



Westco Crimping Guide lines for Westco fittings

Best to start .020" to .030" larger and then adjust from there. The hose diameters, machine settings and die sizes can all vary.

We have been using these ratio formulas and usually are very close to the desired crimp diameter. Be sure to check for the proper hose bubble inside at the back of the fitting. Refer to our picture for example.

Example: if you have a 1 1/2" ID hose and the OD is 2.25. Multiple the 2.25 inches x the 1.050 multiplier and your starting crimp diameter should be 2.36". Adjust as needed.

Multiplier chart:

1" hose

If hose OD is 1.46" or below use x 1.10

If hose is 1.47" to 1.59" use x 1.090

If hose is 1.60" and above use x 1.075

1 1/2" hose

If hose is 2.00" and below use x 1.060

If hose is 2.01" and above use x 1.050

2" hose

If hose is 2.62" and below use x 1.040

If hose is 2.63" and above use x 1.030

2 1/2" hose

Use x 1.030 on all hoses

3" hose

Use x 1.012 on all hoses