



CRIMPING PARAMETERS CHART

Parametri di pressatura



BRAIDED HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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 options)	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		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.	n.s.
	B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
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.	n.s.					
B1T FOR STANDARD FITTINGS	B1T03	B1T04	B1T05	B1T06	B1T08	B1T10	B1T12	B1T16	B1T20	B1T24		
	15.4	16.4	18.2	20.1	24.2	26.4	30.8	38.9	48.3	54.2		
n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
B12T FOR STANDARD FITTINGS	B12T08	B12T10	B12T12									
	23.5	26.4	30.8									
n.s.	n.s.	n.s.										
TEKNO/2SN EN 853 2SN - SAE100 R2AT (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		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.	n.s.
	B2T FOR STANDARD FITTINGS	B2T03	B2T04	B2T05	B2T06	B2T08	B2T10	B2T12	B2T16	B2T20	B2T24	
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.	n.s.		
B12T FOR STANDARD FITTINGS	B12T08	B12T10	B12T12									
	24.4	27.2	32.0									
n.s.	n.s.	n.s.										
TEKNO/1ST EN 853 1ST - SAE100 R1A	B1R.. FOR STANDARD FITTINGS	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32
		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 - SAE100 R2A	B2R.. FOR STANDARD FITTINGS	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32
		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 options)	B1SC.. FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
		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	B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32	
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.	n.s.		
TEKNO/2SC EXCEED AN857 2SC (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N	
		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.	n.s.	
	B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
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.	n.s.					
TEKNO/1SC PLUS EXCEED AN857 1SC	B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
		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	B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32	
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.	n.s.		

BRAIDED HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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/2SC PLUS EXCEED AN857 2SC (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
			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		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
		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.				

STRONGER/1 SAE 100 R16 (scelta consigliata) (recommended options)	B1R FOR STANDARD FITTINGS	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20		
		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	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N					
		16.2	18.1	18.4	20.0	23.2	26.2					
			n.s.	n.s.	n.s.	n.s.	n.s.					
B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
		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.				

STRONGER/2 EXCEED SAE 100 R16 (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N				
			18.5	19.0	21.3	23.4	27.7	31.2				
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.				
	B1R FOR STANDARD FITTINGS		B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20		
			17.2	19.2	21.5	25.5	28.5	32.5	40.0	47.4		
			21	22	23	25	28	34	37	43		

TH/17 SAE 100 R17 (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS						B12T10N	B12T12N	B12T16N			
							27.6	31.1	39.0			
							n.s.	n.s.	n.s.			
	B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			15.6	16.9	18.8	22.5	28.0	30.5	37.9			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1R FOR STANDARD FITTINGS		B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16			
			16.5	18.0	19.7	24.5	29.0	32.3	39.5			
		21	22	23	25	28	34	37				
B1K FOR STANDARD FITTINGS		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12					
		15.0	16.3	18.1	-	-	-					
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.					

TEKNOJACK	B12T..N FOR STANDARD FITTINGS		B12T04N		B12T06N						
			19.0		20.3						
			n.s.		n.s.						

FORTHREE	B2R FOR STANDARD FITTINGS		B2R04		B2R06	B2R08	B2R10	B2R12	B2R16		
			19.0		24.0	26.8	30.3	34.8	42.1		
			21		23	25	28	34	37		

TEKNOMASTER 2SN	B2R FOR STANDARD FITTINGS		B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16		
			17.6	20.0	22.9	26.0	29.7	33.6	41.6		
			21	22	23	25	28	34	37		

