

Hydraulic Rubber Hoses

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Quick Swaging

Hydraulic Hoses

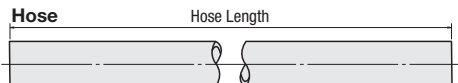
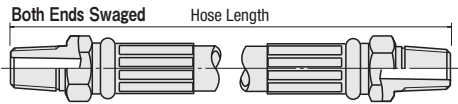


① Hydraulic Rubber Hose (with Spring Guard)
② Hydraulic Rubber Hose (Wire Braided Type)

Type			Connection	Material		Operating Temperature Range
7.0MPa Type	14.0MPa Type	20.6MPa Type		Hose	Wire Braided	
HOSTR	HOSCR	HOSYR	Both Ends Swaged	Synthetic Rubber (Reinforcement: Hard Steel Wire)	-	-40 ~ 100°C
HOSTW	HOSCW	HOSYRW		Inner Tube: Polyester Elastomer Reinforcement: Polyester Fiber Outer Covering: Polyurethane Elastomer	EN 1.1158 Equiv.	
HOSTS	HOSCS	HOSYRS			EN 1.4301 Equiv.	
-	HOMCR	HOMYR			-	-40 ~ 100°C (60°C for Water)

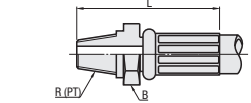
For Max. Operating Pressure of HOMCR, see Hose Dimensions Table.

Metal Fitting Shape	Material	Surface Treatment
A B C D E F G H	EN 1.1158 Equiv.	Trivalent Chromate
AS BS DS	EN 1.4301 Equiv.	-

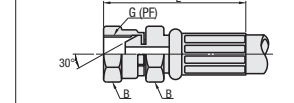


Swage Fitting Shapes

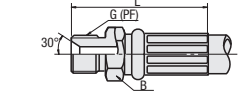
Shape A (EN 1.1158 Equiv.)
Shape AS (EN 1.4301 Equiv.)



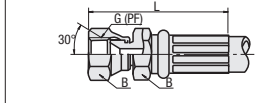
Shape B (EN 1.1158 Equiv.) Nut can be turned.
Shape BS (EN 1.4301 Equiv.)



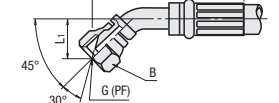
Shape C (EN 1.1158 Equiv.)



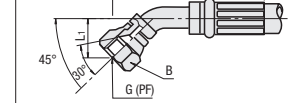
Shape D (EN 1.1158 Equiv.) Nut can be turned.
Shape DS (EN 1.4301 Equiv.)



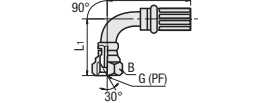
Shape E (45° PF Fitting 30° Male) Nut can be turned.



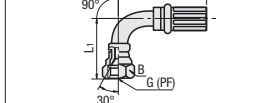
Shape F (45° PF Fitting 30° Female) Nut can be turned.



Shape G (90° PF Fitting 30° Male) Nut can be turned.



Shape H (90° PF Fitting 30° Female) Nut can be turned.



Hose Dimensions

Hose Nominal I.D.	I.D. (mm)	HOST		I.D. (mm)	Min. Bending Radius (mm)	HOSCR		I.D. (mm)	Min. Bending Radius (mm)	HOSYR		I.D. (mm)	Min. Bending Radius (mm)	HOMCR		I.D. (mm)	Min. Bending Radius (mm)	HOMYR	
		Min. Bending Radius (mm)	Max. Operating Pressure (MPa)			Min. Bending Radius (mm)	Max. Operating Pressure (MPa)			Min. Bending Radius (mm)	Max. Operating Pressure (MPa)			Min. Bending Radius (mm)	Max. Operating Pressure (MPa)			Min. Bending Radius (mm)	Max. Operating Pressure (MPa)
6	6.3	60	7.0	6.3	50	14.0	20.6	6.3	60	6.3	50	6.3	60	6.3	30	19.0	6.3	50	20.6
9	9.5	75		9.5	65			9.5	80	9.5	65	9.5	80	9.5	50	15.5	9.5	65	
12	12.7	90		12.7	70			12.7	90	12.7	70	12.7	90	12.7	60	13.5	12.7	80	
15	15.9	120	14.0	15.9	110	20.6	20.6	15.9	120	15.9	120	15.9	120	-	-	-	-	-	
19	19	140		19	130			19	140	19	140	19	140	-	-	-	-	-	
25	25.4	170		25.4	170			25.4	180	25.4	180	25.4	180	-	-	-	-	-	

