

Swaging chart

Stainless steel - Universal

Hose Type	Inside diameter		Ferrule dim. Ø	Layers	Skive length		Ferrule Part No.	Swaging Daimeter Ø +0 / -0,1 mm	Die Set Ref.	Adjustment
	inches	mm			in	out				
1 braided layer - Standard: EN 853-1SN / SAE 100 R1AT										
NST-HF 6	1/4"	06	23,0	1			SFD-12T-06-RVS	18,1		
NST-HF 8	5/16"	08	24,0				SFD-12T-08-RVS	19,0		
NST-HF 10	3/8"	10	26,0				SFD-12T-10-RVS	20,6		
NST-HF 13	1/2"	13	29,0				SFD-12T-13-RVS	22,8		
NST-HF 16	5/8"	16	33,0				SFD-12T-16-RVS	27,2		
NST-HF 20	3/4"	20	37,0				SFD-12T-20-RVS	31,1		
NST-HF 25	1"	25	46,0				SFD-12T-25-RVS	39,2		
2 braided layers - Standard: EN 853-2SN / SAE 100 R2AT										
HST-HF 6	1/4"	06	23,0	2			SFD-12T-06-RVS	18,6		
HST-HF 8	5/16"	08	24,0				SFD-12T-08-RVS	19,5		
HST-HF 10	3/8"	10	26,0				SFD-12T-10-RVS	21,7		
HST-HF 13	1/2"	13	29,0				SFD-12T-13-RVS	23,8		
HST-HF 16	5/8"	16	33,0				SFD-12T-16-RVS	28,4		
HST-HF 20	3/4"	20	37,0				SFD-12T-20-RVS	32,1		
HST-HF 25	1"	25	46,0				SFD-12T-25-RVS	40,2		
4 spiral layers - skive - Standard: SAE 100 R9R / DIN 20023 - 4SP / EN 856-4SP										
HDR 6	1/4"	06	22,0	4		21,0	SFD-24S-06-RVS	18,8		
HDR 10	3/8"	10	26,0			23,0	SFD-24S-10-RVS	23,4		
HDR 13	1/2"	13	30,0			23,5	SFD-24S-13-RVS	26,7		
HDR 16	5/8"	16	33,0			26,5	SFD-24S-16-RVS	29,7		
HDR 20	3/4"	20	38,0			31,0	SFD-24S-20-RVS	34,4		
HDR 25	1"	25	46,0			38,0	SFD-24S-25-RVS	42,2		
1 braided layer stainless steel/PTFE										
PTFE-1-DN06	1/4"	06	15	1			SFD 1-PTFE-06-RVS	13,0		
PTFE-1-DN08	5/16"	08	17				SFD-1-PTFE-08-RVS	13,8		
PTFE-1-DN10	3/8"	10	18				SFD-1-PTFE-10-RVS	15,5		
PTFE-1-DN13	1/2"	13	24				SFD-12-PTFE-13-RVS	20,5		
PTFE-1-DN16	5/8"	16	28				SFD-12-PTFE-16-RVS	23,5		
PTFE-1-DN20	3/4"	20	30				SFD-12-PTFE-20-RVS	27,0		
PTFE-1-DN25	1"	25	36				SFD-1-PTFE-25-RVS	34,1		
2 braided layers Stainless steel/PTFE										
PTFE-2-DN06	1/4"	06	18	2			SFD-1K-06-RVS	13,6		
PTFE-2-DN08	5/16"	08	19				SFD-1K-08-RVS	14,6		
PTFE-2-DN10	3/8"	10	22				SFD-1K-10-RVS	17,5		
PTFE-2-DN13	1/2"	13	24				SFD-12-PTFE-13-RVS	20,7		
PTFE-2-DN16	5/8"	16	28				SFD-12-PTFE-16-RVS	25,2		
PTFE-2-DN20	3/4"	20	30				SFD-12-PTFE-20-RVS	27,5		
PTFE-2-DN25	1"	25	40				SFD-2-PTFE-25-RVS	34,5		
1 braided layer - convoluted - stainless steel/PTFE										
95-COM-06	1/4"	6	16,0	1			SFA-95C-06-RVS	12,2		
95-COM-10	3/8"	10	21,5				SFA-95C-10-RVS	16,8		
95-COM-13	1/2"	13	25,0				SFA-95C-13-RVS	20,2		
95-COM-16	5/8"	16	29,0				SFA-95C-16-RVS	24,0		
95-COM-20	3/4"	20	34,0				SFA-95C-20-RVS	26,3		
95-COM-25	1"	25	40,0				SFA-95C-25-RVS	34,0		
95-COM-32	1 1/4"	32	46,0				SFA-95C-32-RVS	39,0		
95-COM-38	1 1/2"	38	55,0				SFA-95C-38-RVS	48,2		
95-COM-50	2"	50	69,0				SFA-95C-50-RVS	60,2		
1 braided layer - convoluted stainless steel/PTFE with steel inserts										
95-COM-06	1/4"	6	15,0	1			SFA-95C-06	12,7		
95-COM-10	3/8"	10	22,0				SFA-95C-10	18,3		
95-COM-13	1/2"	13	25,0				SFA-95C-13	20,8		
95-COM-16	5/8"	16	30,0				SFA-95C-16	24,1		
95-COM-20	3/4"	20	35,0				SFA-95C-20	27,7		
95-COM-25	1"	25	42,0				SFA-95C-25	34,8		
95-COM-32	1 1/4"	32	48,3				SFA-95C-32	42		
95-COM-38	1 1/2"	38	54,0				SFA-95C-38	45,7		
95-COM-50	2"	50	73,0				SFA-95C-50	60,6		

