



INTERPUMP

FLUID SOLUTIONS 

Powered by I.M.M. Hydraulics

**Technical Data
General sales terms
and conditions**



INTERPUMP
FLUID SOLUTIONS 

Powered by I.M.M. Hydraulics

**THE STRENGTH OF A BIG GROUP
GUARANTEE OF HIGH QUALITY**



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WORLDWIDE CONNECTION

Interpump Fluid Solutions (delivered by IMM Hydraulics Spa) is an important part of the Interpump Group. We provide our customers across the world with a complete suite of hydraulic hoses, fittings, machines and accessories; solutions for a wide range of applications and sectors. Interpump Fluid Solutions is an important link in the Interpump Group with hydraulic power generators and actuators.



THE STRUCTURE AND PRODUCTION PLANTS OF I.M.M. HYDRAULICS

I.M.M. Hydraulics S.pA. is a world leader and acknowledged innovator in the production of hose and fittings for hydraulic systems.

The company supplies the most prestigious manufacturers in the world and its products are used in many sectors such as agriculture, marine, offshore, construction, lifting equipment, energy, military movement, cleaning, rail.

We provide international sales and service from our manufacturing facilities in 5 countries, 10 production and commercial sites, and the collaboration of 550 members of staff.

10% of our team are engineers and product specialists working in research and development. We are driven and inspired by innovation and we are fully continuous improvement oriented.

I.M.M. Hydraulics SpA owns the trademarks: Interpump Fluid Solutions, Hypress and Hydralok.

**Thirty years of productions has made us
the ideal partner for your hydraulic fluid solutions.**



Growing turnover



30 years of know how



80.000 sqm of facilities



Staff of 500 people



Worldwide connection

I.M.M. HYDRAULICS PRODUCTION

I.M.M. Hydraulics SpA is a multinational company that project manages, produces and distributes hydraulic hoses and hose fittings, as well as related assembly and test trial equipment.

The know-how acquired in 30 years of experience and continuous study of technological innovation for the implementation of new solutions, allows I.M.M. to position themselves as one of the most influential international benchmarks in the production of fluid connection systems.

The high technological standards, the substantial investments in process and material quality allow us to grow our core competencies. As a market leader, we produce 40 million items a year and achieve a consolidated turnover in excess of 70 million Euros.

Our manufacturing plants cover more than 80,000 square metres with over 500 machines and assembly systems.

THE STRENGTHS OF I.M.M.

Our core strengths include:

- Certified and proven quality in the field;
- Extreme reliability;
- Flexibility and continuous improvement;
- Innovation;
- Product integration for comprehensive solutions.

IMM is highly flexible and provides Solutions in line with market demands that meet ISO, SAE, EN, JIS construction standards, as appropriate. We exceed International standards with high performance and customer-focused solutions.

Our dedicated new product development focus, not only satisfies but exceeds customer needs.

"MARKET-IN" base approach is an I.M.M. unique ability in order to focus all efforts in the most important aspect of every business: the CUSTOMER.

Dedicated products development (or a combination of products) is an aspect that makes the difference between IMM and others companies in "SATISFYING NECESSITY", which springs from a NEED. The study and the development of customer-specific solutions is therefore a absolute value added result for IMM.

EVIDENCE OF TECHNICAL SPECIFICATIONS

Fitting Solutions:

- a. I.M.M. supplies fittings in both two-piece solution and ONE PIECE solution, highlighting the absolute ability to meet the demands of different markets globally.
- b. I.M.M. fittings can also be supplied in the INOX version as a proof of the ability to provides high value added solutions for the most demanding applications.

Surface Treatments on Fittings:

I.M.M. can provide different surface treatments according to client's request, and also in this case highlight an important range of possible solutions:

- a. Standard plating process: high corrosion resistance, even in the presence of operating temperatures up to -100°C ;
- b. IR-ZN-IR plating process: used in automotive sector when a black color with high corrosion resistance is required;
- c. Zinc Nickel Plating: this coating is used when high corrosion resistance under heavy exposure is required;
- d. E-Coat: this coating is applied on the metal parts in order to protect them from corrosion and from the aggressive action of atmospheric agents.



Product Qualification:

All our products are qualified in accordance with the related construction standards and technical specifications. All required tests are performed in our test laboratory with the latest generation machines. In ongoing collaboration with the market, we provide dedicated testing solutions for all projects developed for our customers.

CERTIFICATION AND I.M.M. MARKET

Along with certified Environment, Quality and Safety Management Systems, we also focus on Type Approvals, for example, Certification of International Organisations for Specific Products. This allows us to provide strategic and highly selective specialisation in markets such as Mining, Naval, Offshore and Automotive. We understand market dynamics and needs through our strong, specialised and reliable team with wide-reaching distribution channels. We supply products and service to all industries requiring fluid line components and hose fittings, through our widespread network of centres across the world.

- DIRECT RETAIL SALES
- EXPRESS DELIVERY
- SALES AND AFTER SALES ASSISTANCE
- HOSE FITTINGS CENTRE
- TEST AND REPORTING SERVICES



your hydraulic partner

Safety, Reliability and High Performance Level are recognized by Certifying Body such as DNV-GL, Bureau Veritas, Lloyd's register, RINA, Korean Register and Nippon Register that have released the related Approvals and Product Certification after dedicated audit and successfully witnessed tests.

