

Crimp Calculation for all No Sweat® Style Fittings

- 1) Hose O.D. _____ (-) Hose I.D. _____ (Total Hose Wall) = (A) _____
 - 2) (A) Times (x) _____ (Percentage Compression Multiplier). = (B) + _____
 - 3) Ferrule Wall Thickness _____ (x) 2 = (C) + _____
 - 4) Hose I.D. _____ = (E) + _____
- Theoretical Crimp O.D. (B + C+ E) = _____

****Percentage Compression Multiplier****

15% = .85 17% = .83 20% = .80 22% = .78 25% = .75

Crimp Calculation for all Pressed In Style Fittings

- 1) Hose O.D. _____ (-) Hose I.D. _____ (Total Hose Wall) = (A) _____
 - 2) (A) Times (x) _____ (Percentage Compression Multiplier). = (B) + _____
 - 3) Ferrule Wall Thickness _____ (x) 2 = (C) + _____
 - 4) Allowance for increase in hose O.D. with the stem = (D) + _____
**** See Chart Below****
 - 5) Hose I.D. _____ = (E) + _____
- Theoretical Crimp O.D. (B + C+ D + E) = _____

Allowance for increase in Hose OD after inserting Stem:

M200 + .035	M500 + .050
M250 + .035	M600 + .050
M300 + .035	M800 + .050
M400 + .035	

****Percentage Compression Multiplier****

15% = .85 17% = .83 20% = .80 22% = .78 25% = .75

MMMI

MARIO MANUFACTURING, INC.

Standard No Sweat and NS150 Assemblies Crimp Calculation Data Chart

Hose Size	Ferrule Part#	Ferrule Wall	Std NS Comp.	Crimp Length	NS150 Comp	Crimp Length	Hose Size	Ferrule Part#	Ferrule Wall	Std NS Comp.	Crimp Length	NS150 Comp	Crimp Length
2"	F200-A	0.120	22%	2-5/8"	25%	1-3/4"	4"	F400-C	0.188	24%	4"		
2"	F200-B	0.120	22%	2-5/8"			4"	F400-D	0.120	24%	4"		
2"	F200-C	0.120	24%	2-5/8"			5"	F500-AA	0.120	20%	4-1/2"	25%	3-3/4"
2"	F200-D	0.120	24%	2-5/8"			5"	F500-A	0.188	24%	4-1/2"		
2-1/2"	F250-A	0.120	22%	2-7/8"			5"	F500-B	0.188	24%	4-1/2"		
2-1/2"	F250-B	0.120	22%	2-7/8"			5"	F500-C	0.188	24%	4-1/2"		
2-1/2"	F250-C	0.120	24%	2-7/8"			6"	F600-AA	0.188	22%	5-1/8"	25%	5"
2-1/2"	F250-D	0.120	24%	2-7/8"			6"	F600-A	0.188	24%	5-1/8"		
3"	F300-AA	0.120	20%	3-3/8"	25%	2-3/8"	6"	F600-B	0.188	24%	5-1/8"		
3"	F300-A	0.120	22%	3-3/8"			6"	F600-C	0.188	24%	5-1/8"		
3"	F300-B	0.120	22%	3-3/8"			6"	F600-D	0.250	24%	5-1/8"		
3"	F300-C	0.120	24%	3-3/8"			8"	F800-AA	0.188	22%	6-1/8"	25%	5-5/8"
3"	F300-D	0.188	24%	3-3/8"			8"	F800-A	0.250	24%	6-1/8"		
4"	F400-AA	0.120	20%	4"	25%	3-3/8"	8"	F800-B	0.250	24%	6-1/8"		
4"	F400-A	0.188	22%	4"			8"	F800-C	0.250	24%	6-1/8"		
4"	F400-B	0.120	22%	4"			8"	F800-D	0.250	24%	6-1/8"		

NS300 Stainless Chemical Assemblies

Hose Size	Ferrule Part#	Ferrule Wall	Std Comp	Crimp Length	Hose Size	Ferrule Part#	Ferrule Wall	Std Comp	Crimp Length
1-1/2"	F150-A	0.120	25%	1-7/8"	3"	F300-A	0.120	25%	2-1/2"
2"	F200-A	0.120	25%	2-1/4"	4"	F400-AA	0.120	25%	3"
2"	F200-B	0.120	25%	2-1/4"	4"	F400-A	0.188	25%	3"
3"	F300-AA	0.120	25%	2-1/2"					

MMI Gold Stems and Ferrules (To Be Used When Having to Press Fitting Into Hose)

