CRIMPING PARAMETERS CHART

inches

BRAIDED HOSES
Tubi trecciati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
TEKNO/1SN EN 853 1SN - SAE100 R1AT (scelta consigliata) (recommended option) Nota / Note: F E	B12T..N FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.630	0.709	0.732	0.807	0.921	1.063	1.213	1.539	1.909	2.244	2.732
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.630	0.701	0.787	0.929	1.079	1.189	1.492			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1T FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	
		0.606	0.646	0.717	0.791	0.953	1.039	1.213	1.531	1.835	2.134	
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
	B12T FOR STANDARD FITTINGS					.08	.10	.12				
						0.925	1.039	1.213				
						n.s.	n.s.	n.s.				
TEKNO/2SN EN 853 2SN - SAE100 R2AT (scelta consigliata) (recommended option) Nota / Note: F E	B12T..N FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.657	0.748	0.772	0.839	0.961	1.110	1.260	1.587	2.008	2.323	2.862
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B2T FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	
		0.618	0.709	0.795	0.843	1.008	1.122	1.260	1.614	1.969	2.264	
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
	B12T FOR STANDARD FITTINGS					.08	.10	.12				
						0.961	1.071	1.260				
						n.s.	n.s.	n.s.				
TEKNO/1ST EN 853 1ST Nota / Note: F E	B1R.. FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.598	0.677	0.740	0.827	1.000	1.110	1.268	1.567	1.835	2.087	2.606
		0.709	0.827	0.866	0.906	0.984	1.102	1.339	1.457	1.693	1.850	2.441
TEKNO/2ST EN 853 2ST Nota / Note: F E	B2R.. FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.693	0.701	0.799	0.906	1.012	1.142	1.319	1.622	2.000	2.232	2.736
		0.728	0.827	0.866	0.906	0.984	1.102	1.339	1.457		1.850	2.520
TEKNO/1SC EXCEED AN857 1SC (scelta consigliata) (recommended option) Nota / Note: F E	B1SC.. FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.602	0.661	0.732	0.886	1.039	1.150	1.453			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	*3			
	B1K FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			0.591	0.642	0.732	0.894	1.039	1.161	1.492	1.764	2.019	2.543
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
TEKNO/2SC EXCEED AN857 2SC (scelta consigliata) (recommended option) Nota / Note: F E	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			18.2	19.0	20.6	23.5	27.4	31.1	39.1	48.7	56.2	71.0
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.638	0.709	0.787	0.937	1.094	1.193	1.492			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

BRAIDED HOSES
Tubi trecciati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
TEKNO/1SC PLUS EXCEED AN857 1SC Nota / Note: F E	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.602	0.661	0.732	0.886	1.039	1.150	1.453			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	*3			
	B1K FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			0.591	0.642	0.732	0.894	1.039	1.161	1.492	1.764	2.000	2.543
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
TEKNO/2SC PLUS EXCEED AN857 2SC (scelta consigliata) (recommended option) Nota / Note: F E	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			0.717	0.748	0.811	0.925	1.079	1.224	1.539	1.917	2.213	2.795
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.638	0.709	0.787	0.937	1.094	1.193	1.492			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
FORTHREE	B2R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16			
			0.748		0.945	1.055	1.193	1.370	1.657			
			0.827		0.906	0.984	1.102	1.339	1.457			
TEKNOMASTER 2SN	B2R FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.693	0.787	0.902	1.024	1.169	1.323	1.638			
			0.827	0.866	0.906	0.984	1.102	1.339	1.457			
STRONGER/1 SAE 100 R16 (scelta consigliata) (recommended option)	B1R FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20		
		0.606	0.681	0.732	0.807	0.992	1.079	1.220	1.535	1.799		
		0.709	0.827	0.866	0.906	0.984	1.102	1.339	1.457	1.693		
	B12T..N FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10					
		0.638	0.713	0.724	0.787	0.913	1.031					
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.					
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.634	0.693	0.768	0.921	1.047	1.142	1.500			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
SLIM (scelta consigliata) (recommended option)	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08		.12				
			0.591	0.661	0.717	0.862		1.130				
			n.s.	n.s.	n.s.	n.s.		n.s.				
	B1K FOR STANDARD FITTINGS		.04	.05	.06	.08			.16			
			0.563	0.618	0.681	0.854			1.390			
			n.s.	n.s.	n.s.	n.s.			n.s.			
	B7R FOR STANDARD FITTINGS	.03										
		0.484										
		n.s.										

