

# Swaging Chart

UNIFLEX HM-14 / 200 / 220 / 260 / 270 / 280 / 290 / 325 - S1 / S2 / S3 / S4 / S6 / S8 / S10

Hose type	Hose dimensions				Internal skive		External skive		Ferrule dimensions				Swage diam.	Die set ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	Prod.code	Ø +/- 0.1 mm		
<b>1 braided layer - thin rubber - Standard: EN 853-1SN / SAE 100 R1AT</b>															
NST-HF 5	3/16"	5	11,4	1					SFA-D1-05	19,0	24,0	AD1-03	14,8	14	0,8
NST-HF 6	1/4"	6	13,0						SFA-D1-06	22,0	24,7	AD1-04	17,2	17	0,2
NST-HF 8	5/16"	8	14,5						SFA-D1-08	23,0	24,7	AD1-05	18,9	17	1,9
NST-HF 10	3/8"	10	17,2						SFA-D1-10	26,0	29,7	AD1-06	21,4	20	1,4
NST-HF 13	1/2"	13	20,1						SFA-D1-13	29,0	30,5	AD1-08	24,7	24	0,7
NST-HF 16	5/8"	16	23,1						SFA-D1-16	32,0	30,5	AD1-10	27,8	24	3,8
NST-HF 20	3/4"	19	27,3						SFA-D1-20	36,0	36,0	AD1-12	31,7	28	3,7
NST-HF 25	1"	25	35,2						SFA-D1-25	44,0	36,7	AD1-16	39,4	36	3,4
NST-HF 32	1-1/4"	32	42,5						SFA-D1-32	53,0	48,6	AD1-20	47,5	47	0,5
NST-HF 40	1-1/2"	38	49,7						SFA-D1-40	62,0	48,6	AD1-24	54,4	54	0,4
<b>2 braided layers - thin rubber - Standard: EN 853-2SN / SAE 100 R2AT</b>															
HST-HF 5	3/16"	5	13,0	2					SFA-D2-05	21,0	24,0	AD2-03	16,3	14	2,3
HST-HF 6	1/4"	6	14,5						SFA-D2-06	23,0	24,7	AD2-04	18,2	17	1,2
HST-HF 8	5/16"	8	16,1						SFA-D2-08	25,0	24,7	AD2-05	20,1	20	0,1
HST-HF 10	3/8"	10	18,5						SFA-D2-10	27,0	29,7	AD2-06	22,3	20	2,3
HST-HF 13	1/2"	13	21,4						SFA-D2-13	30,0	30,5	AD2-08	25,4	24	1,4
HST-HF 16	5/8"	16	24,6						SFA-D2-16	33,0	30,5	AD2-10	28,8	28	0,8
HST-HF 20	3/4"	19	29,0						SFA-D2-20	37,0	36,0	AD2-12	32,5	32	0,5
HST-HF 25	1"	25	36,8						SFA-D2-25	45,0	36,7	AD2-16	39,9	36	3,9
HST-HF 32	1-1/4"	32	46,4						SFA-D2-32	56,0	48,6	AD2-20	49,6	47	2,6
HST-HF 40	1-1/2"	38	53,7						SFA-D2-40	64,0	48,5	AD2-24	56,7	54	2,7
HST-HF 50	2"	51	65,9					SFA-D2-50	77,0	48,6	AD2-32	70,8	67	3,8	
<b>1 braided layer compact hose - Standard: EN 857-1SC</b>															
NSK 6	1/4"	6	12,1	1					SFA-D1-06	22,0	24,7	AD1-04	16,5	14	2,5
NSK 8	5/16"	8	14,1						SFA-D1-08	23,0	24,7	AD1-05	18,1	17	1,1
NSK 10	3/8"	10	15,6						SFA-D1-10	26,0	29,7	AD1-06	20,4	20	0,4
NSK 13	1/2"	13	19,5						SFA-D1-13	29,0	30,5	AD1-08	23,9	20	3,9
<b>2 braided layers compact hose - Standard: EN 857-2C</b>															
HSK-HF 6	1/4"	6	13,2	2					SFA-D1-06	22,0	24,7	AD1-04	17,4	17	0,4
HSK-HF 8	5/16"	8	14,5						SFA-D1-08	23,0	24,7	AD1-05	19,0	17	2,0
HSK-HF 10	3/8"	10	17,0						SFA-D1-10	26,0	29,7	AD1-06	21,2	20	1,2
HSK-HF 13	1/2"	13	20,3						SFA-D1-13	29,0	30,5	AD1-08	24,8	24	0,8
HSK-HF 16	5/8"	16	23,9						SFA-D1-16	32,0	30,5	AD1-10	27,9	24	3,9
HSK-HF 20	3/4"	19	27,7						SFA-D1-20	36,0	36,0	AD1-12	31,7	28	3,7
HSK-HF 25	1"	25	34,6					SFA-D1-25	44,0	36,7	AD1-16	39,4	36	3,4	