BRAIDED HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

SLIM (scelta consigliata) (recommended options)	B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08		B1SC12					
			15.0	16.8	18.2	21.9		28.7					
		n.s.	n.s.	n.s.	n.s.		n.s.						
	B1K FOR STANDARD FITTINGS		B1K04	B1K05	B1K06	B1K08			B1K16				
		14.3	15.7	17.3	21.7			35.3					
		n.s.	n.s.	n.s.	n.s.			n.s.					
B7R FOR STANDARD FITTINGS		B7R03											
		12.3											
		n.s.											
SERVOCOMANDO	B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08							
			15.5	17.0	18.6	22.5							
			n.s.	n.s.	n.s.	n.s.							
LIFT-PLUS EN 81.2	B12T..N FOR STANDARD FITTINGS										B12T24	B12T32	
											56.8	71.0	
										n.s.	n.s.		
	B1SC FOR STANDARD FITTINGS							B1SC12	B1SC16				
								29.2	36.4				
								n.s.	n.s.				
B1R FOR STANDARD FITTINGS										B1R20			
										45.6			
										43			
SEWER CLEANING	B1SC FOR STANDARD FITTINGS					B1SC08		B1SC12	B1SC16				
						22.5		29.1	36.9				
						n.s.		n.s.	*3				
	B1R FOR STANDARD FITTINGS					B1R08		B1R12	B1R16				
						24.3		31.3	*				
						25		34	37				
VULCAN /1 EXCEED EN853 1SN SAE R1AT	B1R FOR STANDARD FITTINGS	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32	
		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	B2R.. FOR STANDARD FITTINGS	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32	
		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/1SC EXCEED EN857 1SC (scelta consigliata) (recommended options)	B1SC.. FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			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.	n.s.	*3				
	B1K FOR STANDARD FITTINGS		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32	
		-	-	-	-	-	-	-	-	-	-		
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
VULCANAIR EXCEED EN857 1SC	B1SC.. FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			-	-	-	-	-	-	37.7				
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.					
	B1K FOR STANDARD FITTINGS		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24		
			-	-	-	-	-	-	38	45.4	51.8		
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
B1T FOR STANDARD FITTINGS									B1T20	B1T24			
									47.6	54.9			
									n.s.	n.s.			

BRAIDED HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

VULCAN/2SC EXCEED EN857 2SC (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
			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.	n.s.
	B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
		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.				
ICEBERG/1 EXCEED EN853 1SN SAE 100 R1AT	B1R FOR STANDARD FITTINGS	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32
		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	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32
		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
ICEBERG/3	B2R FOR STANDARD FITTINGS		B2R04		B2R06	B2R08	B2R10	B2R12	B2R16			
			19.0		24.0	26.8	30.3	34.8	42.1			
			21		23	25	28	34	37			
ICEBERG/1SC EXCEED EN857 1SC	B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			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		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32
		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.	
ICEBERG/2SC EXCEED EN857 2SC (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
			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		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
		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.				
EVERGREEN/1SN EXCEED EN853 1SN SAE100R1AT (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		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.	
	B1SC FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
		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.				
EVERGREEN/2SN EXCEED EN853 2SN SAE100R2AT	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		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.	
EVERGREEN/1ST EXCEED EN853 1ST SAE100R1A	B1R.. FOR STANDARD FITTINGS	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32
		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
EVERGREEN/2ST EXCEED EN853 2ST SAE100R2A	B2R.. FOR STANDARD FITTINGS	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32
		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

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

EVERGREEN/1SC EXCEED EN857 1SC	B1SC.. FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			15.3	16.8	18.6	22.5	26.4	29.2	36.9			
	B1K FOR STANDARD FITTINGS	B1K03	B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32
		-	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.	*3			
EVERGREEN/2SC EXCEED EN857 2SC (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
			18.2	19.0	20.6	23.5	27.4	31.1	39.1	48.7	56.2	71.0
	B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			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.	n.s.	n.s.	
FOREVER/1SN EN853 1SN SAE100 R1AT (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
	B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			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.	n.s.	n.s.	
FOREVER/2SN EN853 2SN SAE100 R2AT	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		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.
FOREVER/1ST EN853 1ST SAE100 R1A	B1R.. FOR STANDARD FITTINGS	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32
		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
FOREVER/2ST EN853 2ST SAE100 R2A	B2R.. FOR STANDARD FITTINGS	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32
		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
FOREVER/1SC EN857 1SC	B1SC.. FOR STANDARD FITTINGS		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			15.3	16.8	18.6	22.5	26.4	29.2	36.9			
	B1K FOR STANDARD FITTINGS	B1K03	B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32
		-	15.0	16.3	18.6	22.7	26.4	29.5	37.9	44.8	51.8	64.6
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	*3			
FOREVER/2SC EN857 2SC (scelta consigliata) (recommended options)	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
			18.2	19	20.6	23.5	27.4	31.1	39.1	48.7	56.2	71.0
	B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			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.	n.s.	n.s.	
PREMIER	B12T..N FOR STANDARD FITTINGS		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N			
			18.0	18.8	20.6	23.5	27.6	31.0	39.1			
	B1SC FOR STANDARD	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			16.2	17.8	20.0	23.8	28	30.3	37.9			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.				

