Vitillo

CRIMPING PARAMETERS CHART

BRAIDED HOSES

HOSESES	DN/DASH SIZE	02/-03	02/-04	03/-05	04/-06	05/-08	06/-10	07/-12	10/-12	12/-20	15/-24	20/-32
	FERRULES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
TEKNO/1SN EN 853 1SN - SAE100 R1AT (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	1,902	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 (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.				
TEKNO/1ST EN 853 1ST - SAE100 R1A	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
		0,71	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,44
TEKNO/2ST EN 853 2ST - SAE100 R2A	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
		0,73	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,52
TEKNO/1SC EXCEED AN857 1SC (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 Note			
	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 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.			
TEKNO/1SC PLUS EXCEED AN857 1SC	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 Note			
	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 (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.			
STRONGER/1 SAE 100 R16 (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		
		0,71	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69		
	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.			
STRONGER/2 EXCEED SAE 100 R16 (recommended option)	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12				
			0,728	0,748	0,839	0,921	1,091	1,228				
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.				
	B1R FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20		
			0,677	0,756	0,846	1,004	1,122	1,280	1,575	1,866		
			0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69		
TEKNOJACK	B12T..N FOR STANDARD FITTINGS		.04		.06							
			0,748		0,799							
			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			
			0,83		0,91	0,98	1,10	1,34	1,46			
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			
			0,83	0,87	0,91	0,98	1,10	1,34	1,46			
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			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
ALPI 4000 (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			
			0,602	0,709	0,787	0,937	1,091	1,193	1,488			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
SLIM (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			
			0,562	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.										
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.						
LIFT-PLUS EN 81.2	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		
										1,69		
SEWER CLEANING	B1SC FOR STANDARD FITTINGS					.08		.12	.16			
						0,886		1,146	1,453			
						n.s.		n.s.	*3 Note			
	B1R FOR STANDARD FITTINGS					.08		.12	.16			
						0,957		1,232	*			
						0,98		1,34	1,46			
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
		0,71	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,44
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
		0,73	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,52
VULCAN AIR EXCEED EN857 1SC	B1SC.. FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			-	-	-	-	-	-	1,452			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1K FOR STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16	.20	.24	
			-	-	-	-	-	-	1,468	1,744	2,031	
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
	B1T FOR STANDARD FITTINGS									.20	.24	
										1,783	2,071	
										n.s.	n.s.	
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
		0,71	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,44
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
		0,73	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,52
ICEBERG/3	B2R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16			
			0,748		0,945	1,055	1,193	1,370	1,657			
			0,83		0,91	0,98	1,10	1,34	1,46			
ICEBERG/1SC EXCEED EN857 1SC	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 Note			
	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.
ICEBERG/2SC EXCEED EN857 2SC (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.			
EVERGREEN/1SN EXCEED EN853 1SN SAE100 R1AT (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.			
EVERGREEN/2SN EXCEED EN853 2SN SAE100 R2AT	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
EVERGREEN/1ST EXCEED EN853 1ST SAE100 R1A	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
		0,71	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,44
EVERGREEN/2ST EXCEED EN853 2ST SAE100 R2A	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
		0,73	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,52
EVERGREEN/1SC EXCEED EN857 1SC	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 Note			
	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.
EVERGREEN/2SC EXCEED EN857 2SC (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.			
FOREVER/1SN EN853 1SN SAE100 R1AT (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	1,531			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
FOREVER/2SN EN853 2SN SAE100 R2AT	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.
FOREVER/1ST EN853 1ST SAE100 R1A	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
		0,71	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,44
FOREVER/2ST EN853 2ST SAE100 R2A	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
		0,73	0,83	0,87	0,91	0,98	1,10	1,34	1,46	1,69	1,85	2,52
FOREVER/1SC EN857 1SC	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 Note			
	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.
FOREVER/2SC EN857 2SC (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.			
PREMIER	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.			
	B1SC STANDARD FITTINGS		.04	.05	.06	.08	.10	.12	.16			
			0,638	0,701	0,787	0,937	1,102	1,193	1,492			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

