

# Crimp Specifications for



## **KURIYAMA Hydraulic Connections** **Hydraulic Hose and Fittings**



**KuriCrimp KC1-H47PI**



**KuriCrimp KC1-H83**



**KuriCrimp KC4-V59**



**KuriCrimp KC4-V159**



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# KuriCrimp™ Tool Selection Guide

## ***Glossary of Terms:***

Skive — Removal of the hose cover by way of knife hand tool, brush wheel or other method, exposing the uppermost layer of reinforcement prior to crimping.

Skive Length — Area to be skived prior to crimping.

Crimp Diameter — The measured outside diameter of the ferrule or shell - measuring the FLAT SURFACES of the crimped ferrule or shell. Acceptable range of tolerance for Alfagomma and Piranhaflex is +/- .005 inches.



Crimping specifications for this unit and these instructions were developed using ALFAGOMMA® hydraulic hose and couplings. Kuriyama of America and ALFAGOMMA® recommend using only the hose and coupling combinations specified in the current Kuriyama of America ALFAGOMMA® catalog and the crimp specifications for these KuriCrimp™ units. Be sure

to read and follow the instructions in the KuriCrimp™ Operations Guide, the instructions beneath the word "Important" below, and the specifications in the KuriCrimp™ Tool Selection Guide which appear on the following pages. Failure to act consistent with any of the above can result in serious bodily injury or damage.

## ***Important!***

The Micro Crimp adjuster setting values shown on this chart are APPROXIMATE SETTINGS only and should be used only as a starting point. Due to differences in calibration and metal surface machining tolerances, the Micro Crimp setting may require adjustment. It is highly recommended that the finished crimp diameter of each assembly made be measured with calipers to determine if adjustment is necessary. To determine actual setting, measure the crimp diameter of the crimped assembly end. To tighten the crimp diameter, adjust the setting to a higher value. To increase (enlarge) the finished crimp diameter, adjust the setting to a lower value.

The column labeled "Actual" adjacent to the "Approx" column in the tables has been provided to give the user a place to record his own ideal Micro Crimp setting.



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360 E. State Parkway, Schaumburg, IL 60173-5335  
Phone: (847) 755-0360 • Toll-free Fax: (800) 800-0320  
International Fax: (847) 885-0996

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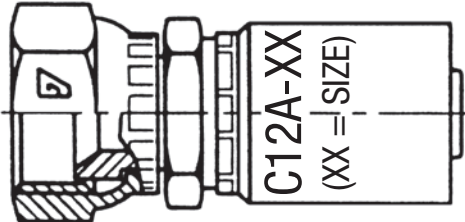
[kuriyama.com](http://kuriyama.com)

## Flexibility of the Alfacrimp System

The Alfacrimp system gives the hose assembler options to stock inventory that best suits their needs. The B series fitting is used on all wire braided style hoses up through 1" ID.

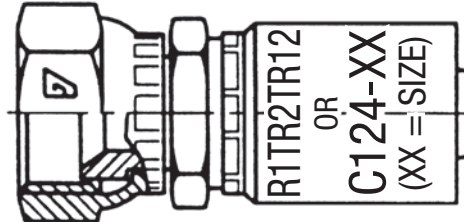
D fitting can be used on the hoses listed below so that there is no need to stock both braided-style fittings and spiral-style fittings.

### (B) Series



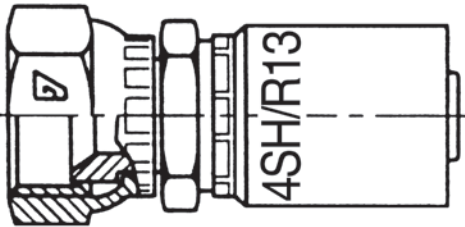
All Alfagomma  
Wire Braided Hose Up  
To 1" ID Size

### (D) Series



TR1MT-20 thru -32  
TR2MT-08 thru -32  
TF2MT-16 thru -32  
T1SNTT-12 thru -32  
T2SNTT-06 thru -32  
ABT3K-20 thru -32  
ABT4K-06 thru -20  
ABT5K-16

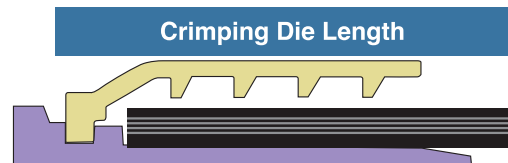
### (F) Series



ABT4K-32  
ABT5K-12 thru -32  
ABT6K-12 thru -20

Note: All Alfagomma crimp fittings require a full length crimp that crimps the entire length of the ferrule including the pre-crimped portion of all one piece fittings. Finished crimps are not to have a bubble at the top or a skirt at the back. Finished crimps should be 100% flat. See illustrations below.

#### BEFORE CRIMPING



#### AFTER CRIMPING



## TR1MT, TR1HT - R1/1SN MINETUFF and HIGH TEMP B & D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.685	17.4	16	1.40
B-05xx	5/16	17.0	0.752	19.1	19	0.10
B-06xx	3/8	18.0	0.835	21.2	19	2.20
B-08xx	1/2	20.0	0.969	24.6	22	2.60
B-10xx	5/8	21.0	1.098	27.9	25	2.90
B-12xx	3/4	24.0	1.248	31.7	29	2.70
B-16xx	1	24.0	1.535	39.0	38	1.00
D-20xx	1 1/4	39.0	1.957	49.7	46	3.70
D-24xx	1 1/2	50.0	2.232	56.7	54	2.70
D-32xx	2	58.0	2.736	69.5	69	0.50

## T1SNTT - R1/1SN TEMP TECH B & D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.685	17.4	16	1.40
B-06xx	3/8	18.0	0.846	21.5	19	2.50
B-08xx	1/2	20.0	0.980	24.9	22	2.90
B-12xx	3/4	24.0	1.264	32.1	29	3.10
B-16xx	1	24.0	1.547	39.3	38	1.30
D-12xx	3/4	32.0	1.386	35.2	34	1.20
D-16xx	1	39.0	1.697	43.1	42	1.10
D-20xx	1 1/4	39.0	1.992	50.6	50	0.60
D-24xx	1 1/2	50.0	2.232	56.7	54	2.70
D-32xx	2	58.0	2.764	70.2	69	1.20

