

CRIMPING PARAMETERS CHART

BRAIDED HOSES
Tubi trecati

HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
TEKNO/15N EN 853 15N - SAE 100 R1AT	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
TEKNO/25N EN 853 25N - SAE 100 R2AT	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
TEKNO/15T EN 853 15T - SAE 100 R1A	15.4	16.4	16.2	17.1	18.2	20.1	24.2	26.4	30.8	38.9	46.6
TEKNO/15T EXCEED AM853 15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
TEKNO/25C EXCEED AM853 25C	16.2	18.0	20.0	23.8	27.8	30.3	37.9	46.6	55.3	64.0	77.7

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HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
TEKNO/15C PLUS EXCEED AM853 15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
TEKNO/25C PLUS EXCEED AM853 25C	16.2	18.0	20.0	23.8	27.8	30.3	37.9	46.6	55.3	64.0	77.7
FORTHREE	15.4	16.4	16.2	17.1	18.2	20.1	24.2	26.4	30.8	38.9	46.6
STRONGER+1 SAE 100 R16	15.2	17.2	18.8	21.0	25.4	28.2	32.1	39.8	46.6	53.0	66.2
SUM	14.2	15.7	17.3	21.7	24.7	27.7	35.3	44.0	52.7	61.4	75.1

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HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
TEKNOIACK	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
LIFT-PLUS EN 612	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
SERVOCOMANDO	15.5	17.0	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
ALPI 3300	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
ALPI 4000	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7

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HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
ICEBERG/1 EXCEED AM853 15N SAE 100 R1AT	15.2	17.2	18.8	21.0	25.4	28.2	32.1	39.8	46.6	53.0	66.2
ICEBERG/2 EXCEED AM853 25N SAE 100 R2AT	17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5
ICEBERG/3	19.0	24.0	26.8	30.3	34.8	42.1	51.0	60.9	70.8	80.7	90.6
VULCAN/1 EXCEED AM853 15N SAE 100 R1AT	15.2	17.2	18.8	21.0	25.4	28.2	32.1	39.8	46.6	53.0	66.2
VULCAN/2 EXCEED AM853 25N SAE 100 R2AT	17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5
VULCAN AIR EXCEED AM853 15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
PREMIER	18.0	18.8	20.6	23.5	27.6	31.0	39.1	48.5	57.0	69.4	83.8

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HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
DOLOMITI/15N EN 853 15N - SAE 100 R1AT	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
DOLOMITI/25N EN 853 25N - SAE 100 R2AT	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
DOLOMITI/15C EXCEED AM853 15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
DOLOMITI/25C EXCEED AM853 25C	16.2	18.0	20.0	23.8	27.8	30.3	37.9	46.6	55.3	64.0	77.7

SPIRAL HOSES
Tubi spirali

HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
TEKNO/15N	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
TEKNO/25N	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
TEKNO/15T	15.4	16.4	16.2	17.1	18.2	20.1	24.2	26.4	30.8	38.9	46.6
TEKNO/15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
TEKNO/25C	16.2	18.0	20.0	23.8	27.8	30.3	37.9	46.6	55.3	64.0	77.7

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TEKNO/15N	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
TEKNO/25N	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
TEKNO/15T	15.4	16.4	16.2	17.1	18.2	20.1	24.2	26.4	30.8	38.9	46.6
TEKNO/15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9	45.6	54.3	63.0	76.7
TEKNO/25C	16.2	18.0	20.0	23.8	27.8	30.3	37.9	46.6	55.3	64.0	77.7

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HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
EVEREST/4000	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
EVEREST/5000	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
EVEREST/6000	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0

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HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
TEKNOBLAST	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
TEKNOBLAST PLUS	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
TEKNOBLAST SUPERB	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0

HOW TO READ THIS CHART

TEKNO/15N

3/16" 1/4" 5/16" 3/8" 1/2" 5/8" 3/4" 1" 1 1/4" 1 1/2" 2"