SPIRAL HOSES

HOSESES	DN/DASH SIZE	02/-03	02/-04	03/-05	04/-06	05/-08	06/-10	07/-12	10/-12	12/-20	15/-24	20/-32
	FERRULES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
TEKNOSPIR/4SP EN856 4SP (recommended option) (severe applications)	B9R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16	.20	.24	.32
			0,756		0,913	1,035	1,173	1,319	1,645	2,150	2,331	2,937
			0,83		0,91	1,06	1,22	1,42	1,89	2,13	2,44	2,52
	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,634			
								0.59 in. 2.05out	0.67 in. 2.64out			
TEKNOSPIR/4SH EN856 4SH (severe applications)	KB4SH FOR INTERLOCK FITTING						.10	.12	.16	.20	.24	.32
							1,251	1,335	1,634	1,976	2,252	2,921
							0.55 in 1.87out	0.59 in 2.05out	0.67 in. 2.64 out	0.85 in. 2.91out	0.87 in. 3.19out	1.14in 3.35out
	B4SH FOR STANDARD FITTINGS									.20	.24	.32
										1,89	2,283	2,776
										2,13	2,44	2,52
TEKNOSPIR/12 EN856 R12 SAE 100 R12	B9R FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	.20	.24	
					0,906	1,043	1,197	1,339	1,650	2,083	2,283	
					0,91	1,06	1,22	1,42	1,89	2,13	2,44	
	B4SH FOR STANDARD FITTINGS										.24	.32
											2,319	2,780
											2,44	2,52
TEKNOSPIR/13 EN856 R13 SAE 100 R13	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,366	1,661			
								0.59 in 2.05out	0.67 in. 2.64out			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2,118	2,413	3,079
										0.85 in. 2.91out	0.87 in. 3.19out	1.14 in. 3.35out
TEKNOSPIR/15 SAE 100 R15	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,634			
								0.59 in. 2.05out	0.67 in. 2.64out			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2,150	2,413	3,047
										0.85 in. 2.91out	0.87 in. 3.19out	1.14 in. 3.35out
ELASTIK/4000	B9R FOR STANDARD FITTINGS							.12	.16	.20		
								1,339	1,654	2,094		
								1,42	1,89	2,13		
ELASTIK/5000	KB4SH FOR INTERLOCK FITTING							.12	.16	.20		
								1,335	1,626	1,988		
								0.59 in. 2.05 out	0.67 in. 2.64 out	0.85 in. 2.91 out		
	B9R FOR STANDARD FITTINGS							.12	.16			
								1,307	1,638			
								1,42	1,89			
ELASTIK/6000	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,626			
								0.59 in. 2.05 out	0.67 in. 2.64 out			
	KBH13 FOR INTERLOCK FITTING									.20		
										2,098		
										0.84 in. 2.91 out		
TEKNOBLAST AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS				.06	.08		.12				
					0,961	1,110		1,520				
					0.59 in. 1.85 out.	0.63 in. 2.05 out		0.75 in. 2.13 out				
TEKNOBLAST PLUS AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS				.06	.08		.12				
					0,969	1,146		1,531				
					0.59 in. 1.85 out	0.63 in. 2.05 out		0.75 in. 2.13 out				
TEKNOBLAST SUPERB AS/NZS 4233.2	WB6 FOR WATERBLAST-FITTINGS					.08		.12				
						-		-				
						-		-				
EVERGREEN/4SP EXCEED EN856 4SP (scelta consigliata) (recommended option) (per impieghi severi) (severe applications)	B9R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16	.20	.24	.32
