

# Swaging Chart

## UNIVERSAL

Hose type	Hose dimensions				Ferrule dimensions				Swage diam. Ø +/- 0.1 mm	Die Set Ref.	Adjustment
	(Inch)	Inner Ø	Outer Ø	Layers	Part No.	Ø	Length	prod.code			
<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		
NST-HF 6	1/4"	6	13,0		SFA-D1-06	22,0	24,7	AD1-04	17,2		
NST-HF 8	5/16"	8	14,5		SFA-D1-08	23,0	24,7	AD1-05	18,9		
NST-HF 10	3/8"	10	17,2		SFA-D1-10	26,0	29,7	AD1-06	21,4		
NST-HF 13	1/2"	13	20,1		SFA-D1-13	29,0	30,5	AD1-08	24,7		
NST-HF 16	5/8"	16	23,1		SFA-D1-16	32,0	30,5	AD1-10	27,8		
NST-HF 20	3/4"	19	27,3		SFA-D1-20	36,0	36,0	AD1-12	31,7		
NST-HF 25	1"	25	35,2		SFA-D1-25	44,0	36,7	AD1-16	39,4		
NST-HF 32	1-1/4"	32	42,5		SFA-D1-32	53,0	48,6	AD1-20	47,5		
NST-HF 40	1-1/2"	38	49,7		SFA-D1-40	62,0	48,6	AD1-24	54,4		
<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		
HST-HF 6	1/4"	6	14,5		SFA-D2-06	23,0	24,7	AD2-04	18,2		
HST-HF 8	5/16"	8	16,1		SFA-D2-08	25,0	24,7	AD2-05	20,1		
HST-HF 10	3/8"	10	18,5		SFA-D2-10	27,0	29,7	AD2-06	22,3		
HST-HF 13	1/2"	13	21,4		SFA-D2-13	30,0	30,5	AD2-08	25,4		
HST-HF 16	5/8"	16	24,6		SFA-D2-16	33,0	30,5	AD2-10	28,8		
HST-HF 20	3/4"	19	29,0		SFA-D2-20	37,0	36,0	AD2-12	32,5		
HST-HF 25	1"	25	36,8		SFA-D2-25	45,0	36,7	AD2-16	39,9		
HST-HF 32	1-1/4"	32	46,4		SFA-D2-32	56,0	48,6	AD2-20	49,6		
HST-HF 40	1-1/2"	38	53,7		SFA-D2-40	64,0	48,5	AD2-24	56,7		
HST-HF 50	2"	50	65,9	SFA-D2-50	77,0	48,6	AD2-32	70,8			
<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		
NSK 8	5/16"	8	14,1		SFA-D1-08	23,0	24,7	AD1-05	18,1		
NSK 10	3/8"	10	15,6		SFA-D1-10	26,0	29,7	AD1-06	20,4		
NSK 13	1/2"	13	19,5		SFA-D1-13	29,0	30,5	AD1-08	23,9		
<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		
HSK-HF 8	5/16"	8	14,5		SFA-D1-08	23,0	24,7	AD1-05	19,0		
HSK-HF 10	3/8"	10	17,0		SFA-D1-10	26,0	29,7	AD1-06	21,2		
HSK-HF 13	1/2"	13	20,3		SFA-D1-13	29,0	30,5	AD1-08	24,8		
HSK-HF 16	5/8"	16	23,9		SFA-D1-16	32,0	30,5	AD1-10	27,9		
HSK-HF 20	3/4"	19	27,7		SFA-D1-20	36,0	36,0	AD1-12	31,7		
HSK-HF 25	1"	25	34,6		SFA-D1-25	44,0	36,7	AD1-16	39,4		