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Hose type	Hose dimensions				Internal skive		External skive		Ferrule dimensions				Swage diam. Ø +/- 0.1 mm	Die set ref.	Adjustment	
	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	Prod.code				
<b>2 braided layers compact hose - Exceeds Standard: EN 857-2SC - SAE 100-R16</b>																
HSK-PQ 6	1/4"	6	13,0	2					SFA-D1-06	22,0	24,7	AD1-04	17,4	17	0,4	
HSK-PQ 8	5/16"	8	14,5						SFA-D1-08	23,0	24,7	AD1-05	18,9	17	1,9	
HSK-PQ 10	3/8"	10	16,8						SFA-D1-10	26,0	29,7	AD1-06	21,3	20	1,3	
HSK-PQ 13	1/2"	13	20,6						SFA-D1-13	29,0	30,5	AD1-08	25,1	24	1,1	
HSK-PQ 16	5/8"	16	23,2						SFA-D1-16	32,0	30,5	AD1-10	27,9	24	3,9	
HSK-PQ 20	3/4"	19	27,6						SFA-D1-20	36,0	36,0	AD1-12	31,7	28	3,7	
HSK-PQ 25	1"	25	35,5						SFA-D1-25	44,0	36,7	AD1-16	39,8	36	3,8	
HSK-PQ 32	1-1/4"	32	42,0						SFA-D1-32	53,0	48,6	AD1-32	47,1	47	0,1	
HSK-PQ 40	1-1/2"	38	49,9						SFA-D1-40	61,0	48,6	AD1-40	54,7	54	0,7	
HSK-PQ 50	2"	51	63,5						SFA-D1-50	75,0	48,6	AD1-50	68,5	67	1,5	
HSK-ST-6	1/4"	6	13,0	2					SFA-D1-06	22,0	24,7	AD1-04	17,4	17	0,4	
HSK-ST-8	5/16"	8	14,5						SFA-D1-08	23,0	24,7	AD1-05	18,9	17	1,9	
HSK-ST-10	3/8"	10	16,8						SFA-D1-10	26,0	29,7	AD1-06	21,3	20	1,3	
HSK-ST-13	1/2"	13	20,6						SFA-D1-13	29,0	30,5	AD1-08	25,1	24	1,1	
HSK-ST-16	5/8"	16	23,2						SFA-D1-16	32,0	30,5	AD1-10	27,9	24	3,9	
HSK-ST-20	3/4"	19	27,6						SFA-D1-20	36,0	36,0	AD1-12	31,7	28	3,7	
HSK-ST-25	1"	25	35,5						SFA-D1-25	44,0	36,7	AD1-16	39,8	36	3,8	
<b>1 braided layer high temperature blue hose - Standard: EN 853-1SN / SAE 100 R1AT</b>																
HT1SN-06	1/4"	6	12,7	1					SFA-D1-06	22,0	24,7	AD1-04	17,2	17	0,2	
HT1SN-10	3/8"	10	16,5						SFA-D1-10	26,0	29,7	AD1-06	21,4	20	1,4	
HT1SN-13	1/2"	13	19,9						SFA-D1-13	29,0	30,5	AD1-08	24,7	24	0,7	
HT1SN-16	5/8"	16	22,7						SFA-D1-16	32,0	30,5	AD1-10	27,8	24	3,8	
HT1SN-20	3/4"	19	27,0						SFA-D1-20	36,0	36,0	AD1-12	31,7	28	3,7	
HT1SN-25	1"	25	35,8						SFA-D1-25	44,0	36,7	AD1-16	39,4	36	3,4	
HT1SN-32	1-1/4"	32	42,1						SFA-D1-32	53,0	48,6	AD1-32	47,5	47	0,5	
HT1SN-40	1-1/2"	38	49,2						SFA-D1-40	61,0	48,6	AD1-40	54,4	54	0,4	
<b>2 braided layers high temperature blue hose - Standard: EN 853-2SN / SAE 100 R2AT</b>																
HT2SN-06	1/4"	6	14,2	2			12,4	19	SFA-4S-06	22,0	26,3	H1100404-04	17,0	17	0,0	
HT2SN-10	3/8"	10	18,4					16,3	19	SFA-4S-10	25,0	28,5	H1100404-06	21,4	20	1,4
HT2SN-13	1/2"	13	21,1					19,3	25	SFA-4S-13	29,0	34,7	H1100404-08	25,6	24	1,6
HT2SN-16	5/8"	16	24,5					22,5	28	SFA-4S-16	33,0	37,5	H1100404-10	28,2	28	0,2
HT2SN-20	3/4"	19	29,0					26,6	33	SFA-4S-20	37,0	41,5	H1100404-12	32,4	32	0,4
HT2SN-25	1"	25	37,4					34,4	37	SFA-4S-25	45,0	47,7	H1100404-16	40,7	40	0,7

