



Industrial Hose

Beverage Hose Crimp Manual



Recommended Crimp Chart Index Selection

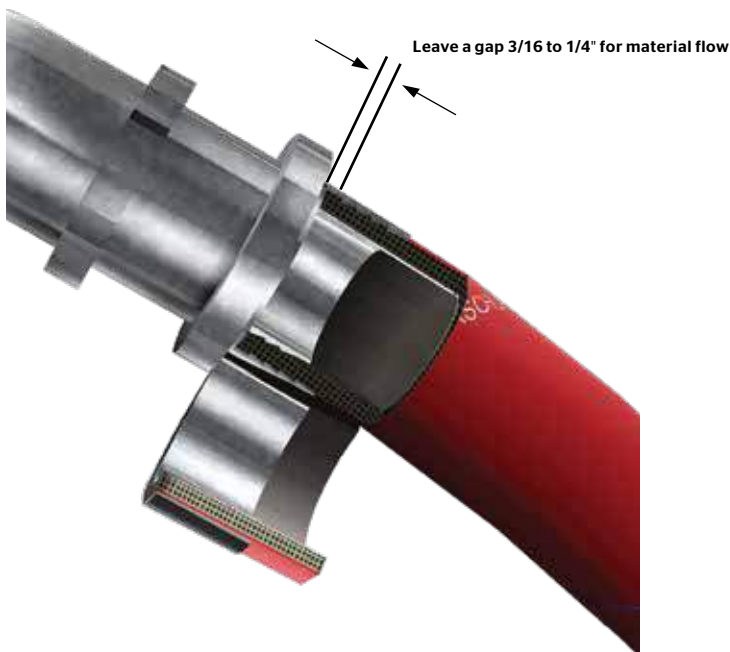
| Hose | Hose ID | | | | |
|--------------------------------------|---------|------|------|------|------|
| | 1.0" | 1.5" | 2.0" | 2.5" | 3.0" |
| Drinkline | | F-A | F-A | | F-B |
| ExtremeFlex Beverage | F-A | F-A | F-A | F-A | F-A |
| ExtremeFlex Beverage EZ Clean | F-C | F-C | F-C | | F-C |
| ExtremeFlex Food | F-A | F-A | F-A | F-A | F-A |
| EZ Glide Wine | | | F-D | | |
| Gray Flextra | | F-A | F-A | F-A | F-A |
| Gray Food | F-A | F-A | F-A | F-A | F-A |
| Purple Snake | F-A | F-A | F-A | | F-A |
| Vintner Reserve | F-A | F-A | F-A | | F-A |
| White Flextra | | F-A | F-A | F-A | F-A |
| White Flexwing | F-A | F-A | F-A | F-A | F-A |
| White Softwall | F-A | F-A | F-A | F-A | F-A |

Note: Always use the latest edition of the crimp chart.

Crimp procedure with Dixon Sanitary Style Crimp Stems

1. Cut hose to length required, ensure that the end is squared off. The coupling components and the hose bore must be clean and free of contaminants. If hose is cut with a saw, it is important to blow out any cutting residue with a reverse air jet—ensure all safety protection is worn. Cutting hose with a knife method helps keep the hose bore clean.
2. Hoses with antistatic or helix wires have the possibility to be made as an “electrically continuous assembly,” so check the customer’s requirement whether it needs to be terminated onto the coupling. Follow standard NAHAD procedure for wire termination.
3. Measure the hose OD with a PI tape or measure the hose wall at 4 positions with a caliper. Hoses with helix wire are considered to have a fixed hose ID, whereas hose without it are more subject to ID change from handling and process. The preferred method for softwall hose is wall measurement with a caliper.
4. Refer to the appropriate chart for final crimp OD.
5. Insert the ferrule over the hose. DO NOT insert the ferrule all the way, leave a gap of about 3/16 to 1/4" gap inside the ferrule for material flow. Then pencil mark the final position of the ferrule on the hose cover. Note: rubber is not compressible and will need a place to flow.
6. Lubricate the hose ID and the stem with a soapy solution from a spray bottle (5% solution of dish soap)
7. Push the stem into the hose while maintaining the ferrule in its final position, make sure the stem is positioned to lock with the ferrule.
8. Dial the crimp diameter.
9. Position the stem and ferrule into the crimping machine, close the dies to lightly grip on the ferrule, validate the stem/ferrule interlocking position. Make sure the hose is aligned with the coupling, then crimp the ferrule.
10. Remove hose end from the crimper, measure the OD over the ferrule and compare with the chart. If needed, make adjustment.

Note: Hose with plastic helices tend to shrink after cooling. It is normal to have to use a hose pusher to insert the stem into the hose.



Dixon Part Numbers Sanitary Style Crimp Stems

Clamp End x Hose Shank

| Size | 316 Stainless Steel Part # |
|------|----------------------------|
| 1" | CSSR100-3A |
| 1½" | CSSR150-3A |
| 2" | CSSR200-3A |
| 2½" | CSSR250 |
| 3" | CSSR300-3A |
| 4" | CSSR400 |

Bevel Seat End x Hose Shank

| Size | Nut Used | 316 Stainless Steel Part # |
|------|----------|----------------------------|
| 1" | 13H-G100 | CBSR100 |
| 1½" | IXAN24 | CBSR150 |
| 2" | IXAN32 | CBSR200 |
| 3" | IXAN300 | CBSR300 |
| 4" | IXAN64 | CBSR400 |

Female I-Line End x Hose Shank

| Size | 316 Stainless Steel Part # |
|------|----------------------------|
| 1½" | CILR150 |
| 2" | CILR200 |
| 3" | CILR300 |
| 4" | CILR400 |

Tube Weld End x Hose Shank

| Size | 316 Stainless Steel Part # |
|------|----------------------------|
| 1½" | CTER150 |
| 2" | CTER200 |
| 3" | CTER300 |
| 4" | CTER400 |

Note: Dixon Sanitary Crimp Stems are only to be used with Dixon Sanitary Stainless Steel Crimp Ferrules.

