

CRIMPING PARAMETERS CHART

PARAMETRI DI PRESSATURA



Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

1SN EVERGREEN FOREVER ICEBERG	B12T	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		15,8	17,6	18,6	20,5	23,0	27,0	30,5	39,0	48,5	56,6	70,3
	B1SC	B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16				
		15,9	17,8	19,8	23,2	27,4	30,2	37,9				
	B1T	B1T03	B1T04	B1T05	B1T06	B1T08	B1T10	B1T12	B1T16	B1T20	B1T24	
		15,2	16,4	18,2	20,1	24,2	26,4	30,8	38,9	47,0	54,0	
	B1R	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32
		15,2	17,2	18,8	21,0	25,4	28,2	32,2	39,8	46,6	53,0	66,2
		18	21	22	23	25	28	34	37	43	47	62

2SN EVERGREEN FOREVER ICEBERG	B12T	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
		16,0	18,7	19,6	21,3	24,3	28,2	32,1	40,3	51,0	59,0	72,7
	B2T	B2T03	B2T04	B2T05	B2T06	B2T08	B2T10	B2T12	B2T16	B2T20	B2T24	
		15,7	18,0	20,2	21,4	25,6	28,5	32,0	41,0	50,0	57,5	
	B2R	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32
		17,6	17,8	20,3	23,0	25,7	29,0	33,5	41,2	50,8	56,7	69,5
		18,5	21	22	23	25	28	34	37	43	47	64

FORTHREE ICEBERG	B2R		B2R04		B2R06	B2R08	B2R10	B2R12	B2R16			
			19,0		24,0	26,8	30,3	34,8	42,1			
			21		23	25	28	34	37			

1SC / 1SC PLUS EVERGREEN FOREVER ICEBERG VULCAN	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			15,3	16,8	18,8	22,5	26,4	29,4	36,9			
	B1K		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	B1K32
			15,0	16,3	18,6	22,7	26,4	29,5	37,9	44,8	51,8	64,6

2SC / 2SC PLUS EVERGREEN FOREVER ICEBERG VULCAN	B12T		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N	B12T20N	B12T24N	B12T32N
			17,9	18,8	20,2	23,5	27,4	30,9	39,1	48,7	56,2	71,0
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			16,2	18,0	19,5	23,2	27,4	30,3	37,9			

STRONGER/1	B1R	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20		
		15,4	17,3	18,6	20,5	25,2	27,4	31,0	39,0	45,7		
		18	21	22	23	25	28	34	37	43		
	B12T	B12T03N	B12T04N	B12T05N	B12T06N	B12T08N	B12T10N					
		16,2	18,1	18,4	20,0	23,2	26,2					
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			16,0	17,6	19,3	23,0	26,6	29,0	38,1			

STRONGER/2	B12T		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N				
			18,5	19,0	21,3	23,4	27,7	31,2				
	B1R		B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20		
			17,2	19,2	21,5	25,5	28,5	32,5	40,0	47,4		

JACK	B12T		B12T04N		B12T06N							
			19,0		20,3							

MASTER 2SN	B2R		B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16			
			17,6	20,0	22,9	26,0	29,4	33,6	41,6			
			21	22	23	25	28	34	37			

ALPI 3300 / R17	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			15,3	16,9	18,6	22,5	28,0	30,6	37,9			

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

ALPI 4000 / R19	B12T			B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N			
				19,0	20,6	23,5	27,3	31,1	39,0			
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			15,3	18,0	20,0	23,8	27,7	30,3	37,8			

SLIM	B1SC		B1SC04	B1SC05	B1SC06	B1SC08		B1SC12				
			15,0	16,8	18,2	21,9		28,7				
	B1K		B1K04	B1K05	B1K06	B1K08			B1K16			
			13,8	15,7	18,1	21,7			35,3			
	B7R	B7R03	12,3									

SERVOCOMANDO	B1SC		B1SC04	B1SC05	B1SC06	B1SC08						
			15,5	17,0	18,7	22,5						

LIFT-PLUS	B12T										B12T24N	B12T32N
											56,8	71,0
	B1SC							B1SC12	B1SC16			
								29,2	36,4			
	B1R									B1R20		
										45,6		
										43		

PREMIER	B12T		B12T04N	B12T05N	B12T06N	B12T08N	B12T10N	B12T12N	B12T16N			
			18,0	18,8	20,6	23,5	27,6	31,0	39,1			
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			16,2	17,8	20,0	23,8	28,0	30,3	37,9			

