

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

Updated 9/22/17  
(Supersedes chart of 8/2/17)

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.**

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(219) 362-9908 or (800) 348-8868**

**NRP-JONES**

**Crimp Specifications for Steel Ferrules**

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
			STEM NO.	PART FERRULE PART NO.						
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	-	-	.690		(115)	
	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	
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			
					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		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.		
			STEM NO.	PART NO.						FERRULE PART NO.
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			
		XF2SNK-08	208-108	508-500	NO SKIVE		.965			
			208-SPS-108	208-200	15/16	.750	.980			

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	-	-	1.105		(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		

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)		

**NRP-JONES**

**Crimp Specifications for Steel Ferrules**

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

**NRP-JONES**

**Crimp Specifications for Steel Ferrules**

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE		Length	SKIVE		CRIMP DIAMETER	DIE NO.	
			STEM NO.	PART NO.		FERRULE PART NO.	Diameter			
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	2004-24	124-124	624-400	-	-	2.040		
		2014-24	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	2004-32	132-132	632-400	-	-	2.480		
		2014-32	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

**NRP-JONES**

**Crimp Data for Aluminum Ferrules**

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.	
			STEM NO.	PART 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" (13/32) (13/32)	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		
	100R5 CC	A005-08	"	506-A-500	-	-	.865		(73)
	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)	

**NRP-JONES**

**Crimp Data for Aluminum Ferrules**

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE		Length	SKIVE		CRIMP DIAMETER	DIE NO.	
			STEM NO.	PART NO.		FERRULE PART NO.	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	-	-	1.105		(94)	
	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	-	-				

**NRP-JONES**

**Crimp Data for Stainless Steel Ferrules and Stems**

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



**NRP-JONES**

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

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

**NRP-JONES**

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

HOSE SIZE	HOSE PART NO.	SOLID MALE		FERRULE PART NO.	Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
		STEM NO.	PART 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		CRIMP DIAMETER	DIE NO.
				Length	Diameter		
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 MALE		FERRULE PART NO.	Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
		STEM NO.	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	-	-	1.105	(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		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
		STEM NO.	PART FERRULE 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		Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
		STEM NO.	PART FERRULE 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)

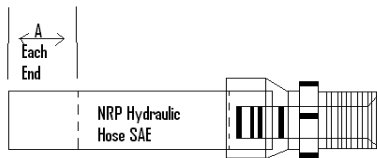
**NRP-JONES**

**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.	COLOR	SPACER RING SIDE	"A" INSERT DEPTH	NOMINAL CRIMP DIAMETER		
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	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)
	Power Jack	A320-04	204-1J-104	11/16	.690		(99)
		XF2SNK-04	204-1J-104	NO SKIVE	.690		
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)
	Power Jack	A320-06	206-1J-106	11/16	.870		(99)
		XF2SNK-06	206-1J-106	NO SKIVE	.850		
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	.950		(58)
		XF2SNK-08	208-1J-108	NO SKIVE	.985		
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

\*NRP Jones has made the 1JSS stainless steel series fittings series using the same dimensions which allows the use of the same crimp dimensions as the carbon steel series

**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	.850	(58)
	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)

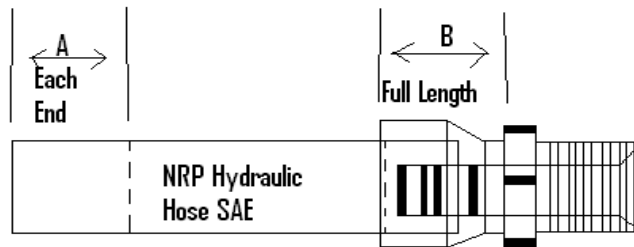
5/8"	1 WIRE	A101-10	210-1J-112	1.100	1.065	
	2 WIRE	A102-10	210-1J-112	1.100	1.105	(35)
	100R5	A005-12	210-1J-112	1.100	1.105	(53)
	100R16	A150-10	210-1J-112	1.100	1.105	(58)
	100R17	A151-10	210-1J-112	1.100	1.105	(58)

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)



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)
1-1/4"	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" (-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-	532-R5-500	3.120	
	100R5	1055-40	240-R5-			

(92)

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

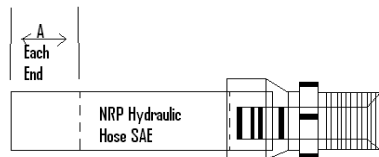
**NRP-JONES**

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

(106)

