

Crimp Specifications for

PIRANHAFLEX™
HYDRAULICS

NEW
P400 CRIMPING
SYSTEM

NEW
UPDATED VERSION
MARCH 28, 2023

Using the *KuriCrimp*™ KD100 AND KD200 Series Crimping Systems



KuriCrimp™ KD160SH & SP
Light and powerful (60 ton) to go
anywhere you need to go; makes
hydraulic hose assemblies up to 1
1/4" ID 100R12 four-spiral hose!



KuriCrimp™ KD165
Has a 60 ton press, crimps 2
and 4 wire hose up to 1 1/4"
and 6 wire up to 1" ID.

Or using the *P400 Crimping System*



PF402 Die Series

Adapter Die Bowl



KURIYAMA
OF AMERICA, INC.

Since 1968

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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 KuriCrimpTM units. Be sure to read and follow the instructions in the KuriCrimpTM Operations Guide, the instructions beneath the

word “Important” below, and the specifications in the KuriCrimpTM 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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PIRANHAFLEXTM PF354/PF354NC-02 (USING ONE-PIECE FITTING)

FITTING PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.003"	CRIMP DIAMETER (mm) ± 0.080	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
F02NPT2	1/8	0.365	9.27	9	0.27	98	KD/D100/200-9/BLACK

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

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm)	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION	#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	99	* KD/D100-13/Purple	0.750	0.900
P-04XX	1/4	0.590	14.99	14	0.99	92	KD/D100-14/Yellow	1.125	1.250

* PF321TC-03 "MUST" be crimped using a KD/D100-13/Purple die or 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. NOTE: the -03 size "MUST" be crimped using a KD/D100-13/Purple die.
- 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.

Figure 1

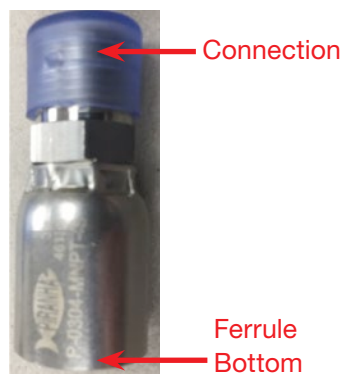


Figure 2



Figure 3

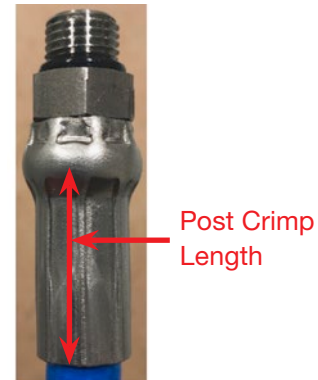
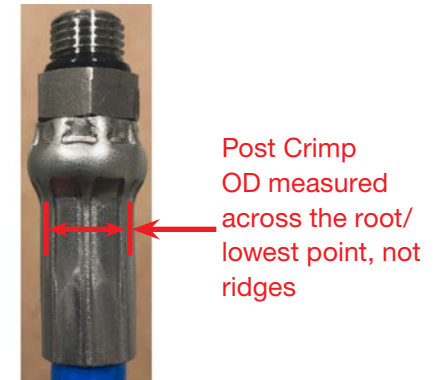


Figure 4



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 & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION	#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	88	KD/D100/200-13/PURPLE	0.750	0.900
P-04XX	1/4	0.590	14.99	14	0.99	92	KD/D100/200-14/YELLOW	1.250	1.250

* PF267/PF267NC/PF354/PF354NC/PFP354/PFP354NC "MUST" be crimped using a KD/D100-13/Purple die or 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. NOTE: the -03 size "MUST" be crimped using a KD/D100-13/Purple die.
- Measure finished crimp length as shown in figure 3. The finish crimp length should be within the +/- tolerances called out in the table above.
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Figure 1