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Hose type	Hose dimensions				Internal skive		External skive		Ferrule dimensions				Swage diam. Ø +/- 0.1 mm	Die set ref.	Adjustment	
	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	Prod.code				
<b>Thermoplastic hose - 1 braided Polyamid layer - Standard: SAE 100 R7</b>																
CR 7-5A	3/16"	5	9,6	1					SFA-TP0-05	15,0	22,0	TP0-03	12,0	12	0,0	
CR 7-6A	1/4"	6	12,2						SFA-TP0-06	17,0	26,5	TP0-04	14,2	14	0,2	
CR 7-8A	5/16"	8	14,3						SFA-TP0-08	19,0	26,5	TP0-05	16,3	14	2,3	
CR 7-10A	3/8"	10	16,0						SFA-TP0-10	22,0	26,5	TP0-06	18,6	17	1,6	
CR 7-13A	1/2"	13	20,3						SFA-TP0-13	26,0	30,5	TP0-08	22,7	20	2,7	
<b>Thermoplastic hose - 1 braided Steel layer</b>																
CR 8-5A	3/16"	5	9,8	1					SFA-TP0-05	15,0	22,0	TP0-03	12,3	12	0,3	
CR 8-6A	1/4"	6	11,9						SFA-TP0-06	17,0	26,5	TP0-04	14,1	14	0,1	
CR 8-8A	5/16"	8	13,2						SFA-TP0-08	19,0	26,5	TP0-05	16,0	14	2,0	
CR 8-10A	3/8"	10	15,9						SFA-TP0-10	22,0	26,5	TP0-06	18,3	17	1,3	
CR 8-13A	1/2"	13	19,3						SFA-TP0-13	26,0	30,5	TP0-08	21,8	20	1,8	
<b>Compact high pressure hose Black - Standard: EN 857-2SC</b>																
SL 560-08	5/16"	8	15,0	2			12,9	19	SFA-SK1-08	21,0	25,5	SK1-05	18,0	17	1,0	
SL 560-10	3/8"	10	17,4				14,7	20	SFA-SK1-10	23,0	27,5	SK1-06	19,9	17	2,9	
<b>3 braided layers high pressure hose - 3SPT SUPERFOREST</b>																
FXP313	1/2"	13	24,8	3				25	SFA-4S-13	29,0	34,7	H1100404-08	26,6	24	2,6	
FXP316	5/8"	16	28,3						28	SFA-4S-16	33,0	37,5	H1100404-10	29,7	28	1,7
FXP320	3/4"	19	32,2						33	SFA-4S-20	37,0	41,5	H1100404-12	33,6	32	1,6
FXP325	1"	25	40,4						37	SFA-4S-25	45,0	47,7	H1100404-16	41,9	40	1,9
<b>Compact high pressure hose Blue - Standard: EN 857-1SC (Alfajet 210)</b>																
SL 3010-06	1/4"	6	12,1	1					SFA-D1-06	22,0	24,7	AD1-04	16,5	14	2,5	
SL 3010-08	5/16"	8	14,1							SFA-TP0-08	19,0	26,5	TP0-05	15,2	14	1,2
SL 3010-10	3/8"	10	15,6							SFA-TP0-10	22,0	26,5	TP0-06	17,8	17	0,8
SL 3010-13	1/2"	13	19,5							SFA-TP0-13	26,0	30,5	TP0-08	21,2	20	1,2
<b>Compact high pressure hose Blue - Standard: EN 857-2SC (Alfajet 400)</b>																
SL 3020-06	1/4"	6	13,4	2			11,2	19	SFA-SK1-06	19,0	25,5	SK1-04	16,1	14	2,1	
SL 3020-08	5/16"	8	15,0				12,9	19	SFA-SK1-08	21,0	25,5	SK1-05	18,0	17	1,0	
SL 3020-10	3/8"	10	17,4				14,7	20	SFA-SK1-10	23,0	27,5	SK1-06	19,9	17	2,9	
SL 3020-13	1/2"	13	20,5				18,1	26	SFA-SK1-13	27,0	33,5	SK1-08	24,0	24	0,0	
<b>Suction/return hose - Standard: SAE 100-R4</b>																
CR 4-20	3/4"	19	30,0	Helix					SFA-TX2-20	38,0	36,0	203-12	34,1	32	2,1	
CR 4-25	1"	25	35,0							SFA-TX2-25	48,0	42,5	203-16	40,8	40	0,8
CR 4-32	1-1/4"	32	41,0							SFA-TX2-32	53,0	56,5	203-20	46,8	44	2,8
CR 4-40	1-1/2"	38	51,0							SFA-TX2-40	60,0	61,5	203-24	53,1	50	3,1
CR 4-50	2"	51	62,0							SFA-TX2-50	76,0	73,5	203-32	66,9	62	4,9
<b>CR6 hose - Standard: SAE 100 R6 - EN 854 R6</b>																
CR 6-6A	1/4"	6	12,7	1					SFA-SK1-06	19,0	25,5	SK1-04	16,6	14	2,6	
CR 6-8A	5/16"	8	14,3							SFA-SK1-08	21,0	25,5	SK1-05	18,7	17	1,7
CR 6-10A	3/8"	10	15,9							SFA-SK1-10	23,0	27,5	SK1-06	20,0	20	0,0
CR 6-13A	1/2"	13	19,8							SFA-SK1-13	27,0	33,5	SK1-08	24,0	24	0,0
CR 6-16A	5/8"	16	23,0							SFA-SK1-16	30	36,5	SK1-10	27,5	24	3,5
CR 6-20A	3/4"	19	26,9							SFA-SK1-20	33,0	40,0	SK1-12	31,3	28	3,3
CR 6-25A	1"	25	33,5							SFA-SK1-25	41,0	46,5	SK1-16	37,8	36	1,8

