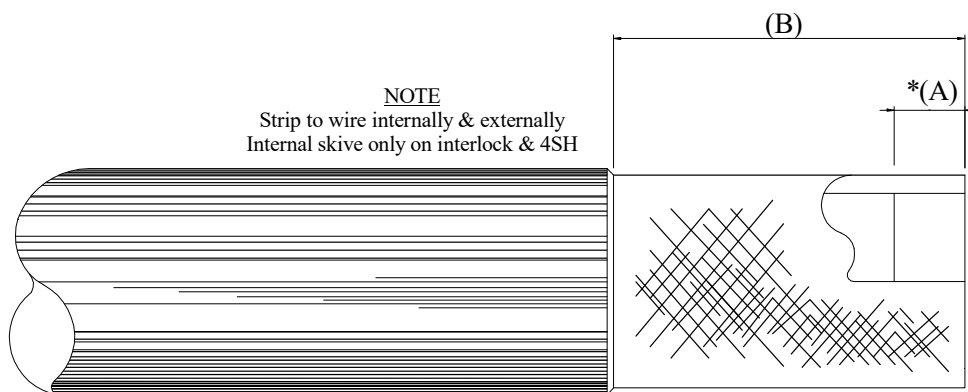


## Swaging & Skiving Dimensions

### Hose Skiving



For Skiving dimensions see A & B dimensions in the tables in this document that relates to the Ferrule you are using. The dimensions given are for guidance only and a slight adjustment of swage diameters may be required to accommodate extreme hose tolerance conditions at assembler's discretion.

## R1A Hose Swage Information SKIVE & NON SKIVE

Hose Diameter Inch	Ferrule	Swage OD		Skive Length (B)		Ferrule	SWAGE O.D.		SKIVE LENGTH
		Inch	mm	Inch	mm		Inch	mm	
1/4"	FR1A-250-04	0.69"	17.53	0.937"	23.8	FR1AT-250-04	0.626"	15.9	N/A
3/8"	FR1A-250-06	0.831"	21.11	1.015"	25.78	FR1AT-250-06	0.795"	20.2	N/A
1/2"	FR1A-250-08	0.99"	25.15	1.015"	25.78	FR1AT-250-08	0.969"	24.6	N/A
5/8"	FR1A-250-10	1.094"	27.79	1.05"	26.67	FR1AT-250-10	1.118"	28.4	N/A
3/4"	FR1A-250-12	1.24"	31.5	1.265"	32.13	FR1AT-250-12	1.22"	31	N/A
1"	FR1A-250-16	1.55"	39.37	1.5"	38.1	FR1AT-250-16	1.594"	40.5	N/A
1. 1/4"	FR1A-250-20	1.877"	47.68	1.682"	42.72	FR1AT-250-20	1.87"	47.5	N/A
1. 1/2"	FR1A-250-24	2.15"	54.61	1.81"	45.97	FR1AT-250-24	2.15"	54.7	N/A
2"	FR1A-250-32	2.659"	67.54	2.55"	64.77	FR1AT-250-32	2.64"	67.1	N/A

## R2A Hose Swage Information SKIVE & NON SKIVE

Hose Diameter Inch	Ferrule	SWAGE O.D.		SKIVE LENGTH (B)		Ferrule	SWAGE O.D.		SKIVE LENGTH
		Inch	mm	Inch	mm		Inch	mm	
1/4"	FR2A-250-04	0.683"	17.35	0.86"	21.84	FR2AT-250-04	0.728"	18.5	N/A
3/8"	FR2A-250-06	0.878"	22.3	0.935"	23.75	FR2AT-250-06	0.85"	21.6	N/A
1/2"	FR2A-250-08	1.015"	25.78	0.94"	23.88	FR2AT-250-08	1.024"	26	N/A
5/8"	FR2A-250-10	1.162"	29.51	1.02"	25.91	FR2AT-250-10	1.173"	29.8	N/A
3/4"	FR2A-250-12	1.335"	33.91	1.18"	29.97	FR2AT-250-12	1.307"	33.2	N/A
1"	FR2A-250-16	1.646"	41.81	1.42"	36.07	FR2AT-250-16	1.681"	42.7	N/A
1. 1/4"	FR2A-250-20	2.10"	51.05	1.805"	45.85	FR2AT-250-20	2.047"	52	N/A
1. 1/2"	FR2A-250-24	2.26"	57.38	1.81"	45.97	FR2AT-250-24	2.36"	60	N/A
2"	FR2A-250-32	2.82"	71.63	2.55"	64.77	FR2AT-250-32	2.807"	71.3	N/A

The above swage diameters are for the guidance only, and should produce an insert bore collapse which does not exceed 0.02" (0.508mm).  
A slight adjustment of swage diameters may be required to accommodate extreme hose tolerance conditions.