VULCAN/1 (NO SKIVE ONLY FOR LOW PRESSURE APPLICATIONS)	B1R	B1R03	B1R04	B1R05	B1R06	B1R08	B1R10	B1R12	B1R16	B1R20	B1R24	B1R32
		15,2	17,2	18,8	21,0	25,1	28,2	32,2	39,8	46,6	53,0	66,2
		18	21	22	23	25	28	34	37	43	47	62
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
			16,2	18,2	20,0	23,8	27,7	30,7	38,7			
	B1T									B1T20	B1T24	
										48,0	54,0	
	B12T											B12T32N
												70,2

VULCAN/2	B2R	B2R03	B2R04	B2R05	B2R06	B2R08	B2R10	B2R12	B2R16	B2R20	B2R24	B2R32
		17,6	17,8	20,3	23,0	25,7	29,9	33,5	41,2	50,8	56,7	69,5
		18,5	21	22	23	25	28	34	37	43	47	64

VULCANAIR	B1SC		B1SC04	B1SC05	B1SC06	B1SC08	B1SC10	B1SC12	B1SC16			
	B1K #		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16	B1K20	B1K24	
		(#) = swaging tollerance +0/-0,1						29,5	36,7	44,3	51,6	
	B1T									B1T20	B1T24	
										45,3	52,6	

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

4SP EVERGREEN FOREVER	B9R		B9R04		B9R06	B9R08	B9R10	B9R12	B9R16	B9R20	B9R24	B9R32
			19,2		23,2	25,7	29,5	33,6	41,6	54,6	59,2	74,6
			21		23	27	31	36	44	54	62	64
	KB4SH Interlock fittings							KB4SH12	KB4SH16			
								32,2	39,8			
	HB4NS Hiperspiral fittings				HB4NS06	HB4NS08	HB4NS10	HB4NS12	HB4NS16			
					26,1	29,0	34,2	37,5	46,5			
	HB6NS Hiperspiral fittings									HB6NS20		
										60,0		

4SH EVERGREEN FOREVER	KB4SH Interlock fittings							KB4SH12	KB4SH16	KB4SH20	KB4SH24	KB4SH32
								33,9	41,5	49,9	57,2	74,2
								15 / 52	17 / 67	21,5 / 74	22 / 81	29 / 85
	B4SH									B4SH20	B4SH24	B4SH32
										47,7	58,0	70,5
	HB4NS Hiperspiral fittings						HB4NS10	HB4NS12	HB4NS16	HB4NS20		

R12 EVERGREEN FOREVER	B9R				B9R06	B9R08	B9R10	B9R12	B9R16			
					23,0	26,5	30,8	34,0	41,9			
					23	27	31	36	48			
	KB4SH Interlock fittings										B4SH24	B4SH32
											58,9	70,6
	HB4NS Hiperspiral fittings				HB4NS06	HB4NS08	HB4NS10	HB4NS12	HB4NS16	HB4NS20		

R13 EVERGREEN FOREVER	KB4SH Interlock fittings							KB4SH12	KB4SH16			
								34,7	42,2			
								15 / 52	17 / 67			
	KBH13 Interlock fittings									KBH1320	KBH1324	KBH1332
										53,8	61,0	78,2
	HB4NS Hiperspiral fittings							HB4NS12	HB4NS16			

R15 EVERGREEN FOREVER	KB4SH Interlock fittings							KB4SH12	KB4SH16			
								33,9	41,5			
								15 / 52	17 / 67			
	KBH13 Interlock fittings									KBH1320	KBH1324	KBH1332
										54,6	60,9	77,4
	HB4NS Hiperspiral fittings						HB4NS10	HB4NS12	HB4NS16			

ELASTIK/4000	B9R							B9R12	B9R16	B9R20		
								34,0	42,0	53,2		
	HB4NS Hiperspiral fittings							36	48	54		

	SPIRAL HOSES
---	--

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

ELASTIK/5000	KB4SH Interlock fittings							KB4SH12	KB4SH16	KB4SH20		
								33,9	41,3	50,5		
								15 / 52	17 / 67	21,5 / 74		
	B9R							B9R12	B9R16			
								33,2	41,6			
								36	48			
	HB4NS Hiperspiral fittings							HB4NS12	HB4NS16	HB4NS20		
								37,3	46,5	57,0		