Table F-A

1.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|---|---------------------------------|--------------------------------------|------------------------------------|---|-----------|---------|---|
| 0.168 / 0.176 | 1.337 / 1.352 | 1 22/64 | 1.514 | 1 33/64 | 34 | 4.46 | Contact Customer Service |
| 0.176 / 0.184 | 1.353 / 1.367 | 1 23/64 | 1.526 | 1 34/64 | 34 | 4.47 | Contact Customer Service |
| 0.184 / 0.191 | 1.368 / 1.383 | 1 24/64 | 1.538 | 1 34/64 | 34 | 5.07 | F16G-1453 |
| 0.192 / 0.199 | 1.384 / 1.980 | 1 25/64 | 1.550 | 1 35/64 | 34 | 5.38 | F16G-1453 |
| 0.200 / 0.207 | 1.339 / 1.414 | 1 26/64 | 1.562 | 1 36/64 | 34 | 5.68 | F16G-1453 |
| 0.208 / 0.215 | 1.415 / 1.430 | 1 27/64 | 1.574 | 1 37/64 | 34 | 5.99 | F16G-1453 |
| 0.215 / 0.223 | 1.431 / 1.445 | 1 28/64 | 1.586 | 1 38/64 | 34 | 6.29 | F16G-1500 |
| 0.223 / 0.230 | 1.446 / 1.461 | 1 29/64 | 1.598 | 1 38/64 | 34 | 6.60 | F16G-1500 |
| 0.231 / 0.238 | 1.462 / 1.477 | 1 30/64 | 1.610 | 1 39/64 | 34 | 6.91 | F16G-1500 |
| 0.239 / 0.246 | 1.478 / 1.492 | 1 31/64 | 1.623 | 1 40/64 | 34 | 7.21 | F16G-1500 |
| 0.247 / 0.254 | 1.493 / 1.508 | 1 32/64 | 1.635 | 1 41/64 | 34 | 7.52 | F16G-1547 |
| 0.254 / 0.262 | 1.509 / 1.523 | 1 33/64 | 1.647 | 1 41/64 | 34 | 7.82 | F16G-1547 |
| 0.262 / 0.270 | 1.524 / 1.539 | 1 34/64 | 1.659 | 1 42/64 | 34 | 8.13 | F16G-1547 |
| 0.270 / 0.277 | 1.550 / 1.555 | 1 35/64 | 1.671 | 1 43/64 | 41 | 1.43 | F16G-1594 |
| 0.278 / 0.285 | 1.556 / 1.570 | 1 36/64 | 1.683 | 1 44/64 | 41 | 1.74 | F16G-1594 |
| 0.286 / 0.293 | 1.557 / 1.586 | 1 37/64 | 1.695 | 1 44/64 | 41 | 2.05 | F16G-1594 |
| 0.293 / 0.301 | 1.587 / 1.602 | 1 38/64 | 1.707 | 1 45/64 | 41 | 2.35 | F16G-1641 |
| 0.301 / 0.309 | 1.603 / 1.617 | 1 39/64 | 1.719 | 1 46/64 | 41 | 2.66 | F16G-1641 |
| 0.309 / 0.316 | 1.618 / 1.633 | 1 40/64 | 1.731 | 1 47/64 | 41 | 2.96 | F16G-1641 |
| 0.317 / 0.324 | 1.634 / 1.648 | 1 41/64 | 1.743 | 1 48/64 | 41 | 3.27 | - |
| 0.325 / 0.332 | 1.649 / 1.664 | 1 42/64 | 1.755 | 1 48/64 | 41 | 3.57 | - |
| 0.333 / 0.340 | 1.665 / 1.680 | 1 43/64 | 1.767 | 1 49/64 | 41 | 3.88 | - |
| 0.340 / 0.348 | 1.681 / 1.695 | 1 44/64 | 1.779 | 1 50/64 | 41 | 4.18 | - |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-A

1.5" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|---|---------------------------------|--------------------------------------|---------------------------------|---|-----------|---------|---|
| 0.168 / 0.176 | 1.837 / 1.852 | 1 54/64 | 2.014 | 2 1/64 | 45 | 6.14 | Contact Customer Service |
| 0.176 / 0.184 | 1.853 / 1.867 | 1 55/64 | 2.026 | 2 2/64 | 45 | 6.45 | Contact Customer Service |
| 0.184 / 0.191 | 1.868 / 1.883 | 1 56/64 | 2.038 | 2 2/64 | 45 | 6.76 | Contact Customer Service |
| 0.192 / 0.199 | 1.884 / 1.898 | 1 57/64 | 2.050 | 2 3/64 | 45 | 7.06 | Contact Customer Service |
| 0.200 / 0.207 | 1.899 / 1.914 | 1 58/64 | 2.062 | 2 4/64 | 45 | 7.37 | F24G-1969 |
| 0.208 / 0.215 | 1.915 / 1.930 | 1 59/64 | 2.074 | 2 5/64 | 45 | 7.67 | F24G-1969 |
| 0.215 / 0.223 | 1.913 / 1.945 | 1 60/64 | 2.086 | 2 5/64 | 45 | 7.98 | F24G-1969 |
| 0.223 / 0.230 | 1.946 / 1.961 | 1 61/64 | 2.098 | 2 6/64 | 45 | 8.28 | F24G-1969 |
| 0.231 / 0.238 | 1.962 / 1.977 | 1 62/64 | 2.110 | 2 7/64 | 50 | 3.59 | F24G-2031 |
| 0.239 / 0.246 | 1.978 / 1.992 | 1 63/64 | 2.122 | 2 8/64 | 50 | 3.89 | F24G-2031 |
| 0.247 / 0.254 | 1.993 / 2.008 | 2 | 2.134 | 2 9/64 | 50 | 4.20 | F24G-2031 |
| 0.254 / 0.262 | 2.009 / 2.023 | 2 1/64 | 2.146 | 2 9/64 | 50 | 4.51 | F24G-2031 |
| 0.262 / 0.270 | 2.024 / 2.039 | 2 2/64 | 2.158 | 2 10/64 | 50 | 4.81 | F24G-2094 |
| 0.270 / 0.277 | 2.040 / 2.055 | 2 3/64 | 2.170 | 2 11/64 | 50 | 5.12 | F24G-2094 |
| 0.278 / 0.285 | 2.056 / 2.070 | 2 4/64 | 2.182 | 2 12/64 | 50 | 5.42 | F24G-2094 |
| 0.286 / 0.293 | 2.071 / 2.086 | 2 5/64 | 2.194 | 2 12/64 | 50 | 5.73 | F24G-2094 |
| 0.293 / 0.301 | 2.087 / 2.102 | 2 6/64 | 2.206 | 2 13/64 | 50 | 6.03 | F24G-2156 |
| 0.301 / 0.309 | 2.103 / 2.117 | 2 7/64 | 2.218 | 2 14/64 | 50 | 6.34 | F24G-2156 |
| 0.309 / 0.316 | 2.118 / 2.133 | 2 8/64 | 2.230 | 2 15/64 | 50 | 6.64 | F24G-2156 |
| 0.317 / 0.324 | 2.134 / 2.148 | 2 9/64 | 2.242 | 2 15/64 | 50 | 6.95 | F24G-2156 |
| 0.325 / 0.332 | 2.149 / 2.164 | 2 10/64 | 2.254 | 2 16/64 | 56 | 1.26 | F24G-2219 |
| 0.333 / 0.340 | 2.165 / 2.180 | 2 11/64 | 2.266 | 2 17/64 | 56 | 1.56 | F24G-2219 |
| 0.340 / 0.348 | 2.181 / 2.195 | 2 12/64 | 2.278 | 2 18/64 | 56 | 1.87 | F24G-2219 |
| 0.348 / 0.355 | 2.196 / 2.211 | 2 13/64 | 2.290 | 2 19/64 | 56 | 2.17 | F24G-2219 |
| 0.356 / 0.363 | 2.212 / 2.227 | 2 14/64 | 2.302 | 2 19/64 | 56 | 2.48 | F24G-2281 |
| 0.364 / 0.371 | 2.228 / 2.242 | 2 15/64 | 2.314 | 2 20/64 | 56 | 2.78 | F24G-2281 |
| 0.372 / 0.379 | 2.243 / 2.258 | 2 16/64 | 2.326 | 2 21/64 | 56 | 3.09 | F24G-2281 |
| 0.379 / 0.387 | 2.259 / 2.273 | 2 17/64 | 2.338 | 2 22/64 | 56 | 3.39 | F24G-2281 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-A