			0,756		0,913	1,035	1,173	1,319	1,645	2,150	2,331	2,937
			0,83		0,91	1,06	1,22	1,42	1,89	2,13	2,44	2,52
	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,634			
								0.59 in 2.05out	0.67 in. 2.64 out			
EVERGREEN/4SH EXCEED EN856 4SH (per impieghi severi) (severe applications)	KB4SH FOR INTERLOCK FITTING						.10	.12	.16	.20	.24	.32
							1,251	1,335	1,634	1,976	2,252	2,921
							0.55 in 1.87out	0.59 in 2.05out	0.67 in. 2.64 out	0.85 in. 2.91out	0.87 in. 3.19out	1.14in 3.35out
	B4SH FOR STANDARD FITTINGS									.20	.24	.32
										1,890	2,283	2,776
										2,13	2,44	2,52
TK-EVERGREEN/12 EXCEED EN856 R12 SAE100 R12	B9R FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	.20	.24	
					0,906	1,043	1,197	1,339	1,650	2,083	2,283	
					0,91	1,06	1,22	1,42	1,89	2,13	2,44	
	B4SH FOR STANDARD FITTINGS										.24	.32
											2,319	2,780
											2,44	2,52
TK-EVERGREEN/13 EXCEED EN856 R13 SAE100 R13	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,366	1,661			
								0.59 in 2.05out	0.67 in 2.64 out			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2,118	2,413	3,079
										0.85 in. 2.91out	0.87 in. 3.19out	1.14in 3.35out
EVERGREEN/R15 SAE100 R15	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,634			
								0.59 in 2.05out	0.67 in. 2.64 out			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2,150	2,413	3,047
										0.85 in. 2.91out	0.87 in. 3.19out	1.14 in. 3.35out
FOREVER/4SP EN 856 4SP (recommended option) (severe applications)	B9R FOR STANDARD FITTINGS		.04		.06	.08	.10	.12	.16	.20	.24	.32
			0,756		0,913	1,035	1,173	1.319	1,645	2,150	2,331	2,937
			0,83		0,91	1,06	1,22	1,42	1,89	2,13	2,44	2,52
	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,634			
								0.59 in 2.05out	0.67 in. 2.64 out			
FOREVER/4SH EN 856 4SH (severe applications)	KB4SH FOR INTERLOCK FITTING						.10	.12	.16	.20	.24	.32
							1,251	1,335	1,634	1,976	2,252	2,921
							0.55 in 1.87out	0.59 in 2.05out	0.67 in. 2.64 out	0.85 in. 2.91out	0.87 in. 3.19out	1.14in 3.35out
	B4SH FOR STANDARD FITTINGS									.20	.24	.32
										1,890	2,283	2,776
										2,13	2,44	2,52
FOREVER/R12 EN 856 R12 - SAE 100R12	B9R FOR STANDARD FITTINGS				.06	.08	.10	.12	.16	.20	.24	
					0,906	1,043	1,197	1,339	1,650	2,083	2,283	
					0,91	1,06	1,22	1,42	1,89	2,13	2,44	
	B4SH FOR STANDARD FITTINGS										.24	.32
											2,319	2,780
											2,44	2,52
TK-FOREVER/R13 EN 856 R13 - SAE 100R13	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,366	1,661			
								0.59 in 2.05out	0.67 in. 2.64 out			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2,118	2,413	3,079
										0.85 in. 2.91out	0.87 in. 3.19out	1.14in 3.35out
FOREVER/R15 SAE 100 R15	KB4SH FOR INTERLOCK FITTING							.12	.16			
								1,335	1,634			
								0.59 in 2.05out	0.67 in. 2.64 out			
	KBH13 FOR INTERLOCK FITTING									.20	.24	.32
										2,150	2,413	3,047
										0.85 in. 2.91out	0.87 in. 3.19out	1.14 in. 3.35out