## TR2MT, TR2HT - R2/2SN MINETUFF and HIGH TEMP B & D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.717	18.2	16	2.20
B-05xx	5/16	17.0	0.791	20.1	19	1.10
B-06xx	3/8	18.0	0.878	22.3	22	0.30
B-08xx	1/2	20.0	1.016	25.8	25	0.80
B-10xx	5/8	21.0	1.130	28.7	25	3.70
B-12xx	3/4	24.0	1.276	32.4	29	3.40
B-16xx	1	24.0	1.567	39.8	38	1.80
D-08xx	1/2	26.0	1.098	27.9	25	2.90
D-10xx	5/8	29.0	1.228	31.2	29	2.20
D-12xx	3/4	32.0	1.406	35.7	34	1.70
D-16xx	1	39.0	1.709	43.4	42	1.40
D-20xx	1 1/4	39.0	2.055	52.2	50	2.20
D-24xx	1 1/2	50.0	2.327	59.1	58	1.10
D-32xx	2	58.0	2.835	72.0	69	3.00

## T2SNTT - R2/2SN TEMP TECH B & D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.724	18.4	16	2.40
B-06xx	3/8	18.0	0.890	22.6	22	0.60
<b>D-08xx</b>	1/2	26.0	1.098	27.9	25	2.90
B-12xx	3/4	24.0	1.295	32.9	29	3.90
B-16xx	1	24.0	1.583	40.2	38	2.20
D-06xx	3/8	21.0	0.945	24.0	22	2.00
D-08xx	1/2	26.0	1.098	27.9	25	2.90
D-12xx	3/4	32.0	1.413	35.9	34	1.90
D-16xx	1	39.0	1.720	43.7	42	1.70
D-20xx	1 1/4	39.0	2.079	52.8	50	2.80
D-24xx	1 1/2	50.0	2.346	59.6	58	1.60
D-32xx	2	58.0	2.854	72.5	69	3.50

## TF2MT, TF2TL, TF2ST, TF2LT - FLEXOPAK 2/R16/2SC B & D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.693	17.6	16	1.60
B-05xx	5/16	17.0	0.760	19.3	19	0.30
B-06xx	3/8	18.0	0.843	21.4	19	2.40
B-08xx	1/2	20.0	0.996	25.3	25	0.30
B-10xx	5/8	21.0	1.106	28.1	25	3.10
B-12xx	3/4	24.0	1.260	32.0	29	3.00
B-16xx	1	24.0	1.551	39.4	38	1.40
D-16xx	1	39.0	1.701	43.2	42	1.20
D-20xx	1 1/4	39.0	1.937	49.2	46	3.20
D-24xx	1 1/2	50.0	2.244	57.0	54	3.00
D-32xx	2	58.0	2.764	70.2	69	1.20

## TF2HO - HOT OILER HOSE D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
D-24xx	1 1/2	50	2.244	57.0	54	3.00

## AT3KMT & AT3KST - ALFATECH 3000/R17 B SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.661	16.8	16	0.80
B-06xx	3/8	18.0	0.811	20.6	19	1.60
B-08xx	1/2	26.0	0.937	23.8	22	1.80
B-10xx	5/8	24.0	1.106	28.1	25	3.10
B-12xx	3/4	28.0	1.260	32.0	29	3.00
B-16xx	1	36.0	1.551	39.4	38	1.40

## AT10KJ - 10,000 PSI JACK HOSE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.693	17.6	16	1.60
B-06xx	3/8	18.0	0.843	21.4	19	2.40

## ABT3K - ALFABIOTECH 3000/R12 D SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
D-20xx	1 1/4	39.0	2.039	51.8	50	1.80
D-24xx	1 1/2	50.0	2.299	58.4	58	0.40
D-32xx	2	58.0	2.886	73.3	73	0.30

## ABT4K - ALFABIOTECH 4000/R12 D & F SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
D-06xx	3/8	21.0	0.965	24.5	22	2.50
D-08xx	1/2	26.0	1.110	28.2	25	3.20
D-10xx	5/8	29.0	1.256	31.9	29	2.90
D-12xx	3/4	32.0	1.406	35.7	34	1.70
D-16xx	1	39.0	1.720	43.7	42	1.70
D-20xx	1 1/4	39.0	2.040	51.8	50	1.80
F-32xx	2	88.0	2.984	75.8	73	2.80

## ABT5K - ALFABIOTECH 5000/R13 D, F & M SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
D-16xx	1	39.0	1.732	44.0	42	2.00
F-12xx	3/4	49.0	1.429	36.3	34	2.30
F-16xx	1	56.0	1.697	43.1	42	1.10
F-20xx‡	1 1/4	84.0	2.071	52.6	50	2.60
F-20xx†	1 1/4	84.0	2.142	54.4	54	0.40
F-24xx#	1 1/2	75.0	2.492	63.3	63	0.30
F-24xx**	1 1/2	75.0	2.457	62.4	60	2.40
F-32xx	2	88.0	3.059	77.7	77	0.70
M-32xx	2	88.0	3.059	77.7	77	0.70

‡Crimp Diameter Valid for Hose Marked Until End 2016, †Crimp Diameter Valid for Hose Marked From 2017,  
 #Crimp Diameter Valid for Hose Marked Until End 2018, \*\*Crimp Diameter Valid for Hose Marked From 2019



## ABT6K - ALFABIOTECH 6000/R15 F SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
F-12xx	3/4	49.0	1.453	36.9	34	2.90
F-16xx	1	56.0	1.732	44.0	42	2.00
F-20xx	1 1/4	84.0	2.236	56.8	54	2.80