*3 Note: Controllare con tampone No-Go diametro 19.65 mm
*3 Note: Check with No-Go gauge diameter 19.65 mm

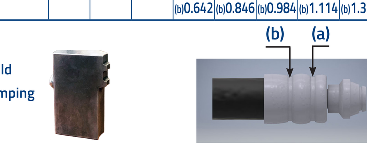
BRAIDED HOSES
Tubi trecciati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
TEKNOJACK	B12T..N FOR STANDARD FITTINGS		.04		.06							
			0.748		0.799							
			n.s.		n.s.							
LIFT-PLUS EN 81.2 (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS										.24	.32
											2.236	2.795
											n.s.	n.s.
	B1SC FOR STANDARD FITTINGS							.12	.16			
								1.150	1.433			
								n.s.	n.s.			
	B1R FOR STANDARD FITTINGS									.20		
										1.795		
										1.693		
	B1K FOR STANDARD FITTINGS									.20		
										1.756		
										n.s.		
	B1T FOR STANDARD FITTINGS									.20		
										1.799		
										n.s.		
SERVOCOMANDO	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.610	0.669	0.732	0.886						
			n.s.	n.s.	n.s.	n.s.						
ALPI 3300	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.614	0.665	0.740	0.886	1.102	1.201	1.492			
			ns	ns	ns	ns	ns	ns	ns			
ALPI 4000 (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS			.05	.06	.08	.10	.12	.16			
				0.748	0.811	0.925	1.075	1.224	1.535			
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.622	0.709	0.787	0.937	1.091	1.193	1.488	0.000		
			ns	ns	ns	ns	ns	ns	ns			
ICEBERG/1 EXCEED EN853 1SN SAE 100 R1AT	B1R FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.598	0.677	0.740	0.827	1.000	1.110	1.268	1.567	1.835	2.087	2.606
		0.709	0.827	0.866	0.906	0.984	1.102	1.339	1.457	1.693	1.850	2.441
ICEBERG/2 EXCEED EN853 2SN SAE 100 R2AT	B2R FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.693	0.701	0.799	0.906	1.012	1.142	1.319	1.622	2.000	2.232	2.736
		0.728	0.827	0.866	0.906	0.984	1.102	1.339	1.457	1.693	1.850	2.520

BRAIDED HOSES
Tubi trecciati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
ICEBERG/3	B2R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16			
			0.748		0.945	1.055	1.193	1.370	1.657			
			0.827		0.906	0.984	1.102	1.339	1.457			
VULCAN /1 EXCEED EN853 1SN SAE R1AT	B1R FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.598	0.677	0.740	0.827	1.000	1.110	1.268	1.567	1.835	2.087	2.606
		0.709	0.827	0.866	0.906	0.984	1.102	1.339	1.457	1.693	1.850	2.441
VULCAN /2 EXCEED EN853 2SN SAE R2AT	B2R.. FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.693	0.701	0.799	0.906	1.012	1.142	1.319	1.622	2.000	2.232	2.736
		18.5	21	22	23	25	28	34	37	43	47	64
VULCAN AIR EXCEED EN857 1SC (scelta consigliata) (recommended option)	BVA.. FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	.20	.24	
					(a)0.622	(a)0.827	(a)0.965	(a)1.094	(a)1.378	(a)1.622	(a)1.870	
					(b)0.642	(b)0.846	(b)0.984	(b)1.114	(b)1.398	(b)1.642	(b)1.890	

mould crimpning unit



NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
PREMIER (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.709	0.740	0.811	0.925	1.087	1.220	1.539			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
PREMIER ONE	B1K FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.575	0.653	0.700	0.854	1.015	1.153	1.433			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

