

Crimp Recommendations

The crimp recommendation charts on pages 542-549 are only guides. It will not apply to every coupling situation. In some instances alternative dies and crimping dimensions must be employed to ensure safety. Experience has shown that variances in the construction of similar hoses and couplings may cause some assemblies to react differently when crimped. It is not uncommon to find hose with an outer diameter that fluctuates from one end to the other or from production lot to production lot. These inconsistencies coupled with the inherent differences between textile or wire braid, hard or soft wall, the presence or absence of an internal spiral wire and the differences in hose coverings make it difficult to establish hard and fast rules. Therefore, it is imperative that hose dimensions are accurately measured, assemblies are tested, and documentation is maintained.

Crimped Dix-Lock and Dual-Lock Recommendation Guide

See pages 100 and 102 for the Dix-Lock and Dual-Lock products.

Hose I.D.	Part #	Hose O.D.		Crimp Diameter (±0.005)	Crimp Length		% Reduction	
		Fractional	Decimal		QM/QB	PHL		
1/2"	QM3WF	54/64	0.844	0.925	1-1/8	1-1/4	18.9	
	QB3WF	55/64	0.859	0.940	1-1/8	1-1/4	18.1	
	QM22WF	56/64	0.875	0.950	1-1/8	1-1/4	18.9	
	QB22WF	57/64	0.891	0.965	1-1/8	1-1/4	18.4	
	QM33WF	58/64	0.906	0.975	1-1/8	1-1/4	19.0	
	QB33WF	59/64	0.922	0.990	1-1/8	1-1/4	18.5	
	PHL8WF		60/64	0.938	1.005	1-1/8	1-1/4	18.0
			61/64	0.953	1.015	1-1/8	1-1/4	18.5
			62/64	0.969	1.030	1-1/8	1-1/4	18.1
			63/64	0.984	1.040	1-1/8	1-1/4	18.6
			1	1.000	1.055	1-1/8	1-1/4	18.2
			1-1/64	1.016	1.065	1-1/8	1-1/4	18.8
			1-2/64	1.031	1.080	1-1/8	1-1/4	18.3
3/4"	QM4WF	1-10/64	1.156	1.220		1-1/4	18.5	
	QB4WF	1-11/64	1.171	1.235		1-1/4	18.0	
	QM23WF	1-12/64	1.187	1.244		1-1/4	18.7	
	QB23WF	1-13/64	1.203	1.260		1-1/4	18.1	
	QM44WF	1-14/64	1.218	1.270		1-1/4	18.8	
	QB44WF	1-15/64	1.234	1.285		1-1/4	18.2	
	PHL12WF		1-16/64	1.250	1.295		1-1/4	18.8
			1-17/64	1.265	1.310		1-1/4	18.4
			1-18/64	1.281	1.320		1-1/4	18.8
			1-19/64	1.296	1.335		1-1/4	18.5
			1-20/64	1.312	1.345		1-1/4	19.0
			1-21/64	1.328	1.360		1-1/4	18.5
			1-22/64	1.343	1.370		1-1/4	19.0

Crimped 3500 Nipple Recommendation Guide

See page 233 for the 3500 Nipples.

Hose I.D.	Part #	Hose O.D.		Crimp Diameter (±0.005)	Crimp Length	% Reduction
		Fractional	Decimal			
1/2"	3512WF	54/64	0.844	0.906	1-1/4	21.1
		55/64	0.859	0.906	1-1/4	24.5
		56/64	0.875	0.938	1-1/4	19.3
		57/64	0.891	0.938	1-1/4	22.6
		58/64	0.906	0.969	1-1/4	17.8
3/4"	3514WF	1-10/64	1.156	1.218	1-7/16	17.8
		1-11/64	1.171	1.218	1-7/16	20.7
		1-12/64	1.187	1.218	1-7/16	23.6
		1-13/64	1.203	1.250	1-7/16	19.4
		1-14/64	1.218	1.250	1-7/16	22
1"	3518WF	1-30/64	1.468	1.500	1-15/16	23
		1-31/64	1.484	1.531	1-15/16	19
		1-32/64	1.500	1.531	1-15/16	21.6
		1-33/64	1.515	1.563	1-15/16	17.9
		1-34/64	1.531	1.563	1-15/16	20.3