Vitillo

CRIMPING PARAMETERS CHART

BRAIDED HOSES
Tubi trecciati

Hose	Fitting	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 /1SNRW 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
			16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
			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			
				16.0	17.8	20.0	23.6	27.4	30.2	37.9			
				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	
			15.4	16.4	18.2	20.1	24.2	26.4	30.8	38.9	46.6	54.2	
			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				
							23.5	26.4	30.8				
							n.s.	n.s.	n.s.				
TEKNO/2SN /2SNRW 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
			16.7	19.0	19.6	21.3	24.4	28.2	32.0	40.3	51.0	59.0	72.7
			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	
			15.7	18.0	20.2	21.4	25.6	28.5	32.0	41.0	50.0	57.5	
			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				
							24.4	27.2	32.0				
							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
			15.2	17.2	18.8	21.0	25.4	28.2	32.2	39.8	46.6	53.0	66.2
			18	21	22	23	25	28	34	37	43	47	62
TEKNO/2ST EN 853 2ST Nota / Note: F E	B2R.. FOR STANDARD FITTINGS		.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5
			18.5	21	22	23	25	28	34	37	43	47	64
TEKNO/1SC EXCEED AN857 1SC (scelta consigliata) (recommended option) Nota / Note: F E	B1SC.. FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				15.3	16.8	18.6	22.5	26.4	29.2	36.9			
				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
				15.0	16.3	18.6	22.7	26.4	29.5	37.9	45.8	51.3	64.6
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	*4	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			
				16.2	18.0	20.0	23.8	27.8	30.3	37.9			
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

BRAIDED HOSES
Tubi trecciati

Hose	Fitting	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			
				15.3	16.8	18.6	22.5	26.4	29.2	36.9			
				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
				15.0	16.3	18.6	22.7	26.4	29.5	37.9	44.8	50.8	64.6
				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
				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			
				16.2	18.0	20.0	23.8	27.8	30.3	37.9			
				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			
				19.0		24.0	26.8	30.3	34.8	42.1			
				21		23	25	28	34	37			
	B5K FOR STANDARD					.06			.12	.16			
						26.1			36.6	44.5			
						n.s.			n.s.	n.s.			
TEKNOMASTER 2SN	B2R FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				17.6	20.0	22.9	26.0	29.7	33.6	41.6			
				21	22	23	25	28	34	37			
STRONGER/1 SAE 100 R16 (scelta consigliata) (recommended option)	B1R FOR STANDARD FITTINGS		.03	.04	.05	.06	.08	.10	.12	.16	.20		
			15.4	17.3	18.6	20.5	25.2	27.4	31.0	39.0	45.7		
			18	21	22	23	25	28	34	37	43		
	B12T..N FOR STANDARD FITTINGS		.03	.04	.05	.06	.08	.10					
			16.2	18.1	18.4	20.0	23.2	26.2					
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.					
	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				16.1	17.6	19.5	23.4	26.6	29.0	38.1			
				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				
				15.0	16.8	18.2	21.9		28.7				
				n.s.	n.s.	n.s.	n.s.		n.s.				
	B1K FOR STANDARD FITTINGS			.04	.05	.06	.08			.16			
				14.3	15.7	17.3	21.7			35.3			
				n.s.	n.s.	n.s.	n.s.			n.s.			
	B7R FOR STANDARD FITTINGS		.03										
			12.3										
			n.s.										

*3 Note: Controllare con tampone No-Go diametro 19.65 mm
*3 Note: Check with No-Go gauge diameter 19.65 mm
*4 Note: Non effettuare il controllo del collasso con tampone Go, No-Go; Rispettare la quota indicata.
*4 Note: No check the diameter with Go, No-Go gauge; Respect the indicated diameter.