° I DIAMETRI DI PRESSATURA INDICATI SONO VALIDI ANCHE PER LE VERSIONI **FOREVER e EVERGREEN** F E

° CRIMPING DIAMETERS REPORTED IN THIS DOCUMENT ARE VALID ALSO FOR **FOREVER AND EVERGREEN** VERSIONS F E

BRAIDED HOSES
Tubi trecciati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
DOLOMITI/1SN EN 853 1SN - SAE100 R1AT (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.630	0.709	0.732	0.807	0.921	1.063	1.213	1.539	1.909	2.244	2.732
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.630	0.701	0.787	0.929	1.079	1.189	1.492			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1T FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	
		0.606	0.646	0.717	0.791	0.953	1.039	1.213	1.531	1.835	2.134	
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
	B12T FOR STANDARD FITTINGS					.08	.10	.12				
						0.925	1.039	1.213				
						n.s.	n.s.	n.s.				
DOLOMITI/2SN EN 853 2SN - SAE100 R2AT (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
		0.657	0.748	0.772	0.839	0.961	1.110	1.260	1.587	2.008	2.323	2.862
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B2T FOR STANDARD FITTINGS	.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	
		0.618	0.709	0.795	0.843	1.008	1.122	1.260	1.614	1.969	2.264	
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
	B12T FOR STANDARD FITTINGS					.08	.10	.12				
						0.961	1.071	1.260				
						n.s.	n.s.	n.s.				
DOLOMITI/1SC EXCEED AN857 1SC (scelta consigliata) (recommended option)	B1SC.. FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.602	0.661	0.732	0.886	1.039	1.150	1.453			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	*3			
	B1K FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			0.591	0.642	0.732	0.894	1.039	1.161	1.492	1.764	2.000	2.543
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
DOLOMITI/2SC EXCEED AN857 2SC (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			0.717	0.748	0.811	0.925	1.079	1.224	1.539	1.917	2.213	2.795
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0.638	0.709	0.787	0.937	1.094	1.193	1.492			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

SPIRAL HOSES
Tubi spiralati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
TEKNOSPIR/4SP EN856 4SP (impieghi severi) (severe applications) Nota / Note: F E	B9R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16	.20	.24	.32
			0.756		0.913	1.035	1.173	1.319	1.646	2.150	2.303	2.937
			0.827		0.906	1.063	1.220	1.417	1.890	2.126	2.441	2.520
	KB4SH FOR INTERLOCK FITTINGS							.12	.16			
								1.335	1.634			
								0.591 in. 2.047out.	0.669 in. 2.638out.			
	B5K FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	B5K206		
					1.016	1.122	1.295	1.417	1.713	2.244		
					n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS				.06	.08	.10	.12	.16			
					1.028	1.133	1.334	1.476	1.831			
					n.s.	n.s.	n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS									.20	.24	
										2.295	coming soon	
										n.s.	n.s.	
TEKNOSPIR/4SH EN856 4SH (impieghi severi) (severe applications) Nota / Note: F E	KB4SH FOR INTERLOCK FITTINGS						.10	.12	.16	.20	.24	.32
							1.252	1.335	1.634	1.976	2.252	2.921
							0.551in 1.870out	0.591 in. 2.047out.	0.669 in. 2.638out.	0.846in. 2.913out.	0.86 in. 3.19 out.	1.141 in. 3.346out
	B4SH FOR STANDARD FITTINGS									.20	.24	.32
										1.858	2.283	2.776
										2.126	2.441	2.520
	B5K FOR STANDARD FITTINGS							.12	.16	B5K204		
								1.417	1.720	2.126		
								n.s.	n.s.			
	HB4NS FOR HYPERSPIRAL FITTINGS						.10	.12	.16	.20	.24	
							1.385	1.476	1.839	2.185	2.484	
							n.s.	n.s.	n.s.	n.s.	n.s.	