2.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.200 / 0.207 | 2.339 / 2.414 | 2 26/64 | 2.560 | 2 36/64 | 62 | 3.03 | Contact Customer Service |
| 0.208 / 0.215 | 2.415 / 2.430 | 2 27/64 | 2.572 | 2 37/64 | 62 | 3.34 | Contact Customer Service |
| 0.215 / 0.223 | 2.431 / 2.445 | 2 28/64 | 2.584 | 2 37/64 | 62 | 3.64 | Contact Customer Service |
| 0.223 / 0.230 | 2.446 / 2.461 | 2 29/64 | 2.596 | 2 38/64 | 62 | 3.95 | Contact Customer Service |
| 0.231 / 0.238 | 2.462 / 2.477 | 2 30/64 | 2.608 | 2 39/64 | 62 | 4.25 | F32G-2531 |
| 0.239 / 0.246 | 2.478 / 2.492 | 2 31/64 | 2.620 | 2 40/64 | 62 | 4.56 | F32G-2531 |
| 0.274 / 0.254 | 2.493 / 2.508 | 2 32/64 | 2.632 | 2 40/64 | 62 | 4.86 | F32G-2531 |
| 0.254 / 0.262 | 2.509 / 2.523 | 2 33/64 | 2.645 | 2 41/64 | 62 | 5.17 | F32G-2531 |
| 0.262 / 0.270 | 2.524 / 2.539 | 2 34/64 | 2.657 | 2 42/64 | 62 | 5.48 | F32G-2594 |
| 0.270 / 0.277 | 2.540 / 2.555 | 2 35/64 | 2.669 | 2 43/64 | 62 | 5.78 | F32G-2594 |
| 0.278 / 0.285 | 2.556 / 2.570 | 2 36/64 | 2.681 | 2 44/64 | 62 | 6.09 | F32G-2594 |
| 0.286 / 0.293 | 2.571 / 2.586 | 2 37/64 | 2.693 | 2 44/64 | 62 | 6.39 | F32G-2594 |
| 0.293 / 0.301 | 2.587 / 2.302 | 2 38/64 | 2.705 | 2 45/64 | 62 | 6.70 | F32G-2656 |
| 0.301 / 0.309 | 2.603 / 2.617 | 2 39/64 | 2.717 | 2 46/64 | 62 | 7.00 | F32G-2656 |
| 0.309 / 0.316 | 2.618 / 2.633 | 2 40/64 | 2.729 | 2 47/64 | 62 | 7.31 | F32G-2656 |
| 0.317 / 0.324 | 2.634 / 2.648 | 2 41/64 | 2.741 | 2 47/64 | 62 | 7.62 | F32G-2656 |
| 0.325 / 0.332 | 2.649 / 2.664 | 2 42/64 | 2.753 | 2 48/64 | 62 | 7.92 | F32G-2719 |
| 0.333 / 0.340 | 2.665 / 2.680 | 2 43/64 | 2.765 | 2 49/64 | 62 | 8.23 | F32G-2719 |
| 0.340 / 0.348 | 2.681 / 2.695 | 2 44/64 | 2.777 | 2 50/64 | 62 | 8.53 | F32G-2719 |
| 0.348 / 0.355 | 2.696 / 2.711 | 2 45/64 | 2.789 | 2 50/64 | 62 | 8.84 | F32G-2719 |
| 0.356 / 0.363 | 2.712 / 2.727 | 2 46/64 | 2.801 | 2 51/64 | 69 | 2.14 | Contact Customer Service |
| 0.364 / 0.371 | 2.728 / 2.742 | 2 47/64 | 2.813 | 2 52/64 | 69 | 2.45 | Contact Customer Service |
| 0.372 / 0.379 | 2.743 / 2.758 | 2 48/64 | 2.825 | 2 53/64 | 69 | 2.75 | Contact Customer Service |
| 0.379 / 0.387 | 2.759 / 2.773 | 2 49/64 | 2.837 | 2 54/64 | 69 | 3.06 | Contact Customer Service |
| 0.387 / 0.395 | 2.774 / 2.789 | 2 50/64 | 2.849 | 2 54/64 | 69 | 3.37 | Contact Customer Service |
| 0.395 / 0.402 | 2.790 / 2.805 | 2 51/64 | 2.861 | 2 55/64 | 69 | 3.67 | Contact Customer Service |
| 0.403 / 0.410 | 2.806 / 2.820 | 2 52/64 | 2.873 | 2 56/64 | 69 | 3.98 | F32G-2875 |
| 0.411 / 0.418 | 2.821 / 2.836 | 2 53/64 | 2.885 | 2 57/64 | 69 | 4.28 | F32G-2875 |
| 0.418 / 0.426 | 2.837 / 2.852 | 2 54/64 | 2.897 | 2 57/64 | 69 | 4.59 | F32G-2875 |
| 0.426 / 0.434 | 2.853 / 2.867 | 2 55/64 | 2.909 | 2 58/64 | 69 | 4.89 | F32G-2875 |
| 0.434 / 0.441 | 2.868 / 2.883 | 2 56/64 | 2.921 | 2 59/64 | 69 | 5.20 | F32G-2938 |
| 0.442 / 0.449 | 2.884 / 2.898 | 2 57/64 | 2.933 | 2 60/64 | 69 | 5.50 | F32G-2938 |
| 0.450 / 0.457 | 2.899 / 2.914 | 2 58/64 | 2.946 | 2 60/64 | 69 | 5.81 | F32G-2938 |
| 0.458 / 0.465 | 2.915 / 2.930 | 2 59/64 | 2.957 | 2 61/64 | 69 | 6.12 | F32G-2938 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-A

