

Swaging Chart

PH Hydraulik - Stainless steel

Swaging Chart

PH Hydraulik - Stainless steel

												UNIFLEX HM10.3 - HM13 HM100 - HM150		UNIFLEX HM14, HM200-HM290 S1 - S9	
Hose type	Hose dimensions				Skive length		Ferrule dimensions				Swage diam. Ø +/- 0,1mm	Die Set Ref.	Adjustment	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Inner	Outer	Part No.	Ø	Length	prod.code					
Alfagomma FLEXOR 1SN/R1AT - SAE 100 R1AT - ISO 1436-1 - UNI EN 853 1SN															
NST-HF 5	3/16"	5	11,4	1			SFP1-05-SS	21,0	23,0	P1-DN05	15,5	14	5,5	14	1,5
NST-HF 6	1/4"	6	13,0				SFP5-06-SS	23,0	31,7	P5-DN06	17,5	17	5,5	17	0,5
NST-HF 8	5/16"	8	14,5				SFP1-08-SS	22,0	34,5	P1-DN08	18,7	17	3,3	17	1,7
NST-HF 10	3/8"	10	17,2				SFP5-10-SS	26,0	33,3	P5-DN10	20,5	20	5,5	20	0,5
NST-HF 13	1/2"	13	20,1				SFP5-13-SS	29,0	34,5	P5-DN12	23,0	20	6	20	3
NST-HF 16	5/8"	16	23,1				SFP5-16-SS	33,0	39,0	P5-DN16	25,7	24	7,3	24	1,7
NST-HF 20	3/4"	19	27,3				SFP5-20-SS	37,0	44,0	P5-DN19	30,5	28	6,5	28	2,5
NST-HF 25	1"	25	35,2				SFP5-25-SS	46,0	45,7	P5-DN25	38,0	36	8	36	2
NST-HF 32	1-1/4"	32	42,5				SFP1-32-SS	55,0	70,0	P1-DN31	49,5	47	5,5	47	2,5
NST-HF 40	1-1/2"	38	49,7				SFP1-40-SS	60,0	70,0	P1-DN38	54,4	54	5,6	54	0,4
Alfagomma FLEXOR 2SN/R2AT - SAE 100 R2AT - ISO 1436-1 - UNI EN 853 2SN															
HST-HF 5	3/16"	5	13,0	2			SFP2-05-SS	21,0	23,0	P2-DN05	16,5	14	4,5	14	2,5
HST-HF 6	1/4"	6	14,5				SFP5-06-SS	23,0	31,7	P5-DN06	18,4	17	4,6	17	1,4
HST-HF 8	5/16"	8	16,1				SFP5-08-SS	24,0	31,5	P5-DN08	19,7	17	4,3	17	2,7
HST-HF 10	3/8"	10	18,5				SFP5-10-SS	26,0	33,3	P5-DN10	21,5	20	4,5	20	1,5
HST-HF 13	1/2"	13	21,4				SFP5-13-SS	29,0	34,5	P5-DN12	23,8	20	5,2	22	1,8
HST-HF 16	5/8"	16	24,6				SFP5-16-SS	33,0	39,0	P5-DN16	26,6	24	6,4	26	0,6
HST-HF 20	3/4"	19	29,0				SFP5-20-SS	37,0	44,0	P5-DN19	31,6	28	5,4	28	3,6
HST-HF 25	1"	25	36,8				SFP5-25-SS	46,0	45,7	P5-DN25	38,9	36	7,1	36	2,9
HST-HF 32	1-1/4"	32	46,4				SFP8-32-SS	59,0	66,5	P8-DN31	50,1	50	8,9	50	0,1
HST-HF 40	1-1/2"	38	53,7				SFP8-40-SS	67,0	67,0	P8-DN38	59,2	57	7,8	57	2,2
Alfagomma FLEXOPAK 1SC - EN 857 1SC - ISO 11237															
NSK 6	1/4"	6	12,1	1			SFPFR7-06-SS	18,0	34,5	PF-R7-DN06	15,5	14	2,5	14	1,5
NSK 8	5/16"	8	14,1				SFPFR7-08-SS	19,0	34,5	PF-R7-DN08	15,6	14	3,4	14	1,6
NSK 10	3/8"	10	15,6				SFPFR7-10-SS	22,0	35,0	PF-R7-DN10	19,3	17	2,7	17	2,3
Alfagomma AT3K - SAE 100 R17 - ISO 11237															
NSK 13	1/2"	13	19,5	1			SFPFR7-13-SS	25,0	37,0	PF-R7-DN12	21,6	20	3,4	20	1,6
Alfagomma FLEXOPAK 2SC - EN 857 2SC - ISO 11237															
HSK-HF 6	1/4"	6	13,2	2			SFP5-06-SS	23,0	31,7	P5-DN06	17,7	17	5,3	17	0,7
HSK-HF 8	5/16"	8	14,5				SFP5-08-SS	24,0	31,5	P5-DN08	19,0	17	5	17	2
HSK-HF 10	3/8"	10	17,0				SFP5-10-SS	26,0	33,3	P5-DN10	20,6	20	5,4	20	0,6
HSK-HF 13	1/2"	13	20,3				SFP5-13-SS	29,0	34,5	P5-DN12	23,2	20	5,8	22	1,2
HSK-HF 16	5/8"	16	23,9				SFP5-16-SS	33,0	39,0	P5-DN16	26,2	24	6,8	24	2,2
HSK-HF 20	3/4"	19	27,7				SFP5-20-SS	37,0	44,0	P5-DN19	30,2	28	6,8	28	2,2
HSK-HF 25	1"	25	34,6				SFP5-25-SS	46,0	45,7	P5-DN25	38,6	36	7,4	36	2,6