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	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	Prod.code	Ø +/- 0.1 mm		
<b>2TE hose - Standard: EN 854 2TE</b>															
2TE-DN06	1/4"	6	13,1	1					SFA-SK1-06	19,0	25,5	SK1-06	16,7	14	2,7
2TE-DN08	5/16"	8	14,9						SFA-SK1-08	21,0	25,5	SK1-08	19	17	2,0
2TE-DN10	3/8"	10	16,5						SFA-SK1-10	23,0	27,5	SK1-10	20,3	20	0,3
2TE-DN13	1/2"	13	19,7						SFA-SK1-13	27,0	33,5	SK1-13	24,4	24	0,4
2TE-DN16	5/8"	16	23,9						SFA-4S-16	33,0	37,5	4S-16	28,9	28	0,9
2TE-DN20	3/4"	19	27,0						SFA-4S-20	37,0	41,5	4S-20	32,4	32	0,4
2TE-DN25	1"	25	34,4						SFA-SK1-25	41,0	46,5	SK1-25	38,1	36	2,1
<b>3TE hose - Standard: EN 854 3TE</b>															
3TE-DN06	1/4"	6	14,4	2					SFA-TX2-06	23,0	24,7	TX2-06	18,4	17	1,4
3TE-DN08	5/16"	8	16,9						SFA-TX2-08	25,0	24,7	TX2-08	20,4	20	0,4
3TE-DN10	3/8"	10	18,5						SFA-TX2-10	27,0	29,7	TX2-10	22	20	2,0
3TE-DN12	1/2"	13	21,7						SFA-TX2-13	30,0	30,5	TX2-13	24,8	24	0,8
3TE-DN16	5/8"	16	25,9						SFA-TX2-16	34,0	35,5	TX2-16	29	28	1,0
3TE-DN20	3/4"	19	29,0						SFA-TX2-20	38,0	36,0	TX2-20	32,2	32	0,2
3TE-DN25	1"	25	35,9						SFA-TX2-25	48,0	42,5	TX2-25	39,1	36	3,1
3TE-DN31	1-1/4"	32	42,3						SFA-TX2-32	53,0	56,5	TX2-32	45,8	44	1,8
3TE-DN38	1-1/2"	40	49,3						SFA-TX2-40	60,0	61,5	TX2-40	52,4	50	2,4
3TE-DN51	2"	51	63,0						SFA-TX2-50	76,0	73,5	TX2-50	66,8	62	4,8