HOSE SIZE	SAE SPEC	HOSE PART		CRIMP	INSERT DEPTH
		NO.	P/N		
3/16" (-4)	100R5	A005-04	204-1PR5-	.560	.875
	100R5	A803-04	204-1PR5-	.560	.875
1/4" (-5)	100R5	A005-05	205-1PR5-	.585	.850
	100R5	A803-05	205-1PR5-	.585	.850
		A360-05	205-1PR5-	.630	
5/16" (-6)	100R5	A005-06	206-1PR5-	.700	.875
	100R5	A803-05	206-1PR5-	.700	.875
		A360-06	206-1PR5-	.720	
13/32" (-8)	100R5	A005-08	208-1PR5-	.820	1.050
	100R5	A803-08	208-1PR5-	.820	1.050
		A360-08	208-1PR5-	.830	
1/2" (-10)	100R5	A005-10	210-1PR5-	.960	1.100
	100R5	A803-10	210-1PR5-	.960	1.100
		A360-10	210-1PR5-	.985	
5/8" (-12)	100R5	A005-12	212-1PR5-	1.080	1.150
	100R5	A803-12	212-1PR5-	1.080	1.150
		A360-12	212-1PR5-	1.10	
7/8" (-16)	100R5	1005-16	216-1PR5-	1.260	1.200
	100R5	1803-16	216-1PR5-	1.260	1.200
1-1/8" (-20)	100R5	1005-20	220-1PR5-	1.520	1.450
	100R5	1803-20	220-1PR5-	1.520	1.450
1-3/8" (-24)	100R5	1005-24	224-1PR5-	1.725	1.650
	100R5	1803-24	224-1PR5-	1.725	1.650
1-13/16" (-32)	100R5	1005-32	232-1PR5-	2.200	2.000
	100R5	1803-32	232-1PR5-	2.200	2.000

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



**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

1W Crimp Specifications

		(97) (107)				(70) (101)	
HOSE SIZ	SAE SPEC	NRP/JONES HOSE PART	SOLID MALE 1PC PART NO.	SKIVE LENGTH	SKIVE DIAMETER	FULL LENGTH CRIMP DIAMETER	INSERT DEPTH
1/2"	100R2AT	A102-08	608-1W-108	NO	NO	1.100	1-1/2
	100R16	A150-08	"	NO	NO	1.100	1-1/2
	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
5/8"	100R2AT	A102-10	610-1W-108	NO	NO	1.18	1.42
	100R16	A150-10	"	NO	NO	1.18	1.42
	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
3/4"	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
	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	
1"	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
	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	
1-1/4"	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
	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	2.075	2	
1-1/2"	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
	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	
2"	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
	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	

•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)**

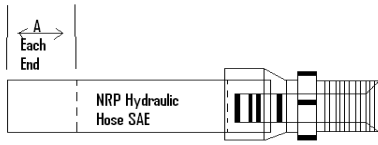
(85)

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**

**Crimp Data for 1Y Fittings  
For 100R13 & 100R15 Non-Skive Hose**

(80)  
(87)  
(100)  
(102)  
(103)  
(104)

Hose Type	Fitting	No. Wire Lays	Fitting Insertion □	Crimp Dim
-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 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

-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.



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
<hr/>					
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

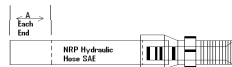
**NRP-JONES**

**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)

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

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

(45)	Page 14	01/02/03	(changed crimp dia on 3/8")
(46)	Page 14	01/15/03	(added illustration B)
(47)	Page 9-11	01/27/03	(added crimp diameter on 3/4" & 1")
(48)	Page 12	02/14/03	(added instruction #4)
(49)	Page 12	02/17/03	(added 1J's and crimp diameters)
(50)	Page 1	02/17/03	(added 206-1J-106)
(51)	Page 1-4	03/04/03	(Deleted <u>all</u> 100R11)
(52)	Page 11	03/04/03	(Changed crimp dia A150-12, 512-500 & 512A500 to 1.320)
(53)	Page 14	04/24/03	(Added 100R3, 100R4, and 100R5)
(54)	Page 9	05/20/03	(added crimp diameter for 5/8" 210-1J-112)
(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	(added A150 & 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	Added 9XF5000 1"
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	8/2/2017	Changed crimp spec for 1/4 R2