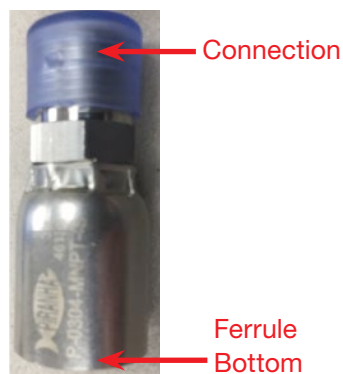


Figure 2

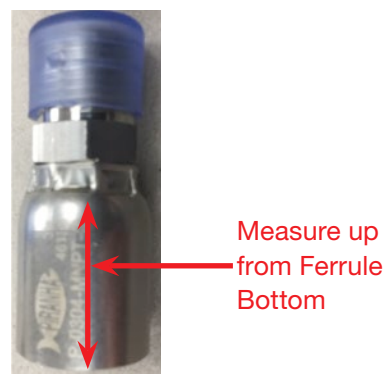


Figure 3

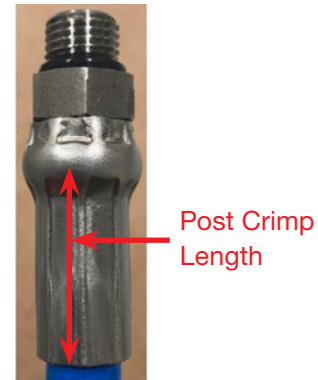
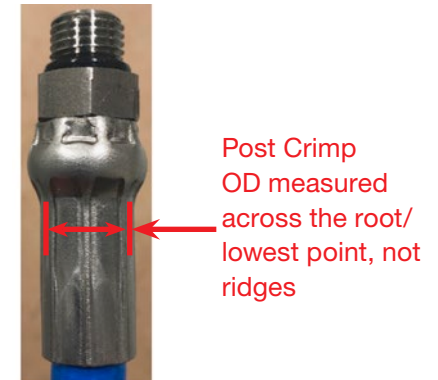


Figure 4



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

FITTING SERIES	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm) ± 0.127	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION	#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	92	KD/D100/200-14/YELLOW	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) ± 0.127	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION	#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	92	KD/D100/200-14/YELLOW	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.
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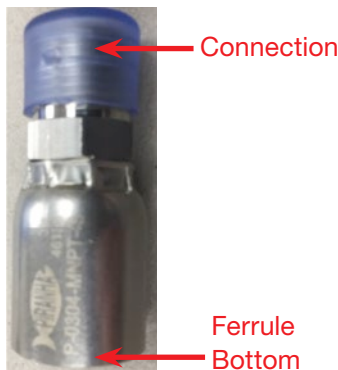


Figure 2



Figure 3

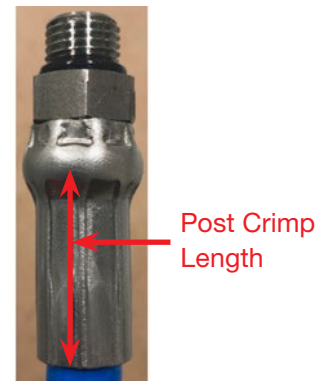
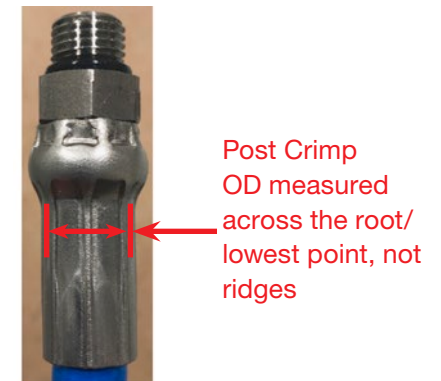


Figure 4



Piranhaflex PF628/PF628NC (USING ONE-PIECE STAINLESS STEEL FITTINGS)

FITTING SERIES	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005 "	CRIMP DIAMETER (mm) ± 0.127	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION	#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	92	KD/D100/200-13/PURPLE	0.750	0.900
P-04XX	1/4	0.560	14.22	14	0.22	98	KD/D100/200-14/YELLOW	1.250	1.250

* PF628/PF628NC "MUST" be crimped using a KD/D100-13/Purple die or 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. NOTE: the -03 size "MUST" be crimped using a KD/D100-13/Purple die.
- 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.