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	(Inch)	Inner Ø	Outer Ø	Layers	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		
HSK-PQ 8	5/16"	8	14,5		SFA-D1-08	23,0	24,7	AD1-05	18,9		
HSK-PQ 10	3/8"	10	16,8		SFA-D1-10	26,0	29,7	AD1-06	21,3		
HSK-PQ 13	1/2"	13	20,6		SFA-D1-13	29,0	30,5	AD1-08	25,1		
HSK-PQ 16	5/8"	16	23,2		SFA-D1-16	32,0	30,5	AD1-10	27,9		
HSK-PQ 20	3/4"	19	27,6		SFA-D1-20	36,0	36,0	AD1-12	31,7		
HSK-PQ 25	1"	25	35,5		SFA-D1-25	44,0	36,7	AD1-16	39,8		
HSK-PQ 32	1-1/4"	32	42,0		SFA-D1-32	53,0	48,6	AD1-32	47,1		
HSK-PQ 40	1-1/2"	38	49,9		SFA-D1-40	61,0	48,6	AD1-40	54,7		
HSK-PQ 50	2"	50	63,5		SFA-D1-50	75,0	48,6	AD1-50	68,5		
HSK-ST-6	1/4"	6	13,0		2	SFA-D1-06	22,0	24,7	AD1-04	17,4	
HSK-ST-8	5/16"	8	14,5	SFA-D1-08		23,0	24,7	AD1-05	18,9		
HSK-ST-10	3/8"	10	16,8	SFA-D1-10		26,0	29,7	AD1-06	21,3		
HSK-ST-13	1/2"	13	20,6	SFA-D1-13		29,0	30,5	AD1-08	25,1		
HSK-ST-16	5/8"	16	23,2	SFA-D1-16		32,0	30,5	AD1-10	27,9		
HSK-ST-20	3/4"	19	27,6	SFA-D1-20		36,0	36,0	AD1-12	31,7		
HSK-ST-25	1"	25	35,5	SFA-D1-25		44,0	36,7	AD1-16	39,8		
<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		
HT1SN-10	3/8"	10	16,5		SFA-D1-10	26,0	29,7	AD1-06	21,4		
HT1SN-13	1/2"	13	19,9		SFA-D1-13	29,0	30,5	AD1-08	24,7		
HT1SN-16	5/8"	16	22,7		SFA-D1-16	32,0	30,5	AD1-10	27,8		
HT1SN-20	3/4"	19	27,0		SFA-D1-20	36,0	36,0	AD1-12	31,7		
HT1SN-25	1"	25	35,8		SFA-D1-25	44,0	36,7	AD1-16	39,4		
HT1SN-32	1-1/4"	32	42,1		SFA-D1-32	53,0	48,6	AD1-32	47,5		
HT1SN-40	1-1/2"	38	49,2		SFA-D1-40	61,0	48,6	AD1-40	54,4		
<b>2 braided layers high temperature blue hose - Standard: EN 853 2SN / SAE 100 R2AT</b>											
HT2SN-06	1/4"	6	14,2	2	SFA-D2-06	23,0	24,7	AD2-04	18,2		
HT2SN-10	3/8"	10	18,4		SFA-D2-10	27,0	29,7	AD2-06	22,3		
HT2SN-13	1/2"	13	21,1		SFA-D2-13	30,0	30,5	AD2-08	25,4		
HT2SN-16	5/8"	16	24,5		SFA-D2-16	33,0	30,5	AD2-10	28,8		
HT2SN-20	3/4"	19	29,0		SFA-D2-20	37,0	36,0	AD2-12	32,5		
HT2SN-25	1"	25	37,4		SFA-D2-25	45,0	36,7	AD2-16	39,9		

