

CRIMPING PARAMETERS CHART

BRAIDED HOSES Tubi intrecciati

TEKNO/15N EN 853 15N - SAE100 R1AT	NOMINAL SIZE											
	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B12T-N	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4	
B15C				16.0	17.8	20.0	23.6	27.4	30.3	37.9		
B1T	15.4	16.4	18.2	20.1	24.2	26.4	30.8	38.9	46.6	54.2		
B12T				23.5	26.4	30.8						

TEKNO/15C PLUS EXCEED AM857 15C

NOMINAL SIZE											
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B15C	15.3	16.8	18.6	22.5	26.4	29.2	36.9				
B1K	15.0	16.3	18.6	22.7	26.4	29.5	37.9	44.8	50.8	64.6	

TEKNOIACK

NOMINAL SIZE											
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B12T-N	19.0										
B15C											

ICEBERG/1 EXCEED AM857 15N SAE100R1AT

NOMINAL SIZE											
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B1R	15.2	17.2	18.8	21.0	25.4	28.2	32.2	39.8	46.6	53.0	66.2
B2R	17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5

DOLOMITI/15N EXCEED AM857 15C SAE100 R1AT

NOMINAL SIZE											
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B12T-N	16.0	18.0	18.6	20.5	23.4	27.0	30.8	39.1	48.5	57.0	69.4
B15C				16.0	17.8	20.0	23.6	27.4	30.3	37.9	

SPIRAL HOSES Tubi spirali

TEKNO/25N EN 853 25N - SAE100 R2AT	NOMINAL SIZE											
	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B12T-N	16.7	19.0	19.6	21.3	24.4	28.2	32.0	39.8	49.3	51.0	59.0	77.7
B2T	15.7	18.0	20.2	21.4	25.6	28.5	32.0	41.0	50.0	57.5		

TEKNO/25C PLUS EXCEED AM857 25C

NOMINAL SIZE												
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	
B12T-N	18.2	19.0	20.6	23.5	27.4	31.1	39.1	48.7	56.2	71.0		
B15C	16.2	18.0	20.0	23.8	27.8	30.3	37.9					

TEKNO/25N EN 853 25N - SAE100 R2AT

NOMINAL SIZE												
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	
B12T-N	16.7	19.0	19.6	21.3	24.4	28.2	32.0	39.8	49.3	51.0	59.0	77.7
B2T	15.7	18.0	20.2	21.4	25.6	28.5	32.0	41.0	50.0	57.5		

ICEBERG/2 EXCEED AM857 25N SAE100R2AT

NOMINAL SIZE											
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B1R	15.2	17.2	18.8	21.0	25.4	28.2	32.2	39.8	46.6	53.0	66.2
B2R	17.6	17.8	20.3	23.0	25.7	29.0	33.5	41.2	50.8	56.7	69.5

DOLOMITI/25N EXCEED AM857 25C SAE100 R2AT

NOMINAL SIZE												
3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	
B12T-N	16.7	19.0	19.6	21.3	24.4	28.2	32.0	39.8	49.3	51.0	59.0	77.7
B2T	15.7	18.0	20.2	21.4	25.6	28.5	32.0	41.0	50.0	57.5		

TERMOPLASTIC HOSES

HOSES	NOMINAL SIZE											
	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
R7*	B7R	11.8	14.1	16.2	18.2	22.2	25.6	29.0	36.8			
	B1K	14.0	17.0	17.6	22.8							

CLEANER HOSES Tubi idropultrici

TEKNOIET/15N IC-60335-2	NOMINAL SIZE											
	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B1R	17.2	18.8	21.0	25.4								
B15C	16.0	17.8	20.0	23.6								

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 must be reduced by increments of 0.1 mm.
- 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.