2.5" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.200 / 0.207 | 2.899 / 2.914 | 2 58/64 | 3.062 | 3 4/64 | 74 | 3.77 | Contact Customer Service |
| 0.208 / 0.215 | 2.915 / 2.930 | 2 59/64 | 3.074 | 3 5/64 | 74 | 4.07 | Contact Customer Service |
| 0.215 / 0.223 | 2.931 / 2.945 | 2 60/64 | 3.086 | 3 5/64 | 74 | 3.38 | Contact Customer Service |
| 0.223 / 0.230 | 2.946 / 2.961 | 2 61/64 | 3.098 | 3 6/64 | 74 | 4.68 | Contact Customer Service |
| 0.231 / 0.238 | 2.962 / 2.977 | 2 62/64 | 3.110 | 3 7/64 | 74 | 4.99 | Contact Customer Service |
| 0.239 / 0.246 | 2.978 / 2.992 | 2 63/64 | 3.122 | 3 8/64 | 74 | 5.29 | Contact Customer Service |
| 0.247 / 0.254 | 2.993 / 3.008 | 3 | 3.134 | 3 9/64 | 78 | 1.60 | F40G-3063 |
| 0.254 / 0.262 | 3.009 / 3.023 | 3 1/64 | 3.146 | 3 9/64 | 78 | 1.91 | F40G-3063 |
| 0.262 / 0.270 | 3.024 / 3.039 | 3 2/64 | 3.158 | 3 10/64 | 78 | 2.21 | F40G-3063 |
| 0.270 / 0.277 | 3.040 / 3.055 | 3 3/64 | 3.170 | 3 11/64 | 78 | 2.52 | F40G-3063 |
| 0.278 / 0.285 | 3.056 / 3.070 | 3 4/64 | 3.182 | 3 12/64 | 78 | 2.82 | F40G-3125 |
| 0.286 / 0.293 | 3.071 / 3.086 | 3 5/64 | 3.194 | 3 12/64 | 78 | 3.13 | F40G-3125 |
| 0.293 / 0.301 | 3.087 / 3.102 | 3 6/64 | 3.206 | 3 13/64 | 78 | 3.43 | F40G-3125 |
| 0.301 / 0.309 | 3.103 / 3.117 | 3 7/64 | 3.218 | 3 14/64 | 78 | 3.74 | F40G-3125 |
| 0.309 / 0.316 | 3.118 / 3.133 | 3 8/64 | 3.230 | 3 15/64 | 78 | 4.04 | F40G-3188 |
| 0.317 / 0.324 | 3.134 / 3.148 | 3 9/64 | 3.242 | 3 15/64 | 78 | 4.35 | F40G-3188 |
| 0.325 / 0.332 | 3.149 / 3.164 | 3 10/64 | 3.254 | 3 16/64 | 78 | 4.66 | F40G-3188 |
| 0.333 / 0.340 | 3.165 / 3.180 | 3 11/64 | 3.266 | 3 17/64 | 78 | 4.96 | F40G-3188 |
| 0.340 / 0.348 | 3.181 / 3.195 | 3 12/64 | 3.278 | 3 18/64 | 78 | 5.27 | F40G-3250 |
| 0.348 / 0.355 | 3.196 / 3.211 | 3 13/64 | 3.290 | 3 19/64 | 78 | 5.57 | F40G-3250 |
| 0.356 / 0.363 | 3.212 / 3.227 | 3 14/64 | 3.302 | 3 19/64 | 78 | 5.88 | F40G-3250 |
| 0.364 / 0.371 | 3.228 / 3.242 | 3 15/64 | 3.314 | 3 20/64 | 78 | 6.18 | F40G-3250 |
| 0.372 / 0.379 | 3.243 / 3.258 | 3 16/64 | 3.326 | 3 21/64 | 78 | 6.49 | F40G-3313 |
| 0.379 / 0.387 | 3.259 / 3.273 | 3 17/64 | 3.338 | 3 22/64 | 78 | 6.79 | F40G-3313 |
| 0.387 / 0.395 | 3.274 / 3.289 | 3 18/64 | 3.350 | 3 22/64 | 78 | 7.10 | F40G-3313 |
| 0.395 / 0.402 | 3.290 / 3.305 | 3 19/64 | 3.362 | 3 23/64 | 78 | 7.41 | F40G-3313 |
| 0.403 / 0.410 | 3.306 / 3.320 | 3 20/64 | 3.374 | 3 24/64 | 78 | 7.71 | F40G-3375 |
| 0.411 / 0.418 | 3.321/3.336 | 3 21/64 | 3.387 | 3 25/64 | 78 | 8.02 | F40G-3375 |
| 0.418 / 0.426 | 3.337 / 3.352 | 3 22/64 | 3.399 | 3 26/64 | 78 | 8.32 | F40G-3375 |
| 0.426 / 0.434 | 3.353 / 3.367 | 3 23/64 | 3.411 | 3 26/64 | 78 | 8.63 | F40G-3375 |
| 0.434 / 0.441 | 3.368 / 3.383 | 3 24/64 | 3.423 | 3 27/64 | 86 | 0.93 | Contact Customer Service |
| 0.442 / 0.449 | 3.384 / 3.398 | 3 25/64 | 3.435 | 3 28/64 | 86 | 1.24 | Contact Customer Service |
| 0.450 / 0.457 | 3.399 / 3.414 | 3 26/64 | 3.447 | 3 29/64 | 86 | 1.55 | Contact Customer Service |
| 0.458 / 0.465 | 3.415 / 3.430 | 3 27/64 | 3.459 | 3 29/64 | 86 | 1.85 | Contact Customer Service |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-A