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Swaging Chart PH Hydraulik - Stainless steel												UNIFLEX HM10.3 - HM13 HM100 - HM150		UNIFLEX HM14, HM200-HM290 S1 - S9	
Hose type	Hose dimensions				Skive length		Ferrule dimensions				Swage diam. Ø +/- 0,1mm	Die Set Ref.	Adjustment	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Inner	Outer	Part No.	Ø	Length	prod.code					
Alfagomma FLEXOPAK 2 MINETUFF - EN 857 2SC (up to 1") - ISO 11237 - SAE 100R16															
HSK-PQ 6	1/4"	6	13,0	2			SFP5-06-SS	23,0	31,7	P5-DN06	17,7	17	5,3	17	0,7
HSK-PQ 8	5/16"	8	14,5				SFP5-08-SS	24,0	31,5	P5-DN08	19,0	17	5	17	2
HSK-PQ 10	3/8"	10	16,8				SFP5-10-SS	26,0	33,3	P5-DN10	20,5	20	5,5	20	0,5
HSK-PQ 13	1/2"	13	20,6				SFP5-13-SS	29,0	34,5	P5-DN12	23,6	20	5,4	22	1,6
HSK-PQ 16	5/8"	16	23,2				SFP5-16-SS	33,0	39,0	P5-DN16	26,2	24	6,8	24	2,2
HSK-PQ 20	3/4"	19	27,6				SFP5-20-SS	37,0	44,0	P5-DN19	30,9	28	6,1	28	2,9
HSK-PQ 25	1"	25	35,5				SFP5-25-SS	46,0	45,7	P5-DN25	38,3	36	7,7	36	2,3
HSK-PQ 32	1-1/4"	32	42,0				SFP1-32-SS	55,0	70,0	P1-DN31	48,1	47	6,9	47	1,1
HSK-PQ 40	1-1/2"	38	49,9				SFP8-40-SS	67,0	67,0	P8-DN38	56,1	54	10,9	54	2,1
Alfagomma FLEXOPAK 2 SUPERTUFF - EN 857 2SC - ISO 11237 - SAE 100 R16															
HSK-ST-6	1/4"	6	13,0	2			SFP5-06-SS	23,0	31,7	P5-DN06	17,7	17	5,3	17	0,7
HSK-ST-8	5/16"	8	14,5				SFP5-08-SS	24,0	31,5	P5-DN08	19,0	17	5	17	2
HSK-ST-10	3/8"	10	16,8				SFP5-10-SS	26,0	33,3	P5-DN10	21,1	20	4,9	20	1,1
HSK-ST-13	1/2"	13	20,6				SFP5-13-SS	29,0	34,5	P5-DN12	23,7	20	5,3	22	1,7
HSK-ST-16	5/8"	16	23,2				SFP5-16-SS	33,0	39,0	P5-DN16	26,4	24	6,6	24	2,4
HSK-ST-20	3/4"	19	27,6				SFP5-20-SS	37,0	44,0	P5-DN19	31,2	28	5,8	28	3,2
HSK-ST-25	1"	25	35,5				SFP5-25-SS	46,0	45,7	P5-DN25	38,7	36	7,3	36	2,7
Alfagomma FLEXOR 7 - SAE 100 R7 - EN 855 R7															
CR 7-5A	3/16"	5	9,6	1			SFPFR7-05-SS	14,0	26,5	PF-R7-DN05	11,5	9	2,5	9	2,5
CR 7-6A	1/4"	6	12,2				SFPFR7-06-SS	18,0	34,5	PF-R7-DN06	15,1	14	2,9	14	1,1
CR 7-8A	5/16"	8	14,3				SFPFR7-08-SS	19,0	34,5	PF-R7-DN08	15,6	14	3,4	14	1,6
CR 7-10A	3/8"	10	16,0				SFPFR7-10-SS	22,0	35,0	PF-R7-DN10	18,6	17	3,4	17	1,6
CR 7-13A	1/2"	13	20,3				SFPFR7-13-SS	25,0	37,0	PF-R7-DN12	21,4	20	3,6	20	1,4
Alfagomma FLEXOR TWB1 - SAE 100															
CR 8-5A	3/16"	5	9,8	1			SFPFR7-05-SS	14,0	26,5	PF-R7-DN05	11,7	9	2,3	9	2,7
CR 8-6A	1/4"	6	11,9				SFPFR7-06-SS	18,0	34,5	PF-R7-DN06	15,1	14	2,9	14	1,1
CR 8-8A	5/16"	8	13,2				SFPFR7-08-SS	19,0	34,5	PF-R7-DN08	15,5	14	3,5	14	1,5
CR 8-10A	3/8"	10	15,9				SFPFR7-10-SS	22,0	35,0	PF-R7-DN10	18,7	17	3,3	17	1,7
CR 8-13A	1/2"	13	19,3				SFPFR7-13-SS	25,0	37,0	PF-R7-DN12	20,9	20	4,1	20	0,9