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### 1SN & 2SN Hose – Dual Purpose Ferrule Swage Information NON SKIVE

Hose Diameter Inch	Ferrule	1SN HOSE SWAGE O.D.			2SN HOSE SWAGE O.D.		
		Inch	mm	SKIVE LENGTH	Inch	mm	SKIVE LENGTH
1/4"	FRDP-250-04	0.709	18	N/A	0.756	19.2	N/A
3/8"	FRDP-250-06	0.807	20.5	N/A	0.835	21.2	N/A
1/2"	FRDP-250-08	0.906	23	N/A	0.965	24.5	N/A
5/8"	FRDP-250-10	1.091	27.7	N/A	1.110	28.2	N/A
3/4"	FRDP-250-12	1.205	30.6	N/A	1.252	31.8	N/A
1"	FRDP-250-16	1.594	40.5	N/A	1.614	41	N/A

### 1SC & 2SC Hose – Dual Purpose Ferrule Swage Information NON SKIVE

Hose Diameter Inch	Ferrule	1SC HOSE SWAGE O.D.			2SC HOSE SWAGE O.D.		
		Inch	mm	SKIVE LENGTH	Inch	mm	SKIVE LENGTH
1/4"	FRC-250-04	0.594"	15.1	N/A	0.610"	15.5	N/A
5/16"	FRC-250-05	0.665"	16.9	N/A	0.709"	18	N/A
3/8"	FRC-250-06	0.780"	19.8	N/A	0.803"	20.4	N/A
1/2"	FRC-250-08	0.890"	22.6	N/A	0.913"	23.2	N/A
5/8"	FRC-250-10	1.024"	26	N/A	1.055"	26.8	N/A
3/4"	FRC-250-12	1.185"	30.1	N/A	1.209"	30.7	N/A
1"	FRC-250-16	1.472"	37.4	N/A	1.520"	38.6	N/A

The above swage diameters are for the guidance only, and should produce an insert bore collapse which does not exceed 0.02" (0.508mm). A slight adjustment of swage diameters may be required to accommodate extreme hose tolerance conditions.

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**Teflon (PTFE) Hose - Smooth Bore & Convoluted Dual Purpose Swage Information NON SKIVE**

Hose Diameter Inch	Ferrule	PTFE HOSE SMOOTH BORE SWAGE O.D			PTFE HOSE CONVOLUTED BORE SWAGE O.D		
		Inch	mm	SKIVE LENGTH	Inch	mm	SKIVE LENGTH
1/4"	FRCP-250-04	0.500"	12.7	N/A	N/A	N/A	N/A
5/16"	FRCP-250-05	0.508"	12.9	N/A	N/A	N/A	N/A
3/8"	FRCP-250-06	0.626"	15.9	N/A	0.626"	15.9	N/A
1/2"	FRCP-250-08	0.819"	20.8	N/A	0.846"	21.5	N/A
5/8"	FRCP-250-10	0.953"	24.2	N/A	0.969"	24.6	N/A
3/4"	FRCP-250-12	1.071"	27.2	N/A	1.079"	27.4	N/A
1"	FRCP-250-16	1.323"	33.6	N/A	1.346"	34.2	N/A

**Teflon (PTFE) Hose - Smooth Bore & Convoluted Dual Purpose Swage Information NON SKIVE**

Hose Diameter Inch	Ferrule	PTFE HOSE SMOOTH BORE SWAGE O.D		
		Inch	mm	SKIVE LENGTH
3/16"	FRP-250-03	0.410"	10.41	N/A
1/4"	FRP-250-04	0.487"	12.37	N/A
5/16"	FRP-250-05	0.512"	13.0	N/A
3/8"	FRP-250-06	0.628"	15.95	N/A
1/2"	FRP-250-08	0.805"	20.45	N/A
5/8"	FRP-250-10	0.880"	22.35	N/A
3/4"	FRP-250-12	1.032"	26.22	N/A
1"	FRP-250-16	1.294"	32.87	N/A

The above swage diameters are for the guidance only, and should produce an insert bore collapse which does not exceed 0.02" (0.508mm).  
A slight adjustment of swage diameters may be required to accommodate extreme hose tolerance conditions.

