







NON-SKIVE HEAVY-DUTY MULTI-SPIRAL ONE-PIECE COUPLING CRIMP CHART

COUPLING CODE	HOSE TYPE	in	3/4"	1"	1-1/4"	1-1/2"	2"
		dash	- 12	- 16	- 20	- 24	- 32
		mm	19mm	25mm	31mm	38mm	51mm
 Part Prefix 'GP'	EN 856-4SH	1.520	1.762	2.189	Available 2009		
		(38.62)	(44.75)	(55.60)			
	SAE 100R13 (EN 856-R13)	1.524	1.803				
		(38.70)	(45.80)				
	SAE 100R15	1.508	1.803	2.331			
		(38.30)	(45.80)	(59.20)			

For reference only, the above crimp diameters are in inches and should be crimped to the specified diameter +/- 0.005. (Crimp diameters in brackets are in metric and should be crimped to the specified diameter +/- 0.13mm).

However, taking tolerances into account, a collapse mandrel is required to obtain optimum coupling retention.

The part numbers for insert bore collapse mandrels are as follows:

HPT-16985-12G for 3/4"

HPT-16985-16G for 1"

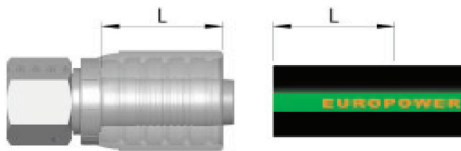
HPT-16985-20G for 1-1/4"

HPT-16985-24G for 1-1/2"

HPT-16985-32G for 2"

Instructions for assembly:

- 1) Cut the hose ends square.
- 2) Mark a line on the hose outer cover (length "L" is shown below) to indicate insertion depth for coupling.
- 3) Lightly lubricate the hose bore with a compatible fluid before pushing the coupling fully on to the hose.



HOSE BORE	LENGTH "L"
3/4"	1.38" (35mm)
1"	2.17" (55mm)
1-1/4"	3.15" (80mm)
1-1/2"	Available 2009
2"	

Place the assembly into the crimper die set so the ferrules largest diameter is within the die set by 0.040 - 0.060" (1.0-1.5mm).

PLEASE NOTE THAT CRIMPERS WITH FLOATING HEAD DOUBLE TAPER DIE SETS ARE NOT PREFERRED FOR CRIMPING THESE COUPLINGS e.g. P20 or P32.