° I DIAMETRI DI PRESSATURA INDICATI SONO VALIDI ANCHE PER LE VERSIONI **ICEBERG / FOREVER / EVERGREEN** F E

° CRIMPING DIAMETERS REPORTED IN THIS DOCUMENT ARE VALID ALSO FOR **ICEBERG / FOREVER / EVERGREEN** VERSIONS F E

SPIRAL HOSES
Tubi spiralati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
TEKNOSPIR/12 EN856 R12 SAE 100 R12 Nota / Note: F E	B9R FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	.20	.24	
					0.906	1.043	1.197	1.339	1.650	2.083	2.303	
					0.906	1.063	1.220	1.417	1.890	2.126	2.441	
	B4SH FOR STANDARD FITTINGS										.24	.32
											2.319	2.780
											2.441	2.520
	B5K FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	B5K206		
					1.031	1.086	1.272	1.409	1.713	2.244		
					n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS				.06	.08	.10	.12	.16			
					1.028	1.142	1.319	1.468	1.831			
					n.s.	n.s.	n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS									.20	.24	
										2.295	coming soon	
										n.s.	n.s.	
TEKNOSPIR/13 EN856 R13 SAE 100 R13 Nota / Note: F E	KB4SH INTERLOCK FITTINGS							.12	.16	.20		
								1.366	1.661	1.960		
								0.591 in. 2.047out.	0.669 in. 2.638out.	0.846 in. 2.913out.		
	KBH13 FOR INTERLOCK FITTINGS										.24	.32
											2.350	3.079
											0.866in. 3.18out	1.14in. 3.34out.
	HB4NS FOR HYPERSPIRAL FITTINGS							.12	.16	.20		
								1.476	1.831	2.185		
								n.s.	n.s.	n.s.		
TEKNOSPIR/15 EN856 R12 SAE 100 R15 Nota / Note: F E	KB4SH INTERLOCK FITTINGS							.12	.16			
								1.335	1.634			
								0.591 in. 2.047out.	0.669 in. 2.638out.			
	KBH13 INTERLOCK FITTINGS									.20	.24	.32
										2.150	2.413	3.047
										0.846in. 2.913out.	0.866in. 3.18out	1.14in. 3.34out.
	HB4NS FOR HYPERSPIRAL FITTINGS						.10	.12	.16			
							1.358	1.476	1.839			
							n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS									.20		
										2.271		
										n.s.		

SPIRAL HOSES
Tubi spiralati

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
EVEREST/3000	B9R FOR STANDARD FITTINGS									.20	.24	.32
										coming soon	2.303	coming soon
										2.126	2.441	2.520
	B5K FOR STANDARD FITTINGS									B5K206		
										2.244		
										n.s.		
	HB6NS FOR HYPERSPIRAL FITTINGS									.20	.24	
										2.295	coming soon	
										n.s.	n.s.	
EVEREST/4000	B9R FOR STANDARD FITTINGS					.08	.10	.12	.16	.20	.24	.32
						coming soon	coming soon	1.339	1.654	2.094	coming soon	coming soon
						1.063	1.220	1.417	1.890	2.126	2.441	2.520
	B5K FOR STANDARD FITTINGS					.08	.10	.12	.16	.20		
						1.086	1.271	1.409	1.713	2.126		
						n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS					.08	.10	.12	.16	.20	.24	
						1.130	1.319	1.468	coming soon	2.185	2.484	
						n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
EVEREST/5000	KB4SH FOR INTERLOCK FITTING							.12	.16	.20	.24	.32
								1.335	1.626	1.960	coming soon	coming soon
								0.591in. 2.047out.	0.669 in. 2.638out.	0.846 in. 2.913out.	0.866in. 3.18out	1.14in. 3.34out.
	KBH13 FOR INTERLOCK FITTINGS										.24	.32
											2.350	3.079
											0.866in. 3.18out	1.14in. 3.34out.
	B9R FOR STANDARD FITTINGS					.08	.10	.12	.16	.20		
						coming soon	1.149	1.307	1.638	2.051		
						1.063	1.220	1.417	1.890	2.126		
	B5K FOR STANDARD FITTINGS					.08	.10	.12	.16	B5K204		
						1.122	1.295	1.417	1.713	2.126		
						n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS					.08	.10	.12	.16	.20		
						1.134	1.335	1.476	1.830	2.185		
						n.s.	n.s.	n.s.	n.s.	n.s.		