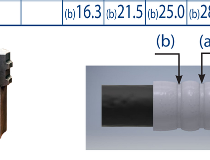
BRAIDED HOSES
Tubi trecciati

Hose	Fitting	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							
				19.0		20.3							
				n.s.		n.s.							
LIFT-PLUS EN 81.2 (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS											.24	.32
												56.8	71.0
												n.s.	n.s.
	B1SC FOR STANDARD FITTINGS								.12	.16			
									29.2	36.4			
									n.s.	n.s.			
	B1R FOR STANDARD FITTINGS										.20		
											45.6		
											43		
	B1K FOR STANDARD FITTINGS										.20		
											44.6		
											n.s.		
	B1T20 FOR STANDARD FITTINGS										.20		
											45.7		
											n.s.		
SERVOCOMANDO	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08						
				15.5	17.0	18.6	22.5						
				n.s.	n.s.	n.s.	n.s.						
ALPI 3300	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				15.6	16.9	18.8	22.5	28.0	30.5	37.9			
				ns	ns	ns	ns	ns	ns	ns			
ALPI 4000 (scelta consigliata) (recommended option)	B12T..N FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
					19.0	20.6	23.5	27.3	31.1	39.0			
					n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				15.8	18.0	20.0	23.8	27.7	30.3	37.8			
				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
			15.2	17.2	18.8	21.0	25.4	28.2	32.2	39.8	46.6	53.0	66.2
			18	21	22	23	25	28	34	37	43	47	62
ICEBERG/2 EXCEED EN853 2SN SAE 100 R2AT	B2R FOR STANDARD FITTINGS		.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5
			18.5	21	22	23	25	28	34	37	43	47	64

BRAIDED HOSES
Tubi trecciati

Hose	Fitting	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			
				19.0		24.0	26.8	30.3	34.8	42.1			
				21		23	25	28	34	37			
VULCAN /1 EXCEED EN853 1SN SAE R1AT	B1R FOR STANDARD FITTINGS		.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			15.2	17.2	18.8	21.0	25.4	28.2	32.2	39.8	46.6	53.0	66.2
			18	21	22	23	25	28	34	37	43	47	62
VULCAN /2 EXCEED EN853 2SN SAE R2AT	B2R.. FOR STANDARD FITTINGS		.03	.04	.05	.06	.08	.10	.12	.16	.20	.24	.32
			17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5
			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)15.8	(a)21.0	(a)24.5	(a)27.8	(a)35.0	(a)41.2	(a)47.5	
						(b)16.3	(b)21.5	(b)25.0	(b)28.3	(b)35.5	(b)41.7	(b)48.0	

blocchetto pressa



Hose	Fitting		5	6	8	10	12	16	19	25	31	38	51
PREMIER / PREMIER RW	B12T..N FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				18.0	18.8	20.3	23.2	27.3	31.3	39.1			
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
PREMIER ONE / PREMIER ONE RW	B1K FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				14.6	16.6	17.8	21.7	25.8	29.3	36.4			
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
SMART ONE (scelta consigliata) (recommended option)	B1K FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				14.6		17.8	21.7	26.4	29.5	37.9			
				n.s.		n.s.	n.s.	n.s.	n.s.	n.s.			
	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				15.3	16.8			26.4	29.2	36.9			
				n.s.	n.s.			n.s.	n.s.	n.s.			
SMART TWO	B12T..N FOR STANDARD FITTINGS			.04	.05	.06	.08	.10	.12	.16			
				18.0	19.0	20.6	23.5	27.4	31.1	39.1			
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

BRAIDED HOSES
Tubi trecciati

Hose	Fitting	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
			16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
			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			
				16.0	17.8	20.0	23.6	27.4	30.2	37.9			
				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	
			15.4	16.4	18.2	20.1	24.2	26.4	30.8	38.9	46.6	54.2	
			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				
							23.5	26.4	30.8				
							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
			16.7	19.0	19.6	21.3	24.4	28.2	32.0	40.3	51.0	59.0	72.7
			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	
			15.7	18.0	20.2	21.4	25.6	28.5	32.0	41.0	50.0	57.5	
			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				
							24.4	27.2	32.0				
							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			
				15.3	16.8	18.6	22.5	26.4	29.2	36.9			
				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
				15.0	16.3	18.6	22.7	26.4	29.5	37.9	45.8	50.8	64.6
				n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	*4	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
				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			
				16.2	18.0	20.0	23.8	27.8	30.3	37.9			
				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