SPIRAL HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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 (scelta consigliata) (recommended option)	B9R FOR STANDARD FITTINGS											
			B9R04		B9R06	B9R08	B9R10	B9R12	B9R16	B9R20	B9R24	B9R32
(impieghi severi) (severe applications)	KB4SH FOR INTERLOCK FITTINGS											
TEKNOSPIR/4SH EN856 4SH (impieghi severi) (severe applications)	KB4SH FOR INTERLOCK FITTINGS											
	B4SH FOR STANDARD FITTINGS											
TEKNOSPIR/12 EN856 R12 SAE 100 R12	B9R FOR STANDARD FITTINGS											
	B4SH FOR STANDARD FITTINGS											
TEKNOSPIR/13 EN856 R13 SAE 100 R13	KB4SH FOR INTERLOCK FITTINGS											
	KBH13 FOR INTERLOCK FITTINGS											
TEKNOSPIR/15 SAE 100 R15	KB4SH FOR INTERLOCK FITTINGS											
	KBH13 FOR INTERLOCK FITTINGS											
ELASTIK/4000	B9R FOR STANDARD FITTINGS											
ELASTIK/5000	KB4SH FOR INTERLOCK FITTING											
	B9R FOR STANDARD FITTINGS											

SPIRAL HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

ELASTIK/6000	KB4SH FOR INTERLOCK FITTING								KB4SH12	KB4SH16				
										33.9	41.3			
	KBH13 FOR INTERLOCK FITTING									15 in. 52 out.	17 in. 67 out.			
												KBH1320		
											53.3			
											21.5 in. 74 out.			
TEKNOBLAST AS/NZS 4233.2	WB4 FOR WATERBLAST-FITTINGS					WB4-06	WB4-08		WB4-12					
						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					WB4-06	WB4-08		WB4-12					
						24.6	29.1		38.9					
						15 in. 47 out.	16 in. 52 out.		19 in. 54 out.					
TEKNOBLAST SUPERB AS/NZS 4233.2	WB6 FOR WATERBLAST-FITTINGS							WB6-08	WB6-12					
								-	-					
EVERGREEN/4SP EXCEED EN856 4SP (scelta consigliata) (recommended option)	B9R FOR STANDARD FITTINGS		B9R04		B9R06	B9R08	B9R10	B9R12	B9R16	B9R20	B9R24	B9R32		
			19.2		23.2	26.3	29.8	33.5	41.8	54.6	59.2	74.6		
			21		23	27	31	36	48	54	62	64		
		(impieghi severi) (severe applications)	KB4SH FOR INTERLOCK FITTING							KB4SH12	KB4SH16			
											33.9	41.5		
								15 in. 52 out.	17 in. 67 out.					
EVERGREEN/4SH EXCEED EN856 4SH	KB4SH FOR INTERLOCK FITTING							KB4SH10	KB4SH12	KB4SH16	KB4SH20	KB4SH24	KB4SH32	
									31.8	33.9	41.5	50.2	57.2	74.2
									14 in. 47.5 out.	15 in. 52 out.	17 in. 67 out.	21.5 in. 74 out.	22 in. 81 out.	29 in. 85 out.
		(impieghi severi) (demanding use)	B4SH FOR STANDARD FITTINGS									B4SH20	B4SH24	B4SH32
													48.0	58.0
										54	62	64		
TK-EVERGREEN/12 EXCEED EN856 R12 SAE100 R12	B9R FOR STANDARD FITTINGS				B9R06	B9R08	B9R10	B9R12	B9R16	B9R20	B9R24			
					23.0	26.5	30.4	34.0	41.9	52.9	58.0			
					23	27	31	36	48	54	62			
		B4SH FOR STANDARD FITTINGS										B4SH24	B4SH32	
													58.9	70.6
										62	64			
TK-EVERGREEN/13 EXCEED EN856 R13 SAE100 R13	KB4SH FOR INTERLOCK FITTING								KB4SH12	KB4SH16				
										34.7	42.2			
										15 in. 52 out.	17 in. 67 out.			
		KBH13 FOR INTERLOCK FITTING										KBH1320	KBH1324	KBH1332
													53.8	61.3
											21.5 in. 74 out.	22 in. 81 out.	29 in. 85 out.	