Swage Fittings Size List

Hose Nominal I.D.	R (PT) G (PF)	Shape A		Shape B		Shape C		Shape D		Shape E		Shape F		Shape G		Shape H	
		B (Wrench Flats)	L	B (Wrench Flats)	L	B (Wrench Flats)	L	B (Wrench Flats)	L	B (Wrench Flats)	L	B (Wrench Flats)	L	B (Wrench Flats)	L	B (Wrench Flats)	L
6	1/4	19	51.5	19	51.5	19	48.0	19	51.5	19	69.0	26.0	19	69.0	26.0	19	52.0
9	3/8	22	62.5	22	62.5	22	59.0	22	62.5	22	88.0	28.5	22	88.0	28.5	22	68.0
12	1/2	27	69.5	27	69.5	27	67.0	27	69.5	27	96.0	33.0	27	96.0	33.0	27	76.0
15	3/4	36	71.9	36	71.9	36	71.9	36	76	36	116.0	41.5	36	116.0	41.5	36	99.0
19	3/4	36	78.5	36	78.5	36	78.5	36	78.5	36	118.0	41.5	36	118.0	41.5	36	98.5
25	1	41	86.5	41	86.5	41	86.5	41	90	41	131.0	47.5	41	131.0	47.5	41	116.0

Hose nominal I.D. 15 is not selectable for EN 1.4301 Equiv. swaged metals.

Part Number		Hose Length 0.1m Increment	L Left End Swaged Shape	R Right End Swaged Shape	Hose Protection Spring Guard
Type	Hose Nominal I.D.				
Hydraulic Rubber Hoses - Both Ends Swaged	6	0.3~20.0	LA LB LC LD LE LF LG LH LAS LBS LDS	RA RB RC RD RE RF RG RH RAS RBS RDS	LSG (Left) RSG (Right)
	9				
	12				
	15				
	19				
Hydraulic Rubber Hoses - Both Ends Swaged Wire Braided (EN 1.1158 Equiv.)	6				
	9				
	12				
	15				
	19				
Hydraulic Plastic Hoses - Both Ends Swaged	6				
	9				
	12				
	15				
	19				

Hose Nominal I.D.	Hose Unit Price/m Unit Price												
	HOSTR	HOSCR	HOSYR	HOSTW	HOSCW	HOSYRW	HOSTS	HOSCS	HOSYRS	HOMCR	HOMYR		
6													
9													
12													
15							-	-	-	-	-		
19										-	-		
25										-	-		

Hose Nominal I.D.	Unit Price Charges for Swaging / Spring Guard (Unit Price of One End Swaged)			
	Shape A, B, C, D	Shape AS, BS, DS	Shape E, F, G, H	Spring Guard
6				
9				
12				
15				
19				
25				

Ordering Example	Part Number	Hose Length	Shape L	Shape R	Hose Protection (Left)	Hose Protection (Right)
	HOSYR9	1.0	LE	RG	LSG	RSG

Alterations	Part Number	Hose Length	Shape L	Shape R	Hose Protection (Left)	Hose Protection (Right)	(EAS)
	HOSYR9	1.0	LE	RG	LSG	RSG	EAS180

Elbow Angle	
Code	EAS
Spec.	When choosing swaged ends with elbows (E, F, G, H), specify the elbow angles. Specifies the angle of the right elbow from left elbow angle (RE, RF, RG, RH) as the basis. (When not specified) (To specify angle)
	Both left and right elbows are in the same direction. Left elbow angle as a standard and EAS270.

- Hose length includes the Swage Fittings.
- For one end hose protection, specify LSG (left) for Spring Guard.
- Spring Guard (Hose Protection) is 300mm longer than swaged part.
- Hose length 0.3 ~ 0.6m with both ends of springs it total hose length plus springs.