Figure 1



Figure 2

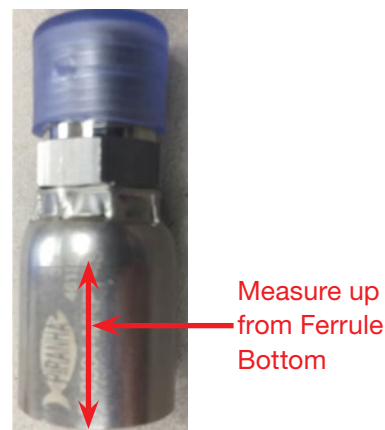


Figure 3

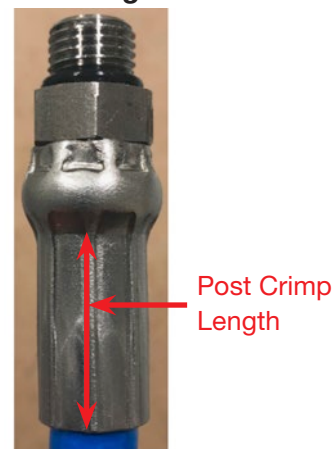
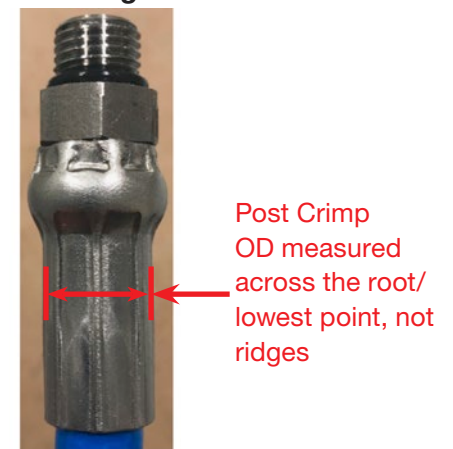


Figure 4



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)	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
PFR-03	3/16	0.475	12.07	12	0.07	99	KD/D100/200-12/Purple
PFR-04	1/4	0.560	14.22	14	0.22	98	KD/D100/200-14/Yellow
PFR7-05	5/16	0.620	15.75	14	1.75	85	KD/D100/200-14/Yellow
PFR-06	3/8	0.700	17.78	16	1.78	85	KD/D100/200-16/Orange
PFR-08	1/2	0.875	22.23	22	0.23	98	KD/D100/200-22/Blue
PFR-12	3/4	1.150	29.21	27	2.21	81	KD/D100/200-27/Brown

*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)	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
PFR3-04	1/4	0.500	12.70	12	0.70	94	KD/D100/200-12/Purple
PFR3-05	5/16	0.600	15.24	14	1.24	89	KD/D100/200-14-Yellow
PFR3-06	3/8	0.665	16.89	16	0.89	92	KD/D100/200-16/Orange
PFR3-08	1/2	0.780	19.81	19	0.81	93	KD/D100/200-19/Black

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)	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
PFR-03	3/16	0.473	12.01	12	0.01	100	KD/D100/200-12/Purple
PFR-04	1/4	0.545	13.84	12	1.84	84	KD/D100/200-12/Purple
PFR-06	3/8	0.685	17.40	16	1.40	88	KD/D100/200-16/Orange
PFR-08	1/2	0.885	22.48	22	0.48	96	KD/D100/200-22/Blue
PFR-12	3/4	1.150	29.21	27	2.21	81	KD/D100/200-27/Brown

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

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm)	DIE & COLOR	METRIC MICROMETER APPROX	KD100 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
AFX-04	1/4	0.700	17.78	16	1.78	85	KD/D100/200-16/Orange
AFX-06	3/8	0.845	21.46	20	1.46	88	KD/D100/200-20/Green
AFX-08	1/2	0.975	24.76	23	1.76	85	KD/D100/200-24/Purple
AFX-12	3/4	1.280	32.51	31	1.51	87	KD/D100/200-31/Yellow

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

FERRULE PART NUMBER	SIZE ID (in)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm)	DIE & COLOR	METRIC MICROMETER APPROX	KD100/200 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
PFR-04	1/4	0.560	14.22	14	0.22	95	KD/D100/200-14/Yellow
PFR-06	3/8	0.700	17.78	16	1.78	85	KD/D100/200-16/Orange
PFR-08	1/2	0.885	22.48	22	0.48	96	KD/D100/200-22/Blue

