose p/n 3/8,1/2,3/4,1,1-1/4)
(68)	Page 8	02/01/06	(corrected ferrule p/n)
(69)	Page 16	05/18/06	(added 1W crimp specs)
(70)	Page 16	04/16/08	(corrected 1/2" crimp diameters)
(71)	Page 5	12/09/08	(removed 100R5RC and made corrections on 100R5CC)
(72)	Page 6	12/09/08	(changed crimp diameter for 5/8" 100R5CC & 100R5RC)
(73)	Page 5	12/09/08	(corrected hose part number for 13/32 A005 and A055)
(74)	1,2,3,4,7	03/25/09	(Removed 100R9 & 100R10)
(75)	Page 3	03/25/09	(Added 100R5CC for 1-1/4")
(76)	Page 17&18	04/10/09	(Added 100R7 & 100R8 Thermoplastic hose)
(77)	Page 4	04/10/09	(Added 100R5 1-13/16")
(78)	Page 3	04/10/09	(Changed 100R5 hose size 1-1/8" & 1-3/8")
(79)	Page 16	05/06/09	(Added 2 Pc Crimp Fittings for 100R5 Hose)
(80)	Page 20	09/16/09	(Added Crimp Specs for 1Y Fittings)
(81)	Page 7	01/14/10	(Corrected hose part number for 3/8" and 1/2" 100R5)
(82)	Page 2	02/17/10	(Changed crimp diameter for 1/2" to .965)
(83)	Page 11	02/17/10	(Changed crimp diameter for 1/2" to .965)
(84)	Page 21	04/09/10	(Added crimp specs for 100R14 PTFE hose)
(85)	Page 18	04/15/10	(Corrected crimp diameter for 1/4")
(86)	Page 22	12/03/10	(Deleted info regarding pin gages)
(87)	Page 20	04/06/11	(Corrected Crimp Diameter for 100R13 -24)
(88)	Page 4	04/12/11	(Added 2-1/2",3" & 3-1/2")
(89)	Page 18	05/16/11	(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)
(92)	Page 16	06/01/12	(Added ferrule and crimp spec for 2-3/8)
(93)	Page 23	08/08/12	(Added tolerance statement)
(94)	Pages 2 & 6	10/10/12	(Changed crimp dia A102-10AT 510-500 & 510-A-500 to 1.105)
(95)	Pgs 9,12	12/19/12	(Changed crimp dia A151-10 & A750-10 to 1.105
(96)	Page 22	01/25/13	(Changed crimp dia for 1/4" to .420-.425)
(97)	Page 18	02/12/13	(Added 4SH hose)
(98)	Cover	05/15/13	(Added Note Regarding Import Crimp Dimensions)
(99)	Page 14	10/18/13	(Added A320-04, A320-06 Power Jack)
(100)	Page 21	01/08/14	(1Y Fittings for 4SH Hose)
(101)	Page 18	01/08/14	(Added Insert Depth)
(102)	Page 21	01/23/14	(Added crimp spec for 2" 100R15)
(103)	Page 21	05/05/14	(Added 100R12)
(104)	Page 21	06/19/14	(Added 100R2 1-1/2" and 2")
(105)	Page 12	06/19/14	(Added crimp dia. for 1-1/2" and 2")
(106)	Page 17	10/06/14	(Changed crimp dia for 3/16, 5/16, 13/32 and 1/2)
(107)	Page 18	01/29/15	(Added 100R1AT 1-1/4, 1-1/2 & 2)
(108)	Page 15	06/23/16	(Corrected insert depth for 1/4")
109	Page 1, 16	08/16/16	Added XF2SNK 1/4", 3/8", 1/2"
110	Page 20	08/24/16	A
111	Page 19	12/29/16	Corrected Instructions and Picture
112	Page 26	03/23/17	Added Aquablast - AB & ABP
113	Page 24	04/13/17	Added skiving note to BOP hose

114	page 19	08/02/17	Added A360 crimp specs
115	Page 1	08/02/17	Changed crimp spec for 1/4 R2
116	Page 8	09/22/17	Added 1J for the Pressure Hose S493 etc.
117	Page 19	12/05/17	Added 1PR5B and updated insert depths and crimp specs
118	Page 20	02/12/18	Page 26 added Hydro Carbon Drain Hose
119	Page 16	03/19/18	Added crimp spec for the 3/4" A840-12
120	Page 27	5/7/2018	Added crimp specs for the KT Fittings
121	Page 16	6/1/2018	Added 1" 1JSS Crimp Specs
		7/31/2018	Deleted 1J page for Old Ferrule Chart Per Tom Blank
122	Page 15	10/22/2018	A151-06 crimp spec change per Tom Blank
123	Page 19	11/2/2018	Added MD5000-32 crimp spec to 1W page
124	Page 22	2/18/2019	Added MD500-24 crimp to 1Y for 1502 Hammer Unions
125	Page 19	9/25/2019	Changed crimp spec for 1312-20SH
126	Page 22	9/27/2019	Added R2 -20 (1-1/4) crimp spec
127	Page 12	12/13/2019	Added XF2SNK Specs Per TB
		1/17/2020	Removed the 2 wire from the 1P, Page 13