16.0 18.0 18.6 20.5 23.4 27.0 30.8 39.1 48.5 57.0 69.4

15.4 16.4 16.2 17.1 18.2 20.1 24.2 26.4 30.8 38.9 46.6

15.3 16.8 18.6 22.5 26.4 29.2 36.9 45.6 54.3 63.0 76.7

16.2 18.0 20.0 23.8 27.8 30.3 37.9 46.6 55.3 64.0 77.7

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

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

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TERMOPLASTIC HOSES

HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
R7*	11.8	14.1	16.2	18.2	22.2	25.6	29.0	36.8			
R7 MTH1*	11.8	14.1	16.2	18.2	22.2	25.6	29.0	36.8			
1TE/RS	15.0	16.6	18.4	22.6	26.1	29.3					
2TE	15.2	16.7	18.1	22.2	26.7	29.8	36.8				
3TE	15.5	16.7	18.5	23.1	27.1	32.5	40.8	46.5			
R3	15.8	16.6	19.5	21.5	24.4	28.4	32.0	41.3	46.5	53.5	
R4	15.8	16.6	19.5	21.5	24.4	28.4	32.0	41.3	46.5	53.5	
R4	15.8	16.6	19.5	21.5	24.4	28.4	32.0	41.3	46.5	53.5	
R4	15.8	16.6	19.5	21.5	24.4	28.4	32.0	41.3	46.5	53.5	
CLEAN-FARM	14.8	14.0	16.7	17.7	22.4						
RP*	14.8	14.0	16.7	17.7	22.4						
R10	14.3	10.0	10.0								

CLEANER HOSES
Tubi idropultrici

HOSES	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
TEKNOIET/15N HC-60335-2	18.0	18.6	20.5	23.4							
TEKNOIET/25N HC-60335-2	17.8	20.3	23.0	25.7							
TEKNOIET/15C HC-60335-2	15.0	16.0	16.0	17.0	18.0	19.0	20.0	21.0	22.0	23.0	24.0
TEKNOIET/25C HC-60335-2	16.2	18.0	20.0	23.8	27.8	30.3	37.9	46.6	55.3	64.0	77.7
TEKNOIET/15T HC-60335-2	15.4	16.4	16.2	17.1	18.2	20.1	24.2	26.4	30.8	38.9	46.6
TEKNOIET/25T HC-60335-2	17.8	20.3	23.0	25.7							
TEKNOIET/PLUS-15N	17.2	18.8	21.0	25.4							
TEKNOIET/PLUS-25N	17.2	18.8	21.0	25.4							
SEWER-CLEANING	14.2	15.7	17.3	21.7	24.7	27.7	35.3	44.0	52.7	61.4	75.1

ASSEMBLY INSTRUCTIONS

Istruzioni di assemblaggio

- Select the hose (A), ferrules (B) and inserts (C)
- Cut the hose squarely using a rotary steel blade to the required length.
- If skiving is required, remove all rubber cover to the "skiving length" specified in the table, avoiding damages to the steel wires reinforcement.
- 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.
- Crimp the ferrule to the diameter specified in the table.
- Inspect the crimp diameter by measuring it on each die impression. 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.
- Insert the "COLLAPSE CONTROL MANOREL".
- If the "NO GO" part of the MANOREL stops in the bore the crimping diameter is correct.
- If the "NO GO" part of the MANOREL goes through the bore, the crimping diameter must be reduced by increments of 0.1 mm.
- If the "GO" part of the MANOREL does not go through the bore, the crimping diameter must be increased.

For more practical 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
- Distortion 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. Re-use of Hose and Fittings
Do not re-use:
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.

CONSTRUZIONE DEL TUBO RACCORDATO

Il personale addetto alla costruzione del tubo raccordato, deve essere opportunamente preparato sull'impiego dei componenti e delle attrezzature specifiche. Raccordare deve essere, solo e fondamentalmente, per la vita del tubo flessibile, mentre una raccordatura male eseguita può creare problemi di filtramento di raccordi, a causare un pericoloso "