Procedure 2401: King Crimp™ with Ferrules  
*effective 06/16*

**Selection**
- 1. Measure the OD of each end of the hose with a diameter tape.  
  *Tip: Mark hose OD on hose after measuring to avoid mistakes on crimp dimensions / sleeve selection.*
- 2. From the current Dixon® catalog, select the correct ferrule for the hose OD just measured.

**Preparation**
- 1. Prepare the hose using Procedure 1100: General Preparation Instructions.
- 2. For 6" ferrules and larger place a mark on shank 5/16" (0.312") from last serration. This is the insertion depth. (See illustration below)

![Illustration of ferrule insertion depth](image)

**Notes**
- 1. Each end of the hose to be assembled must be measured accurately.
- 2. 5/16" (0.312") insertion depth may need adjustment based upon hose construction and presence or absence of metal reinforcement.
- 3. Crimp diameters can be located in the current DPL, on the ferrule or by calling 800-355-1991.
- 4. Dwell, or hold, the finished crimp diameter for 3 to 5 seconds. This allows the metal to retain its new diameter.
- 5. Finished crimp diameter must be measured for each fitting. Tolerance is ±0.010" from published crimp diameter.  
  *Tip: Use crimp die closest to crimp diameter without going over for best results. (ex. crimp diameter 31mm, use 30mm die)*
- 6. If finished crimp diameter is larger than tolerance re-crimp. If crimp diameter is smaller than tolerance consult Dixon®.
- 7. Consult the King Crimp™ Pressure Recommendation Chart or Dixon® for coupling working pressures and for working pressures above 70˚F.

**Process**
- 1. Slide ferrule over hose until turnover end contacts hose end.
- 2. Insert fitting to locking groove or insertion depth mark.
- 3. Set the crimp diameter on the crimper.
- 4. Bring hose with fitting and ferrule through the back of the crimper so that it is facing the operator.
- 5. Slowly jog dies closed. Make sure dies clear coupler head or adapter hose stop or King Combination nipple body.
- 6. Position ferrule so turnover end is even with the end of the crimp dies.
- 7. Slowly close dies until they just contact ferrule. Make positioning adjustments if necessary.
- 8. Push coupler head or adapter hose stop or King Combination nipple locking groove shoulder against turnover end of ferrule making sure dies clear coupling.
- 9. Close the dies until the machine has reached the set crimp diameter and hold / dwell for 3 - 5 seconds.
- 10. Open dies, pull assembly forward and measure crimp diameter.  
  *Tip: Crimp all hose ends having the same OD to speed up crimping process by not having to continually change crimper specifications.*
- 11. Inspect the ferrule for folds and creases and to ensure the gripping fingers engage the locking groove.