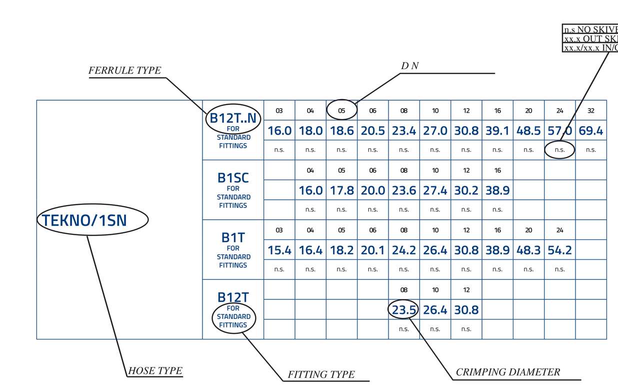
SPIRAL HOSES
Tubi spiralati

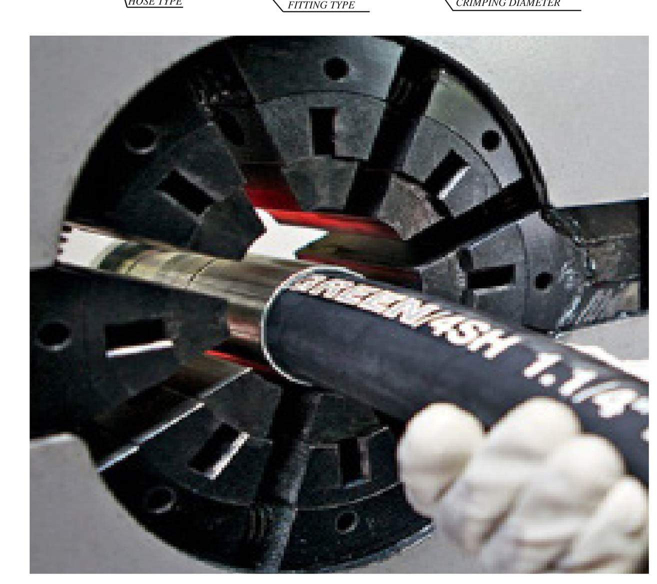
NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
EVEREST/6000	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1.335	1.626			
								0.591in. 2.047out.	0.669 in. 2.638out.			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2.098	2.372	coming soon
										0.85 in. 2.91 out.	0.866in. 3.18out	1.14in. 3.34out.
	HB4NS FOR HYPERSPIRAL FITTINGS				.06	.08	.10	.12	.16			
					1.027	1.142	1.326	1.476	1.838			
					n.s.	n.s.	n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS									.20		
										2.275		
										n.s.		
	B9R FOR STANDARD FITTINGS		.04		.06	.08	.10					
			coming soon		coming soon	coming soon	coming soon					
			0.827		0.906	1.063	1.220					
TEKNOBLAST AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS				.06	.08		.12				
					0.961	1.110		1.520				
					0.59 in. 47 out.	0.63 in. 52 out.		0.75 in. 54 out.				
TEKNOBLAST PLUS AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS				.06	.08		.12	.16			
					0.969	1.146		1.531	1.634			
					0.59 in. 47 out.	0.63 in. 52 out.		0.75 in. 54 out.	0.67 in. 57 out.			
TEKNOBLAST SUPERB AS/NZS 4233.2	WB6 FOR WATERBLAST-FITTINGS					.08		.12				
						-		1.622				
						-		0.75 in. 54 out.				

Nota: Data la larga tolleranza ammessa sulle dimensioni dei tubi, le quote di pressatura espresse sono indicative, si consiglia pertanto di utilizzare sempre i tamponi passa non passa per verificare il giusto collasso del codolo.

Note: Considering the wide tolerance admitted on the hoses dimensions, the expressed crimping diameters have to be considered as approximate; therefore, it is recommended to use always the go – no go g auge in order to check the tail collapse.