Hose Size	Ferrule Part#	Ferrule Wall	Exp Fac Decimal	Exp Fac 1/64"	Std Comp	Crimp Length	Hose Size	Ferrule Part#	Ferrule Wall	Exp Fac Decimal	Exp Fac 1/64"	Std Comp	Crimp Length
2"	F200-A	0.120	0.035	2/64"	22%	2-5/8"	4"	F400-C	0.188	0.035	2/64"	24%	4"
2"	F200-B	0.120	0.035	2/64"	22%	2-5/8"	4"	F400-D	0.120	0.035	2/64"	24%	4"
2"	F200-C	0.120	0.035	2/64"	24%	2-5/8"	5"	F500-AA	0.120	0.050	3/64"	22%	4-1/2"
2"	F200-D	0.120	0.035	2/64"	24%	2-5/8"	5"	F500-A	0.188	0.050	3/64"	24%	4-1/2"
2-1/2"	F250-A	0.120	0.035	2/64"	22%	2-7/8"	5"	F500-B	0.188	0.050	3/64"	24%	4-1/2"
2-1/2"	F250-B	0.120	0.035	2/64"	22%	2-7/8"	5"	F500-C	0.188	0.050	3/64"	24%	4-1/2"
2-1/2"	F250-C	0.120	0.035	2/64"	24%	2-7/8"	6"	F600-AA	0.188	0.050	3/64"	22%	5-1/8"
2-1/2"	F250-D	0.120	0.035	2/64"	24%	2-7/8"	6"	F600-A	0.188	0.050	3/64"	24%	5-1/8"
3"	F300-AA	0.120	0.035	2/64"	20%	3-3/8"	6"	F600-B	0.188	0.050	3/64"	24%	5-1/8"
3"	F300-A	0.120	0.035	2/64"	22%	3-3/8"	6"	F600-C	0.188	0.050	3/64"	24%	5-1/8"
3"	F300-B	0.120	0.035	2/64"	22%	3-3/8"	6"	F600-D	0.250	0.050	3/64"	24%	5-1/8"
3"	F300-C	0.120	0.035	2/64"	24%	3-3/8"	8"	F800-AA	0.188	0.050	3/64"	24%	6-1/8"
3"	F300-D	0.188	0.035	2/64"	24%	3-3/8"	8"	F800-A	0.250	0.050	3/64"	24%	6-1/8"
4"	F400-AA	0.120	0.035	2/64"	20%	4"	8"	F800-B	0.250	0.050	3/64"	24%	6-1/8"
4"	F400-A	0.188	0.035	2/64"	22%	4"	8"	F800-C	0.250	0.050	3/64"	24%	6-1/8"
4"	F400-B	0.120	0.035	2/64"	22%	4"	8"	F800-D	0.250	0.050	3/64"	24%	6-1/8"

Note: The compression % listed are meant to be generic for MMI Couplings. Compression % may need to be adjusted for individual hose brands and applications. Adjustments are the responsibility of end user.

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Crimp Calculation Data Chart

DECIMAL EQUIVALENT CHART

INCHES by 1/64"	DECIMAL EQUIVALENT		INCHES by 1/64"	DECIMAL EQUIVALENT
1/64"	0.016		33/64"	0.515
2/64"	0.031		34/64"	0.531
3/64"	0.047		35/64"	0.547
4/64"	0.063		36/64"	0.563
5/64"	0.078		37/64"	0.578
6/64"	0.094		38/64"	0.594
7/64"	0.109		39/64"	0.609
8/64"	0.125		40/64"	0.625
9/64"	0.141		41/64"	0.641
10/64"	0.156		42/64"	0.656
11/64"	0.172		43/64"	0.672
12/64"	0.188		44/64"	0.688
13/64"	0.203		45/64"	0.703
14/64"	0.219		46/64"	0.718
15/64"	0.234		47/64"	0.734
16/64"	0.250		48/64"	0.750
17/64"	0.266		49/64"	0.766
18/64"	0.281		50/64"	0.781
19/64"	0.297		51/64"	0.797
20/64"	0.313		52/64"	0.813
21/64"	0.328		53/64"	0.828
22/64"	0.344		54/64"	0.844
23/64"	0.360		55/64"	0.860
24/64"	0.375		56/64"	0.875
25/64"	0.391		57/64"	0.891
26/64"	0.406		58/64"	0.906
27/64"	0.422		59/64"	0.922
28/64"	0.438		60/64"	0.938
29/64"	0.453		61/64"	0.953
30/64"	0.469		62/64"	0.969
31/64"	0.484		63/64"	0.984
32/64"	0.500		64/64"	1.000