3.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.262 / 0.270 | 3.524 / 3.539 | 3 34/64 | 3.657 | 3 42/64 | 92 | 0.89 | – |
| 0.270 / 0.277 | 3.540 / 3.555 | 3 35/64 | 3.669 | 3 43/64 | 92 | 1.20 | – |
| 0.278 / 0.285 | 3.556 / 3.570 | 3 36/64 | 3.681 | 3 44/64 | 92 | 1.50 | F48G-3625 |
| 0.286 / 0.293 | 3.571 / 3.586 | 3 37/64 | 3.693 | 3 44/64 | 92 | 1.81 | F48G-3625 |
| 0.293 / 0.301 | 3.587 / 3.602 | 3 38/64 | 3.705 | 3 45/64 | 92 | 2.12 | F48G-3625 |
| 0.301 / 0.309 | 3.603 / 3.617 | 3 39/64 | 3.717 | 3 46/64 | 92 | 2.42 | F48G-3625 |
| 0.309 / 0.316 | 3.618 / 3.633 | 3 40/64 | 3.729 | 3 47/64 | 92 | 2.73 | F48G-3688 |
| 0.317 / 0.324 | 3.634 / 3.648 | 3 41/64 | 3.741 | 3 47/64 | 92 | 3.03 | F48G-3688 |
| 0.325 / 0.332 | 3.649 / 3.664 | 3 42/64 | 3.753 | 3 48/64 | 92 | 3.34 | F48G-3688 |
| 0.333 / 0.340 | 3.665 / 3.680 | 3 43/64 | 3.766 | 3 49/64 | 92 | 3.64 | F48G-3688 |
| 0.340 / 0.348 | 3.681 / 3.695 | 3 44/64 | 3.778 | 3 50/64 | 92 | 3.95 | F48G-3750 |
| 0.348 / 0.355 | 3.696 / 3.711 | 3 45/64 | 3.790 | 3 51/64 | 92 | 4.25 | F48G-3750 |
| 0.356 / 0.363 | 3.712 / 3.727 | 3 46/64 | 3.802 | 3 51/64 | 92 | 4.56 | F48G-3750 |
| 0.364 / 0.371 | 3.728 / 3.742 | 3 47/64 | 3.802 | 3 52/64 | 92 | 4.87 | F48G-3750 |
| 0.372 / 0.379 | 3.743 / 3.758 | 3 48/64 | 3.826 | 3 53/64 | 96 | 1.17 | F48G-3813 |
| 0.379 / 0.387 | 3.759 / 3.773 | 3 49/64 | 3.838 | 3 54/64 | 96 | 1.48 | F48G-3813 |
| 0.387 / 0.395 | 3.774 / 3.789 | 3 50/64 | 3.850 | 3 54/64 | 96 | 1.78 | F48G-3813 |
| 0.395 / 0.402 | 3.790 / 3.805 | 3 51/64 | 3.862 | 3 55/64 | 96 | 2.09 | F48G-3813 |
| 0.403 / 0.410 | 3.806 / 3.820 | 3 52/64 | 3.874 | 3 56/64 | 96 | 2.39 | F48G-3875 |
| 0.411 / 0.418 | 3.821 / 3.836 | 3 53/64 | 3.886 | 3 57/64 | 96 | 2.70 | F48G-3875 |
| 0.418 / 0.426 | 3.837 / 3.852 | 3 54/64 | 3.898 | 3 57/64 | 96 | 3.01 | F48G-3875 |
| 0.426 / 0.434 | 3.853 / 3.867 | 3 55/64 | 3.910 | 3 58/64 | 96 | 3.31 | F48G-3875 |
| 0.434 / 0.441 | 3.868 / 3.883 | 3 56/64 | 3.922 | 3 59/64 | 96 | 3.62 | F48G-3938 |
| 0.442 / 0.449 | 3.884 / 3.898 | 3 57/64 | 3.934 | 3 60/64 | 96 | 3.92 | F48G-3938 |
| 0.450 / 0.457 | 3.899 / 3.914 | 3 58/64 | 3.946 | 3 61/64 | 96 | 4.23 | F48G-3938 |
| 0.458 / 0.465 | 3.915 / 3.930 | 3 59/64 | 3.958 | 3 61/64 | 96 | 4.53 | F48G-3938 |
| 0.465 / 0.473 | 3.931 / 3.945 | 3 60/64 | 3.970 | 3 62/64 | 96 | 4.84 | Contact Customer Service |
| 0.473 / 0.480 | 3.946 / 3.961 | 3 61/64 | 3.982 | 3 63/64 | 96 | 5.14 | Contact Customer Service |
| 0.481 / 0.488 | 3.962 / 3.977 | 3 62/64 | 3.994 | 4 | 96 | 5.45 | Contact Customer Service |
| 0.489 / 0.496 | 3.978 / 3.992 | 3 63/64 | 4.006 | 4 | 96 | 5.76 | Contact Customer Service |
| 0.497 / 0.504 | 3.993 / 4.008 | 4 | 4.018 | 4 1/64 | 100 | 2.06 | Contact Customer Service |
| 0.504 / 0.512 | 4.009 / 4.023 | 4 1/64 | 4.030 | 4 2/64 | 100 | 2.37 | Contact Customer Service |
| 0.512 / 0.520 | 4.024 / 4.039 | 4 2/64 | 4.042 | 4 3/64 | 100 | 2.67 | Contact Customer Service |
| 0.520 / 0.527 | 4.040 / 4.055 | 4 3/64 | 4.054 | 4 3/64 | 100 | 2.98 | Contact Customer Service |
| 0.528 / 0.535 | 4.056 / 4.070 | 4 4/64 | 4.066 | 4 4/64 | 100 | 3.28 | F48G-4106 |
| 0.536 / 0.543 | 4.071 / 4.086 | 4 5/64 | 4.078 | 4 5/64 | 100 | 3.59 | F48G-4106 |
| 0.543 / 0.551 | 4.087 / 4.102 | 4 6/64 | 4.090 | 4 6/64 | 100 | 3.89 | F48G-4106 |
| 0.551 / 0.559 | 4.103 / 4.117 | 4 7/64 | 4.102 | 4 7/64 | 100 | 4.20 | F48G-4106 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-B

