

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

Updated 9/4/24
(Supersedes chart of 8/7/24)

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 MALE		SKIVE Length	SKIVE Diameter	CRIMP DIAMETER	DIE NO.
			STEM NO.	PART NO.				
3/16"	100R1 A	A001-03	203-102	203-200	Updated 8/7/24	To Wire	.545	
	100R1 AT	A101-03	(Supersedes)	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	-	-	.635	(131)
	100R5 RC	A055-04	"	503-500	-	-	.635	(131)
								(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.					
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		FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.	
			STEM NO.	PART NO.		Length	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		FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.	
			STEM NO.	PART NO.		Length	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	124-124			624-400	-	-	2.040	
		2014-24	124-124			624-400	-	-	2.040	(146)
	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	132-132			632-400	-	-	2.480	(146)
	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		Length	SKIVE		CRIMP DIAMETER	DIE NO.	
			STEM NO.	PART NO.		FERRULE PART NO.	Diameter			
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)		

NRP-JONES

Crimp Data for Aluminum Ferrules

HOSE SIZE	HOSE SPEC	HOSE PART NO.	SOLID MALE		Length	SKIVE		CRIMP	
			STEM NO.	PART PART NO.		Diameter	DIAMETER	DIE NO.	
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 STEM PART		FERRULE PART NO.	SKIVE		CRIMP	
			NO.	NO.		Length	Diameter	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		CRIMP DIAMETER	DIE NO.
				Length	Diameter		
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 MALE STEM PART NO.	FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.
				Length	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	-	-	1.105	(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 STEM PART NO.	FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.
				Length	Diameter		
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		FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.
		STEM NO.	PART NO.		Length	Diameter		
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		FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.
		STEM NO.	PART NO.		Length	Diameter		
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		FERRULE PART NO.	SKIVE		CRIMP DIAMETER	DIE NO.
		STEM NO.	PART NO.		Length	Diameter		
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	
3/4"	XF2SNK-12	212-112	512-500	NO SKIVE		1.320	31MM	(139)
		212-1J-112				1.290	31MM	
1"	XF2SNK-16	216-116	516-500	NO SKIVE		1.650	39MM	(139)

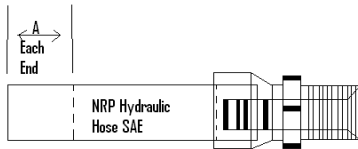
NRP-JONES

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		
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)
	100R15	1211-06	206-1J-106	.845	.885	(133)
	100R16	A150-06	206-1J-106	.845	.850	(58)
	100R17	A151-06	206-1J-106	.845	.825	(58 & 122 & 141)
	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)

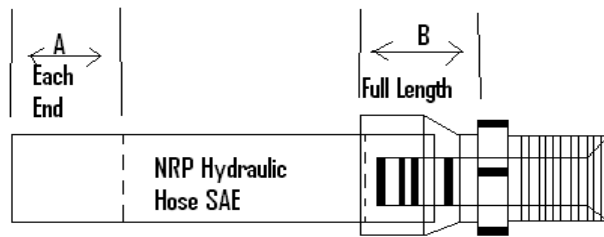
3/4" (7/8")	1 WIRE	A101-12	212-1J-112	1.140	1.250	
	2 WIRE	A102-12	212-1J-112	1.140	1.290	
	100R3	B003-12	212-1J-112	1.140	1.320	(53)
	100R4	2014-12	212-1J-112	1.140	1.290	(53)
	100R5	1005-16	212-1J-112	1.140	1.290	(53)
	100R16	A150-12	212-1J-112	1.140	1.250	(58)
	100R17	A151-12	212-1J-112	1.140	1.290	(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 PART	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

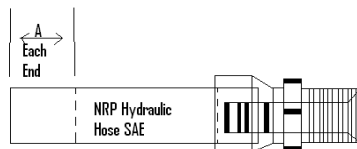
NRP-JONES

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

(106)