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	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	prod.code	Ø +/- 0.1 mm		
<b>AlfaBiotech - Non Skive - Standard Inserts</b>															
<b>ALFABIOTECH 4000 - MINETUFF ISO 18752</b>															
ABT-4K-DN20-4S	3/4"	19	29,5	4					SFA-204-20	42,0	39,5	H1200204-12	35,7	32	3,7
ABT-4K-DN25-4S	1"	25	37,5		SFA-204-25	50,0	47,5	H1200204-16	43,4	40	3,4				
ABT-4K-DN32-4S	1-1/4"	32	45,7		SFA-204-32	62,0	50,2	H1200204-20	51,8	50	1,8				
<b>ALFABIOTECH 5000 - MINETUFF ISO 18752</b>															
ABT-5K-DN16-4S	5/8"	16	26,3	4					SFA-204-16	38,0	36,6	H1200204-10	30,9	28	2,9
										Max. 280 bar					
<b>ALFABIOTECH 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-6K-DN10-4S	3/8"	10	20,1	4					SFA-204-10	30,0	28,0	H1200204-06	24,5	24	0,5
										Max. 280 bar					
ABT-6K-DN13-4S	1/2"	13	23,0						SFA-204-13	34,0	33,9	H1200204-08	28,2	28	0,2
										Max. 280 bar					
<b>AlfaBiotech - Non Skive - NS Inserts</b>															
<b>ALFABIOTECH 4000 - MINETUFF ISO 18752</b>															
ABT-4K-DN40-4S	1-1/2"	38	51,8	4					SFA-NS4-40	70,0	89,5	H1300NS4-24	59,6	57	2,6
ABT-4K-DN50-4S	2"	51	66,8		SFA-NS4-50	87,0	125	H1300NS4-32	77,3	74	3,3				
<b>ALFABIOTECH EVOLUTION 4000 - MINETUFF ISO 18752</b>															
ABT-EV4K-DN40-4S	1-1/2"	38	50,6	4					SFA-NS4-40	70,0	89,5	H1300NS4-24	58,8	57	1,8
ABT-EV4K-DN50-4S	2"	51	64,7		SFA-NS4-50	87,0	125	H1300NS4-32	75,8	74	1,8				
<b>ALFABIOTECH 5000 - MINETUFF ISO 18752</b>															
ABT-5K-DN20-4S	3/4"	19	31,0	4					SFA-NS4-20	44,0	55	H1300NS4-12	36,8	36	0,8
ABT-5K-DN25-4S	1"	25	38,0		SFA-NS4-25	51,0	64	H1300NS4-16	43,1	40	3,1				
ABT-5K-DN32-4S	1-1/4"	32	45,8		SFA-NS4-32	61,0	99	H1300NS4-20	54,5	54	0,5				
ABT-5K-DN40-6S	1-1/2"	38	54,8	6					SFA-NS6-40	73,0	89,5	H1300NS6-24	63,2	62	1,2
ABT-5K-DN50-6S	2"	51	70,2		SFA-NS6-50	89,0	125	H1300NS6-32	80,5	78	2,5				
<b>ALFABIOTECH EVOLUTION 5000 - MINETUFF ISO 18752</b>															
ABT-EV5K-DN20-4S	3/4"	19	29,4	4					SFA-NS4-20	44,0	55	H1300NS4-12	36,1	36	0,1
ABT-EV5K-DN25-4S	1"	25	37,4		SFA-NS4-25	51,0	64	H1300NS4-16	43,1	40	3,1				
ABT-EV5K-DN32-4S	1-1/4"	32	44,0		SFA-NS4-32	61,0	99	H1300NS4-20	53,6	50	3,6				
ABT-EV5K-DN40-6S	1-1/2"	38	54,8	6					SFA-NS6-40	73,0	89,5	H1300NS6-24	62,2	62	0,2
ABT-EV5K-DN50-6S	2"	51	68,7		SFA-NS6-50	89,0	125	H1300NS6-32	79,6	78	1,6				
<b>ALFABIOTECH 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-6K-DN20-4S	3/4"	19	31,4	4					SFA-NS4-20	44,0	55	H1300NS4-12	37,4	36	1,4
ABT-6K-DN25-4S	1"	25	38,6		SFA-NS4-25	51,0	64	H1300NS4-16	44,0	44	0,0				
ABT-6K-DN32-6S	1-1/4"	32	49,3		6				SFA-NS6-32	65,0	99	H1300NS6-20			
<b>ALFABIOTECH EVOLUTION 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-EV6K-DN20-4S	3/4"	19	30,6	4					SFA-NS4-20	44,0	55	H1300NS4-12	37,4	36	1,4
ABT-EV6K-DN25-4S	1"	25	38,0		SFA-NS4-25	51,0	64	H1300NS4-16	44,0	44	0,0				
ABT-EV6K-DN32-6S	1-1/4"	32	47,6		6				SFA-NS6-32	65,0	99	H1300NS6-20			

