



CRIMPING CHART

CRIMP REFERENCE

CSP-0096-01-2016-02

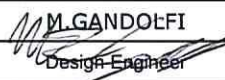

Intertraco 4ST

EXCEEDS: EN 856 4SP - SAE 100 R12, SIZES -10 -12 -16

EXCEEDS: EN 856 4SH, SIZES -20-24-32

ASSEMBLING PARAMETERS FOR TWO PIECES S312T NO SKIVE FERRULE FOR SPIRAL HOSE

BORE DIAMETER			INSERT TYPE	FERRULE CODE	Crimping Diameter		Internal Skive Length		External Skive Length		Crimping Type
					mm	inch	mm	inch	mm	inch	
DN	inch	size			0 -0.2	0 -0.008	± 0.5	± 0.02	± 0.5	± 0.02	
16	5/8"	10	B10	S312T10	30.0	1.181	NO	--	NO	--	FLAT
19	3/4"	12	B12	S312T12	34.4	1.354	NO	--	NO	--	FLAT
25	1"	16	B16	S312T16	41.7	1.642	NO	--	NO	--	FLAT
31	1.1/4"	20	B20	S312T20	51.9	2.043	NO	--	NO	--	FLAT
38	1.1/2"	24	B24	S312T24	60.2	2.370	NO	--	NO	--	FLAT
51	2"	32	B32	S312T32	73.8	2.906	NO	--	NO	--	FLAT

RELEASED	 M. GANDOLFI Design Engineer	APPROVED	 U. BONINI Quality Assurance	DATE	REV
				17/2/2016	01

DISCLAIMER: The above crimping diameters and assembling instructions are strictly related to the nominated Intertraco hydraulic hoses and fittings