Quick Swaging



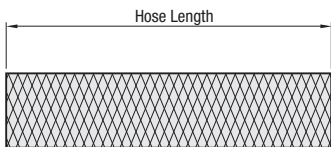
HOKT (Hose Body)

Material

Material	Operating Temperature Range
Weather Resistant Synthetic Rubber Reinforcement: Wire Braided Spiral Wires	-40°C~93°C

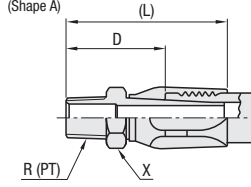
Swage Fitting Shapes

Material	Surface Treatment
EN 1.1158 Equiv.	Trivalent Chromate

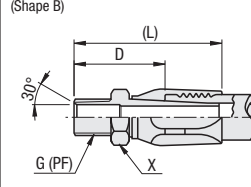


Swage Fitting Shapes

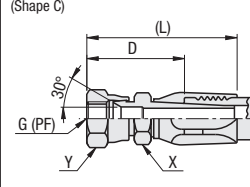
HOKTA (Shape A)



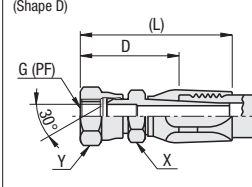
HOKTB (Shape B)



HOKTC (Shape C)



HOKTD (Shape D)



Hose Dimensions

Hose Nominal I.D.	I.D.	O.D.	HOKT		
			Min. Bending Radius (mm)	Max. Operating Pressure (MPa)	Min. Destructive Pressure (MPa)
6	6.4	14.7	85	20.7	82.7
7	7.9	17.1	100	15.5	62.0
12	12.7	23.4	140	12.1	48.3
15	15.9	27.4	165	10.3	41.4

Swage Fittings Size List

Hose Nominal I.D.	R (PT) G (PF)	HOKTA (Shape A)			HOKTB (Shape B)			HOKTC (Shape C)				HOKTD (Shape D)			
		X (Wrench Flats)	D	(L)	X (Wrench Flats)	D	(L)	X (Wrench Flats)	Y (Wrench Flats)	D	(L)	X (Wrench Flats)	Y (Wrench Flats)	D	(L)
6	1/4	17	32	52	17	32	52	17	19	37	57	17	19	37	57
7	3/8	19	36	59	19	36	59	19	22	41	64	19	22	41	64
12	1/2	22	43	76	22	43	76	22	27	47	80	22	27	47	80
15	3/4	30	48	88	30	48	88	30	36	53	93	30	36	53	93

Part Number		Hose Length 0.1m Increment	Hose Unit Price/m Unit Price
Type	Hose Nominal I.D.		
HOKT	6	0.3~10.0	
	7		
	12		
	15		

Part Number		Unit Price	
Type	Hose Nominal I.D.	HOKTA HOKTC	HOKTB HOKTD
HOKTA HOKTB HOKTC HOKTD	6		
	7		
	12		
	15		



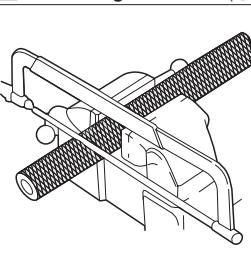
Features

- Length is determined based on machine in order to assemble.

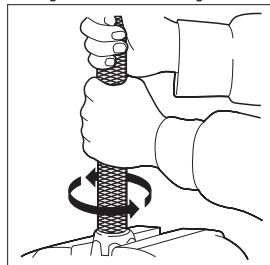
Precautions for Use

- Due to customer assembly, it is not applicable to PL Law (Product Liability Law).
- Please note that any trouble after assembly will be self-responsibility.

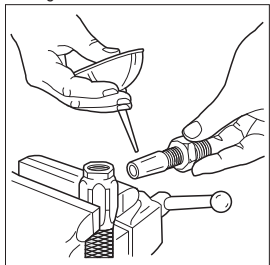
Assembling Procedure (The cut length of hose is the length of hose with fitting deducted of D dimension of both ends fitting.)



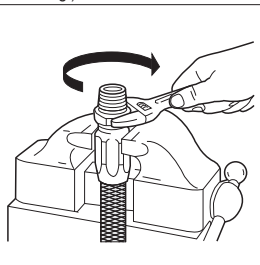
- Hose is cut perpendicular to axial direction. Use saw to cut the hose, thereafter, remove cutting chips from inside the hose.



- Nip the socket into the vice, insert the hose. While rotating counterclockwise, screw all the way completely, then return 1/4 rotation.



- Apply assembly lubricant to nipple outer surface and hose inner surface.



- While rotating the nipple clockwise, screw into the ket, and make the clearance between hex of nipple and socket to become 0.2 to 1.0mm.