

Hydraulic Rubber Hoses

Hydraulic Rubber Hoses Quick Swaging

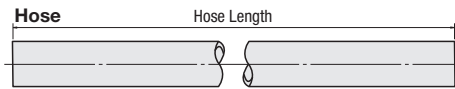
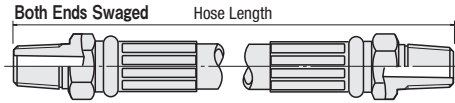
Hydraulic Hoses



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

Shape A (S25C) Shape AS (SUS304)	Shape B (S25C) Nut can be turned. Shape BS (SUS304)	Shape C (S25C)	Shape D (S25C) Nut can be turned. Shape DS (SUS304)
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.	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	60	7.0		6.3	50	14.0		6.3	60	20.6		6.3	30	19.0		6.3	50			
9	9.5	75		9.5	65	9.5		80	9.5	65		9.5	60	15.5	9.5	65			9.5	80	
12	12.7	90		12.7	70	12.7		90	12.7	70		12.7	60	13.5	12.7	80			12.7	90	
15	15.9	120		15.9	110	15.9		120	15.9	120		-	-	-	-	-	-	-	-	-	-
19	19	140		19	130	19		140	19	140		-	-	-	-	-	-	-	-	-	-
25	25.4	170	25.4	170	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	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 LE LF LG LH LAS LBS LDS	RA RB RC RD RE RF RG RH RAS RBS RDS	LSG (Left) RSG (Right)
	HOSTR HOSCR HOSYR				
	12				
	15				
	19				
Hydraulic Rubber Hoses - Both Ends Swaged Wire Braided (S25C)	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	
	HOSTW HOSCW HOSYRW				
	12				
	15				
	19				
Hydraulic Plastic Hoses - Both Ends Swaged	6	0.3~20.0	LA LB LC LD	RA RB RC RD	
	HOMCR HOMYR				

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) (To specify angle)

Both left and right elbows are in the same direction.

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

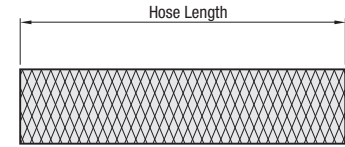


HOKT
(Hose Body)

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

Swage Fitting Shapes

Material	Surface Treatment
S25C	Trivalent Chromate



Swage Fitting Shapes

HOKTA (Shape A)	HOKTB (Shape B)	HOKTC (Shape C) Nut can be turned.	HOKTD (Shape D) Nut can be turned.
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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 Unit Price	HOKTB Unit Price
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 t ket, and make the clearance between hex of nipple and socket to become 0.2 to 1.0mm.

- Hose is cut perpendicular to axial direction. Use saw to cut the hose, thereafter, remove cutting chips from inside 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 t ket, and make the clearance between hex of nipple and socket to become 0.2 to 1.0mm.