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Swaging Chart PH Hydraulik - Stainless steel												UNIFLEX HM10.3 - HM13 HM100 - HM150		UNIFLEX HM14, HM200-HM290 S1 - S9	
Hose type	Hose dimensions				Skive length		Ferrule dimensions				Swage diam. Ø +/- 0,1mm	Die Set Ref.	Adjustment	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Inner	Outer	Part No.	Ø	Length	prod.code					
ALFABIOTECH EVOLUTION 5000 - MINETUFF ISO 18752															
ABT-EV5K-DN16-4S	5/8"	16	25,4	4		28,0	SFP3-16-SS	33,0	40,0	P3-DN16	29,5	28	3,5	28	1,5
ABT-EV5K-DN20-4S	3/4"	19	29,4			33,5	SFP3-20-SS	38,0	45,0	P3-DN19	34,1	32	3,9	32	2,1
ABT-EV5K-DN25-4S	1"	25	37,4			38,0	SFP3-25-SS	46,0	50,0	P3-DN25	42,4	40	3,6	40	2,4
ALFABIOTECH EVOLUTION 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15															
ABT-EV6K-DN06-4S	1/4"	6	17	4		25,0	SFP3-06-SS	22,0	34,5	P3Sp4-DN06	19,6	17	2,4	19	0,6
ABT-EV6K-DN10-4S	3/8"	10	19,8			25,0	SFP3-10-SS	26,0	35,0	P3-DN10	23,2	20	2,8	22	1,2
ABT-EV6K-DN13-4S	1/2"	13	22,5			28,0	SFP3-13-SS	30,0	37,0	P3-DN12	27,1	24	2,9	26	1,1
Transfer Oil 066 R7 ANTIABRASION - SAE 100 R7 - EN 855 R7 - ISO3949-R7															
CR 7-5T	3/16"	5	9,6	1			SFPFR7-05-SS	14,0	26,5	PF-R7-DN05	11,5	9	2,5	9	2,5
CR 7-6T	1/4"	6	12,2				SFPFR7-06-SS	18,0	34,5	PF-R7-DN06	15,1	14	2,9	14	1,1
CR 7-8T	5/16"	8	14,3				SFPFR7-08-SS	19,0	34,5	PF-R7-DN08	15,6	14	3,4	14	1,6
CR 7-10T	3/8"	10	16,0				SFPFR7-10-SS	22,0	35,0	PF-R7-DN10	18,6	17	3,4	17	1,6
CR 7-13T	1/2"	13	20,3				SFPFR7-13-SS	25,0	37,0	PF-R7-DN12	21,4	20	3,6	20	1,4
Transfer Oil 087 ISB STEEL BRAID ANTIABRASION - SAE 100 R1															
CR 8-5T	3/16"	5	9,8	1			SFPFR7-05-SS	14,0	26,5	PF-R7-DN05	11,7	9	2,3	9	2,7
CR 8-6T	1/4"	6	11,9				SFPFR7-06-SS	18,0	34,5	PF-R7-DN06	15,1	14	2,9	14	1,1
CR 8-8T	5/16"	8	13,2				SFPFR7-08-SS	19,0	34,5	PF-R7-DN08	15,5	14	3,5	14	1,5
CR 8-10T	3/8"	10	15,9				SFPFR7-10-SS	22,0	35,0	PF-R7-DN10	18,7	17	3,3	17	1,7
CR 8-13T	1/2"	13	19,3				SFPFR7-13-SS	25,0	37,0	PF-R7-DN12	20,9	20	4,1	20	0,9
Transfer Oil 030 - PTFE - ISSB															
PTFE1WDN06	1/4"	6	9,2	1			SFPTFE-06-SS	14,0	33,0	PF-PTFE-DN06	11,5	9	2,5	9	2,5
PTFE1WDN08	5/16"	8	11,0				SFPTFE-08-SS	17,0	33,0	PF-PTFE-DN08	14,1	14	2,9	14	0,1
PTFE1WDN10	3/8"	10	12,7				SFPTFE-10-SS	19,0	33,0	PF-PTFE-DN10	16,0	14	3	14	2
PTFE1WDN13	1/2"	13	16,1				SFPTFE-13-SS	23,0	35,0	PF-PTFE-DN12	20,0	20	3	20	0
PTFE1WDN16	5/8"	16	19,8				SFPTFE-16-SS	27,0	38,0	PF-PTFE-DN16	23,3	20	3,7	22	1,3
PTFE1WDN20	3/4"	20	23,0				SFPTFE-20-SS	30,0	44,0	PF-PTFE-DN19	26,7	24	3,3	26	0,7
PTFE1WDN25	1"	25	28,8				SFPTFE-25-SS	37,0	50,0	PF-PTFE-DN 25	33,1	32	3,9	32	1,1
Transfer Oil 031 - PTFE ISSB CONVOLUTED															
PTFEC1DN10	3/8"	10	15,2	1			SFWPTFE-10-SS	23,5	33,0	PF-W-PTFE-DN10	17,8	17	5,7	17	0,8
PTFEC1DN13	1/2"	13	18,8				SFWPTFE-13-SS	26,3	35,0	PF-W-PTFE-DN12	20,3	20	6	20	0,3
PTFEC1DN16	5/8"	16	22,1				SFWPTFE-16-SS	30,0	38,0	PF-W-PTFE-DN16	24,1	24	5,9	24	0,1
PTFEC1DN20	3/4"	20	24,6				SFWPTFE-20-SS	34,3	44,0	PF-W-PTFE-DN19	27,4	24	6,9	26	1,4
PTFEC1DN25	1"	25	32,8				SFWPTFE-25-SS	40,6	50,0	PF-W-PTFE-DN25	34,0	32	6,6	32	2

