

## Generic Swaging Diameter Chart

Skive												
HOSE	DN	5	6	8	10	12	16	19	25	31	38	51
	INCH	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
	DASH	-03	-04	-05	-06	-08	-10	-12	-16	-20	-24	-32
EN 853 1SN SAE 100 R1AT	SKIVE PF11	14.2	17.8	18.8	21.7	25.2	27.8	31.2	37.7	46.7	55.0	66.0
	EXTERNAL SKIVE (L1)	18.0	22.5	22.5	22.5	26.0	27.0	31.0	39.0	45.0	50.0	58.0
	R.O.D.	9.4	10.8	12.8	14.9	18.0	20.8	24.9	32.7	39.8	46.3	60.0
EN 857 1SC	SKIVE PF11		17.0	17.9	20.6	24.3	27.2	30.2	37.5			
	EXTERNAL SKIVE (L1)		22.5	22.5	22.5	26.0	27.2	31.0	39.0			
	R.O.D.		10.2	11.6	13.6	17.1	20.1	23.8	31.0			
EN 857 2SC	SKIVE PF11		17.8	19.0	21.7	25.3	28.5	32.0	38.5			
	EXTERNAL SKIVE (L1)		22.5	22.5	22.5	26.0	27.0	31.0	37.0			
	R.O.D.		11.4	13.0	15.0	18.3	22.2	25.5	33.0			
2 K COMPACT EXCEEDS EN 857 2SC	SKIVE PF11		18.0	18.5	21.6	25.5	28.6	32.1	38.3			
	EXTERNAL SKIVE (L1)		22.5	22.5	22.5	26.0	27.0	31.0	38.0			
	R.O.D.		11.6	12.9	14.8	18.5	22.1	26.0	32.9			
EN 853 2SN SAE 100 R2AT	SKIVE PF12 / PF13	PF12	PF12	PF12	PF12	PF12	PF13	PF13	PF13	PF12	PF12	PF12
	EXTERNAL SKIVE (L1)	18.3	17.3	19.4	22.0	26.3	29.0	33.1	40.5	49.3	58.9	72.3
	R.O.D.	11.0	12.5	14.0	16.5	20.2	23.1	26.5	34.4	43.7	50.7	62.9
EN 856 4SP	SKIVE PF12 / PF13		PF12		PF12	PF12	PF13	PF13	PF13	PF12	PF12	PF12
	EXTERNAL SKIVE (L1)		18.8		23.4	26.3	29.5	34.4	42.2	51.7	59.1	73.0
	R.O.D.		14.5		17.7	20.7	24.7	28.0	35.4	46.2	51.5	64.9
EN 856 R12	SKIVE PF12 / PF13				PF12	PF12	PF13	PF13	PF13	PF12	PF12	PF12
	EXTERNAL SKIVE (L1)				22.9	26.7	30.1	33.6	41.5	50.2	58.2	71.5
	R.O.D.				17.3	20.7	24.5	27.5	35.3	43.2	50.1	63.3