SPIRAL HOSES
Tubi spiralati

Hose	Fitting	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
				19.2		23.2	26.3	29.8	33.5	41.8	54.6	58.5	74.6
				21		23	27	31	36	48	54	62	64
	KB4SH FOR INTERLOCK FITTINGS								.12	.16			
									33.9	41.5			
									15 in. 52 out.	17 in. 67 out.			
	B5K FOR STANDARD FITTINGS					.06	.08	.10	.12	.16	B5K206		
						25.8	28.5	32.9	36.0	43.5	57.0		
						n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS					.06	.08	.10	.12	.16			
						26.5	27.8	33.9	37.5	46.5			
						n.s.	n.s.	n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS										.20	.24	
											58.3	64.5	
											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
								31.8	33.9	41.5	50.2	57.2	74.2
								14 in. 47.5out	15 in. 52 out.	17 in. 67 out.	21.5 in. 74 out.	22 in. 81 out.	29 in. 85 out.
	B4SH FOR STANDARD FITTINGS										.20	.24	.32
											47.2	58.0	70.5
											54	62	64
	B5K FOR STANDARD FITTINGS								.12	.16	B5K204		
									36.0	43.7	54.0		
									n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS							.10	.12	.16	.20	.24	
								34.5	37.5	46.7	55.5	62.5	
								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

Hose	Fitting	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	
						23.0	26.5	30.4	34.0	41.9	52.9	58.5	
						23	27	31	36	48	54	62	
	B4SH FOR STANDARD FITTINGS											.24	.32
												58.9	70.6
												62	64
	B5K FOR STANDARD FITTINGS					.06	.08	.10	.12	.16	B5K206		
						26.2	27.6	32.3	35.8	43.5	57.0		
						n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS					.06	.08	.10	.12	.16			
						26.1	27.5	33.5	37.3	46.5			
						n.s.	n.s.	n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS										.20	.24	
											58.3	64.5	
											n.s.	n.s.	
TEKNOSPIR/13 EN856 R13 SAE 100 R13 Nota / Note: F E	KB4SH FOR INTERLOCK FITTINGS								.12	.16	.20		
									34.7	42.2	49.8		
									15 in. 52 out.	17 in. 67 out.	21.5 in. 74 out.		
	KBH13 FOR INTERLOCK FITTINGS											.24	.32
												59.7	78.2
												22 in. 81 out.	29 in. 85 out.
	HB4NS FOR HYPERSPIRAL FITTINGS								.12	.16	.20	HB6NS24	
									38	46.5	55.5	64.5	
									n.s.	n.s.	n.s.	n.s.	
TEKNOSPIR/15 EN856 R12 SAE 100 R15 Nota / Note: F E	KB4SH FOR INTERLOCK FITTINGS								.12	.16			
									33.9	41.5			
									15 in. 52 out.	17 in. 67 out.			
	KBH13 FOR INTERLOCK FITTINGS										.20	.24	.32
											54.6	61.3	77.4
											21.5 in. 74 out.	22 in. 81 out.	29 in. 85 out.
	HB4NS FOR HYPERSPIRAL FITTINGS							.10	.12	.16			
								34.5	37.5	46.7			
								n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS										.20	.24	
											57.8	64.5	
											n.s.	n.s.	