ELASTIK/6000	KB4SH Interlock fittings							KB4SH12	KB4SH16			
								33,9	41,3			
								15 / 52	17 / 67			
	KBH13 Interlock fittings									KBH1320		
										53,3		
										21,5 / 74		
	HB4NS Hiperspiral fittings							HB4NS12	HB4NS16			
								37,5	46,5			
	HB6NS Hiperspiral fittings									HB6NS20		
										60,0		

	CLEANER HOSES
--	---

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

JET 1SN/1ST 250 IEC-60335-2	B12T		B12T04N	B12T05N	B12T06N	B12T08N						
			18,0	18,6	20,5	23,4						
	B1R		B1R04	B1R05	B1R06	B1R08						
			17,2	18,8	21,0	25,4						
			21	22	23	25						
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08						
			16,0	17,8	20,0	23,6						

JET 2SN/2ST 400	B2R		B2R04	B2R05	B2R06	B2R08						
			17,8	20,3	23,0	25,7						
			21	22	23	25						
	B12T		B12T04N	B12T05N	B12T06N	B12T08N						
			18,6	19,6	21,6	24,4						

JET 1SN PLUS 315	B1R		B1R04	B1R05	B1R06							
			17,2	18,8	21,0							
			21	22	23							

JET 2SN PLUS 600	B2R		B2R04	B2R05	B2R06							
			17,8	20,3	23,0							
			21	22	23							

JET 1SC 250	B1SC		B1SC04	B1SC05	B1SC06	B1SC08						
			15,3	16,8	18,6	22,5						

JET 2SC 400	B12T		B12T04N	B12T05N	B12T06N	B12T08N						
			18,2	19,0	20,4	23,5						
	B1SC		B1SC04	B1SC05	B1SC06	B1SC08						
			16,2	18,0	20,0	23,8						

BLAST AS/NZS 4233.2	WB4				WB406	WB408		WB412				
					24,4	28,2		38,6				
					15 / 47	16 / 52		19 / 54				

			CLEANER HOSES									
---	--	--	------------------------	--	--	--	--	--	--	--	--	--

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

BLAST PLUS AS/NZS 4233.2	WB4				WB406	WB408		WB412				
					24,6	29,1		38,9				
					15 / 47	16 / 52		19 / 54				

BLAST SUPERB AS/NZS 4233.2	WB6					WB408		WB612				

			TEXTILE BRAIDED HOSES									
--	--	--	--------------------------------	--	--	--	--	--	--	--	--	--

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

1TE / R6	B7R	B7R03	B7R04	B7R05	B7R06	B7R08	B7R10	B7R12				
		12,1	15,0	16,6	18,4	22,6	26,1	29,3				
	B1K		B1K04	B1K05	B1K06	B1K08	B1K10	B1K12	B1K16			
			15,2	16,7	18,1	22,2	26,7	29,9	36,8			
	B1T	B1T03										
		15,2										

2TE	B7R		B7R04	B7R05	B7R06	B7R08						
			15,5	16,7	18,5	23,1						
	B1K		B1K04	B1K05	B1K06	B1K08		B1K12			B1K24	
			14,8	17,3	18,0	22,0		29,9			52,0	
	B3R						B3R10	B3R12	B3R16	B3R20		
							27,1	32,5	40,8	46,5		
	B1T	B1T03										
		16,0										

3TE	B1T	B1T03									B1T24	
		15,8									53,5	
	B3R		B3R04	B3R05	B3R06	B3R08	B3R10	B3R12	B3R16	B3R20		

R3	B3R					B3R08	B3R10	B3R12	B3R16			
						25,0	28,5	35,8	41,2			

R4								B3R12	B3R16	B3R20	B12T24N	B12T32N
								34,0	42,4	48,8	58,7	71,7

R4 FLEX								B3R12	B3R16	B3R20	B1T24	B12T32N
								33,2	41,5	47,8	54,7	73,7

R4 CORRUGATED								B3R12	B3R16	B3R20	B1T24	B12T32N
								33,5	41,3	48,7	55	70,2

			THERMOPLASTIC HOSES									
--	--	--	------------------------------	--	--	--	--	--	--	--	--	--

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

R7	B7R	B7R03	B7R04	B7R05	B7R06	B7R08	B7R10	B7R12	B7R16			
		12,0	14,1	16,2	18,2	22,2	25,6	29,0	36,8			
	B1K		B1K04	B1K05	B1K06	B1K08						