3.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.340 / 0.348 | 3.681 / 3.695 | 3 44/64 | 3.812 | 3 52/64 | 92 | 4.83 | F48G-3750 |
| 0.348 / 0.355 | 3.396 / 3.711 | 3 45/64 | 3.825 | 3 53/64 | 92 | 5.16 | F48G-3750 |
| 0.356 / 0.363 | 3.712 / 3.727 | 3 46/64 | 3.838 | 3 54/64 | 92 | 5.48 | F48G-3750 |
| 0.364 / 0.371 | 3.728 / 3.742 | 3 47/64 | 3.851 | 3 54/64 | 92 | 5.81 | F48G-3750 |
| 0.372 / 0.379 | 3.743 / 3.758 | 3 48/64 | 3.864 | 3 55/64 | 96 | 2.13 | F48G-3813 |
| 0.379 / 0.387 | 3.759 / 3.773 | 3 49/64 | 3.876 | 3 56/64 | 96 | 2.46 | F48G-3813 |
| 0.387 / 0.395 | 3.774 / 3.789 | 3 50/64 | 3.889 | 3 57/64 | 96 | 2.79 | F48G-3813 |
| 0.395 / 0.402 | 3.790 / 3.805 | 3 51/64 | 3.902 | 3 58/64 | 96 | 3.11 | F48G-3813 |
| 0.403 / 0.410 | 3.806 / 3.820 | 3 52/64 | 3.915 | 3 59/64 | 96 | 3.44 | F48G-3875 |
| 0.411 / 0.418 | 3.821 / 3.836 | 3 53/64 | 3.928 | 3 59/64 | 96 | 3.76 | F48G-3875 |
| 0.418 / 0.426 | 3.837 / 3.852 | 3 54/64 | 3.940 | 3 60/64 | 96 | 4.06 | F48G-3875 |
| 0.426 / 0.434 | 3.853 / 3.867 | 3 55/64 | 3.953 | 3 61/64 | 96 | 4.41 | F48G-3875 |
| 0.434 / 0.441 | 3.868 / 3.883 | 3 56/64 | 3.966 | 3 62/64 | 96 | 4.74 | F48G-3938 |
| 0.442 / 0.449 | 3.884 / 3.898 | 3 57/64 | 3.979 | 3 63/64 | 96 | 5.06 | F48G-3938 |
| 0.450 / 0.457 | 3.899 / 3.914 | 3 58/64 | 3.992 | 3 63/64 | 96 | 5.39 | F48G-3938 |
| 0.458 / 0.465 | 3.915 / 3.930 | 3 59/64 | 4.004 | 4 | 96 | 5.71 | F48G-3938 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-C

1.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.215 / 0.223 | 1.431 / 1.445 | 1 28/64 | 1.573 | 1 37/64 | 34 | 5.96 | F16G-1500 |
| 0.223 / 0.230 | 1.446 / 1.461 | 1 29/64 | 1.585 | 1 37/64 | 34 | 6.25 | F16G-1500 |
| 0.231 / 0.238 | 1.462 / 1.477 | 1 30/64 | 1.596 | 1 38/64 | 34 | 6.55 | F16G-1500 |
| 0.239 / 0.246 | 1.478 / 1.492 | 1 31/64 | 1.608 | 1 39/64 | 34 | 6.84 | F16G-1500 |
| 0.247 / 0.254 | 1.493 / 1.508 | 1 32/64 | 1.619 | 1 40/64 | 34 | 7.13 | F16G-1547 |
| 0.254 / 0.262 | 1.509 / 1.523 | 1 33/64 | 1.631 | 1 40/64 | 34 | 7.43 | F16G-1547 |
| 0.262 / 0.270 | 1.524 / 1.539 | 1 34/64 | 1.643 | 1 41/64 | 34 | 7.72 | F16G-1547 |
| 0.270 / 0.277 | 1.540 / 1.555 | 1 35/64 | 1.654 | 1 42/64 | 34 | 8.02 | F16G-1594 |
| 0.278 / 0.285 | 1.556 / 1.570 | 1 36/64 | 1.666 | 1 43/64 | 34 | 8.31 | F16G-1594 |
| 0.286 / 0.293 | 1.571 / 1.586 | 1 37/64 | 1.677 | 1 43/64 | 34 | 8.60 | F16G-1594 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-C

1.5" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|---|---------------------------------|--------------------------------------|------------------------------------|---|-----------|---------|---|
| 0.200 / 0.207 | 1.899 / 1.914 | 1 58/64 | 2.049 | 2 3/64 | 50 | 2.05 | F24G-1969 |
| 0.208 / 0.215 | 1.915 / 1.930 | 1 59/64 | 2.061 | 2 4/64 | 50 | 2.35 | F24G-1969 |
| 0.215 / 0.223 | 1.931 / 1.945 | 1 60/64 | 2.072 | 2 5/64 | 50 | 2.64 | F24G-1969 |
| 0.223 / 0.230 | 1.946 / 1.961 | 1 61/64 | 2.084 | 2 5/64 | 50 | 2.93 | F24G-1969 |
| 0.231 / 0.238 | 1.962 / 1.977 | 1 62/64 | 2.096 | 2 6/64 | 50 | 3.23 | F24G-2031 |
| 0.239 / 0.246 | 1.978 / 1.992 | 1 63/64 | 2.107 | 2 7/64 | 50 | 3.52 | F24G-2031 |
| 0.247 / 0.254 | 1.993 / 2.008 | 2 | 2.119 | 2 8/64 | 50 | 3.81 | F24G-2031 |
| 0.254 / 0.262 | 2.009 / 2.023 | 2 1/64 | 2.130 | 2 8/64 | 50 | 4.11 | F24G-2031 |
| 0.262 / 0.270 | 2.024 / 2.039 | 2 2/64 | 2.142 | 2 9/64 | 50 | 4.40 | F24G-2094 |
| 0.270 / 0.277 | 2.040 / 2.055 | 2 3/64 | 2.153 | 2 10/64 | 50 | 4.70 | F24G-2094 |
| 0.278 / 0.285 | 2.056 / 2.070 | 2 4/64 | 2.165 | 2 11/64 | 50 | 4.99 | F24G-2094 |
| 0.286 / 0.293 | 2.071 / 2.086 | 2 5/64 | 2.177 | 2 11/64 | 50 | 5.28 | F24G-2094 |
| 0.293 / 0.301 | 2.087 / 2.102 | 2 6/64 | 2.188 | 2 12/64 | 50 | 5.58 | F24G-2156 |
| 0.301 / 0.309 | 2.103 / 2.117 | 2 7/64 | 2.200 | 2 13/64 | 50 | 5.87 | F24G-2156 |
| 0.309 / 0.316 | 2.118 / 2.133 | 2 8/64 | 2.211 | 2 14/64 | 50 | 6.16 | F24G-2156 |
| 0.317 / 0.324 | 2.134 / 2.148 | 2 9/64 | 2.223 | 2 14/64 | 50 | 6.16 | F24G-2156 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-C