SPIRAL HOSES
Tubi spiralati

Hose	Fitting	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
											52.9	58.5	coming soon
											62	62	64.
	B5K FOR STANDARD FITTINGS										B5K206		
											57		
											n.s.		
	HB6NS FOR HYPERSPIRAL FITTINGS										.20	.24	
											58.3	64.5	
											n.s.	n.s.	
EVEREST/4000	B9R FOR STANDARD FITTINGS						.08	.10	.12	.16	.20	.24	.32
							26.5	30.4	34.0	41.9	53.2	coming soon	coming soon
							27	31	36	48	54	62	64
	B5K FOR STANDARD FITTINGS						.08	.10	.12	.16	B5K204		
							27.6	32.3	35.8	43.5	54.0		
							n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS						.08	.10	.12	.16	.20	.24	
							27.5	33.5	37.3	46.5	55.5	62.5	
							n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	
EVEREST/5000	KB4SH FOR INTERLOCK FITTING								.12	.16	.20		
									33.9	41.3	49.8		
									15 in. 52 out.	17 in. 67 out.	21.5 in. 74 out.		
	KBH13 FOR INTERLOCK FITTINGS											.24	.32
												59.7	78.2
												22 in. 81 out.	29 in. 85 out.
	B9R FOR STANDARD FITTINGS						.08	.10	.12	.16	.20		
							26.3	29.2	33.2	41.6	52.1		
							27	31	36	48	54		
	B5K FOR STANDARD FITTINGS						.08	.10	.12	.16	B5K204		
							28.5	32.9	36	43.5	54.0		
							n.s.	n.s.	n.s.	n.s.	n.s.		
	HB4NS FOR HYPERSPIRAL FITTINGS						.08	.10	.12	.16	.20	HB6NS24	
							27.8	33.9	37.5	46.5	55.5	64.5	
							n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	

SPIRAL HOSES
Tubi spiralati

Hose	Fitting	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			
									33.9	41.3			
									15 in. 52 out.	17 in. 67 out.			
	KBH13 FOR INTERLOCK FITTING										.20	.24	.32
											53.3	60.5	77.4
											21.5 in. 74 out.	22 in. 81 out.	29 in. 85 out.
	HB4NS FOR HYPERSPIRAL FITTINGS					.06	.08	.10	.12	.16			
						25.8	27.8	33.9	37.5	46.7			
						n.s.	n.s.	n.s.	n.s.	n.s.			
	HB6NS FOR HYPERSPIRAL FITTINGS										.20	.24	
											57.8	64.5	
											n.s.	n.s.	
	B9R FOR STANDARD FITTINGS			.04		.06	.08	.10	.12	.16			
				coming soon		23.2	26.5	29.2	33.5	41.8			
				21		23	27	31	36	48			
EVEREST/6000 4C * B5K and B9R ferrules are suitable for applications reaching a maximum of 350Bar	KB4SH FOR INTERLOCK FITTING								.12	.16	.20		
									33.2	40.2	50.2		
									15 in. 52 out.	17 in. 67 out.	21.5 in. 74 out.		
	HB4NS FOR HYPERSPIRAL FITTINGS								.12	.16	.20		
									37	45	54.2		
									n.s.	n.s.	n.s.		
	B5K* FOR STANDARD FITTINGS								.12	.16	B5K204		
									36.2	43.4	53.4		
									n.s.	n.s.	n.s.		
	B9R* FOR STANDARD FITTINGS								.12	.16	.20		
									33.6	40.1	51		
									36	48	54		

SPIRAL HOSES
Tubi spiralati

Hose	Fitting	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/7300	KB4SH FOR INTERLOCK FITTING								.12	.16			
									33.9	41.3			
									15 in. 52 out.	17 in. 67 out.			
	KBH13 FOR INTERLOCK FITTING										.20		
											53.3		
											21.5 in. 74 out.		
TEKNOBLAST AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS					.06	.08		.12				
						24.4	28.2		38.6				
						15 in. 47 out.	16 in. 52 out.		19 in. 54 out.				
TEKNOBLAST PLUS AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS					.06	.08		.12	.16			
						24.6	29.1		38.9	41.5			
						15 in. 47 out.	16 in. 52 out.		19 in. 54 out.	17 in. 57 out.			
TEKNOBLAST SUPERB AS/NZS 4233.2	WB6 FOR WATERBLAST-FITTINGS						.08		.12				
							-		41.2				
							-		19 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 gauge in order to check the tail collapse.

