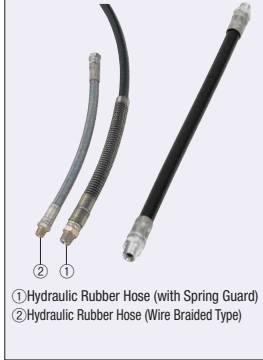


# Hydraulic Rubber Hoses

# Hydraulic Rubber Hoses Quick Swaging

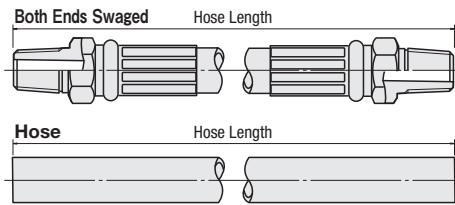
## Hydraulic Hoses



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			S25C	
HOSTS	HOSCS	HOSYRS		SUS304		
				Inner Tube: Polyester Elastomer Reinforcement: Polyester Fiber Outer Covering: Polyurethane Elastomer	-	-40 ~ 100°C (60°C for Water)
				HOMCR	HOMYR	

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

Metal Fitting Shape	Material	Surface Treatment
A B C D E F G H	S25C	Trivalent Chromate
AS BS DS	SUS304	-



## Swage Fitting Shapes

<b>Shape A</b> (S25C) <b>Shape AS</b> (SUS304)	<b>Shape B</b> (S25C) <span style="color:red">Nut can be turned.</span> <b>Shape BS</b> (SUS304)	<b>Shape C</b> (S25C)	<b>Shape D</b> (S25C) <span style="color:red">Nut can be turned.</span> <b>Shape DS</b> (SUS304)
<b>Shape E</b> (45° PF Fitting 30° Male) <span style="color:red">Nut can be turned.</span>	<b>Shape F</b> (45° PF Fitting 30° Female) <span style="color:red">Nut can be turned.</span>	<b>Shape G</b> (90° PF Fitting 30° Male) <span style="color:red">Nut can be turned.</span>	<b>Shape H</b> (90° PF Fitting 30° Female) <span style="color:red">Nut can be turned.</span>

## Hose Dimensions

Hose Nominal I.D.	HOST				HOSC				HOSYR				HOMCR				HOMYR			
	I.D. (mm)	Min. Bending Radius (mm)	Max. Operating Pressure (MPa)		I.D. (mm)	Min. Bending Radius (mm)	Max. Operating Pressure (MPa)		I.D. (mm)	Min. Bending Radius (mm)	Max. Operating Pressure (MPa)		I.D. (mm)	Min. Bending Radius (mm)	Max. Operating Pressure (MPa)		I.D. (mm)	Min. Bending Radius (mm)	Max. Operating Pressure (MPa)	
6	6.3	40	7.0		6.3	45	14.0		6.3	45	20.6		6.3	30	19.0		6.3	50		
9	9.5	50		9.5	55	9.5		60	9.5	65										
12	12.7	60		12.7	70	12.7		80	12.7	80										
15	15.9	80		15.9	95	15.9		110	15.9	110										
19	19	100		19	110	19		130	19	130										
25	25.4	120	25.4	140	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	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	44.5	19	52.0	44.5				
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	51.5	22	68.0	51.5				
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	59.5	27	76.0	59.5				
15	3/4	36	71.9	36	76	36	71.9	36	76	36	116.0	41.5	36	116.0	41.5	36	99.0	77.0	36	99.0	77.0				
19	3/4	36	78.5	36	78.5	36	75.0	36	78.5	36	118.0	41.5	36	118.0	41.5	36	98.5	77.0	36	98.5	77.0				
25	1	41	86.5	41	90	41	86.5	41	90	41	131.0	47.5	41	131.0	47.5	41	116.0	90.5	41	116.0	90.5				

Hose nominal I.D. 15 is not selectable for SUS304 swaged metals.

Part Number	Hose Nominal I.D.	Hose Length 0.1m Increment	L Left End Swaged Shape	R Right End Swaged Shape	Hose Protection Spring Guard
Hydraulic Rubber Hoses - Both Ends Swaged	6	0.3~20.0	LA LB LC LD	RA RB RC RD	LSG (Left) RSG (Right)
	9				
	12				
	15				
	19				
Hydraulic Rubber Hoses - Both Ends Swaged Wire Braided (S25C) (SUS304)	6	0.3~20.0	LA LB LC LD	RA RB RC RD	LSG (Left) RSG (Right)
	9				
	12				
	15				
	19				
Hydraulic Plastic Hoses - Both Ends Swaged	6	0.3~20.0	LA LB LC LD	RA RB RC RD	-
	9				
	12				

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

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

### Alterations

#### Elbow Angle

Code: EAS

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) (Specifying angle)

Both left and right elbows are in the same direction. Left elbow angle as reference.

Ordering Code: Select from EAS90, EAS180 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

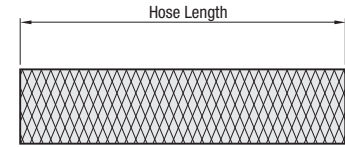


**HOKT**  
(Hose Body)

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

**Swage Fitting Shapes**

Material	Surface Treatment
S25C	Trivalent Chromate



## Swage Fitting Shapes

<b>HOKTA</b> (Shape A)	<b>HOKTB</b> (Shape B)	<b>HOKTC</b> (Shape C) <span style="color:red">Nut can be turned.</span>	<b>HOKTD</b> (Shape D) <span style="color:red">Nut can be turned.</span>
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## 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 Nominal I.D.	Hose Length 0.1m Increment	Hose Unit Price/m Unit Price
HOKT	6	0.3~10.0	
	7		
	12		
	15		

Part Number	Hose Nominal I.D.	HOKTA	HOKTC	HOKTB	HOKTD
HOKT	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.