HOW TO READ THIS CHART





TERMOPLASTIC HOSES

HOSES		DN/DASH SIZE	0,2/-03	0,2/-04	0,3/-05	0,4/-06	0,5/-08	0,6/-10	0,7/-12	1,0/-12	1,2/-20	1,5/-24	2,0/-32
		FERRULES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
R7* THERMO-PLASTIC * Diametri di pressatura su tubo ZEC * Crimping diameter on ZEC hose	B7R		B7R03	B7R04	B7R05	B7R06	B7R08	B7R10	B7R12	B7R16			
			11.8	14.1	16.2	18.2	22.2	25.6	29.0	36.8			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1K			B1K04	B1K05	B1K06	B1K08						
				14.0	17.0	17.6	22.8						
				n.s.	n.s.	n.s.	n.s.						
R7 MTH1* THERMO-PLASTIC * Diametri di pressatura su tubo ZEC * Crimping diameter on ZEC hose	B7R		B7R03	B7R04	B7R05	B7R06	B7R08	B7R10	B7R12	B7R16			
			11.8	14.1	16.2	18.2	22.2	25.6	29.0	36.8			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1K			B1K04	B1K05	B1K06	B1K08						
				13.8	17.0	18.0	21.7						
				n.s.	n.s.	n.s.	n.s.						

TEXTILE HOSES

HOSES		DN/DASH SIZE	0,2/-03	0,2/-04	0,3/-05	0,4/-06	0,5/-08	0,6/-10	0,7/-12	1,0/-12	1,2/-20	1,5/-24	2,0/-32
		FERRULES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
1TE/R6	B7R			B7R04	B7R05	B7R06	B7R08	B7R10	B7R12				
				0.591	0.654	0.724	0.890	1.028	1.154	0.000			
	B1K			B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16			
				0.598	0.657	0.713	0.874	1.051	1.173	1.449			
	B1 T		B1T03										
			0.598										
	B6R		B6R03										
			0.476										
2TE	B7R			B7R04	B7R05	B7R06	B7R08						
				0.610	0.657	0.728	0.909						
	B1K			B1K04	B1K05	B1K06	B1K08		B1K12			B1K24	
				0.598	0.681	0.732	0.901		1.181			2.047	
	B1T		B1T03										
			0.630										
	B3R							B3R10	B3R12	B3R16	B3R20		
								1.067	1.280	1.606	1.831		
3TE			B1T03	B3R04	B3R05	B3R06	B3R08	B3R10	B3R12	B3R16	B3R20	B1T24	
			0.622	0.614	0.768	0.846	0.961	1.118	1.295	1.622	1.831	2.106	0.000
R3 TEXTILES HOSES	B3R						B3R08	B3R10	B3R12	B3R16			
							0.984	1.122	1.409	1.622			
R4 TEXTILES HOSES LISCIO (SMOOTH)									B3R12	B3R16	B3R20	B12T24N	B12T32N
									1.339	1.669	1.921	2.311	2.823
R4 SAUGFLEX X- PLUS-G LISCIO (SMOOTH)									B3R12	B3R16	B3R20	B1T24	B12T32N
									1.319	1.650	1.882	2.154	2.902
R4 SAUGFLEX CORRUGATO (CORRUGATED)									B3R12	B3R16	B3R20	B1T24	B12T32N
									1.213	1.642	1.882	2.165	2.764
CLEAN FARM	B1SC						B1SC08						
							0.961						
	B1K						B1K08						
							0.913						
R8* TEXTILES HOSES			B7R03	B1K04	B1K05	B1K06	B1K08						
			0.465	0.551	0.657	0.697	0.882						
R18 TEXTILES HOSES	B1SC			B1SC04	B1SC05	B1SC06							
				0.602	0.709	0.787							

PTFE

HOSES		DN/DASH SIZE	0,2/-03	0,2/-04	0,3/-05	0,4/-06	0,5/-08	0,6/-10	0,7/-12	1,0/-16	1,2/-20	1,5/-24	2,0/-32
		FERRULES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
PTFE LISCIO (SMOOTH) 1BRAID *	BPTFE		BPTFE03	BPTFE04	BPTFE05	BPTFE06	BPTFE08	BPTFE10	BPTFE12	BPTFE16			
			0.433	0.516	0.579	0.638	0.819	0.874	1.098	1.358			
PTFE LISCIO (SMOOTH) 2BRAIDS *			BPTFE03	B7R04	B7R05	B7R06	BPTFE08	B7R10		B7R16			
			0.472	0.504	0.610	0.661	0.831	0.961		1.366			
PTFE CORRUGATO (CORRUGATED)	BPTFEC			BPTFEC04		BPTFEC06	BPTFEC08	BPTFEC10	BPTFEC12	BPTFEC16	BPTFEC20	BPTFEC24	BPTFEC32
				0.504		0.630	0.764	0.874	1.031	1.283	1.772	1.984	2.480
	B7R			B7R04				B7R10					
				0.504				0.957					

