



## Crimped Hose End Specifications

Recommended Compatible Hose Crimping Machine available at:

[DiscountHydraulicHose.com](http://DiscountHydraulicHose.com)

Part number: D100H Hand Operated Portable Hose Crimper

The Die part numbers and micrometer settings are as follows:

- 04 D100-10MM-Black (2.14)
- 06 and -08 D100-16MM-Orange (.35)
- 10 D100-22M-Brown (3.05)
- 12 D100-25mm-Green (0.5)
- 16 D100-31MM-Silver (2.83)

Finished Crimp Diameter Specifications for **Phenix Double Swivel Crimp Type Hose Ends**  
Compatible Phenix Hose: K100, K400 and K4400 series.

Braided Hose Size	Finished Crimp Diameter (+/- 0.005)
-04	0.475
-06	0.640
-08	0.753
-10	0.930
-12	1.065
-16	1.300

Finished Crimp Diameter Specifications for **Phenix PTFE Crimp Type Hose Ends**  
Compatible Phenix Hose: K300 Series

PTFE Hose Size	Finished Crimp Diameter
-03	0.300 - 0.305
-04	0.350 - 0.355
-06	0.478 - 0.483
-08	0.568 - 0.573
-10	0.673 - 0.678

It is common practice to use a light lubricant on the die jaws as well as the crimp collar. The collar must be positioned evenly inside the die and completely cover the entire length of the collar with only the bevel showing.

Final measurement of the finished crimp is taken at the small inner diameter between the crimp ridges. Each crimp must be checked and the final assembly should be pressure tested to twice the system operation pressure.