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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 15.2	B7R04 15.0	B7R05 16.6	B7R06 18.4	B7R08 22.6	B7R10 26.1	B7R12 29.3				
	B1K			B1K04 15.2	B1K05 16.7	B1K06 18.1	B1K08 22.2	B1K10 26.7	B1K12 29.8	B1K16 36.8			
	B1T		B1T03 15.2										
	B6R		B6R03 12.1										
2TE / 2TE RW	B7R			B7R04 15.5	B7R05 16.7	B7R06 18.5	B7R08 23.1						
	B1K			B1K04 15.2	B1K05 17.3	B1K06 18.6	B1K08 22.9		B1K12 30			B1K24 52.0	
	B1T		B1T03 16.0										
	B3R							B3R10 27.1	B3R12 32.5	B3R16 40.8	B3R20 46.5		
3TE / 3TE RW			B1T03 15.8	B3R04 15.6	B3R05 19.5	B3R06 21.5	B3R08 24.4	B3R10 28.4	B3R12 32.9	B3R16 41.2	B3R20 46.5	B1T24 53.5	
R3 TEXTILES HOSES	B3R						B3R08 25.0	B3R10 28.5	B3R12 35.8	B3R16 41.2			
R4 TEXTILES HOSES LISCIO (SMOOTH)									B3R12 34.0	B3R16 42.4	B3R20 48.8	B12T24N 58.7	B12T32N 71.7
R4 SAUGFLEX X-PLUS-G LISCIO (SMOOTH)									B3R12 33.5	B3R16 41.9	B3R20 47.8	B1T24 54.7	B12T32N 73.7
R4 SAUGFLEX CORRUGATO (CORRUGATED)									B3R12 30.8	B3R16 41.7	B3R20 47.8	B1T24 55.0	B12T32N 70.2
CLEAN FARM	B1SC						B1SC08 24.4						
	B1K						B1K08 23.2						
R8* TEXTILES HOSES			B7R03 11.8	B1K04 14.0	B1K05 16.7	B1K06 17.7	B1K08 22.4						
R18 TEXTILES HOSES	B1SC			B1SC04 15.3	B1SC05 18	B1SC06 20.0							

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 11.0	BPTFE04 13.1	BPTFE05 14.7	BPTFE06 16.2	BPTFE08 20.8	BPTFE10 22.2	BPTFE12 27.9	BPTFE16 34.5			
PTFE LISCIO (SMOOTH) 2BRAIDS *			BPTFE03 12.0	B7R04 12.8	B7R05 15.5	B7R06 16.8	BPTFE08 21.1	B7R10 24.4		B7R16 34.7			
PTFE CORRUGATO (CORRUGATED)	BPTFEC			BPTFEC04 12.8		BPTFEC06 16.0	BPTFEC08 19.4	BPTFEC10 22.2	BPTFEC12 26.2	BPTFEC16 32.6	BPTFEC20 45.0	BPTFEC24 50.4	BPTFEC32 63
	B7R			B7R04 12.8				B7R10 24.3					