SPIRAL HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

EVERGREEN/R15 SAE100 R15	KB4SH FOR INTERLOCK FITTING									KB4SH12	KB4SH16					
											33.9	41.5				
										15 in. 52 out.	17 in. 67 out.					
	KBH13 FOR INTERLOCK FITTING												KBH1320	KBH1324	KBH1332	
												54.6	61.3	77.4		
												21.5 in. 74 out.	22 in. 81 out.	29 in. 85 out.		
FOREVER/4SP EN 856 4SP (scelta consigliata) (recommended option)	B9R FOR STANDARD FITTINGS		B9R04		B9R06	B9R08	B9R10	B9R12	B9R16	B9R20	B9R24	B9R32				
			19.2		23.2	26.3	29.8	33.5	41.8	54.6	59.2	74.6				
		21		23	27	31	36	48	54	62	64					
	KB4SH FOR INTERLOCK FITTING															
FOREVER/4SH EN 856 4SH (impieghi severi) (demanding use)	KB4SH FOR INTERLOCK FITTING															
FOREVER/R12 EN 856 R12 - SAE 100R12	B9R FOR STANDARD FITTINGS				B9R06	B9R08	B9R10	B9R12	B9R16	B9R20	B9R24					
					23.0	26.5	30.4	34.0	41.9	52.9	58.0					
				23	27	31	36	48	54	62						
	B4SH FOR STANDARD FITTINGS												B4SH24	B4SH32		
												58.9	70.6			
												62	64			
TK-FOREVER/R13 EN 856 R13 - SAE 100R13	KB4SH FOR INTERLOCK FITTING															
FOREVER/R15 SAE 100 R15	KB4SH FOR INTERLOCK FITTING															
KBH13 FOR INTERLOCK FITTING																

CLEANER HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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	B12T04N	B12T05N	B12T06N	B12T08N									
			18.0	18.6	20.5	23.4									
					n.s.	n.s.	n.s.	n.s.							
		B1R FOR STANDARD FITTINGS	B1R04	B1R05	B1R06	B1R08									
			17.2	18.8	21.0	25.4									
					21	22	23	25							
B1SC FOR STANDARD FITTINGS	B1SC04	B1SC05	B1SC06	B1SC08											
	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	B2R04	B2R05	B2R06	B2R08									
			17.8	20.3	23.0	25.7									
					21	22	23	25							
		B12T..N FOR STANDARD FITTINGS	B12T04N	B12T05N	B12T06N	B12T08N									
			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	B1SC04	B1SC05	B1SC06	B1SC08									
			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	B12T04N	B12T05N	B12T06N	B12T08N							
18.2	19				20.9	23.5									
					n.s.	n.s.	n.s.	n.s.							
B1SC FOR STANDARD FITTINGS	B1SC04			B1SC05	B1SC06	B1SC08									
	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	B1R04	B1R05	B1R06	B1R08									
			17.2	18.8	21.0	25.4									
						21	22	23	25						
TEKNOJET/2ST IEC-60335-2		B2R FOR STANDARD FITTINGS	B2R04	B2R05	B2R06	B2R08									
			17.8	20.3	23.0	25.7									
						21	22	23	25						
TEKNOJET/PLUS 1SN		B1R FOR STANDARD FITTINGS	B1R04	B1R05	B1R06										
			17.2	18.8	21.0										
						21	22	23							
TEKNOJET/PLUS 2SN		B2R FOR STANDARD FITTINGS	B2R04	B2R05	B2R06										
			17.8	20.3	23.0										
						21	22	23							

THERMO-PLASTIC HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

R7 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.	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 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.	n.s.			
	B1K		B1K04	B1K05	B1K06	B1K08							
			13.8	17.0	18.0	21.7							
			n.s.	n.s.	n.s.	n.s.							