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	(Inch)	Inner Ø	Outer Ø	Layers	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		
CR 7-6A	1/4"	6	12,2		SFA-TP0-06	17,0	26,5	TP0-04	14,2		
CR 7-8A	5/16"	8	14,3		SFA-TP0-08	19,0	26,5	TP0-05	16,3		
CR 7-10A	3/8"	10	16,0		SFA-TP0-10	22,0	26,5	TP0-06	18,6		
CR 7-13A	1/2"	13	20,3		SFA-TP0-13	26,0	30,5	TP0-08	22,7		
<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		
CR 8-6A	1/4"	6	11,9		SFA-TP0-06	17,0	26,5	TP0-04	14,1		
CR 8-8A	5/16"	8	13,2		SFA-TP0-08	19,0	26,5	TP0-05	16,0		
CR 8-10A	3/8"	10	15,9		SFA-TP0-10	22,0	26,5	TP0-06	18,3		
CR 8-13A	1/2"	13	19,3		SFA-TP0-13	26,0	30,5	TP0-08	21,8		
<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		
SL 3010-08	5/16"	8	14,1		SFA-TP0-08	19,0	26,5	TP0-05	15,2		
SL 3010-10	3/8"	10	15,6		SFA-TP0-10	22,0	26,5	TP0-06	17,8		
SL 3010-13	1/2"	13	19,5		SFA-TP0-13	26,0	30,5	TP0-08	21,2		
<b>Compact high pressure hose Blue - Standard: EN 857 2SC (Alfajet 400)</b>											
SL 3020-06	1/4"	6	13,4	2	SFA-D1-06	22,0	24,7	AD1-04	17,4		
SL 3020-08	5/16"	8	15,0		SFA-D1-08	23,0	24,7	AD1-05	19,0		
SL 3020-10	3/8"	10	17,4		SFA-D1-10	26,0	29,7	AD1-06	21,2		
SL 3020-13	1/2"	13	20,5		SFA-D1-13	29,0	30,5	AD1-08	24,8		
<b>Compact high pressure hose Black - Standard: EN 857 2SC</b>											
SL 560-08	5/16"	8	15,0	2	SFA-D1-08	23,0	24,7	AD1-05	19,0		
SL 560-10	3/8"	10	17,4		SFA-D1-10	26,0	29,7	AD1-06	21,2		
<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		
CR 4-25	1"	25	35,0		SFA-TX2-25	48,0	42,5	203-16	40,8		
CR 4-32	1-1/4"	32	41,0		SFA-TX2-32	53,0	56,5	203-20	46,8		
CR 4-40	1-1/2"	38	51,0		SFA-TX2-40	60,0	61,5	203-24	53,1		
CR 4-50	2"	50	62,0		SFA-TX2-50	76,0	73,5	203-32	66,9		
CR 4-63	2-1/2"	63	76,0		SFA-TX2-63	89,0	85,0	203-40	80,3		
<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		
CR 6-8A	5/16"	8	14,3		SFA-SK1-08	21,0	25,5	SK1-05	18,7		
CR 6-10A	3/8"	10	15,9		SFA-SK1-10	23,0	27,5	SK1-06	20,0		
CR 6-13A	1/2"	13	19,8		SFA-SK1-13	27,0	33,5	SK1-08	24,0		
CR 6-16A	5/8"	16	23,0		SFA-SK1-16	30	36,5	SK1-10	27,5		
CR 6-20A	3/4"	19	26,9		SFA-SK1-20	33,0	40,0	SK1-12	31,3		
CR 6-25A	1"	25	33,5		SFA-SK1-25	41,0	46,5	SK1-16	37,8		