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# Swaging Chart

UNIFLEX HM-14 / 200 / 220 / 260 / 270 / 280 / 290 / 325 - S1 / S2 / S3 / S4 / S6 / S8 / S10

Hose type	Hose dimensions				Internal skive		External skive		Ferrule dimensions				Swage diam.	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	prod.code	Ø +/- 0.1 mm		
<b>AlfaBiotech - Skive - Standard Inserts</b>															
<b>ALFABIOTECH 4000 - MINETUFF ISO 18752</b>															
ABT-4K-DN20-4S	3/4"	19	29,5	4			26,6	33	SFA-4S-20	37,0	41,5	H1100404-12	32,3	32	0,3
ABT-4K-DN25-4S	1"	25	37,5				34,6	37	SFA-4S-25	45,0	47,7	H1100404-16	40,9	40	0,9
<b>ALFABIOTECH EVOLUTION 4000 - MINETUFF ISO 18752</b>															
ABT-EV4K-DN20-4S	3/4"	19	29,0	4			26,7	33	SFA-4S-20	37,0	41,5	H1100404-12	32,3	32	0,3
ABT-EV4K-DN25-4S	1"	25	37,2				34,6	37	SFA-4S-25	45,0	47,7	H1100404-16	40,9	40	0,9
ABT-EV4K-DN32-4S	1-1/4"	32	44,2				41,8	41	SFA-4S-32	55,0	54,5	H1100404-20	49,1	47	2,1
ABT-EV4K-DN40-4S	1-1/2"	38	50,6				48	47	SFA-4S-40	67,0	61,1	H1100404-24	58,4	57	1,4
ABT-EV4K-DN50-4S	2"	51	64,7				62,1	60	SFA-4S-50	82,0	75,1	H1100404-32	74,5	71	0,5
<b>ALFABIOTECH 5000 - MINETUFF ISO 18752</b>															
ABT-5K-DN16-4S	5/8"	16	26,3	4			23,5	28	SFA-4S-16	33,0	37,5	H1100404-10	28,9	28	0,9
ABT-5K-DN20-4S	3/4"	19	31,0				28,2	33	SFA-4S-20	37,0	41,5	H1100404-12	33,3	32	1,3
ABT-5K-DN25-4S	1"	25	38,0				34,8	37	SFA-4S-25	45,0	47,7	H1100404-16	41,2	40	1,2
<b>ALFABIOTECH EVOLUTION 5000 - MINETUFF ISO 18752</b>															
ABT-EV5K-DN16-4S	5/8"	16	25,4	4			23,2	28	SFA-4S-16	33,0	37,5	H1100404-10	29	28	1,0
ABT-EV5K-DN20-4S	3/4"	19	29,4				27,2	33	SFA-4S-20	37,0	41,5	H1100404-12	32,6	32	0,6
ABT-EV5K-DN25-4S	1"	25	37,4				34,8	37	SFA-4S-25	45,0	47,7	H1100404-16	41,2	40	1,2
<b>ALFABIOTECH 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-6K-DN06-4S	1/4"	6	17,3	4			14,7	19	SFA-4S-06	22,0	26,3	H1100404-04	18,3	17	1,3
ABT-6K-DN10-4S	3/8"	10	20,1				17,5	19	SFA-4S-10	25,0	28,5	H1100404-06	22,0	20	2,0
ABT-6K-DN13-4S	1/2"	13	23,0				20,2	25	SFA-4S-13	29,0	34,7	H1100404-08	26,3	24	2,3
<b>ALFABIOTECH EVOLUTION 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-EV6K-DN06-4S	1/4"	6	17,0	4			14,7	19	SFA-4S-06	22,0	26,3	H1100404-04	18,3	17	1,3
ABT-EV6K-DN10-4S	3/8"	10	19,8				17,5	19	SFA-4S-10	25,0	28,5	H1100404-06	22	20	2,0
ABT-EV6K-DN13-4S	1/2"	13	22,5				20,2	25	SFA-4S-13	29,0	34,7	H1100404-08	26,3	24	2,3