EVEREST/4000

TEKNOBLAST AS/NZS 4233.2	NOMINAL SIZE			
	WB4	WB5	WB6	WB7
B4	24.4	28.2	38.6	
B5				30.9

HOW TO READ THIS CHART

PTFE HOSES

HOSES	NOMINAL SIZE											
	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
PTFE (NON CONDUCTIVE)	BPTFE	11.0	13.1	14.7	16.2	20.8	22.2	27.9	34.5			
PTFE (CONDUCTIVE)	BPTFEC	12.0	12.8	15.5	16.8	21.1	24.4	34.7				

SEWER CLEANING

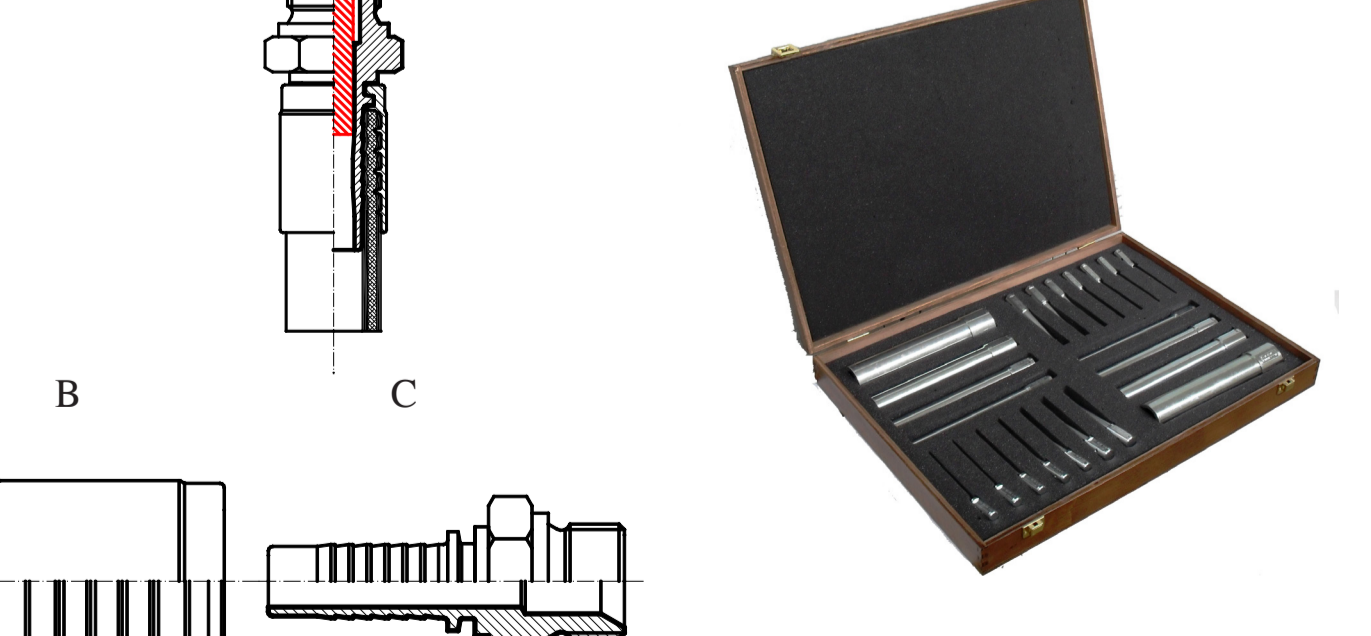
TEKNOIET/15T IC-60335-2	NOMINAL SIZE											
	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"
B1R	17.2	18.8	21.0	25.4								
B15C	16.2	18.0	20.0	23.8								

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



INSERT BORE COLLAPSE CONTROL

NOMINAL SIZE	GO, NO GO MANDRELS DIAMETERS (mm)	
	GO	NO-GO
03	2.30	2.80
04	1/4"	3.30
05	5/16"	4.70
06	3/8"	6.05
08	1/2"	8.35
10	5/8"	10.85
12	3/4"	13.50
16	1"	18.50
20	1 1/4"	23.05
24	1 1/2"	29.80
32	2"	41.60

WIRE SPIRAL HOSES STANDARD FITTINGS

NOMINAL SIZE	GO, NO GO MANDRELS DIAMETERS (mm)	
	GO	NO-GO
04	1/4"	3.15
06	3/8"	6.15
08	1/2"	7.60
10	5/8"	10.05
12	3/4"	12.35
16	1"	17.30
20	1 1/4"	22.25
24	1 1/2"	29.15
32	2"	40.70

WIRE SPIRAL HOSES INTERLOCK FITTINGS

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