The swage dimensions listed in the tables are approximate data.
 Due to variations in hose, coupling tolerances and slight deviation in the swaging machine differences may occur.
 All of the information contained in this document has been composed with the utmost care.
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Swaging chart

Stainless steel - Universal

Hose Type	Inside diameter		Ferrule dim. Ø	Layers	Skive length		Ferrule Part No.	Swaging Daimeter Ø +0 / -0,1 mm	Die Set Ref.	Adjustment
	inches	mm			in	out				
Thermoplastic hose - 1 braided Polyamid layer - Standard: SAE 100 R7										
CR 7-6	1/4"	06	18,0	1			SFD-1K-06-RVS	14,6		
CR 7-8	5/16"	08	19,0				SFD-1K-08-RVS	16,5		
CR 7-10	3/8"	10	22,0				SFD-1K-10-RVS	18,6		
CR 7-13	1/2"	13	26,0				SFD-1K-13-RVS	23,0		
Thermoplastic hose - 1 braided Steel layer										
CR 8-8	5/16"	08	19,0	1			SFD-1K-08-RVS	16,2		
CR 8-10	3/8"	10	22,0				SFD-1K-10-RVS	18,3		
CR 8-13	1/2"	13	26,0				SFD-1K-13-RVS	21,8		
1 braided layer compact hose - Standard: EN 857-1SC										
NSK 6	1/4"	06	18,0	1			SFD-1K-06-RVS	14,8		
NSK 8	5/16"	08	19,0				SFD-1K-08-RVS	16,8		
NSK 10	3/8"	10	22,0				SFD-1K-10-RVS	19,0		
NSK 13	1/2"	13	26,0				SFD-1K-13-RVS	23,6		
2 braided layer compact hose - Standard: EN 857-2SC - SAE 100-R16 + HSK-HF + HSK-ST Supertuff										
HSK-PQ 6	1/4"	06	23,0	2			SFD-12T-06-RVS	17,9		
HSK-PQ 8	5/16"	08	24,0				SFD-12T-08-RVS	18,9		
HSK-PQ 10	3/8"	10	26,0				SFD-12T-10-RVS	20,9		
HSK-PQ 13	1/2"	13	29,0				SFD-12T-13-RVS	23,6		
HSK-PQ-16	5/8"	16	33,0				SFD-12T-16-RVS	27,6		
HSK-PQ-20	3/4"	20	37,5				SFD-12T-20-RVS	31,0		
HSK-PQ-25	1"	25	46,0				SFD-12T-25-RVS	39,0		
Compact high pressure hose black - Standard: EN 857-2SC										
SL 560-08	5/16"	08	21,0	2		22,5	SFD-1S-08-RVS	18,8		
SL 560-10	3/8"	10	24,0			22,5	SFD-1S-10-RVS	21,7		