2.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.247 / 0.254 | 2.493 / 2.508 | 2 32/64 | 2.607 | 2 39/64 | 62 | 4.22 | F32G-2594 |
| 0.254 / 0.262 | 2.509 / 2.523 | 2 33/64 | 2.618 | 2 40/64 | 62 | 4.50 | F32G-2594 |
| 0.262 / 0.270 | 2.524 / 2.539 | 2 34/64 | 2.629 | 2 40/64 | 62 | 4.79 | F32G-2594 |
| 0.270 / 0.277 | 2.540 / 2.555 | 2 35/64 | 2.641 | 2 41/64 | 62 | 5.07 | F32G-2594 |
| 0.278 / 0.285 | 2.556 / 2.570 | 2 36/64 | 2.652 | 2 42/64 | 62 | 5.36 | F32G-2594 |
| 0.286 / 0.293 | 2.571 / 2.586 | 2 37/64 | 2.663 | 2 42/64 | 62 | 5.64 | F32G-2656 |
| 0.293 / 0.301 | 2.587 / 2.602 | 2 38/64 | 2.674 | 2 43/64 | 62 | 5.93 | F32G-2656 |
| 0.301 / 0.309 | 2.603 / 2.617 | 2 39/64 | 2.686 | 2 44/64 | 62 | 6.22 | F32G-2656 |
| 0.309 / 0.316 | 2.618 / 2.633 | 2 40/64 | 2.697 | 2 45/64 | 62 | 6.50 | F32G-2656 |
| 0.317 / 0.324 | 2.634 / 2.648 | 2 41/64 | 2.708 | 2 45/64 | 62 | 6.79 | F32G-2656 |
| 0.325 / 0.332 | 2.649 / 2.664 | 2 42/64 | 2.719 | 2 46/64 | 62 | 7.07 | F32G-2719 |
| 0.333 / 0.340 | 2.665 / 2.680 | 2 43/64 | 2.731 | 2 47/64 | 62 | 7.36 | F32G-2719 |
| 0.340 / 0.348 | 2.681 / 2.695 | 2 44/64 | 2.742 | 2 47/64 | 69 | 0.64 | F32G-2719 |
| 0.348 / 0.355 | 2.696 / 2.711 | 2 45/64 | 2.753 | 2 48/64 | 69 | 0.93 | F32G-2719 |
| 0.356 / 0.363 | 2.712 / 2.727 | 2 46/64 | 2.764 | 2 49/64 | 69 | 1.22 | F32G-2875 |
| 0.364 / 0.371 | 2.728 / 2.742 | 2 47/64 | 2.776 | 2 50/64 | 69 | 1.50 | F32G-2875 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-C

2.5" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|---|---------------------------------|--------------------------------------|------------------------------------|---|-----------|---------|--|
| 0.247 / 0.254 | 2.993 / 3.008 | 3 | 3.099 | 3 6/64 | 78 | 0.7 | F40G-3063 |
| 0.254 / 0.262 | 3.009 / 3.023 | 3 1/64 | 3.109 | 3 7/64 | 78 | 1.0 | F40G-3063 |
| 0.262 / 0.270 | 3.024 / 3.039 | 3 2/64 | 3.120 | 3 8/64 | 78 | 1.3 | F40G-3063 |
| 0.270 / 0.277 | 3.040 / 3.055 | 3 3/64 | 3.131 | 3 8/64 | 78 | 1.5 | F40G-3063 |
| 0.278 / 0.285 | 3.056 / 3.070 | 3 4/64 | 3.142 | 3 9/64 | 78 | 1.8 | F40G-3125 |
| 0.286 / 0.293 | 3.071 / 3.086 | 3 5/64 | 3.153 | 3 10/64 | 78 | 2.1 | F40G-3125 |
| 0.293 / 0.301 | 3.087 / 3.102 | 3 6/64 | 3.164 | 3 11/64 | 78 | 2.4 | F40G-3125 |
| 0.301 / 0.309 | 3.103 / 3.117 | 3 7/64 | 3.175 | 3 11/64 | 78 | 2.6 | F40G-3125 |
| 0.309 / 0.316 | 3.118 / 3.133 | 3 8/64 | 3.186 | 3 12/64 | 78 | 2.9 | F40G-3188 |
| 0.317 / 0.324 | 3.134 / 3.148 | 3 9/64 | 3.197 | 3 13/64 | 78 | 3.2 | F40G-3188 |
| 0.325 / 0.332 | 3.149 / 3.164 | 3 10/64 | 3.208 | 3 13/64 | 78 | 3.5 | F40G-3188 |
| 0.333 / 0.340 | 3.165 / 3.180 | 3 11/64 | 3.219 | 3 14/64 | 78 | 3.8 | F40G-3188 |
| 0.340 / 0.348 | 3.181 / 3.195 | 3 12/64 | 3.230 | 3 15/64 | 78 | 4.0 | F40G-3250 |
| 0.348 / 0.355 | 3.196 / 3.211 | 3 13/64 | 3.241 | 3 15/64 | 78 | 4.3 | F40G-3250 |
| 0.356 / 0.363 | 3.212 / 3.227 | 3 14/64 | 3.252 | 3 16/64 | 78 | 4.6 | F40G-3250 |
| 0.364 / 0.371 | 3.228 / 3.242 | 3 15/64 | 3.263 | 3 17/64 | 78 | 4.9 | F40G-3250 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-C