* VALIDO ANCHE PER TUBO CONDUTTIVO (ALSO VALID FOR CONDUCTING TUBE)

CLEANER HOSES
Tubi idropulitrice

NOMINAL BORE / INTERNAL DIAMETER	DN	5	6	8	10	12	16	19	25	31	38	51
	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4.8	6.4	7.9	9.5	12.8	16	19	25.4	31.8	38.1	50.8
TEKNOJET/1SN IEC-60335-2 (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.709	0.732	0.807	0.921						
			n.s.	n.s.	n.s.	n.s.						
	B1R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.677	0.740	0.827	1.000						
			0.827	0.866	0.906	0.984						
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.630	0.701	0.787	0.929						
			n.s.	n.s.	n.s.	n.s.						
TEKNOJET/2SN IEC-60335-2 (scelta consigliata) (recommended option)	B2R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.701	0.799	0.906	1.012						
			0.827	0.866	0.906	0.984						
	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.748	0.772	0.839	0.961						
			n.s.	n.s.	n.s.	n.s.						
TEKNOJET/1SC IEC-60335-2	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.602	0.661	0.732	0.886						
			n.s.	n.s.	n.s.	n.s.						
TEKNOJET/2SC IEC-60335-2 (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.717	0.748	0.823	0.925						
			n.s.	n.s.	n.s.	n.s.						
	B1SC FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.638	0.709	0.787	0.937						
			n.s.	n.s.	n.s.	n.s.						
TEKNOJET/1ST IEC-60335-2	B1R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.677	0.740	0.827	1.000						
			0.827	0.866	0.906	0.984						
TEKNOJET/2ST IEC-60335-2	B2R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.701	0.799	0.906	1.012						
			0.827	0.866	0.906	0.984						
TEKNOJET/PLUS 1SN	B1R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.677	0.740	0.827	1.000						
			0.827	0.866	0.906	0.984						
TEKNOJET/PLUS 2SN	B2R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0.701	0.799	0.906	1.012						
			0.827	0.866	0.906	0.984						
SEWER CLEANING	B1SC FOR STANDARD FITTINGS					.08		.12	.16			
						0.886		1.146	1.453			
						n.s.		n.s.	*3			
	B1R FOR STANDARD FITTINGS					.08		.12	.16			
						0.957		1.232	*			
						0.984		1.339	1.457			

** Please check compatibility with hose external diameter, that may change depending on the manufacturer's
** Verificare la compatibilità con il diametro esterno del tubo che potrebbe variare a seconda della casa costruttrice.

ASSEMBLY INSTRUCTIONS

1- Select the hose (A), ferrules (B) and inserts (C)

2- Cut the hose squarely using a rotary steel blade to the required length.

3- If skiving is required, remove all rubber cover to the "skiving length" specified in the table, avoiding damages to the steel wires reinforcement.

4- Place the ferrule fully onto the hose.
Push the insert fully into the hose.
Select the "COLLAPSE CONTROL MANOREL"
Insert the MANOREL into the insert bore.
The "NO GO" part of the MANOREL must fully go into the insert bore. .
Remove the MANOREL.

5-Crimp the ferrule to the diameter specified in the table

6- Inspect the crimp diameter by measuring it on each die impressions. All measurements must be taken in the center of ferrule length. All measurements must be according to the specified crimping diameters, within a tolerance +0,01-0,2 mm.

7- Insert the "COLLAPSE CONTROL MANOREL".

8- If the "NO GO" part of the MANDREL stops in the bore the crimping diameter and the bore collapse are correct.

9- If the "NO GO" part of the MANDREL goes through the bore, the crimping diameter must be reduced by increments of 0,1 mm

10- If the "GO" part of the MANDREL does not go through the bore, the crimping diameter must be increased.

