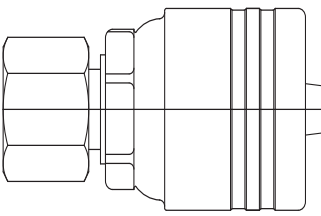


# HDS-17700

# RUBBER HOSE SWAGING DATA

# 1 PIECE FITTING

FITTING CODE	HOSE TYPE	05	06	08	10	12	16	20	25	32	40	50	DN
		3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"	in.
		03	04	05	06	08	10	12	16	20	24	32	SIZE
 <p><b>'A' SERIES</b></p>	SAE100 R1AT (EN 853 1SN)		0.684 (17.37)	0.789 (20.04)	0.865 (21.97)	0.952 (24.18)	1.169 (29.69)	1.343 (34.11)	1.666 (42.32)	1.923 (48.84)			NON SKIVE
	SAE100 R2AT (EN 853 2SN)		0.733 (18.62)	0.805 (20.45)	0.888 (22.56)	0.990 (25.15)	1.184 (30.07)	1.337 (33.96)	1.659 (42.14)	2.017 (51.23)			
	EH221 (2SNK)		0.693 (17.60)	0.764 (19.41)	0.853 (21.67)	0.992 (25.20)	1.176 (29.87)	1.295 (32.89)	1.605 (40.77)				
	SAE 100R16		0.695 (17.65)		0.851 (21.62)	0.959 (24.36)	1.184 (30.07)	1.293 (32.84)	1.605 (40.77)				
	SAE 100R17		0.662 (16.81)		0.839 (21.31)	0.965 (24.51)	1.207 (30.66)	1.291 (32.79)	1.609 (40.87)				
	SAE100 R12T (EN 856 R12T)				0.882 (22.40)	1.025 (26.04)	1.270 (32.26)	1.345 (34.16)	1.682 (42.72)	2.015 (51.18)			

'CUT THE HOSE END SQUARE, LIGHTLY LUBRICATE THE HOSE BORE WITH A COMPATIBLE FLUID, PUSH THE COUPLING FULLY ON TO THE HOSE, PLACE THE ASSEMBLY IN TO THE SWAGING MACHINE DIE SET SUCH THAT THE LARGEST DIAMETER OF THE FERRULE IS WITHIN THE DIE SET BY 1.0 TO 1.5mm (0.040-0.060)". NOTE THAT SWAGING MACHINES WITH FLOATING HEAD DOUBLE TAPER DIE SETS ARE NOT SUITABLE FOR SWAGING THESE COUPLINGS e.g. P20, P32'.

THE ABOVE SWAGING DIAMETERS ARE IN INCHES AND SHOULD BE SWAGED TO THE SPECIFIED DIAMETER +/- 0.005" (SWAGING DIAMETERS IN BRACKETS ARE IN METRIC AND SHOULD BE SWAGED TO THE SPECIFIED DIAMETER +/-0.13mm)



NOTE: 'X' INSERTS ARE NOT TO BE USED WITH MULTI-SPIRAL HOSE ON SIZES 1-1/4", 1-1/2" & 2"  
BRAZED INSERTS ARE NOT TO BE USED WITH MULTI-SPIRAL HOSE

Designed,  
Matched &  
Qualified