3.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.262 / 0.270 | 3.524 / 3.539 | 3 34/64 | 3.619 | 3 40/64 | 86 | 5.93 | - |
| 0.270 / 0.277 | 3.540 / 3.555 | 3 35/64 | 3.630 | 3 40/64 | 86 | 6.21 | - |
| 0.278 / 0.285 | 3.556 / 3.570 | 3 36/64 | 3.641 | 3 41/64 | 86 | 6.49 | F48G-3625 |
| 0.286 / 0.293 | 3.571 / 3.586 | 3 37/64 | 3.652 | 3 42/64 | 86 | 6.77 | F48G-3625 |
| 0.293 / 0.301 | 3.587 / 3.602 | 3 38/64 | 3.663 | 3 42/64 | 86 | 7.05 | F48G-3625 |
| 0.301 / 0.309 | 3.603 / 3.617 | 3 39/64 | 3.674 | 3 43/64 | 86 | 7.32 | F48G-3625 |
| 0.309 / 0.316 | 3.618 / 3.633 | 3 40/64 | 3.685 | 3 44/64 | 92 | 1.60 | F48G-3688 |
| 0.317 / 0.324 | 3.634 / 3.648 | 3 41/64 | 3.696 | 3 45/64 | 92 | 1.88 | F48G-3688 |
| 0.325 / 0.332 | 3.649 / 3.664 | 3 42/64 | 3.707 | 3 45/64 | 92 | 2.16 | F48G-3688 |
| 0.333 / 0.340 | 3.665 / 3.680 | 3 43/64 | 3.718 | 3 46/64 | 92 | 2.43 | F48G-3688 |
| 0.340 / 0.348 | 3.681 / 3.695 | 3 44/64 | 3.729 | 3 47/64 | 92 | 2.71 | F48G-3750 |
| 0.348 / 0.355 | 3.696 / 3.711 | 3 45/64 | 3.740 | 3 47/64 | 92 | 2.99 | F48G-3750 |
| 0.356 / 0.363 | 3.712 / 3.727 | 3 46/64 | 3.751 | 3 48/64 | 92 | 3.27 | F48G-3750 |
| 0.364 / 0.371 | 3.728 / 3.742 | 3 47/64 | 3.762 | 3 49/64 | 92 | 3.55 | F48G-3750 |

Note: Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand. This chart refers to Dixon Sanitary Style Crimp Stems.

Table F-D

2.0" Hose Crimp Chart

| Measured Hose Wall Thickness Min. / Max. | Measured Hose OD Min. / Max. | Measured Hose OD In Closest 64ths | Finished Crimp Diameter Decimal | Finished Crimp Diameter Closest 64th | Crimp Die | Setting | Dixon Sanitary Stainless Steel Crimp Ferrules |
|--|------------------------------|-----------------------------------|---------------------------------|--------------------------------------|-----------|---------|---|
| 0.290 | 2.580 | 2 37/64 | 2.770 | 2 49/64 | 69 | 1.4 | F32G-2656 |
| 0.300 | 2.600 | 2 38/64 | 2.790 | 2 50/64 | 69 | 1.8 | F32G-2656 |
| 0.310 | 2.620 | 2 40/64 | 2.800 | 2 51/64 | 69 | 2.2 | F32G-2656 |
| 0.320 | 2.640 | 2 41/64 | 2.820 | 2 52/64 | 69 | 2.6 | F32G-2719 |
| 0.330 | 2.660 | 2 42/64 | 2.830 | 2 53/64 | 69 | 2.9 | F32G-2719 |
| 0.340 | 2.680 | 2 44/64 | 2.850 | 2 54/64 | 69 | 3.3 | F32G-2719 |
| 0.350 | 2.700 | 2 45/64 | 2.860 | 2 55/64 | 69 | 3.7 | F32G-2719 |
| 0.360 | 2.720 | 2 46/64 | 2.880 | 2 56/64 | 69 | 4.1 | F32G-2875 |
| 0.370 | 2.740 | 2 47/64 | 2.900 | 2 56/64 | 69 | 4.5 | F32G-2875 |
| 0.380 | 2.760 | 2 49/64 | 2.910 | 2 58/64 | 69 | 4.8 | F32G-2875 |
| 0.390 | 2.780 | 2 50/64 | 2.920 | 2 59/64 | 69 | 5.2 | F32G-2875 |

Refer to assembly instructions to use branding coil.

Note: A hose pusher is required for coupling insertion.

Refer to Recommended Crimp Chart Index Selection to validate if you are using the appropriate chart for the hose on hand.

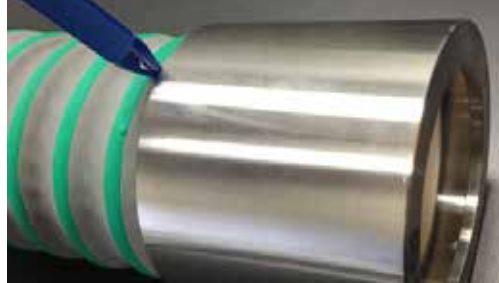
This chart refers to Dixon Sanitary Style Crimp Stems.

Assembly instructions for hose with PVC helix in the cover

1. Using a caliper, measure the hose wall thickness in 4 locations before applying the banding coil, then calculate the average wall thickness.

Banding coil is mainly used to fill the gap between the PVC helices on the cover and to help seal the tube at the tip of the nipple. Use the dedicated transparent banding coils.

2. Slide the ferrule temporary over the hose end, and mark the finish location of the ferrule on the hose.



3. Put the required number of turns of the banding coils under the ferrule position, insert the ferrule and leave about 1" of banding coil past the ferrule edge.



4. Insert the stem, validate the final position of the ferrule and crimp according to crimp chart.

Part Numbers: 21005556 BANDING COIL POLY ROD for EZ GLIDE WINE ID 1.5" and 2" X 5'
21005557 BANDING COIL POLY ROD for EZ GLIDE WINE ID 3 » X5'

ContiTech

Industrial Fluid Solutions

Market segment
Industrial Hose

Contact
ContiTech
703 S. Cleveland Massillon Road
Fairlawn, OH 44333-3023 U.S.A.
1-800-235-4632
www.contitech.us

Your local contact
www.contitech.de/contactlocator

Canada
1-888-275-4397

Mexico
1-800-439-7373

ContiTech. Smart Solutions Beyond Rubber

The ContiTech division of the Continental Corporation is one of the world's leading industry specialists. As a technology partner, our name is synonymous with expertise in development and materials for components made of natural rubber and plastics and also in combination with other materials such as metal, fabrics or silicone. By integrating electronic components, we are also generating solutions for the future.

Beyond products, systems and services, we also provide holistic solutions and have a formative influence on the industrial infrastructure. We see digitalization and current trends as an opportunity to work with our customers to add sustainable value - for both sides and for good.