HOSE SIZE	SAE SPEC	HOSE PART 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
1/4"	100R5	A005-05	205-1PR5-	.600	.850
(-5)	100R5	A803-05	205-1PR5-	.600	.850
		A360-05	205-1PR5-	.600	
	100R5		205-1PR5B-	.600	
5/16"	100R5	A005-06	206-1PR5-	.700	.875
(-6)	100R5	A803-05	206-1PR5-	.700	.875
		A360-06	206-1PR5-	.720	
	100R5		206-1PR5B-	.700	.875
13/32"	100R5	A005-08	208-1PR5-	.800	1.150
(-8)	100R5	A803-08	208-1PR5-	.800	1.150
		A360-08	208-1PR5-	.830	
	100R5		208-1PR5B-	.800	1.150
1/2"	100R5	A005-10	210-1PR5-	.960	1.100
(-10)	100R5	A803-10	210-1PR5-	.960	1.100
		A360-10	210-1PR5-	.985	
	100R5		210-1PR5B-	.960	1.10
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	
	100R5		212-1PR5B-	1.080	1.15
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

		(97) (107)	(70) (101)				
HOSE SIZ	SAE SPEC	NRP/JONES HOSE PART NO.	SOLID MALE PC 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	1.155	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
	4SH	1312-10SH	"	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	"	1.445	AS NEEDED	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	2.010	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
MUDD DOG	MD5000-32	"	NO	NO	2.740	2-3/4	

•Double Angle Dies

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

Crimp Data for One-Piece Couplings

For NRP-Jones 2020 100R7 and 100R8 Thermoplastic Hose

Hose Size	SAE Spec	Hose Part No.	Solid Male Stem Part No.	"A" Insert Depth	Nominal Crimp Diameter
1/4"	100R7	3107N-04	204-R7-104	1.25	.575
	100R8	3108N-04	204-R7-104	1.25	.575
3/8"	100R7	3107N-06	206-R7-106	1.42	.700
	100R8	3108N-06	206-R7-106	1.42	.700
1/2"	100R7	3107N-08	208-R7-108	1.5	.850
	100R8	3108N-08	208-R7-108	1.5	.850

NRP-JONES

Crimp Data for One-Piece Couplings

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

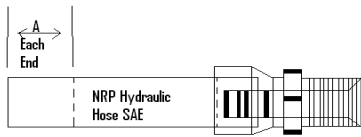
(85)

Hose Size	SAE Spec	Hose Part No.	Solid Male		Nominal Crimp Diameter
			Stem Part No.	"A" Insert Depth	
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
	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
For 100R13 & 100R15 Non-Skive Hose**

(80)
(87)
(100)
(103)

Hose Type	Fitting	No. Wire Lays	SKIVE LENGTH	SKIVE DIA.	Fitting Insertion	Crimp Dim
-10 4SH	610-1Y	4			1.420	1.245
-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	1.82
-16 4SH	616-Y	4			2.560	1.768
-20 100R2	620-Y	2			2.950	2.06
-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 DAWG	1502-*24Y					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
MUDD DAWG	1502-*32Y					2.898
PS5646-32	1502-*32Y		2.75	TO WIRE	3.070	3.114

(132)

(145)

(126)

(104)

(124 & 136)

(104)

(102)

(137)

(138)

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/FERRULE	SKIVE LENGTH	FULL LENGTH CRIMP DIAMETER
3/8	BOP	A822-06	206-106/206-200	0.75"	0.76
1/2	BOP	A822-08	208-108/208-200	0.81"	0.975
3/4	BOP	A822-12	212-112/212-200	1.06"	1.235
1	BOP	A822-16	216-116/216-200	1.13"	1.56
1-1/4	BOP	1822-20	620-1W-120	1.85"	2.125
3/8	BOP	A825-06	206-106/206-200	0.75"	0.76
1/2	BOP	A825-08	208-108/208-200	0.81"	0.975
3/4	BOP	white layline 1825-12	612-1W-112	see note below	1.375"
3/4	BOP	yellow layline 1825-12	612-1W-112	see note below	1.40"
1	BOP	white layline 1825-16	616-1W-116	see note below	1.70"
1	BOP	yellow layline 1825-16	616-1W-116	see note below	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

1825-12: WHITE LAYLINE SKIVE TO BLACK COVER 1.620" (LENGTH) (143)

YELLOW LAYLINE SKIVE TO BLACK COVER 1.620" (LENGTH). SKIVE BLACK COVER TO WIRE 1.445" (LENGTH)

1825-16: WHITE LAYLINE SKIVE TO BLACK COVER 1.84" (LENGTH)