## TAJ3BK/BU - ALFAJET 210 and KK4BK/BU K-Kleen 4000 Pressure Washer B SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.661	16.8	16	0.80
B-06xx	3/8	18.0	0.811	20.6	19	1.60
B-08xx	1/2	26.0	0.937	23.8	22	1.80

## TAJ5BK/BU - ALFAJET 400 Pressure Washer B SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
B-04xx	1/4	17.0	0.697	17.7	16	1.70
B-06xx	3/8	18.0	0.835	21.2	19	2.20
B-08xx	1/2	20.0	0.976	24.8	22	2.80

## FLEXOR RIG F & M SERIES ONE-PIECE NON-SKIVE

FITTING PART NUMBER	SIZE ID (in)	INSERT LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
F-16xx	1	56.0	1.728	43.9	42	1.90
F-20xx†	1 1/4	84.0	2.071	52.6	50	2.60
F-20xx‡	1 1/4	84.0	2.272	57.7	54	3.70
F-24xx†	1 1/2	75.0	2.492	63.3	63	0.30
F-24xx‡	1 1/2	75.0	2.528	64.2	63	1.20
F-32xx	2	88.0	3.059	77.7	77	0.70
M-32xx	2	88.0	3.071	77.7	77	1.00

‡Crimp Diameter Valid for Hose Marked Until 2Q 2016, †Crimp Diameter Valid for Hose Marked After 2Q 2016

## PIRANHAFLEX™ PF354/PF354NC-02 (USING ONE-PIECE FITTING)

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
F02NPT2	1/8	0.365	9.27	9†	0.27

† Special die size, consult factory for price and availability

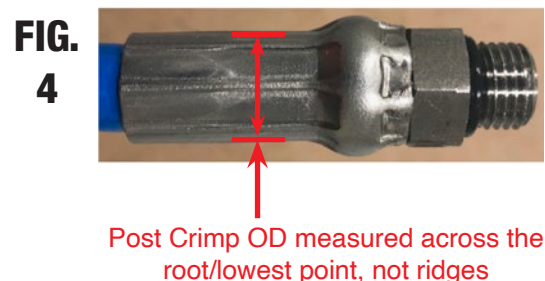
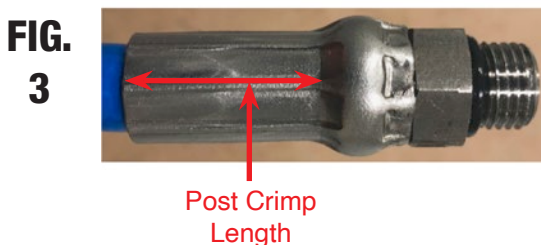
## PIRANHAFLEX™ PF321TC (USING ONE-PIECE) STAINLESS STEEL FITTINGS

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX	#1) Pre Crimp - Crimp position from bottom of Ferrule measured up	#2) Post Crimp Length (INCHES) (+/-0.010)
*P-03XX	3/16	0.515	*13.10	13†	0.10	0.750	0.900
P-04XX	1/4	0.590	14.99	14	0.99	1.125	1.250

*\*PF321TC-03 "MUST" be crimped using a true 13mm die to achieve a proper crimp*

† Special die size, consult factory for price and availability

- This is "NOT" a full ferrule crimp and the crimp location is measured from the ferrule bottom up towards the connection (see figures 1 & 2)
- Refer to the above crimp table for proper crimp diameter and set up crimper accordingly.
- Measure finished crimp length as shown in figure 3.
- Measure finished crimp diameter (across the flats/roots) (see figure 4). The finish crimp should be within +/- tolerances called out in the table above.
- Both the "post crimp diameter" and "post crimp length" must be measured and within tolerances to assure a proper crimp.

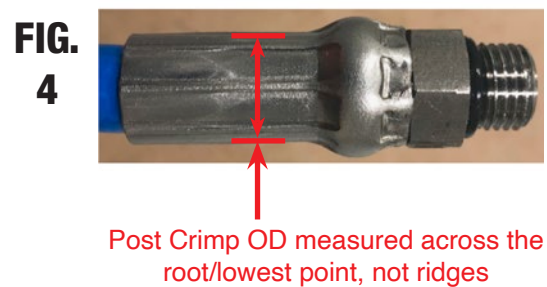
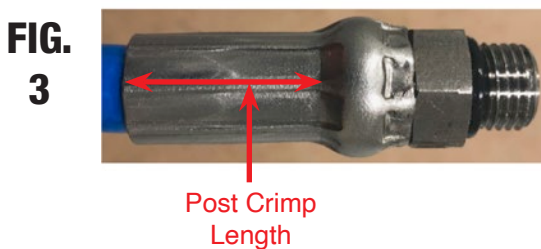
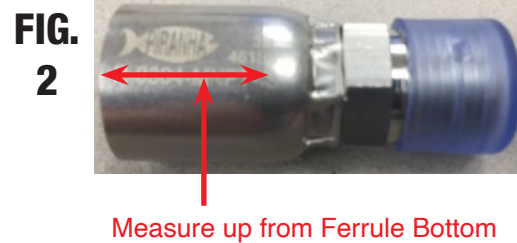


## PIRANHAFLEX™ PF267/PF267NC/PF354/PF354NC/PFP354/ PFP354NC (USING ONE-PIECE STAINLESS STEEL FITTINGS)

FITTING SERIES	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.127	DIE SIZE	METRIC MICROMETER APPROX	#1) Pre Crimp - Crimp position from bottom of Ferrule measured up	#2) Post Crimp Length (INCHES) (+/-0.010)
* P-03XX	3/16	0.530	*13.46	13	0.46	0.750	0.900
P-04XX	1/4	0.590	14.99	14	0.99	1.250	1.250

\* PF267/PF267NC/PF354/PF354NC/PFP354/PFP354NC "MUST" be crimped using a true 13mm die to achieve a proper crimp

- This is "NOT" a full ferrule crimp and the crimp location is measured from the ferrule bottom up towards the connection (see figures 1 & 2)
- Refer to the above crimp table for proper crimp diameter and set up crimper accordingly.
- Measure finished crimp length as shown in figure 3. The finish crimp length should be within the +/- tolerances called out in the table above.
- Measure finished crimp diameter (across the flats/roots) (see figure 4). The finish crimp should be within +/- tolerances called out in the table above.
- Both the "post crimp diameter" and " post crimp length" must be measured and within tolerances to assure a proper crimp.