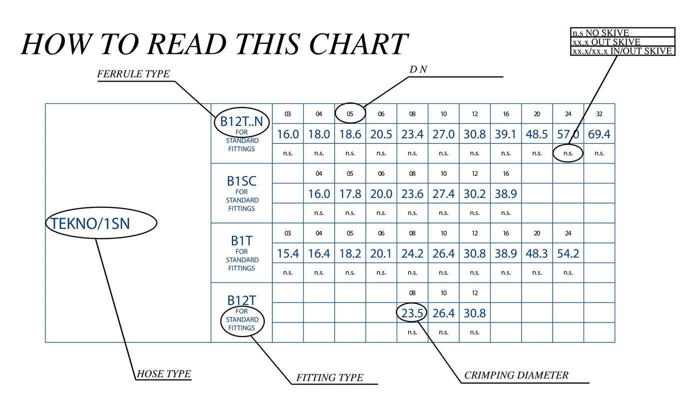
CLEANERS HOSES

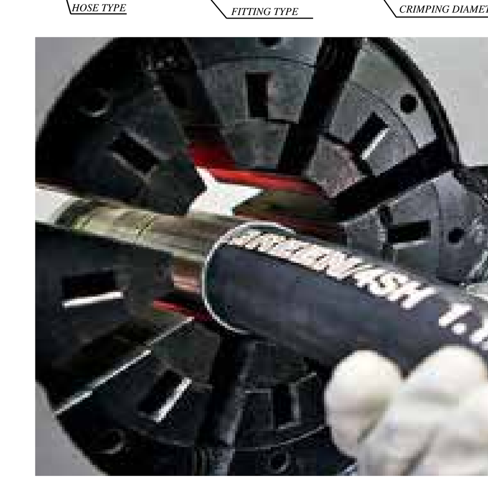
HOSESES	DN/DASH SIZE	02/-03	02/-04	03/-05	04/-06	05/-08	06/-10	07/-12	10/-12	12/-20	15/-24	20/-32
	FERRULES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
TEKNOJET/1SN IEC-60335-2 (recommended option)	B12T..N FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0,709	0,732	0,807	0,921						
			n.s.	n.s.	n.s.	n.s.						
	B1R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0,677	0,740	0,827	1,000						
			0,83	0,87	0,91	0,98						
	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 (recommended option)	B2R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0,701	0,799	0,906	1,012						
			0,83	0,87	0,91	0,98						
	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 (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						
			0,83	0,87	0,91	0,98						
TEKNOJET/2ST IEC-60335-2	B2R FOR STANDARD FITTINGS		.04	.05	.06	.08						
			0,701	0,799	0,906	1,012						
			0,83	0,87	0,91	0,98						
TEKNOJET/PLUS 1SN	B1R FOR STANDARD FITTINGS		.04	.05	.06							
			0,677	0,740	0,827							
			0,83	0,87	0,91							
TEKNOJET/PLUS 2SN	B2R FOR STANDARD FITTINGS		.04	.05	.06							
			0,701	0,799	0,906							
			0,83	0,87	0,91							

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 gauge in order to check the tail collapse.

** Please check compatibility with hose external diameter, that may change depending on the manufacturer's

HOW TO READ THIS CHART





VITILLO technical department rev. 0918-40

TERMOPLASTIC HOSES

HOSES	DN/DASH SIZE	02/-03	02/-04	03/-05	04/-06	05/-08	06/-10	07/-12	10/-12	12/-20	15/-24	20/-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*	B7R	.03	.04	.05	.06	.08	.10	.12	.16			
		0,465	0,555	0,638	0,717	0,874	1,008	1,142	1,449			
	B1K		.04	.05	.06	.08						
			0,551	0,669	0,693	0,898	-	-				
R7 MTH1* (* Crimping diameter on ZEC hose)	B7R	.03	.04	.05	.06	.08	.10	.12	.16			
		0,465	0,555	0,638	0,717	0,874	1,008	1,142	1,449			
	B1K		.04	.05	.06	.08	.10	.12	.16			
			0,543	0,669	0,709	0,854	-	-				