TEXTILES HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	19	25	31	38	51
INTERNAL DIAMETER	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

1TE	B7R	B7R03	B7R04	B7R05	B7R06	B7R08	B7R10	B7R12				
		12.1	14.1	15.9	18	21.8	25.1	28.2				
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.				
	B1K		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16			
		14.3	16.7	17.2	21.5	25.8	28.7	37.1				
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.				

2TE	B7R		B7R04	B7R05	B7R06	B7R08	B7R10						
			14.6	16.3	18.5	22	26.1						
			n.s.	n.s.	n.s.	n.s.	n.s.						
	B1K		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12		B1K24			
			14.8	17	18	21.8	26.6	29.6		52			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		n.s.			
	B1T03					B3R10	B3R12	B3R16	B3R20				
	15.3					26	30.9	40.4	45.7				
	n.s.					n.s.	n.s.	n.s.	n.s.				

3TE		B1T03	B3R04	B3R05	B3R06	B3R08	B3R10	B3R12	B3R16	B3R20	B1T24	B12T32N
		15.8	15.9	18.1	20.3	22.8	27.0	31.9	40.6	46.1	53.5	69.0
		n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.

R3	B3R					B3R08	B3R10	B3R12	B3R16	B3R20		
						25.0	28.5	35.8	41.2	-		
						n.s.	n.s.	n.s.	n.s.	n.s.		

R4 LISCIO (SMOOTH)								B3R12	B3R16	B3R20	B12T24N	B12T32N
								34.0	42.4	48.8	58.7	71.7
								n.s.	n.s.	n.s.	n.s.	n.s.

R4 SAUGFLEX X-PLUS-G LISCIO (SMOOTH)								B3R12	B3R16	B3R20	B1T24	B12T32N
								33.5	41.9	47.8	54.7	73.7
								n.s.	n.s.	n.s.	n.s.	n.s.

R4 SAUGFLEX CORRUGATO (CORRUCATED)									B3R12	B3R16	B3R20	B1T24	B1T32N
									30.8	41.7	48.7	55.0	70.2
									n.s.	n.s.	n.s.	n.s.	n.s.

R6	B7R		B7R04	B7R05	B7R06	B7R08	B7R10	B7R12	B7R16			
			14.8	17.2	18.9	23.2	25.8	29.9	37.6			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			
	B1K		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16			
			15	16	18.4	22.6	26.1	29.7	36.3			
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.			

R8		B7R03	B1K04	B1K05	B1K06	B1K08					
		11.8	14.0	16.7	17.7	22.4					
		n.s.	n.s.	n.s.	n.s.	n.s.					

R18	B1SC		B1SC04		B1SC06						
			15.3		20.0						
			n.s.		n.s.						

PTFE HOSES

NOMINAL BORE	DN	5	6	8	10	12	16	20	25	32	40	50
INTERNAL DIAMETER	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

PTFE LISCIO (SMOOTH) 1 BRAID *	BPTFE	BPTFE03	BPTFE04	BPTFE05	BPTFE06	BPTFE08	BPTFE10	BPTFE12	BPTFE16			
		11.0	13.1	14.7	16.2	20.8	22.2	27.9	34.5			
PTFE LISCIO (SMOOTH) 2 BRAIDS *		BPTFE03	B7R04	B7R05	B7R06	BPTFE08	B7R10		B7R16			
		12	12.8	15.5	16.8	21.1	24.4		34.7			
PTFE CORRUGATO (CORRUCATED)	BPTFEC		BPTFEC04	BPTFEC05	BPTFEC06	BPTFEC08	BPTFEC10	BPTFEC12	BPTFEC16	BPTFEC20	BPTFEC24	BPTFEC32
			12.8	-	16.0	19.4	22.2	26.2	33.6	45	50.4	63
	B7R		B7R04				B7R10					
			12.8				24.3					

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

** 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.

*3 Note: Controllo con tampone No-Go diametro 19.65 mm

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

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.