## PIRANHAFLEX™ PF344LMT (USING ONE-PIECE STAINLESS STEEL FITTINGS)

FITTING SERIES	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX	#1) Pre Crimp - Crimp position from bottom of Ferrule measured up	#2) Post Crimp Length (INCHES) (+/- 0.010)
P-04XX	1/4	0.590	14.99	14	0.99	1.250	1.250

## PIRANHAFLEX™ PF427/PF427NC (USING ONE-PIECE STAINLESS STEEL FITTINGS)

FITTING SERIES	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX	#1) Pre Crimp - Crimp position from bottom of Ferrule measured up	#2) Post Crimp Length (INCHES) (+/- 0.010)
P-04XX	1/4	0.590	14.99	14	0.99	1.250	1.250

- This is "NOT" a full ferrule crimp and the crimp location is measured from the ferrule bottom up towards the connection (see figures 1 & 2)
- Refer to the above crimp table for proper crimp diameter and set up crimper accordingly.
- Measure finished crimp length as shown in figure 3. The finish crimp length should be within the +/- tolerances called out in the table above.
- Measure finished crimp diameter (across the flats/roots) (see figure 4). The finish crimp should be within +/- tolerances called out in the table above.
- Both the "post crimp diameter" and "post crimp length" must be measured and within tolerances to assure a proper crimp.

**FIG. 1**



Ferrule Bottom

Connection

**FIG. 2**



Measure up from Ferrule Bottom

**FIG. 3**



Post Crimp Length

**FIG. 4**



Post Crimp OD measured across the root/lowest point, not ridges

## PIRANHAFLEX™ PF628/PF628NC (USING ONE-PIECE STAINLESS STEEL FITTINGS)

FITTING SERIES	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX	#1) Pre Crimp - Crimp position from bottom of Ferrule measured up	#2) Post Crimp Length (INCHES) (+/- 0.010)
*P-03XX	3/16	0.515	*13.1	13	0.10	0.750	0.900
P-04XX	1/4	0.560	14.22	14	0.22	1.250	1.250

\* PF354/PF354NC/PFP354/PF354NC/PF267/PF267NC "MUST" be crimped using a true 13mm die to achieve a proper crimp

- This is "NOT" a full ferrule crimp and the crimp location is measured from the ferrule bottom up towards the connection (see figures 1 & 2)
- Refer to the above crimp table for proper crimp diameter and set up crimper accordingly.
- Measure finished crimp length as shown in figure 3. The finish crimp length should be within the +/- tolerances called out in the table above.
- Measure finished crimp diameter (across the flats/roots) (see figure 4). The finish crimp should be within +/- tolerances called out in the table above.
- Both the "post crimp diameter" and "post crimp length" must be measured and within tolerances to assure a proper crimp.

**FIG. 1**



Ferrule Bottom

Connection

**FIG. 2**



Measure up from Ferrule Bottom

**FIG. 3**



Post Crimp Length

**FIG. 4**



Post Crimp OD measured across the root/lowest point, not ridges

# Piranhaflex™ T400 Tool Selector Guide

Refer to the Piranhaflex™ Tool Selector Chart to choose the correct Die Size, Spacer along with the Main Pusher Plate for the correct size Piranhaflex™ hose you are going to crimp.

## PF354/PF354NC/PFP354/PFP354NC/PF367/PF367NC/PF267/PF267NC/PFAN388NC/PFLT364 – TWO-PIECE A INSERT + PFR FERRULE

	PFR-03	PFR-04	PFR7-05*	PFR-06	PFR-08
Crimp Spec	12.07	14.22	15.75	17.78	22.23
Die Size	12	14.2	14.2	17.4	22.2
Die Color	Purple	Yellow	Yellow	Orange	Blue
Spacer	None	None	#2	#1	None
Pusher Plate	Nose Up	Nose Up	Nose Down	Nose Down	Nose Up

\*PFR7-05 ferrules are to be used only with SAE 100R7 hoses!

## PF628/PF628NC/PF321TC – TWO-PIECE A INSERT + PFR FERRULE

	PFR-03	PFR-04	PFR-06	PFR-08
Crimp Spec	12.01	13.84	17.4	22.48
Die Size	12	12	17.4	22.2
Die Color	Purple	Purple	Orange	Blue
Spacer	None	#2	None	#1
Pusher Plate	Nose Up	Nose Down	Nose Up	Nose Down

## PF427/PF427NC – TWO-PIECE A INSERT + PFR FERRULE

	PFR-04	PFR-06	PFR-08
Crimp Spec	14.22	17.78	22.48
Die Size	14.2	17.4	22.2
Die Color	Yellow	Orange	Blue
Spacer	None	#1	#1
Pusher Plate	Nose Up	Nose Down	Nose Down

## PF344LMT – TWO-PIECE A INSERT + PFR FERRULE

	PFR-04	PFR-06	PFR-08
Crimp Spec	14.22	17.78	22.23
Die Size	14.2	17.4	22.2
Die Color	Yellow	Orange	Blue
Spacer	None	#1	#1
Pusher Plate	Nose Up	Nose Down	Nose Up

## PIRANHAFLEX™ PF354/PF354NC/PFP354/PFP354NC/PF367/ PF367NC/PF267/PF267NC/PFAN388NC/PFLT364 (USING TWO-PIECE) A INSERT + PFR FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
PFR-03	3/16	0.475	12.07	12	0.07
PFR-04	1/4	0.560	14.22	14	0.22
PFR7-05*	5/16	0.620	15.75	14	1.75
PFR-06	3/8	0.700	17.78	16	1.78
PFR-08	1/2	0.875	22.23	22	0.23
PFR-12	3/4	1.150	29.21	29	0.21

\*PFR7-05 ferrules are to be used only with SAE 100R7 hoses!