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	(Inch)	Inner Ø	Outer Ø	Layers	Part No.	Ø	Length	prod.code			
<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		
2TE-DN08	5/16"	8	14,9		SFA-SK1-08	21,0	25,5	SK1-08	19		
2TE-DN10	3/8"	10	16,5		SFA-SK1-10	23,0	27,5	SK1-10	20,3		
2TE-DN13	1/2"	13	19,7		SFA-SK1-13	27,0	33,5	SK1-13	24,4		
2TE-DN16	5/8"	16	23,9		SFA-4S-16	33,0	37,5	4S-16	28,9		
2TE-DN20	3/4"	19	27,0		SFA-4S-20	37,0	41,5	4S-20	32,4		
2TE-DN25	1"	25	34,4		SFA-SK1-25	41,0	46,5	SK1-25	38,1		
<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		
3TE-DN08	5/16"	8	16,9		SFA-TX2-08	25,0	24,7	TX2-08	20,4		
3TE-DN10	3/8"	10	18,5		SFA-TX2-10	27,0	29,7	TX2-10	22		
3TE-DN12	1/2"	13	21,7		SFA-TX2-13	30,0	30,5	TX2-13	24,8		
3TE-DN16	5/8"	16	25,9		SFA-TX2-16	34,0	35,5	TX2-16	29		
3TE-DN20	3/4"	19	29,0		SFA-TX2-20	38,0	36,0	TX2-20	32,2		
3TE-DN25	1"	25	35,9		SFA-TX2-25	48,0	42,5	TX2-25	39,1		
3TE-DN31	1-1/4"	32	42,3		SFA-TX2-32	53,0	56,5	TX2-32	45,8		
3TE-DN38	1-1/2"	40	49,3		SFA-TX2-40	60,0	61,5	TX2-40	52,4		
3TE-DN51	2"	50	63,0		SFA-TX2-50	76,0	73,5	TX2-50	66,8		
<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		
ABT-4K-DN25-4S	1"	25	37,5		SFA-204-25	50,0	47,5	H1200204-16	43,4		
ABT-4K-DN32-4S	1-1/4"	32	45,7		SFA-204-32	62,0	50,2	H1200204-20	51,8		
<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		
<b>Max. 280 bar</b>											
<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		
<b>Max. 280 bar</b>											
ABT-6K-DN13-4S	1/2"	13	23,0		SFA-204-13	34,0	33,9	H1200204-08	28,2		
<b>Max. 280 bar</b>											

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<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		
ABT-4K-DN50-4S	2"	51	66,8		SFA-NS4-50	87,0	125	H1300NS4-32	77,3		
<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		
ABT-EV4K-DN50-4S	2"	51	64,7		SFA-NS4-50	87,0	125	H1300NS4-32	75,8		
<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		
ABT-5K-DN25-4S	1"	25	38,0		SFA-NS4-25	51,0	64	H1300NS4-16	43,1		
ABT-5K-DN32-4S	1-1/4"	32	45,8		SFA-NS4-32	61,0	99	H1300NS4-20	54,5		
ABT-5K-DN40-6S	1-1/2"	38	54,8	6	SFA-NS6-40	73,0	89,5	H1300NS6-24	63,2		
ABT-5K-DN50-6S	2"	51	70,2		SFA-NS6-50	89,0	125	H1300NS6-32	80,5		
<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		
ABT-EV5K-DN25-4S	1"	25	37,4		SFA-NS4-25	51,0	64	H1300NS4-16	43,1		
ABT-EV5K-DN32-4S	1-1/4"	32	44,0		SFA-NS4-32	61,0	99	H1300NS4-20	53,6		
ABT-EV5K-DN40-6S	1-1/2"	38	54,8	6	SFA-NS6-40	73,0	89,5	H1300NS6-24	62,2		
ABT-EV5K-DN50-6S	2"	51	68,7		SFA-NS6-50	89,0	125	H1300NS6-32	79,6		
<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		
ABT-6K-DN25-4S	1"	25	38,6		SFA-NS4-25	51,0	64	H1300NS4-16	44		
ABT-6K-DN32-6S	1-1/4"	32	49,3		6	SFA-NS6-32	65,0	99	H1300NS6-20	56,8	
<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		
ABT-EV6K-DN25-4S	1"	25	38,0		SFA-NS4-25	51,0	64	H1300NS4-16	44		
ABT-EV6K-DN32-6S	1-1/4"	32	47,6		6	SFA-NS6-32	65,0	99	H1300NS6-20	55,6	

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