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

CLEANER HOSES
Tubi idropulitrice

Hose	Fitting	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						
				18.0	18.6	20.5	23.4						
				n.s.	n.s.	n.s.	n.s.						
	B1R FOR STANDARD FITTINGS			.04	.05	.06	.08						
				17.2	18.8	21.0	25.4						
				21	22	23	25						
	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08						
				16.0	17.8	20.0	23.6						
				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						
				17.8	20.3	23.0	25.7						
				21	22	23	25						
	B12T..N FOR STANDARD FITTINGS			.04	.05	.06	.08						
				19.0	19.6	21.3	24.4						
				n.s.	n.s.	n.s.	n.s.						
TEKNOJET/1SC IEC-60335-2	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08						
				15.3	16.8	18.6	22.5						
				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						
				18.2	19.0	20.9	23.5						
				n.s.	n.s.	n.s.	n.s.						
	B1SC FOR STANDARD FITTINGS			.04	.05	.06	.08						
				16.2	18.0	20.0	23.8						
				n.s.	n.s.	n.s.	n.s.						
TEKNOJET/1ST IEC-60335-2	B1R FOR STANDARD FITTINGS			.04	.05	.06	.08						
				17.2	18.8	21.0	25.4						
				21	22	23	25						
TEKNOJET/2ST IEC-60335-2	B2R FOR STANDARD FITTINGS			.04	.05	.06	.08						
				17.8	20.3	23.0	25.7						
				21	22	23	25						
TEKNOJET/PLUS 1SN	B1R FOR STANDARD FITTINGS			.04	.05	.06	.08						
				17.2	18.8	21.0	25.4						
				21	22	23	25						
TEKNOJET/PLUS 2SN	B2R FOR STANDARD FITTINGS			.04	.05	.06	.08						
				17.8	20.3	23.0	25.7						
				21	22	23	25						
SEWER CLEANING	B1SC FOR STANDARD FITTINGS						.08		.12	.16			
							22.5		29.1	36.9			
							n.s.		n.s.	*3			
	B1R FOR STANDARD FITTINGS						.08		.12	.16			
							24.3		31.3	*			
							25		34	37			

** 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
Istruzioni di assemblaggio

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.

COSTRUZIONE DEL TUBO RACCORDATO

Il personale addetto alla costruzione del tubo raccordato, deve essere opportunamente preparato sull'impiego dei componenti e delle attrezzature specifiche.
Raccordature ben eseguite, sono fondamentali per la vita del tubo flessibile, mentre una raccordatura male eseguita può creare problemi di sfilamento dai raccordi, e causare un pericoloso "effetto frusta" del tubo o peggio, creare possibili incendi od esplosioni per i vapori o per le nebulizzazioni del fluido trasportato.

Controllo dei componenti
Prima della raccordatura esaminare i componenti per:
- Configurazione e tipologia
- Pulizia
- Danni sulla copertura
- Intaccature
- Diametri
- Ostruzioni all'interno dei tubi
- Altri difetti visibili
- Danni in genere
- Lunghezze idonee
- Bave di lavorazione
- Corrosioni

Compatibilità dei tubi e dei raccordi
Porre molta attenzione nella valutazione della compatibilità tubo/raccordo. Non accoppiare tubo e raccordo provenienti da due produttori diversi senza autorizzazione da parte degli stessi costruttori

Dispositivi di sicurezza
Durante la produzione del tubo raccordato, utilizzare sempre dispositivi di sicurezza personali, quali occhiali protettivi, mascherine filtranti ed adeguata ventilazione

Riutilizzo dei tubi e dei raccordi
Nella produzione del tubo raccordato non utilizzare mai:
a. Raccordi pressati che si siano sfilati in esercizio
b. Parti di raccordo recuperate da altri tubi raccordati
c. Tubi utilizzati per altre operazioni di controllo e verifica

Pulizia interna dei tubi raccordati
I tubi raccordati possono raccogliere parti contaminanti durante la lavorazione.
Flussare i tubi fino al raggiungimento ad un livello di pulizia ottimale.

1- Scegliere il tubo (A), le boccole (B) e gli inserti (C)

2- Tagliare il tubo alla lunghezza richiesta usando una lama rotante di acciaio.

3- Se è richiesta la spellatura esterna, asportare più gomma della copertura possibile fino alla "lunghezza di spellatura" specificata nella presente tabella, evitando di danneggiare i fili di acciao del rinforzo.

4- Posizionare la boccola sul tubo.
Inserire l'inserto nel tubo.
Selezionare la "SPINA di CONTROLLO COLLASSO"
Inserire la SPINA nel foro dell'inserto.
La parte "Non Passa" deve entrare completamente nel foro dell'inserto.
Rimuovere la SPINA.

5- Pressare la boccola al diametro di pressatura specificato nella tabella.