## PIRANHAFLEX™ PF151R3/PF415CP (USING TWO-PIECE) A INSERT + PFR3 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
PFR3-04	1/4	0.500	12.70	12	0.70
PFR3-05	5/16	0.600	15.24	14	1.24
PFR3-06	3/8	0.665	16.89	16	0.89
PFR3-08	1/2	0.780	19.81	19	0.81

## PIRANHAFLEX™ PF628/PF628NC/PF321TC (USING TWO-PIECE) A INSERT + PFR FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
PFR-03	3/16	0.473	12.01	12	0.01
PFR-04	1/4	0.545	13.84	12	1.84
PFR-06	3/8	0.685	17.40	16	1.40
PFR-08	1/2	0.885	22.48	22	0.48
PFR-12	3/4	1.150	29.21	29	0.21

## PIRANHAFLEX™ PF528/PF528NC (USING TWO-PIECE) A INSERT + AFX FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AFX-04	1/4	0.700	17.78	16	1.78
AFX-06	3/8	0.845	21.46	20†	1.46
AFX-08	1/2	0.975	24.76	24†	0.76
AFX-12	3/4	1.280	32.51	31†	1.51

† Special die size, consult factory for price and availability

## PIRANHAFLEX™ PF427/PF427NC (USING TWO-PIECE) A INSERT + PFR FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
PFR-04	1/4	0.560	14.22	14	0.22
PFR-06	3/8	0.700	17.78	16	1.78
PFR-08	1/2	0.885	22.48	22	0.48

## PIRANHAFLEX™ PF344LMT (USING TWO-PIECE) A INSERT + PFR/AFX FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
PFR-04	1/4	0.560	14.22	14	0.22
PFR-06	3/8	0.700	17.78	16	1.78
PFR-08	1/2	0.875	22.23	22	0.23
AFX-12	3/4	1.225	31.12	31†	0.12
AFX-16	1	1.600	40.64	39†	1.64

† Special die size, consult factory for price and availability



## TR1MT, TR1HT - R1/1SN MINETUFF and HIGH TEMP TWO-PIECE A INSERT + AF1 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF1-03	3/16	0.583	14.8	14	0.80
AF1-04	1/4	0.677	17.2	16	1.20
AF1-05	5/16	0.744	18.9	16	2.90
AF1-06	3/8	0.843	21.4	19	2.40
AF1-08	1/2	0.972	24.7	22	2.70
AF1-10	5/8	1.094	27.8	25	2.80
AF1-12	3/4	1.248	31.7	29	2.70
AF1-16	1	1.551	39.4	38	1.40
AF1-20	1 1/4	1.870	47.5	46	1.50
AF1-24	1 1/2	2.142	54.4	54	0.40
AF1-32	2	2.677	68.0	63	5.00

## TR1MT, TR1HT - R1/1SN MINETUFF and HIGH TEMP TWO-PIECE A INSERT + AF2 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF2-16	1	1.527	38.8	38	0.40

## T1SN TT - R1/1SN TEMP TECH TWO-PIECE A INSERT + AF1 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF1-04	1/4	0.677	17.2	16	1.20
AF1-06	3/8	0.850	21.6	19	2.60
AF1-08	1/2	0.984	25.0	22	3.00
AF1-12	3/4	1.264	32.1	29	3.10
AF1-16	1	1.563	39.7	38	1.70
AF1-20	1 1/4	1.894	48.1	46	2.10
AF1-24	1 1/2	2.150	54.6	54	0.60
AF1-32	2	2.717	69.0	69	0.00

## TR2MT, TR2HT - R2/2SN MINETUFF and HIGH TEMP TWO-PIECE A INSERT + AF2 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF2-04	1/4	0.717	18.2	16	2.20
AF2-05	5/16	0.791	20.1	19	1.10
AF2-06	3/8	0.878	22.3	22	0.30
AF2-08	1/2	1.000	25.4	25	0.40
AF2-10	5/8	1.134	28.8	25	3.80
AF2-12	3/4	1.280	32.5	29	3.50
AF2-16	1	1.571	39.9	38	1.90
AF2-20	1 1/4	1.953	49.6	46	3.60
AF2-24	1 1/2	2.232	56.7	54	2.70
AF2-32	2	2.787	70.8	69	1.80

## T2SNTT - R2/2SN TEMP TECH TWO-PIECE A INSERT + AF2 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF2-04	1/4	0.724	18.4	16	2.40
AF2-06	3/8	0.890	22.6	22	0.60
AF2-08	1/2	1.016	25.8	25	0.80
AF2-12	3/4	1.299	33.0	29	4.00
AF2-16	1	1.583	40.2	38	2.20
AF2-20	1 1/4	1.976	50.2	50	0.20
AF2-24	1 1/2	2.248	57.1	54	3.10
AF2-32	2	2.803	71.2	69	2.20