For more pretical recommendations regarding the assembly of hydraulic hoses to refer the standard SAE J1273 Feb 2009

HOSE-ASSEMBLY FABRICATION

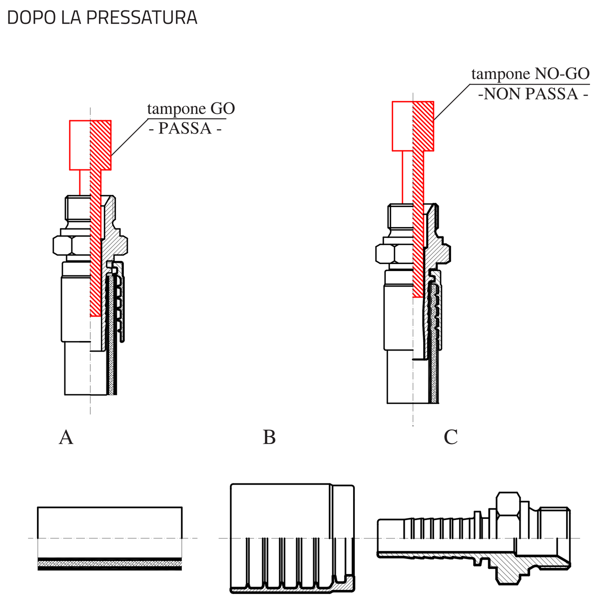
Persons fabricating hose assemblies should be trained in the proper use of equipment and materials.
Properly assembled fittings are vital to the integrity of a hose assembly. Improperly assembled fittings can separate from the hose and may cause serious injury or property damage from whipping hose, or from fire or explosion of vapor expelled from the hose.

Component Inspection
Prior to assembly, examine components for:

- Configuration and types
- Clean
- Damage on cover
- Nicks
- Diameters
- Obstruction of the tubes within
- More visible defects
- Damage in general
- Lengths suitable
- Swelling
- Machining burrs
- Corrosion

Hose Fittings Compatibility
Pay attention to the hose – fittings compatibility.
Do not use a hose from one manufacturer with a hose fitting from another manufacturer without the consent from the same manufacturers
Safety Equipment
During fabrication, use proper safety equipment, including eye protection, respiratory protection, and adequate ventilation.
Reuse of Hose and Fittings
Do not reuse:
a. Field-attachable fittings that have blown or pulled off hose
b. Any part of hose fittings that were permanently crimped or swaged to hose
c. Hose that has been in service after system checkout
Clean inside of the tubes connected
The tubes connected shares may collect contaminants during processing. Flush the pipes until they reach an optimum level of cleanliness.

AFTER PRESSING
DOPO LA PRESSATURA



COLLAPSE CONTROL MANOREL
SPINE CONTROLLO COLLASSO

INSERT BORE COLLAPSE CONTROL
Controllo del collasso

WIRE BRAIDED HOSES STANDARD FITTINGS
Tubo trecciato
Raccordo standard

NOMINAL SIZE		GO, NO GO MANDRELS DIAMETERS (mm)	
		GO	NO-GO
03	3/16"	0,091	0,110
04	1/4"	0,130	0,148
05	5/16"	0,185	0,205
06	3/8"	0,238	0,258
08	1/2"	0,329	0,344
10	5/8"	0,427	0,449
12	3/4"	0,531	0,543
16	1"	0,728	0,756
20	1.1/4"	0,907	0,941
24	1.1/2"	1,173	1,209
32	2"	1,638	1,677

WIRE SPIRAL HOSES STANDARD FITTINGS
Tubo spiralato
Raccordo standard

NOMINAL SIZE		GO, NO GO MANDRELS DIAMETERS (mm)	
		GO	NO-GO
04	1/4"	0,124	0,142
06	3/8"	0,220	0,246
08	1/2"	0,299	0,331
10	5/8"	0,396	0,429
12	3/4"	0,486	0,524
16	1"	0,681	0,722
20	1.1/4"	0,876	0,919
24	1.1/2"	1,148	1,193
32	2"	1,602	1,654

WIRE SPIRAL HOSES INTERLOCK FITTINGS
Tubo spiralato
Raccordo interlock

NOMINAL SIZE		GO, NO GO MANDRELS DIAMETERS (mm)	
		GO	NO-GO
12	3/4"	0,478	0,516
16	1"	0,650	0,691
20	1.1/4"	0,876	0,919
24	1.1/2"	1,069	1,114
32	2"	1,524	1,575

VITILLO technical department rev. 07 18 23-71