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Hose type	Hose dimensions				Skive length		Ferrule dimensions				Swage diam. Ø +/- 0,1mm	Die Set Ref.	Adjustment	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Inner	Outer	Part No.	Ø	Length	prod.code					
Gates MXT - SAE 100R16 - EN857 2SC															
4MXT	1/4"	6	14,0	2			SFP5-06-SS	23,0	31,7	P5-DN06	18,5	17	4,5	17	1,5
5MXT	5/16"	8	15,2				SFP5-08-SS	24,0	31,5	P5-DN08	19,4	17	4,6	19	0,4
6MXT	3/8"	10	17,1				SFP5-10-SS	26,0	33,3	P5-DN10	21,3	20	4,7	20	1,3
8MXT	1/2"	13	20,2				SFP5-13-SS	29,0	34,5	P5-DN12	23,9	20	5,1	22	1,9
10MXT	5/8"	16	24,0				SFP5-16-SS	33,0	39,0	P5-DN16	27,0	24	6	26	1
12MXT	3/4"	19	27,4				SFP1-20-SS	36,0	45,0	P1-DN19	31,6	28	4,4	28	3,6
16MXT	1"	25	35,1				SFP5-25-SS	46,0	45,7	P5-DN25	38,5	36	7,5	36	2,5
Gates M2T MegaFlex - SAE 100R16															
4M2T	1/4"	6	14,0	2			SFP5-06-SS	23,0	31,7	P5-DN06	18,2	17	4,8	17	1,2
5M2T	5/16"	8	15,2				SFP5-08-SS	24,0	31,5	P5-DN08	19,0	17	5	19	0
6M2T	3/8"	10	17,8				SFP5-10-SS	26,0	33,3	P5-DN10	21,2	20	4,8	20	1,2
8M2T	1/2"	13	20,8				SFP5-13-SS	29,0	34,5	P5-DN12	24,0	24	5	22	2
10M2T	5/8"	16	24,1				SFP5-16-SS	33,0	39,0	P5-DN16	28,0	28	5	26	2
12M2T	3/4"	19	28,2				SFP5-20-SS	37,0	44,0	P5-DN19	31,8	28	5,2	28	3,8
16M2T	1"	25	35,3				SFP5-25-SS	46,0	45,7	P5-DN25	38,6	36	7,4	36	2,6
Gates M3K Mega3000 - SAE 100R17															
4M3K	1/4"	6	12,2	1			SFPFR7-06-SS	18,0	34,5	PF-R7-DN06	15,5	14	2,5	14	1,5
5M3K	5/16"	8	15,1				SFPFR7-08-SS	19,0	34,5	PF-R7-DN08	16,0	14	3	14	2
6M3K	3/8"	10	16,0				SFP1-10-SS	25,0	35,0	P1-DN10	21,2	20	3,8	20	1,2
8M3K	1/2"	13	20,2	2			SFP1-13-SS	28,0	37,0	P1-DN12	24,1	24	3,9	24	0,1
12M3K	3/4"	20	29,0				SFP5-20-SS	37,0	44,0	P5-DN19	32,0	32	5	32	0
16M3K	1"	25	37,7			39,0	SFP1-25-SS	45,0	50,0	P1-DN25	40,4	40	4,6	40	0,4
Gates M4K Mega4000 - SAE 100R19															
4M4K	1/4"	6	13,7	2			SFP5-06-SS	23,0	31,7	P5-DN06	18,5	17	4,5	17	1,5
5M4K	5/16"	8	15,4				SFP5-08-SS	24,0	31,5	P5-DN08	19,6	17	4,4	19	0,6
6M4K	3/8"	10	17,5				SFP5-10-SS	26,0	33,3	P5-DN10	21,4	20	4,6	20	1,4
8M4K	1/2"	13	20,8				SFP5-13-SS	29,0	34,5	P5-DN12	23,9	20	5,1	22	1,9
10M4K	5/8"	16	25,0				SFP5-16-SS	33,0	39,0	P5-DN16	28,0	28	5	28	0
12M4K	3/4"	20	29,1				SFP5-20-SS	37,0	44,0	P5-DN19	31,7	28	5,3	28	3,7