TEXTILE HOSES

HOSES	DN/DASH SIZE	02/-03	02/-04	03/-05	04/-06	05/-08	06/-10	07/-12	10/-12	12/-20	15/-24	20/-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	B7R	.03	.04	.05	.06	.08	.10	.12				
		0,476	0,555	0,626	0,709	0,858	0,988	1,110				
	B1K		.04	.05	.06	.08	.10	.12	.16			
			0,563	0,657	0,677	0,850	1,016	1,130	1,461			
2TE	B7R		.04	.05	.06	.08	.10	.12				
			0,575	0,642	0,728	0,866	1,028	-				
	B1K		.04	.05	.06	.08	.10	.12			.24	
			0,583	0,669	0,709	0,858	1,047	1,165			2,047	
	B3R						.10	.12	.16	.20		
							1,024	1,217	1,591	1,799		
	B1T	.03										
		0,602										
3TE	B3R	B1T03	.04	.05	.06	.08	.10	.12	.16	.20	B1T24	B12T32N
		0,622	0,626	0,713	0,799	0,898	1,063	1,256	1,598	1,815	2,106	2.7
R3 TEXTILES HOSES	B3R					.08	.10	.12	.16	.20		
						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	1,917	2,165	2,764
R6 TEXTILES HOSES	B7R		.04	.05	.06	.08	.10	.12	.16			
			0,583	0,677	0,744	0,913	1,016	1,177	1,480			
	B1K		.04	.05	.06	.08	.10	.12	.16			
			0,591	0,630	0,724	0,890	1,028	1,169	1,429			
R8 TEXTILES HOSES		B7R03	B1K04	B1K05	B1K06	B1K08						
		0,465	0,551	0,657	0,697	0,882						
R18 TEXTILES HOSES			B1SC04		B1SC06							
			0,602		0,787							

PTFE HOSES

HOSES	DN/DASH SIZE	02/-03	02/-04	03/-05	04/-06	05/-08	06/-10	07/-12	10/-12	12/-20	15/-24	20/-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	.03	.04	.05	.06	.08	.10	.12	.16			
		0,433	0,516	0,579	0,638	0,819	0,874	1,098	1,358			
PTFE LISCIO (SMOOTH) 2 BRAIDS *	B7R	BPTFE	.04	.05	.06	BPTFE	.10		.16			
		0.472	0,504	0,610	0,661	0.831	0,961		1,366			
PTFE (CORRUCATED)	BPTFEC		.04		.06	.08	.10	.12	.16	.20	.24	.32
			0,504		0,630	0,764	0,874	1,031	1,323	1,772	1,984	2,480
	B7R		.04				.10					
			0,504				0,957					

** Please check compatibility with hose external diameter, that may change depending on the manufacturer's

ASSEMBLY INSTRUCTIONS

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.

COLLAPSE CONTROL MANOREL

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".

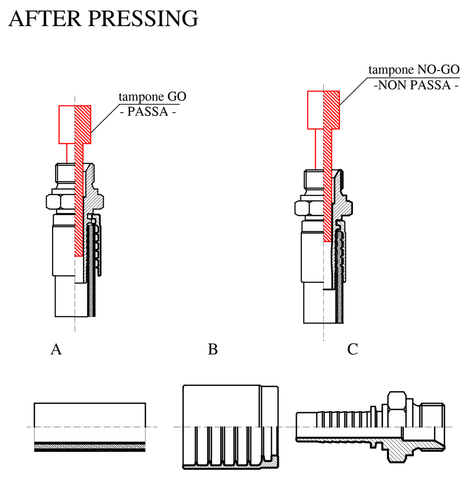
8- If the "NO GO" part of the MANDREL stops in the bore the crimping diameter and the bore collapse are correct.