No Skive												
HOSE	DN	5	6	8	10	12	16	19	25	31	38	51
	INCH	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"
	DASH	-03	-04	-05	-06	-08	-10	-12	-16	-20	-24	-32
EN 853 1SN SAE 100 R1AT	NO SKIVE PF22	15.6	17.6	18.6	20.7	23.6	27.2	30.9	38.5	48.3	56.4	69.4
	O.D.	11.9	13.2	15.1	17.7	20.6	23.8	27.7	35.6	43.8	50.5	64.5
EN 857 1SC	NO SKIVE PF24		15.4	16.9	18.9	23.1	25.6	28.9	36.7			
	O.D.		12.0	13.8	15.7	19.6	22.2	25.9	33.2			
1 K COMPACT EXCEEDS EN 857 1SC	NO SKIVE PF24		15.5	16.9	19.0	22.9	25.5	28.8	36.6			
	O.D.		12.1	13.7	15.7	19.2	22.3	26.0	33.2			
EN 853 2SN SAE 100 R2AT	NO SKIVE PF22	16.6	18.4	19.4	21.8	24.1	27.8	31.8	39.3	50.6	58.4	71.4
	O.D.	13.4	14.7	16.2	18.9	21.2	24.5	28.7	36.6	47.5	53.9	66.8
EN 857 2SC	NO SKIVE PF24		16.3	17.8	19.7	23.7	27.1	30.3	38.1			
	O.D.		13.2	14.6	16.6	19.7	23.9	27.2	35.6			
2 K COMPACT EXCEEDS EN 857 2SC	NO SKIVE PF24		16.4	18.0	19.9	24.2	26.8	30.6	38.1			
	O.D.		13.5	15.0	16.8	20.5	23.7	27.7	35.6			
EN 855 R7 SAE 100 R7	NO SKIVE PF23	11.2	14.7	16.1	18.6	23.4	27.0	30.2	37.1			
	O.D.	9.6	12.2	14.3	16.1	20.4	23.7	27.1	34.0			
EN 855 R8 SAE 100 R8	NO SKIVE PF23	11.0	14.3	15.7	18.2	22.9						
	O.D.	8.9	11.6	13.5	15.7	19.9						
THERMOPLASTIC 1 STEEL BRAID	NO SKIVE PF23	11.3	14.4	15.6	18.7	22.3	26.2	29.6	37.0			
	O.D.	9.7	11.7	13.3	15.5	18.8	22.0	25.8	33.0			

Double Skive (Interlock)												
HOSE	DN	6	8	10	12	16	19	25	31	38	51	
	INCH	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 1/2"	2"	
	DASH	-04	-05	-06	-08	-10	-12	-16	-20	-24	-32	
EN 856 4SH	DOUBLE SKIVE (INTERLOCK) MPF3					MPF3	MPF3	MPF3	MPF3	MPF3	MPF3	
	EXTERNAL SKIVE (L1)					48.0	52.0	57.0	64.0	79.0	82.0	
	INTERNAL SKIVE (L2)					16.0	17.0	18.0	21.0	25.0	26.0	
SAE 100 R13	DOUBLE SKIVE (INTERLOCK) MPF3 / MPF4					MPF3	MPF3	MPF4	MPF4	MPF4	MPF4	
	EXTERNAL SKIVE (L1)					36.0	42.5	55.0	64.0	77.0	82.0	
	INTERNAL SKIVE (L2)					17.0	18.0	21.0	24.0	26.0		
SAE 100 R15	DOUBLE SKIVE (INTERLOCK) MPF3 / MPF4					MPF3	MPF3	MPF3	MPF4	MPF4		
	EXTERNAL SKIVE (L1)					33.0	35.5	42.0	54.5	64.0		
	INTERNAL SKIVE (L2)					16.0	17.0	18.0	21.0	24.0		
R.O.D.						25.8	28.5	35.5	45.0	54.0		

### Crimping data of hydraulic hoses in combination with VOSS fittings

**Caution:** The values indicated here are recommended values on the basis of estimates. They were not determined by tests. The values shown are therefore to be seen only as approximate values and are non-binding. Individual practices/conditions in pressing operations (e.g. selection of the hose press or the crimping jaws), Skiving and the way these items are used can lead to significantly deviated values. If you require information on specific individual pressing conditions or values, please contact VOSS technical support.

**Skiving:** Hoses that require skiving must be skived down to the wire layer. Wires may not be injured upon skiving under any circumstances. For wire braided hoses a remaining rubber film of 0.2 to 0.3 mm after skiving is acceptable. Verification of correct crimping may only be undertaken by measuring insert bore collapse values. Indicated outside diameters of crimped ferrules (crimp dia reference) are of a non-binding indicative nature only as specific values vary due to the normed tolerances of the diameters of hoses and fittings. The examination of the optimal bore collapse takes place with the help of the mandrel gauge case! (Mandrel gauge case Art.-No.: 7004791900). The given values represent a starting point for the own definition of the swaging dimensions. Correct swaging dimensions lead to optimal bore collapse.

**Warning:** Use of incorrect parts or incorrect crimping may lead to leakage, failure or bursting of the hose line and may - particularly in operations with high operational pressure - result in material damage and/or personal injury. In case of doubt please seek specialist advice!

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