<b>TR4XF (T634AA) and (T604AA) - R4 TWO-PIECE A INSERT + AFX NON-SKIVE FERRULE</b>						(Can also be used with T202, T605, T616, T632 and T644)
FERRULE PART NUMBER	SIZE ID (in)	EXTERNAL DIAMETER HOSE (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm)	DIE SIZE	METRIC MICROMETER APPROX.
AFX-12	3/4	27.5	1.268	32.2	31	1.20
		28.0	1.283	32.6		1.60
		28.5	1.295	32.9		1.90
		29.0	1.311	33.3		2.30
		29.5	1.327	33.7		2.70
		30.0	1.343	34.1	34	0.10
		30.5	1.354	34.4		0.40
AFX-16	1	33.5	1.531	38.9	38	0.90
		34.0	1.547	39.3		1.30
		34.5	1.559	39.6		1.60
		35.0	1.575	40.0		2.00
		35.5	1.591	40.4		2.40
		36.0	1.606	40.8		2.80
		36.5	1.618	41.1		3.10
AFX-20	1 1/4	40.5	1.768	44.9	42	2.90
		41.0	1.783	45.3		3.30
		41.5	1.795	45.6		3.60
		42.0	1.811	46.0	46	0.00
		42.5	1.827	46.4		0.40
		43.0	1.843	46.8		0.80
		43.5	1.854	47.1		1.10
AFX-24	1 1/2	46.5	2.016	51.2	50	1.20
		47.0	2.031	51.6		1.60
		47.5	2.043	51.9		1.90
		48.0	2.059	52.3		2.30
		48.5	2.075	52.7		2.70
		49.0	2.091	53.1		3.10
		49.5	2.102	53.4		3.40

**TR4XF (T634AA) and (T604AA) - R4 (continued)**  
**TWO-PIECE A INSERT + AFX NON-SKIVE FERRULE**

(Can also be used with T202, T605, T616, T632 and T644)

FERRULE PART NUMBER	SIZE ID (in)	EXTERNAL DIAMETER HOSE (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm)	DIE SIZE	METRIC MICROMETER APPROX.
AFX-32	2	59.5	2.559	65.0	63	2.00
		60.0	2.575	65.4		2.40
		60.5	2.587	65.7		2.70
		61.0	2.602	66.1		3.10
		61.5	2.618	66.5		3.50
		62.0	2.634	66.9		3.90
		62.5	2.646	67.2		4.20
AFX-40	2 1/2	73.5	3.106	78.9	77	1.90
		74.0	3.118	79.2		2.20
		74.5	3.134	79.6		2.60
		75.0	3.146	79.9		2.90
		75.5	3.161	80.3		3.30
		76.0	3.173	80.6		3.60
		75.6	3.189	81.0		4.00

## TR5, TR5HT, TR5TT - R5/R5 HIGH TEMP and TEMP TECH TWO-PIECE A INSERT + AFX NON-SKIVE FERRULE

HOSE SERIES NUMBER	FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
TR5-04	AFX-03	3/16	0.654	16.6	16	0.60
TR5-05	AFX-04	1/4	0.728	18.5	16	2.50
TR5-06	AFX-05	5/16	0.819	20.8	19	1.80
TR5-08	AFX-06	13/32	0.925	23.5	22	1.50
TR5-10	AFX-08	1/2	1.031	26.2	25	1.20
TR5-12	AFX-10	5/8	1.185	30.1	29	1.10
TR5-16	AFX-12	7/8	1.362	34.6	34	0.60
TR5-20	AFX-16	1 1/8	1.669	42.4	42	0.40
TR5-24	AFX-20	1 3/8	1.874	47.6	46	1.60
TR5-32	AFX-32	1 13/16	2.441	62.0	60	2.00

HOSE SERIES NUMBER	DASH SIZE	SIZE ID (in)	PART NUMBER	INSERTS			
				OTHER TYPES	NPT MALE	JIC FEMALE SWIVEL	JIC 90° FEMALE SWIVEL
TR5-04	04	3/16	AFX-03	A-03XX-XXXX	A-0302-MNPT	A-0304-FJDH	A-0304-FJ9M
TR5-05	05	1/4	AFX-04	A-04XX-XXXX	A-0404-MNPT	A-0404-FJDH	A-0404-FJ9M
TR5-06	06	5/16	AFX-05	A-05XX-XXXX	A-0506-MNPT	A-0506-FJDH	A-0506-FJ9M
TR5-08	08	13/32	AFX-06	A-06XX-XXXX	A-0606-MNPT	A-0606-FJDH	A-0606-FJ9M
TR5-10	10	1/2	AFX-08	A-08XX-XXXX	A-0808-MNPT	A-0808-FJDH	A-0808-FJ9M
TR5-12	12	5/8	AFX-10	A-10XX-XXXX	A-1012-MNPT	A-1012-FJDH	A-1012-FJ9M
TR5-16	16	7/8	AFX-12	A-14XX-XXXX	A-1416-MNPT	A-1416-FJDH	-
TR5-20	20	1 1/8	AFX-16	A-18XX-XXXX	A-1820-MNPT	A-1820-FJDH	-
TR5-24	24	1 3/8	AFX-20	A-22XX-XXXX	A-2224-MNPT	A-2224-FJDH	-
TR5-32	32	1 13/16	AFX-32	A-29XX-XXXX	A-2932-MNPT	A-2932-FJDH	-

## TF2MT, TF2TL, TF2ST, TF2LT - FLEXOPAK 2/R16/2SC TWO-PIECE A INSERT + AF1 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF1-04	1/4	0.685	17.4	16	1.40
AF1-05	5/16	0.744	18.9	16	2.90
AF1-06	3/8	0.839	21.3	19	2.30
AF1-08	1/2	0.988	25.1	25	0.10
AF1-10	5/8	1.098	27.9	25	2.90
AF1-12	3/4	1.248	31.7	29	2.70
AF1-16	1	1.567	39.8	38	1.80
AF1-20	1 1/4	1.854	47.1	46	1.10
AF1-24	1 1/2	2.154	54.7	54	0.70
AF1-32	2	2.697	68.5	63	5.50

## TF2MT, TF2ST, TF2LT - FLEXOPAK 2/R16/2SC TWO-PIECE A INSERT + AF2 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF2-12	3/4	1.248	31.7	29	2.70
AF2-16	1	1.543	39.2	38	1.20