SPINE CONTROLLO COLLASSO COLLAPSE CONTROL MANOREL



COMPATIBILITY CHART

Tabella di compatibilità

BRAIDED HOSES																
	B1R	B2R	B1T	B2T	B12T.N	B12T	B1SC	B1K	B3R	B9R	B4SH	B7R	KB4SH	KBH	WB4	WB6
TEKNO/1SN			■		■	■	■									
TEKNO/2SN				■	■	■										
TEKNO/1ST	■															
TEKNO/2ST		■														
TEKNO/1SC							■	■								
TEKNO/2SC					■		■									
TEKNO/1SC PLUS							■									
TEKNO/2SC PLUS					■		■									
STRONGER/1	■				■		■									
STRONGER/2	■				■											
TH 17	■				■		■	■								
TEKNOJACK					■											
FORTHREE		■														
TEKNOMASTER 2SN		■														
SLIM							■	■				■				
SERVOCOMANDO							■									
LIFT-PLUS	■	■														
SEWER-CLEANING	■						■									
VULCAN/1	■															
VULCAN/2		■														
VULCAN/SC1							■	■								
VULCAN/SC2					■		■									
ICEBERG/1	■															
ICEBERG/2		■														
ICEBERG/3		■														
ICEBERG/SC1							■	■								
ICEBERG/SC2					■		■									
EVERGREEN/1SN					■		■									
EVERGREEN/2SN					■											
EVERGREEN/1ST	■															
EVERGREEN/2ST		■														
EVERGREEN/1SC							■	■								
EVERGREEN/2SC					■		■									
FOREVER/1SN					■		■									
FOREVER/2SN					■											
FOREVER/1ST	■															
FOREVER/2ST		■														
FOREVER/1SC							■	■								
FOREVER/2SC					■		■									

SPIRAL HOSES

	B1R	B2R	B1T	B2T	B12T.N	B12T	B1SC	B1K	B3R	B9R	B4SH	B7R	KB4SH	KBH	WB4	WB6
TEKNOSPIR/4SP										■			■			
TEKNOSPIR/4SH											■		■			
TEKNOSPIR/12										■	■					
TEKNOSPIR/13													■	■		
TEKNOSPIR/15													■	■		
ELASTIK/4000										■	■					
ELASTIK/5000													■			
TEKNOBLAST															■	
TEKNOBLAST PLUS															■	
TEKNOBLAST SUPERB																■
TK-EVERGREEN/4SP										■			■			
TK-EVERGREEN/4SH											■		■			
TK-EVERGREEN/R12										■	■					
TK-EVERGREEN/R13													■	■		
TK-EVERGREEN/R15													■	■		
TK-FOREVER/4SP										■			■			
TK-FOREVER/4SH											■		■			
TK-FOREVER/R12										■	■					
TK-FOREVER/R13													■	■		
TK-FOREVER/R15													■	■		

CLEANER HOSES

	B1R	B2R	B1T	B2T	B12T.N	B12T	B1SC	B1K	B3R	B9R	B4SH	B7R	KB4SH	KBH	WB4	WB6
TEKNOJET/1SN	■				■		■									
TEKNOJET/2SN		■			■											
TEKNOJET/1SC							■									
TEKNOJET/2SC					■		■									
TEKNOJET 1ST	■															
TEKNOJET/2ST		■														
TEKNOJET/PLUS 1SN	■															
TEKNOJET/PLUS 2SN		■														

THERMOPLASTIC HOSES

	B1R	B2R	B1T	B2T	B12T.N	B12T	B1SC	B1K	B3R	B9R	B4SH	B7R	KB4SH	KBH	WB4	WB6
R7								■				■				
R7MTH1												■				

TEXTILES HOSES

	B1R	B2R	B1T	B2T	B12T.N	B12T	B1SC	B1K	B3R	B9R	B4SH	B7R	KB4SH	KBH	WB4	WB6
R6 1TE								■				■				
2TE								■								
R3									■							
R8								■								

ASSEMBLY INSTRUCTIONS

Istruzioni di assemblaggio

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 acciaio 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 diametro di pressatura deve essere ridotto, di decimo in decimo

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

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".