YELLOW LAYLINE SKIVE TO BLACK COVER 1.840" (LENGTH). SKIVE BLACK COVER TO WIRE 1.785" (LENGTH)

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 AB-08 1/2" 12,500psi Hose	0.687	1.5	1.112	26mm
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 1/2" 16,000psi Hose	0.5	1.625	1.173	26mm
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

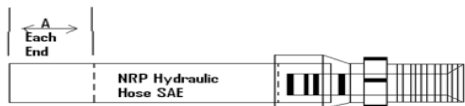
(118)

<u>HOSE</u>	<u>FITTINGS</u>	<u>SKIVE</u>	<u>CRIMP</u>
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-KI	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			
	100R4	2014-16	216-KT	1.660	1.475	35MM	
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	

(129)



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.

IMPORTANT:

The crimp diameters listed are accurate in most applications but not conclusive because of the wide tolerance on the 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. Unless otherwise indicated, crimp specifications have a tolerance of $\pm .005$ "

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 8/60/96)
(9)	Page 8	3/8/94	(addition)
(10)	Page 5	1/20/95	(addition)
(11)	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	9/15/02	(was 1.010)
(19)	Page 15	10/22/92	(addition)
(20)	Page 1 & 5	4/7/93	(was .900)
(21)	Page 1	6/23/93	(was .740)
(22)	Page 11	6/23/92	(addition)
(23)	Page 1 & 5	6/23/92	(was .865)
(24)	Page 2-4	8/25/93	(addition)
(25)	Page 2-4	3/8/94	(addition)
(26)	Page 10	3/8/94	(addition)
(27)	Page 12	1/20/95	(addition)
(28)	Page 2	2/1/95	(piece)
(29)	Page 14	2/15/95	(addition)
(30)	Page 7	4/13/95	(correction)
(31)	Page 13	4/13/95	couplings & correct
(32)	Page 9-11	4/13/95	crimping specs
(33)	Page 2	8/30/96	crimping data
(34)	Page 14	8/30/96	Insert Depths
(35)	Page 11	9/15/03	for 5/8" & add 1-5/8
(36)	Page 1	10/22/93	diameter for A001
(37)	Page 2-4	4/7/94	(added 2014)
(38)	Page 9-11	6/23/94	Add A151-10, A151-12 & A151-16 Chaned pg# to 12a & 12b
(39)	Page 12	6/23/92	2"
(40)	Page 11	6/23/92	from 1.000 to .980
(41)	Page 1	8/25/93	on 3/8"
(42)	Page 5	3/8/94	on 3/8"
(43)	Page 9-11	3/8/94	on 3/8"
(44)	Page 11	1/20/95	on 3/8"
(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 <u>all</u> 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"
(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
128	Page 13	1/17/2020	Removed the 2 wire from the 1P, Page 13
129	Page 26	2/14/2020	Added 1" 2014-16 KT crimp spec
130	Page 1	2/20/2020	Changed 3/16" 100R5CC & 100R5RC crimp spec
131	Page 19	7/20/2020	Added 1312-10SH crimp spec
132	Page 22	8/12/2020	Added -10 4SH with 610-1Y crimp specs
133	Page 14	8/28/2020	Added 1211-06 1J Crimp Spec
134	Page 20	9/17/2020	Added 2020 R7 & R8 Specs
135	Page 19	12/2/2020	Updated Skive Length & Included AS NEEDED
136	Page 23	1/12/2021	Change name to Mudd Dawg
137	Page 23	1/12/2021	Added 2" Mudd Dawg crimp spec
138	Page 23	1/27/2021	Added PS5646-32 Crimp Spec
139	Page 12	7/5/2022	Added XF2SNK-8 & 16

140	Page 19	3/2/2023	corrected crimp dim on 608-1W for R15
141	PAGE 14	4/17/2023	CORRECTED 1J 100R17 3/8" CRIMP DIAMETER
142	PAGE 18	11/1/2023	CORRECTED R5-208-1PR5 CRIMP DIAMETER
143	PAGE 24	3/1/2024	BOP-182512/16 NEW SKIVE LENGTH
144	PAGE 24	3/1/2024	ADDED FITTING INFO FOR 2 PC
145	PAGE 23	8/7/2024	CORRECTED CRIMP DIM ON -16 100R15 616-1Y
146	PAGE 4	9/4/2024	UPDATED 1-1/2 & 2" 100R4