## 4 Spiral R9R Hose Swage Information

Hose Diameter	Ferrule	Dim (A)		Dim (B)		Swage Diameter	
		inch	mm	Inch	mm	Inch	mm
1/4"	FR9R-250-04	N/A	N/A	1.378"	35	0.787"	19.99
3/8"	FR9R-250-06	N/A	N/A	1.496"	38	0.921"	23.39
1/2"	FR9R-250-08	N/A	N/A	1.457"	37	1.063"	27
5/8"	FR9R-250-10	N/A	N/A	1.575"	40	1.132"	28.75
3/4"	FR9R-250-12	N/A	N/A	1.969"	50	1.342"	34.09
1"	FR9R-250-16	N/A	N/A	2.520"	64	1.681"	42.7
** 1 1/4"	FR9R-250-20	N/A	N/A	N/A	N/A	N/A	N/A
** 1 1/2"	FR9R-250-24	N/A	N/A	N/A	N/A	N/A	N/A
** 2"	FR9R-250-32	N/A	N/A	N/A	N/A	N/A	N/A

\*\* See 4SH Interlock Swage Information on Page 6.

### NOTE

- Swage to given diameter  $\pm 0.005"$  (0.13mm).
- Hose inner tube must be skived using the correct internal skiving mandrel.

## R12 Interlock Hose Swage Information

Hose Diameter inch	Ferrule	Dim (A)		Dim (B)		Swage Diameter	
		Inch	mm	Inch	mm	Inch	mm
1 1/4"	FR9R-250-20	0.846"	21.50	2.913"	74.00	2.008"	51.00
1 1/2"	FR9R-250-24	0.866"	22.00	3.189"	81.00	2.252"	57.20
2"	FR9R-250-32	1.142"	29.00	3.346"	85.00	2.835"	72.00

### NOTE

- Swage to given diameter  $\pm 0.005"$  (0.13mm).
- Hose inner tube must be skived using the correct internal skiving mandrel.

The above swage diameters are for the guidance only, if the swage diameter does not produce a bore collapse underneath the wire trap of between 0.020" and 0.030" (0.50mm and 0.76mm) it must be adjusted to do so. A slight adjustment of swage diameters may be required to accommodate extreme hose tolerance conditions.

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## R13 Interlock Hose Swage Information

Hose Diameter inch	Ferrule	Dim (A)		Dim (B)		Swage Diameter	
		Inch	mm	Inch	mm	Inch	mm
3/4"	FR13-250-12	0.496"	12.60	2.047"	52.00	1.356"	34.44
1"	FR13-250-16	0.669"	17.00	2.559"	65.00	1.663"	42.24
1 1/4"	FR13-250-20	0.846"	21.50	2.913"	74.00	2.118"	53.80
1 1/2"	FR13-250-24	0.866"	22.00	3.189"	81.00	2.382"	60.50
2"	FR13-250-32	1.142"	29.00	3.346"	85.00	3.067"	77.90

### NOTE

- Swage to given diameter  $\pm 0.005"$  (0.13mm).
- Hose inner tube must be skived using the correct internal skiving mandrel.

## 4SH Interlock Hose Swage Information

Hose Diameter inch	Ferrule	Dim (A)		Dim (B)		Swage Diameter	
		Inch	mm	Inch	mm	Inch	mm
3/4"	FR13-250-12	0.496"	12.60	2.047"	52.00	1.343"	34.10
1"	FR13-250-16	0.669"	17.00	2.559"	65.00	1.673"	42.50
1 1/4"	FR9R-250-20	0.846"	21.50	2.913"	74.00	1.988"	50.50
1 1/2"	FR9R-250-24	0.866"	22.00	3.189"	81.00	2.244"	57.00
2"	FR9R-250-32	1.142"	29.00	3.346"	85.00	2.835"	72.00

### NOTE

- Swage to given diameter  $\pm 0.005"$  (0.13mm).
- Hose inner tube must be skived using the correct internal skiving mandrel.

The above swage diameters are for the guidance only, if the swage diameter does not produce a bore collapse underneath the wire trap of between 0.020" and 0.030" (0.50mm and 0.76mm) it must be adjusted to do so. A slight adjustment of swage diameters may be required to accommodate extreme hose tolerance conditions.