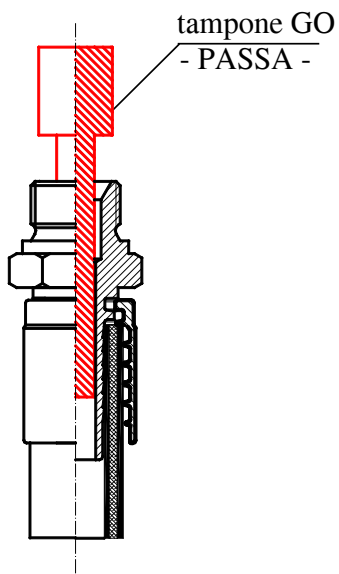
8- If the "NO GO" part of the MANDREL stops in the bore the crimping diameter and the bore collapse are correct.

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.

BEFORE PRESSING

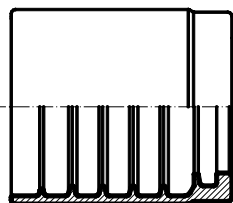
Prima della pressatura



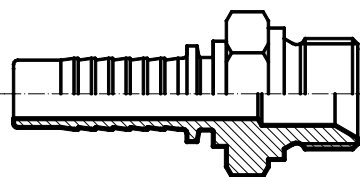
A



B

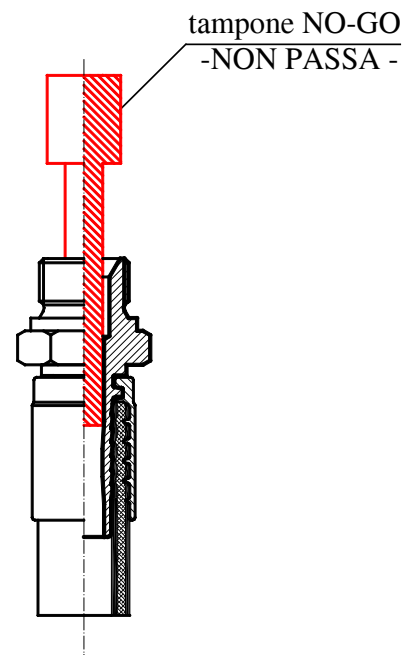


C



AFTER PRESSING

Dopo la pressatura



INSERT BORE COLLAPSE CONTROL

Controllo del collasso foro

WIRE BRAIDED HOSES STANDARD FITTINGS

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

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"	40.7	42.0

WIRE SPIRAL HOSES INTERLOCK FITTINGS

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	28.3
32	2"	38.7	40.0

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 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.

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 check-out*

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.

HOW TO READ THIS CHART

Come leggere la tabella

TIPO BOCCOLA FERRULE TYPE		CODICE BOCCOLA FERRULE CODE											
TEKNO/1SN	B12T..N FOR STANDARD FITTINGS	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N	
		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		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
			16.0	17.8	20.0	23.6	27.4	30.2	38.9				
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.				
	B1T FOR STANDARD FITTINGS	B1T03	B1T04	B1T05	B1T06	B1T08	B1T10	B1T12	B1T16	B1T20	B1T24		
		15.4	16.4	18.2	20.1	24.2	26.4	30.8	38.9	48.3	54.2		
			n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.	n.s.		
	B12T FOR STANDARD FITTINGS					B12T08	B12T10	B12T12					
						23.5	26.4	30.8					
						n.s.	n.s.	n.s.					

n.s. NO SKIVE
xx.x OUT SKIVE
xx.x/xx.x IN/OUT SKIVE

We feel better
under pressure

Vitillo S.p.a.
Zona Pip Camporeale
83031 Ariano Irpino (AV)
Italy
Tel. +39 0825 881555-56
Fax +39 0825 881532
vitillo.eu
info@vitillo.eu