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# Swaging Chart

## UNIFLEX HM-14 / 200 / 220 / 260 / 270 / 280 / 290 / 325 - S1 / S2 / S3 / S4 / S6 / S8 / S10

Hose type	Hose dimensions				Internal skive		External skive		Ferrule dimensions				Swage diam.	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	prod.code	Ø +/- 0.1 mm		
<b>AlfaBiotech - Skive - Interlock G2 (H) Inserts</b>															
<b>ALFABIOTECH 4000 - MINETUFF ISO 18752</b>															
ABT-4K-DN25-4S	1"	25	37,5	4	29,3	16	34,6	48	SFA-H4-25	46,0	55,7	H1700200-16	41,6	40	1,6
ABT-4K-DN40-4S	1-1/2"	38	51,8		42,0	19	49,0	56	SFA-H4-40	62,0	68,0	H1700200-24	57,2	57	0,2
ABT-4K-DN50-4S	2"	51	66,8		56,8	26	64,0	69	SFA-H4-50	78,0	79,5	H1700200-32	73,3	71	2,3
<b>ALFABIOTECH EVOLUTION 4000 - MINETUFF ISO 18752</b>															
ABT-EV4K-DN25-4S	1"	25	37,2	4	29,1	16	34,6	48	SFA-H4-25	46,0	55,7	H1700200-16	41,6	40	1,6
ABT-EV4K-DN32-4S	1-1/4"	32	44,2		35,6	18	41,8	54	SFA-H4-32	55,0	66,0	H1700200-20	49,8	47	2,8
ABT-EV4K-DN40-4S	1-1/2"	38	50,6		42,2	19	48	56	SFA-H4-40	62,0	68,0	H1700200-24	56,4	54	2,4
ABT-EV4K-DN50-4S	2"	51	64,7		55,2	26	62,1	69	SFA-H4-50	78,0	79,5	H1700200-32	71,8	71	0,8
<b>ALFABIOTECH 5000 - MINETUFF ISO 18752</b>															
ABT-5K-DN20-4S	3/4"	19	31,0	4	22,9	14	28,2	42	SFA-H4-20	38,0	48,7	H1700200-12	33,6	32	1,6
ABT-5K-DN25-4S	1"	25	38,0		29,6	16	34,8	48	SFA-H4-25	46,0	55,7	H1700200-16	41,7	40	1,7
ABT-5K-DN32-4S	1-1/4"	32	45,8		36,6	18	43	56	SFA-H4-32	55,0	66,0	H1700200-20	50,7	50	0,7
ABT-5K-DN40-6S	1-1/2"	38	54,8	6	42,2	19	52,2	58	SFA-H46-40	69,5	68,0	H1700301-24	62,0	62	0,0
<b>ALFABIOTECH EVOLUTION 5000 - MINETUFF ISO 18752</b>															
ABT-EV5K-DN20-4S	3/4"	19	29,4	4	22,4	17	27,2	42	SFA-H4-20	38,0	48,7	H1700200-12	32,8	32	0,8
ABT-EV5K-DN25-4S	1"	25	37,4		29,6	16	34,8	48	SFA-H4-25	46,0	55,7	H1700200-16	41,7	40	1,7
ABT-EV5K-DN32-4S	1-1/4"	32	44,0		36,1	18	41,8	54	SFA-H4-32	55,0	66,0	H1700200-20	49,8	47	2,8
ABT-EV5K-DN40-6S	1-1/2"	38	54,8	6	42,2	19	52,2	58	SFA-H46-40	69,5	68,0	H1700301-24	62	62	0,0
ABT-EV5K-DN50-6S	2"	51	68,7		55,3	26	66,3	67	SFA-H46-50	88,0	79,5	H1700301-32	79,7	71	1,7
<b>ALFABIOTECH 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-6K-DN16-4S	5/8"	16	28,2	4	20,3	14	25,4	39	SFA-H46-16	35,5	46,0	H1700301-10	32,0	32	0,0
ABT-6K-DN20-4S	3/4"	19	31,4		22,8	14	28,6	42	SFA-H4-20	38,0	48,7	H1700200-12	33,5	32	1,5
ABT-6K-DN25-4S	1"	25	38,6		29,3	16	35,8	48	SFA-H4-25	46,0	55,7	H1700200-16	41,7	40	1,7
ABT-6K-DN32-6S	1-1/4"	32	49,3	6	37,9	18	46,5	56	SFA-H46-32	62,0	66,0	H1700301-20	55,6	54	1,6
ABT-6K-DN40-6S	1-1/2"	38	56,5		43,9	19	53,7	58	SFA-H46-40	69,5	68,0	H1700301-24	63,2	62	1,2
<b>ALFABIOTECH EVOLUTION 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-EV6K-DN16-4S	5/8"	16	27,8	4	19,1	14	25,5	39	SFA-H46-16	35,5	46,0	H1700301-10	32,0	32	0,0
ABT-EV6K-DN20-4S	3/4"	19	30,6		22,4	14	28,4	42	SFA-H4-20	38,0	48,7	H1700200-12	33,5	32	1,5
ABT-EV6K-DN25-4S	1"	25	38,0		29,0	16	35,6	48	SFA-H4-25	46,0	55,7	H1700200-16	41,7	40	1,7
ABT-EV6K-DN32-6S	1-1/4"	32	47,6	6	35,7	18	44,8	56	SFA-H46-32	62,0	66,0	H1700301-20	54,3	54	0,3
ABT-EV6K-DN40-6S	1-1/2"	38	54,4		42,1	19	51,8	58	SFA-H46-40	69,5	68,0	H1700301-24	61,6	57	4,6