6- Controllare il diametro di pressatura misurandolo su ogni coppia di morsetti.
Le misure vanno prese al centro della lunghezza della boccola. Tutte le misure prese devono essere in accordo con il diametro di pressatura specificato (+0,01-0,2 mm.).

7- Inserire la "SPINA di CONTROLLO COLLASSO".

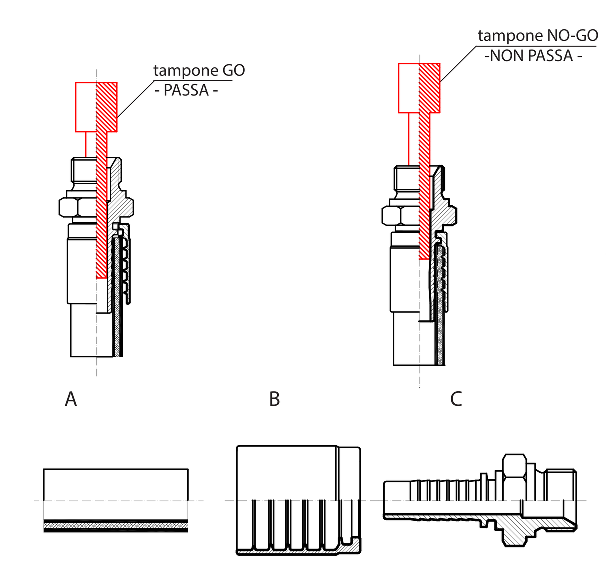
8- Se la parte "Non passa" della "SPINA di CONTROLLO COLLASSO" si blocca nel foro, il diametro di pressatura ed il collasso del foro sono corretti.

9 - Se la parte "Non passa" della "SPINA di CONTROLLO COLLASSO" entra completamente nel foro, il diamentro di pressatura deve essere ridotto, di decimo in decimo

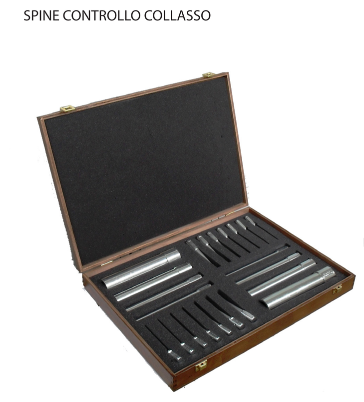
10 -Se la parte "Passa" della "SPINA di CONTROLLO non entra nel foro, il diametro di pressatura deve essere aumentato.

Per ulteriori raccomandazioni pratiche riguardanti l'assemblaggio di tubi idraulici far riferimento alla norma SAE J1273 feb 2009

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"	2.30	2.80
04	1/4"	3.30	3.75
05	5/16"	4.70	5.20
06	3/8"	6.05	6.55
08	1/2"	8.35	8.75
10	5/8"	10.85	11.40
12	3/4"	13.50	13.80
16	1"	18.50	19.20
20	1.1/4"	23.05	23.90
24	1.1/2"	29.80	30.70
32	2"	41.60	42.60

WIRE SPIRAL HOSES STANDARD FITTINGS
Tubo spiralato Raccordo standard

NOMINAL SIZE		GO, NO GO MANDRELS DIAMETERS (mm) GO	NO-GO
04	1/4"	3.15	3.60
06	3/8"	5.60	6.25
08	1/2"	7.60	8.40
10	5/8"	10.05	10.90
12	3/4"	12.35	13.30
16	1"	17.30	18.35
20	1.1/4"	22.25	23.35
24	1.1/2"	29.15	30.30
32	2"	40.70	42.00

WIRE SPIRAL HOSES INTERLOCK FITTINGS
Tubo spiralato Raccordo interlock

NOMINAL SIZE		GO, NO GO MANDRELS DIAMETERS (mm) GO	NO-GO
12	3/4"	12.15	13.10
16	1"	16.50	17.55
20	1.1/4"	22.25	23.35
24	1.1/2"	27.15	28.30
32	2"	38.70	40.00