## AT3KMT, AT3KST - ALFATECH 3000/R17 TWO-PIECE A INSERT + AF1 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF1-04	1/4	0.650	16.5	16	0.50
AF1-06	3/8	0.803	20.4	19	1.40
AF1-08	1/2	0.941	23.9	22	1.90
AF1-10	5/8	1.098	27.9	25	2.90
AF1-12	3/4	1.248	31.7	29	2.70
AF1-16	1	1.567	39.8	38	1.80

## AT3KMT, AT3KST - ALFATECH 3000/R17 TWO-PIECE A INSERT + AF2 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER SETTING APPROX
AF2-12	3/4	1.248	31.7	29	2.70
AF2-16	1	1.543	39.2	38	1.20

## ABT3K - ALFABIOTECH 3000/R12 TWO-PIECE A INSERT + AF4 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AF4-20	1 1/4	2.039	51.8	50	1.80
AF4-24	1 1/2	2.299	58.4	58	0.40

## ABT4K - ALFABIOTECH 4000/R12 TWO-PIECE A INSERT + AF4 NON-SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AF4-06	3/8	N/A	0.965	24.5	22	2.50
AF4-08	1/2	N/A	1.110	28.2	25	3.20
AF4-10	5/8	N/A	1.217	30.9	29	1.90
AF4-12	3/4	N/A	1.406	35.7	34	1.70
AF4-16	1	N/A	1.709	43.4	42	1.40
AF4-20	1 1/4	N/A	2.039	51.8	50	1.80

## ABT4K - ALFABIOTECH 4000/R12 TWO-PIECE A INSERT + AS4 EXTERNAL SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AS4-06	3/8	19.0 OD	0.866	22.0	19	3.00
AS4-08	1/2	25.0 OD	1.035	26.3	25	1.30
AS4-10	5/8	28.0 OD	1.138	28.9	25	3.90
AS4-12	3/4	33.0 OD	1.272	32.3	29	3.30
AS4-16	1	37.0 OD	1.610	40.9	38	2.90

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## ABT4K - ALFABIOTECH 4000 TWO-PIECE INTERLOCK X INSERT + XF2 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF2-24	1 1/2	81.0 OD 22.0 ID	2.252	57.2	54	3.20
XF2-32	2	85.0 OD 29.0 ID	2.886	73.3	73	0.30

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## ABT5K - ALFABIOTECH 5000/R13 TWO-PIECE A INSERT + AS4 EXTERNAL SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AS4-10	5/8	28.0 OD	1.138	28.9	25	3.90
AS4-12	3/4	33.0 OD	1.311	33.3	31	2.30
AS4-16	1	37.0 OD	1.622	41.2	38	3.20

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.



## ABT5K - ALFABIOTECH 5000/R13 TWO-PIECE INTERLOCK X INSERT + XF1 or XF2 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF2-12	3/4	52.0 OD 15.0 ID	1.323	33.6	31	2.60
XF2-16	1	65.0 OD 17.0 ID	1.642	41.7	38	3.70
XF2-20‡	1 1/4	74.0 OD 22.0 ID	1.957	49.7	46	3.70
XF2-20†	1 1/4	74.0 OD 22.0 ID	2.004	50.9	50	0.90
XF1-24#	1 1/2	81.0 OD 22.0 ID	2.488	63.2	63	0.20
XF1-24**	1 1/2	81.0 OD 22.0 ID	2.441	62.0	60	2.00
XF1-32	2	85.0 OD 29.0 ID	3.173	80.6	77	3.60

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

‡Crimp Diameter Valid for Hose Marked Until End 2016

†Crimp Diameter Valid for Hose Marked From 2017

#Crimp Diameter Valid for Hose Marked Until End 2018

\*\*Crimp Diameter Valid for Hose Marked From 2019

## ABTP5K - ALFABIOTECH 5500 PLUS TWO-PIECE A INSERT + AS4 EXTERNAL SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AS4-12	3/4	33.0 OD	1.299	33.0	31	2.00

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## ABTP5K - ALFABIOTECH 5500 PLUS TWO-PIECE INTERLOCK X INSERT + XF2 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF2-12	3/4	52.0 OD 15.0 ID	1.323	33.6	31	2.60
XF2-16	1	65.0 OD 17.0 ID	1.654	42.0	42	0.00

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## ABT6K - ALFABIOTECH 6000/R15 TWO-PIECE A INSERT + AS4 EXTERNAL SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AS4-04	1/4	19.0 OD	0.720	18.3	16	2.30
AS4-06	3/8	19.0 OD	0.866	22.0	22	0.00
AS4-08	1/2	25.0 OD	1.035	26.3	25	1.30

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## ABT6K - ALFABIOTECH 6000/R15 TWO-PIECE INTERLOCK X INSERT + XF1 or XF2 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF1-10	5/8	50.0 OD 15.0 ID	1.248	31.7	29	2.70
XF2-12	3/4	52.0 OD 15.0 ID	1.339	34.0	31	3.00
XF2-16	1	65.0 OD 17.0 ID	1.642	41.7	38	3.70
XF1-20	1 1/4	74.0 OD 21.5 ID	2.189	55.6	54	1.60
XF1-24	1 1/2	81.0 OD 22.0 ID	2.488	63.2	63	0.20

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## ABT6K - ALFABIOTECH 6000/R15 TWO-PIECE INTERLOCK Z INSERT + ZF1 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	WIRE ID/OD (mm)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
ZF1-32	2	56.6 ID 68.1 OD	26.0 ID 87.0 OD	2.984	75.8	73	2.80

**\*\*Caution! Production crimper with 340+ tons of crimp force required for this ferrule! Call KOA for information and instruction!**

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## WB10 - WATERBLAST 10K TWO-PIECE A INSERT + EXTERNAL SKIVE AS4 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	WIRE OD (mm)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AS4-06	3/8	17.5 OD	19.0 OD	0.866	19.0	19.0	3.00