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# Swaging Chart

UNIFLEX HM-14 / 200 / 220 / 260 / 270 / 280 / 290 / 325 - S1 / S2 / S3 / S4 / S6 / S8 / S10

Hose type	Hose dimensions				Internal skive		External skive		Ferrule dimensions				Swage diam.	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Ø	Length	Ø	Length	Part No.	Ø	Length	prod.code	Ø +/- 0.1 mm		
<b>AlfaBiotech - Skive - Interlock (H) Inserts</b>															
<b>ALFABIOTECH 4000 - MINETUFF ISO 18752</b>															
ABT-4K-DN25-4S	1"	25	37,5	4	29,3	17	34,6	65	SFA-4H-25	46,0	74,7	H1400200-16	41,6	40	1,6
ABT-4K-DN40-4S	1-1/2"	38	51,8		42,0	22	49,0	81	SFA-4H-40	70,0	89,5	H1400200-24	57,2	57	0,2
ABT-4K-DN50-4S	2"	51	66,8		56,8	29	64,0	85	SFA-4H-50	87,0	125	H1400200-32	73,3	71	2,3
<b>ALFABIOTECH EVOLUTION 4000 - MINETUFF ISO 18752</b>															
ABT-EV4K-DN25-4S	1"	25	37,2	4	29,3	17	34,6	65	SFA-4H-25	46,0	74,7	H1400200-16	41,6	40	1,6
ABT-EV4K-DN32-4S	1-1/4"	32	44,2		36,1	22	41,8	74	SFA-4H-32	55,0	88,2	H1400200-20	49,8	47	2,8
ABT-EV4K-DN40-4S	1-1/2"	38	50,6		42,2	22	48	81	SFA-4H-40	70,0	89,5	H1400200-24	56,4	54	2,4
ABT-EV4K-DN50-4S	2"	51	64,7		55,1	29	62,1	85	SFA-4H-50	87,0	125	H1400200-32	71,8	71	0,8
<b>ALFABIOTECH 5000 - MINETUFF ISO 18752</b>															
ABT-5K-DN20-4S	3/4"	19	31,0	4	22,9	15	28,2	52	SFA-4H-20	38,0	60,2	H1400200-12	33,6	32	1,6
ABT-5K-DN25-4S	1"	25	38,0		29,6	17	34,8	65	SFA-4H-25	46,0	74,7	H1400200-16	41,7	40	1,7
ABT-5K-DN32-4S	1-1/4"	32	45,8		36,6	22	43	74	SFA-4H-32	55,0	88,2	H1400200-20	50,7	50	0,7
ABT-5K-DN40-6S	1-1/2"	38	54,8	6	42,2	22	52,2	81	SFA-R15-40	69,5	94,0	H1400301-24	62,0	62	0,0
ABT-5K-DN50-6S	2"	51	70,2		56,6	29	67,4	85	SFA-R13-50	88,0	99,0	H1400301-32	80,6	71	2,6
<b>ALFABIOTECH EVOLUTION 5000 - MINETUFF ISO 18752</b>															
ABT-EV5K-DN20-4S	3/4"	19	29,4	4	22,4	15	27,2	52	SFA-4H-20	38,0	60,2	H1400200-12	32,8	32	0,8
ABT-EV5K-DN25-4S	1"	25	37,4		29,6	17	34,8	65	SFA-4H-25	46,0	74,7	H1400200-16	41,7	40	1,7
ABT-EV5K-DN32-4S	1-1/4"	32	44,0		36,1	22	41,8	74	SFA-4H-32	55,0	88,2	H1400200-20	49,8	47	2,8
ABT-EV5K-DN40-6S	1-1/2"	38	54,8		42,2	22	52,2	81	SFA-R15-40	69,5	94,0	H1400301-24	62	62	0,0
<b>ALFABIOTECH 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-6K-DN16-4S	5/8"	16	28,2	4	20,3	15	25,4	50	SFA-R15-16	35,5	57,5	H1400301-10	31,7	28	3,7
ABT-6K-DN20-4S	3/4"	19	31,4		22,8	15	28,6	52	SFA-4H-20	38,0	60,2	H1400200-12	34,0	32	2,0
ABT-6K-DN25-4S	1"	25	38,6		29,3	17	35,8	65	SFA-4H-25	46,0	74,7	H1400200-16	41,7	40	1,7
ABT-6K-DN32-6S	1-1/4"	32	49,3	6	37,9	22	46,5	74	SFA-R15-32	62,0	88,0	H1400301-20	55,6	54	1,6
ABT-6K-DN40-6S	1-1/2"	38	56,5		43,9	22	53,7	81	SFA-R15-40	69,5	94,0	H1400301-24	63,2	62	1,2
<b>ALFABIOTECH EVOLUTION 6000 - MINETUFF ISO 18752 EXCEEDS SAE 100 R15</b>															
ABT-EV6K-DN16-4S	5/8"	16	27,8	4	19,1	15	25,5	50	SFA-R15-16	35,5	57,5	H1400301-10	31,7	28	3,7
ABT-EV6K-DN20-4S	3/4"	19	30,6		22,4	15	28,4	52	SFA-4H-20	38,0	60,2	H1400200-12	34,0	32	2,0
ABT-EV6K-DN25-4S	1"	25	38,0		29	17	35,6	65	SFA-4H-25	46,0	74,7	H1400200-16	41,7	40	1,7
ABT-EV6K-DN32-6S	1-1/4"	32	47,6		35,7	22	44,8	74	SFA-R15-32	62,0	88,0	H1400301-20	54,3	54	0,3
ABT-EV6K-DN40-6S	1-1/2"	38	54,4	6	42,1	22	51,8	81	SFA-R15-40	69,5	94,0	H1400301-24	61,6	57	4,6

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