Compact high pressure hose blue - Standard: EN 857-2SC (Alfajet 210 / 400) Coldwater										
SL 3010-06	1/4"	06	19,0	1			SFD-1K-06-RVS	14,8		
SL 3010-08	5/16"	08	19,0				SFD-1K-08-RVS	16,8		
SL 3010-10	3/8"	10	22,0				SFD-1K-10-RVS	19,0		
SL 3010-13	1/2"	13	26,0				SFD-1K-13-RVS	23,6		
SL 3020-06	1/4"	06	21,0	2		22,5	SFD-1S-06-RVS	17,8		
SL 3020-08	5/16"	08	21,0			22,5	SFD-1S-08-RVS	18,8		
SL 3020-10	3/8"	10	24,0			22,5	SFD-1S-10-RVS	21,7		
SL 3020-13	1/2"	13	28,0			26,0	SFD-1S-13-RVS	25,2		
Compact high pressure hose blue - Standard: EN 857-2SC (Alfajet 210 / 400) Hotwater / Steam cleaner										
SL 5020-06	1/4"	06	19,0	1			SFD-1K-06-RVS	14,8		
SL 5020-08	5/16"	08	19,0				SFD-1K-08-RVS	16,8		
SL 5020-10	3/8"	10	22,0				SFD-1K-10-RVS	19,0		
SL 5020-13	1/2"	13	26,0				SFD-1K-13-RVS	23,6		
SL 5030-06	1/4"	06	21,0	2		22,5	SFD-1S-06-RVS	17,8		
SL 5030-08	5/16"	08	21,0			22,5	SFD-1S-08-RVS	18,8		
SL 5030-10	3/8"	10	24,0			22,5	SFD-1S-10-RVS	21,7		
SL 5030-13	1/2"	13	28,0			26,0	SFD-1S-13-RVS	25,2		
1 braided layer - Standard: EN 853-1ST / SAE 100 R1A										
NS 6	1/4"	06	20,0	1		19,0	SFD-1S-06-RVS	17,8		
NS 8	5/16"	08	21,0			19,0	SFD-1S-08-RVS	18,8		
NS 10	3/8"	10	24,0			20,0	SFD-1S-10-RVS	21,7		
NS 13	1/2"	13	28,0			26,0	SFD-1S-13-RVS	25,2		
NS 16	5/8"	16	31,0			28,0	SFD-1S-16-RVS	28,8		
NS 20	3/4"	20	35,0			33,0	SFD-1S-20-RVS	32,5		
NS 25	1"	25	42,0			37,0	SFD-1S-25-RVS	38,8		
2 braided layers - Standard: EN 853-2ST / SAE 100 R2A										
HS 6	1/4"	06	22,0	2		17,0	SFD-24S-06-RVS	17,6		
HS 8	5/16"	08	23,0			19,0	SFD-24S-08-RVS	20,0		
HS 10	3/8"	10	26,0			20,0	SFD-24S-10-RVS	22,5		
HS 13	1/2"	13	30,0			26,0	SFD-24S-13-RVS	26,3		
HS 16	5/8"	16	33,0			28,0	SFD-24S-16-RVS	29,1		
HS 20	3/4"	20	38,0			33,0	SFD-24S-20-RVS	33,8		
HS 25	1"	25	46,0			37,0	SFD-24S-25-RVS	42,2		

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