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## WB10 - WATERBLAST 10K TWO-PIECE INTERLOCK X INSERT + XF2 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	WIRE OD (mm)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF2-08	1/2	20.4 OD 16.4 ID	45.0 OD 13.0 ID	1.083	27.5	25.0	2.50
XF2-12	3/4	28.4 OD 22.8 ID	52.0 OD 15.0 ID	1.339	34.0	31.0	3.00
XF2-16	1	35.2 OD 29.7 ID	65.0 OD 17.0 ID	1.650	41.9	38.0	3.90

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## WB15 - WATERBLAST 15K TWO-PIECE INTERLOCK W INSERT + WF9 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	WIRE OD (mm)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
WF9-08	1/2		35.0 OD 13.0 ID	1.110	28.2	25.0	3.20
WF9-12	3/4		42.0 OD 14.0 ID	1.390	35.3	34.0	1.30

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

**TAJ3BK, TAJ3BU - ALFAJET 210 and KK4BK/BU  
K-Kleen 4000 PRESSURE WASHER  
TWO-PIECE A INSERT + AF1 FERRULE**

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AF1-04	1/4	0.650	16.5	16	0.50
AF1-06	3/8	0.803	20.4	19	1.40
AF1-08	1/2	0.941	23.9	22	1.90

**TAJ5BK, TAJ5BU - ALFAJET 400 PRESSURE WASHER  
TWO-PIECE A INSERT + AF1 FERRULE**

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AF1-04	1/4	0.685	17.4	16	1.40
AF1-06	3/8	0.835	21.2	19	2.20
AF1-08	1/2	0.976	24.8	22	2.80

## TR14TB - R14 PTFE TRUE BORE TUBE/STAINLESS BRAID TWO-PIECE A INSERT + AFT FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AFT-03	3/16	0.441	11.2	10	1.20
AFT-04	1/4	0.496	12.6	12	0.60
AFT-05	5/16	0.598	15.2	14	1.20
AFT-06	3/8	0.720	18.3	16	2.30
AFT-08	1/2	0.819	20.8	19	1.80
AFT-10	5/8	0.949	24.1	22	2.10
AFT-12	3/4	1.091	27.7	25	2.70
AFT-16	1	1.370	34.8	34	0.80

## TR14C - PTFE CONVOLUTED TRUE BORE TUBE/ STAINLESS BRAID 2-PIECE NON-SKIVE A INSERT + AFT FERRULE

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AFT-06	3/8	0.720	18.3	16	2.30
AFT-08	1/2	0.819	20.8	19	1.80
AFT-10	5/8	0.949	24.1	22	2.10
AFT-12	3/4	1.091	27.7	25	2.70
AFT-16	1	1.370	34.8	34	0.80
AFT-20	1 1/4	1.654	42.0	38	4.00
AFT-24	1 1/2	1.894	48.1	46	2.10
AFT-32	2	2.402	61.0	58	3.00

## FLEXOR RIG TWO-PIECE INTERLOCK X INSERT + XF1 or XF2 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF2-16	1	65.0 OD 17.0 ID	1.657	42.1	42	0.10
XF2-20†	1 1/4	74.0 OD 22.0 ID	1.957	49.7	46	3.70
XF1-20‡	1 1/4	74.0 OD 21.5 ID	2.197	55.8	54	1.80
XF1-24†	1 1/2	81.0 OD 22.0 ID	2.488	63.2	63	0.20
XF1-24‡	1 1/2	81.0 OD 22.0 ID	2.504	63.6	63	0.60
XF1-32	2	85.0 OD 29.0 ID	3.189	80.6	77	4.00
XF1-40	2 1/2	90.0 OD 33.0 ID	3.563	90.5	86	4.50

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

†Crimp Diameter Valid for Hose Marked after 2Q 2016

‡Crimp Diameter Valid for Hose Marked Until 2Q 2016

## ABT2K - FLEXOR RIG 3200 “NEW” STYLE 4 WIRE SPIRAL HOSE CONSTRUCTION TWO-PIECE V INSERT + VS4 EXTERNAL SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
XF1-40	2 1/2	90.0 OD 33.0 ID	3.472	88.2	86	2.20
VS4-48	3	80 OD ONLY	3.740	95.0	86	9.00

## AT10KOC - OILWELL CEMENTING 10,000 PSI TWO-PIECE INTERLOCK Z INSERT + ZF1 FERRULE

FERRULE PART NUMBER	SIZE ID (in)	WIRE ID/OD (mm)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in)	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
ZF1-32	2	57.8 ID 68.3 OD	87.0 OD 26.0 ID	3.008	76.4	73.0	3.40

**\*\*Caution! Production crimper with 350+ tons of crimp force required for this ferrule! Call KOA for information and instruction!**

**ATTENTION: ALL INTERLOCK FITTINGS REQUIRE INTERNAL AND EXTERNAL SKIVING FOR PROPER ASSEMBLY.**

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.

## AF3B - ALFAFOREST 3 BRAID AND DH3SPT DUNLOP HIFLEX 3 BRAID TWO-PIECE A INSERT + AS4 EXTERNAL SKIVE FERRULE

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (mm)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.1 mm	DIE SIZE	METRIC MICROMETER APPROX
AS4-06	3/8	19.0 OD	0.862	21.9	19	2.90

Note: Skive tooling requires either a KSKIVE2 electric or KSKIVE1 manual skive machine to properly function with the quick change skive tooling.



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PARQUE INDUSTRIAL OMOLAP  
APODACA, N.L. CP:66633, MÉXICO  
Telefonos: (81) 1086-1870 0 71  
Lada sin Costo 01 800 822 52 00  
FAX: (81) 1086-1869  
Internet: www.kuriyama.com.mx  
www.kuriyama.com  
Correo Electronico: ventas@kuriyama.com

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#### HEADQUARTERS, SALES OFFICE AND WAREHOUSE

360 E. State Parkway, Schaumburg, IL 60173-5335  
Phone: (847) 755-0360 • Toll-free Fax: (800) 800-0320  
International Fax: (847) 885-0996



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

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