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

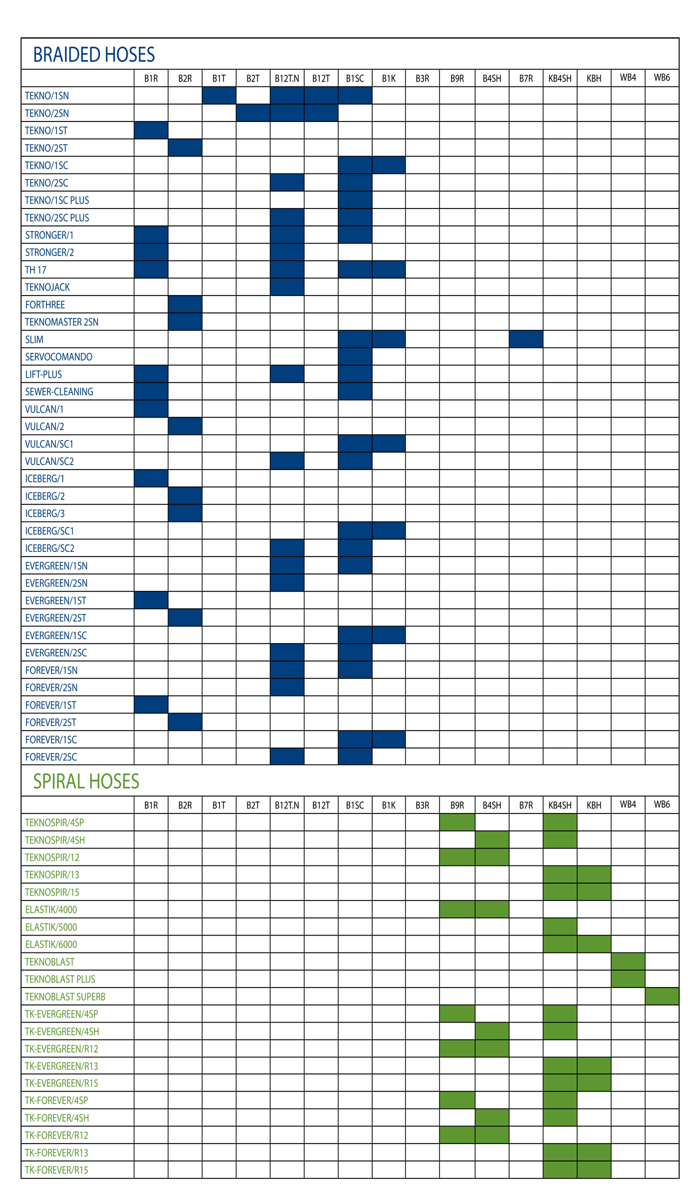
10- If the "GO" part of the MANDREL does not go through the bore, the crimping diameter must be increased.

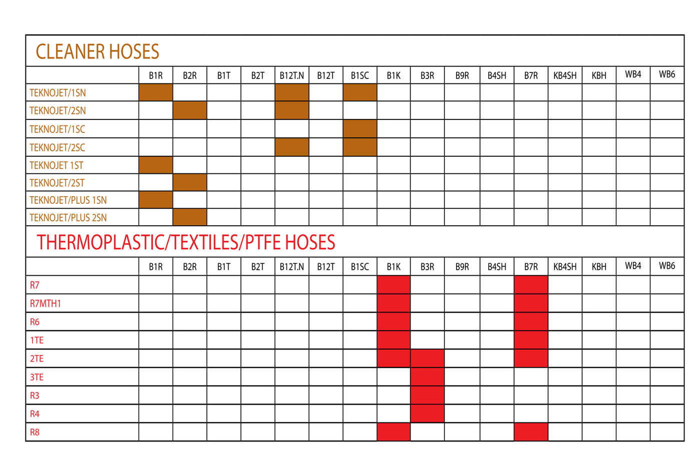
For more pretical recommendations regarding the assembly of hydraulic hoses to refer the standard SAE J1273 Feb 2009

AFTER PRESSING



COMPATIBILITY CHART





INSERT BORE COLLAPSE CONTROL

WIRE BRAIDED HOSES STANDARD FITTINGS

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

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

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

All dimensions are expressed in inches

* ALSO VALID FOR CONDUCTING TUBE

*3 Note: Check with No-Go gauge diameter 19.65 mm

We feel better under pressure

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