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Hose type	Hose dimensions				Skive length		Ferrule dimensions				Swage diam. Ø +/- 0,1mm	Die Set Ref.	Adjustment	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Inner	Outer	Part No.	Ø	Length	prod.code					
Gates M5K Mega5000 - EN 857 2SC - ISO 18752															
4M5K	1/4"	6	13,7	2			SFP5-06-SS	23,0	31,7	P5-DN06	18,4	17	4,6	17	1,4
5M5K	5/16"	8	15,4				SFP5-08-SS	24,0	31,5	P5-DN08	19,3	17	4,7	19	0,3
6M5K	3/8"	10	17,5				SFP5-10-SS	26,0	33,3	P5-DN10	21,3	20	4,7	20	1,3
8M5K	1/2"	13	21,9				SFP5-13-SS	29,0	34,5	P5-DN12	25,0	24	4	24	1
Gates M6K Mega6000 - EN 857 2SC															
4M6K	1/4"	6	14,9	2			SFP5-06-SS	23,0	31,7	P5-DN06	18,9	17	4,1	17	1,9
Gates EFG5K MegaSpiral - ISO 3862 R13 - EN 856 4SP															
8EFG5K	1/2"	13	24,0	4		27,0	SFP3-13-SS	30,0	37,0	P3-DN12	26,7	24	3,3	26	0,7
10EFG5K	5/8"	16	27,6			28,0	SFP3-16-SS	33,0	40,0	P3-DN16	30,1	28	2,9	28	2,1
12EFG5K	3/4"	20	31,4		16,0	42,0	SFP3-20-SS	38,0	45,0	P3-DN19	34,4	32	3,6	32	2,4
Gates EFG6K MegaSpiral - SAE 100R15															
6EFG6K	3/8"	10	20,2	4		25,0	SFP3-10-SS	26,0	35,0	P3-DN10	22,9	20	3,1	22	0,9
8EFG6K	1/2"	13	24,0			27,0	SFP3-13-SS	30,0	37,0	P3-DN12	26,9	24	3,1	26	0,9
10EFG6K	5/8"	16	27,6			28,0	SFP3-16-SS	33,0	40,0	P3-DN16	29,7	28	3,3	28	1,7