	THERMOPLASTIC HOSES
---	---

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

R8	B7R	B7R03	B7R04		B7R06							
		11,8	13,8		18,2							
	B1K		B1K04	B1K05	B1K06	B1K08						
			14,0	16,7	18,4	22,4						

MTH1 EN853	B7R	B7R03	B7R04	B7R05	B7R06	B7R08	B7R10	B7R12	B7R16			
		12,0	14,1	16,2	18,2	22,2	25,6	29,0	36,8			
	B1K		B1K04	B1K05	B1K06	B1K08						
			13,8	17,0	18,0	21,7						

R18	B1SC		B1SC04		B1SC06							
			15,3		19,9							
	B7R	B703R	B704R									
		12,1	14,3									

	PTFE HOSES
--	--

Nominal bore	DN	5	6	8	10	12	16	19	25	31	38	51
Internal diameter	inches	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1.1/4"	1.1/2"	2"
	mm	4,8	6,4	7,9	9,5	12,8	16,0	19,0	25,4	31,8	38,1	50,8

PTFE-1FHL SMALL THICKNESS	BPTFE	BPTFE03	BPTFE04	BPTFE05	BPTFE06	BPTFE08	BPTFE10	BPTFE12	BPTFE16			
		11,6	13,8	14,7	16,2	20,8	22,2	27,9	34,5			

PTFE-1FHM MEDIUM THICKNESS	BPTFE	BPTFE03	BPTFE04	BPTFE05	BPTFE06	BPTFE08	BPTFE10	BPTFE12	BPTFE16			
		11,6	13,8	14,7	16,2	20,8	22,2	27,9	34,5			

PTFE-CLWB CONVOLUTED	BPTFEC		BPTFEC04	BPTFEC05	BPTFEC06	BPTFEC08	BPTFEC10	BPTFEC12	BPTFEC16	BPTFEC20	BPTFEC24	BPTFEC32
			12,8	-	16,0	19,4	22,7	26,2	33,2	44,0	50,4	62,5
	B7R		B7R04				B7R10					
			12,8				24,3					

18/09/2019	Last date update
+0 / -0,2 mm	Tolerance on the pressing diameter
± 0,5mm	Tolerance on the skive lenght

	Box with pressing diameter controlled by our internal produccion (with GO-No GO gauges)
	Box with pressing diameter never checked
	Box indicating the ferrules recommended by the manufacturer for that type of hose

The control with the gauges GO/NO GO is always necessary

WIRE BRAIDED HOSES WITH STANDARD FITTINGS		GO, NO GO MANDRELS DIAMETERS (mm)	
		GO	NO-GO
03	3/16"	2,30	2,80
04	1/4"	3,30	3,75
05	5/16"	4,70	5,20
06	3/8"	6,05	6,55
08	1/2"	8,35	8,75
10	5/8"	10,85	11,40
12	3/4"	13,50	13,80
16	1"	18,50	19,20
20	1.1/4"	23,05	23,90
24	1.1/2"	29,80	30,70
32	2"	41,60	42,60

WIRE SPIRAL HOSES WITH STANDARD FITTINGS		GO, NO GO MANDRELS DIAMETERS (mm)	
		GO	NO-GO
04	1/4"	3,15	3,60
06	3/8"	5,60	6,25
08	1/2"	7,60	8,40
10	5/8"	10,05	10,90
12	3/4"	12,35	13,30
16	1"	17,30	18,35
20	1.1/4"	22,25	23,35
24	1.1/2"	29,15	30,30
32	2"	40,70	42,00

WIRE SPIRAL HOSES WITH INTERLOCK FITTINGS		GO, NO GO MANDRELS DIAMETERS (mm)	
		GO	NO-GO
12	3/4"	12,15	13,10
16	1"	16,50	17,55
20	1.1/4"	22,25	23,35
24	1.1/2"	27,15	28,30
32	2"	38,70	40,00

*	Check with No-Go gauge diameter 19,65mm
---	---

Date	Variation
08/08/2019	Update swaging diameter Vulcanair with B1K ferrule
03/09/2019	Update swaging diameter textile hoses
18/09/2019	update swaging diameter spiral hoses Elastik and ferrule for Hyperspiral fittings

Note: Considering the wide tolerance admitted on the hoses dimensions, the expressed crimping diameters have to be considered as approximate; therefore, it is recommended to use always the go - no go gauge in order to check the tail collapse.

Nota: Data la larga tolleranza ammessa sulle dimensioni dei tubi, le quote di pressatura espresse sono indicative; si consiglia pertanto di utilizzare sempre i tamponi passa - non passa per verificare il giusto collasso del codolo.



©FOSCARIN GROUP S.R.L.
Via del Lavoro 8
31033 Castelfranco Veneto (TV)