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

FERRULE PART NUMBER	SIZE ID (in)	SKIVE LENGTH (If Req.)	SKIVE TOOL NUMBER (If Req.)	CRIMP DIAMETER (in) ± 0.005"	CRIMP DIAMETER (mm)	DIE & COLOR	METRIC MICROMETER APPROX	KD100 STANDARD MICROMETER APPROX	KD100/200 SERIES DIE SELECTION
PFR-04	1/4	N/R	N/R	0.560	14.22	14	0.22	98	KD/D100/200-14/Yellow
PFR-06	3/8	N/R	N/R	0.700	17.78	16	1.78	85	KD/D100/200-16/Orange
PFR-08	1/2	N/R	N/R	0.875	22.23	22	0.23	98	KD/D100/200-22/Blue
AFX-12	3/4	N/R	N/R	1.225	31.12	31	0.12	99	KD/D100/200-31/Yellow
AFX-16	1	N/R	N/R	1.600	40.64	39	1.64	86	KD/D100/200-39/Red

Cautionary and Warranty Statement

Cautionary Statement

All Products sold and distributed by Kuriyama of America, Inc. are commodities and are sold based on their ability to perform within each product's published specifications. The Products are not sold for particular purposes, uses or applications. Purchasers and users are solely responsible for determining whether the Products are suitable for the purchaser's or user's intended purposes, uses or applications. Purchasers and users shall conduct their own engineering studies or tests, or retain qualified engineers, consultants or testing laboratories before determining the proper use, suitability or propriety of the Products. Alfagomma and Piranha Hose hoses and fittings are designed, engineered and tested to be used together in an assembly. Alfagomma and Piranha Hose do not recommend or authorize the use of their hoses or fittings with another manufacturer's hoses or fittings, as doing so may result in unreliable or unsafe assemblies.

Purchasers and users should follow all instructions contained in the catalogs, brochures, technical bulletins and other documents of Kuriyama of America, Alfagomma and Piranha Hose. Kuriyama of America, Alfagomma and Piranha Hose recommend only those hose and coupling combinations specified in the applicable Hydraulic Products Catalogs. The Products, including but not limited to, hose, tubing or couplings, may fail due to the use or conveyance of substances at elevated or lowered temperatures or at excessive pressure, the conveyance of abrasive, injurious, flammable, explosive or damaging substances.

Hose or tubing used in bent configurations will be subjected to increased abrasion. Hose clamps or couplings may loosen after initial installation, and all sections of hose and tubing – including connections, couplings, clamps, conductivity and bonding – should be inspected frequently, regularly and consistently, and should be replaced, adjusted or re-tightened to avoid leakage, prevent injuries or damage, and for general safety purposes.

Purchasers or users of the Products should frequently and consistently undertake inspections and protective measures with respect to the use and application of Products, which should include the examination of tube and cover, conditions of the hose or tubing, and the identification, repair or replacement of sections showing cracking, blistering, separations, internal and external abrasions, leaking or slipped couplings or connections and make proper proof tests.

Kuriyama of America, Alfagomma and Piranha Hose shall not be liable or responsible for hose assemblies that have not been produced in conformance with their assembly recommendations and current crimp data charts.

Limited Warranty and Limitation of Liability

The Products sold or distributed by Kuriyama of America are warranted to its customers to be free from defects in material and workmanship at the time of shipment by us, subject to the following provisions. ALL WARRANTY CLAIMS SHALL BE MADE WITHIN SIX (6) MONTHS AFTER KURIYAMA OF AMERICA SHIPPED THE PRODUCTS. KURIYAMA OF AMERICA'S LIABILITY HEREUNDER IS LIMITED, AT KURIYAMA OF AMERICA'S EXCLUSIVE DISCRETION, TO 1) REFUND OF THE PURCHASE PRICE PAID TO IT FOR DEFECTIVE PRODUCTS; OR 2) REPLACEMENT OF ANY DEFECTIVE PRODUCT OR PART UPON ITS AUTHORIZED RETURN TO KURIYAMA OF AMERICA.

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