I.M.M. Hydraulics is member of UNI (Italian Standardization Body) and ASSOFLUID (Italian Association of Hydraulics and Pneumatics Operators and Manufacturers).

This is a consistent Value Added in order to be always updated and informed about standards, applications and solutions.

Management System		Certifying Body
Quality	ISO 9001:2015	DNV-GL
Environment	ISO 14001:2015	DNV-GL
Health and Safety	BS OHSAS 18001:2007	DNV-GL

Type Approvals	
DNV-GL	Hypress 4SP, Hypress 4SH, HIPAC 2SC, KAIZEN 2SN HyGreen 4SH, HyGreen R13, HyGreen R15, MARATHON MSHA, Hypress R17 MSHA, Hypress 2SC MSHA
ABS	Hypress R17 MSHA, Hypress 2SC MSHA, HIPAC 2SC, KAIZEN 2SN, Hypress 1SC, MARATHON MSHA, Hypress 4SH, Hypress R13, Hypress R15, HyGreen 4SH, HyGreen R13, HyGreen R15
LLOYD's Register	Hypress 2SC, HIPAC 2SC, Hypress 2SN, KAZIEN 2SN, HyGreen 4SH, HyGreen R13, HyGreen R15, Marathon MSHA, Hypress R17 MSHA, Hypress 2SC MSHA
RINA	HIPAC 2SC, KAIZEN 2SN
Bureau Veritas	HyGreen 4SH, HyGreen R13, HyGreen R15, Hypress 2SC MSHA, Hypress R17 MSHA, HIPAC 2SC MSHA & MARATHON MSHA, HIPAC 1SC, LongLife 1SC, HIPAC 2SC, LongLife 2SC, KAIZEN 2SN, Hypress 4SH, Hypress 4SP, Hypress R15
KR	Hygreen 4SH, R13, R15, Hypress 4SH, Hypress 4SP, Hypress r15, Hypress R17, Hypress 2SC, Marathon 2SC, Kaizen 2SN, HIPAC 1SC, HIPAC 2SC, LongLife 1SC, LongLife 2SC
NKK	INTERPUMP Hypress R17, INTERPUMP Hypress 4SH, INTERPUMP KAIZEN 2SN, INTERPUMP HIPAC - LONGLIFE 1SC&2SC, INTERPUMP Hypress 4SP, INTERPUMP Hypress 2SC, INTERPUMP Marathon, HyGreen 4SH, HyGreen R13, HyGreen R15

Special Certification	
MSHA	Cover Compound
LAPI - EN 45545-2	Hose HyRail

Marine Equipment Directive	
DNV-GL	MED-D (HIPAC 2SC, KAIZEN 2SN, Hypress 4SP, Hypress 4SH, HyGreen 4SH, HyGreen R13, HyGreen R15, Hypress R17, Hypress 2SC, MARATHON)

Regulatory Compliance

- RoHS
- REACH

Collaborations/Associations

- ASSOFLUID
- UNI

[illegible]

INTERPUMP Hipac 2SC

3 THE002K



1 APPLICATIONS



6 TYPE APPROVAL :

MED, DNV - GL, RINA, BV, LLOYD'S.

4 APPLICABLE SPECS. :

IMM - EXCEED DIN EN 857 2SC - ISO 11237 2SC

No skive hose - Exceed EN specification - Impulse tested up to 1.000.000 cycles MED certificate (ISO 15540/15541)


Internal hose: Synthetic rubber, extruded whole without joints, of uniform thickness.

Reinforcement: two high tensile steel wire braids.

Covering: Anti-abrasive synthetic rubber, resistant to oils, fuels and atmospheric conditions.

Recommended fluid: Hydraulic fluids petroleum based, glycol-water based, lubricant

Operating temperature: from -40 to + 120° C (Intermittent), from -40 to +70° C for water based fluids

10			11		12		13		14		15		16
7													
Part number	ID		Size	OD	Max WP		Min BP		Min BR		Weight		Ferrule
	in	mm		mm	bar	psi	bar	psi	mm	inch	kg/m	lb/ft	
THE002K-04	1/4"	6.4	4	13.3	430	6235	1720	24940	50	1.969	0.285	0.191	001C-04
THE002K-05	5/16"	8.0	5	14.8	400	5800	1600	23200	60	2.362	0.329	0.221	001C-05
THE002K-06	3/8"	9.5	6	17.1	350	5075	1400	20300	70	2.756	0.422	0.283	001C-06
THE002K-08	1/2"	12.7	8	20.4	310	4495	1240	17980	80	3.150	0.517	0.347	001C-08
THE002K-10	5/8"	16.0	10	23.5	280	4060	1120	16240	100	3.937	0.626	0.421	001C-10
THE002K-12	3/4"	19.0	12	27.6	240	3480	960	13920	120	4.724	0.765	0.514	001C-12
THE002K-16	1 "	25.4	16	35.8	210	3045	840	12180	160	6.299	1.171	0.787	001C-16
THE002K-20	1.1/4"	31.8	20	43.1	160	2320	640	9280	250	9.843	1.53	1.028	001C-20
THE002K-24	1.1/2"	38.1	24	50.6	150	2175	600	8700	260	10.236	2.12	1.425	001C-24

8

Note:

MARKING: Available also embossed brand version. In case of order use TFW0085N.

ih INTERPUMP EXCEEDS ISO 11237/EN 857 - 2SC DN 6 I.D. 1/4" - W.P. 430 BAR/6235 PSI

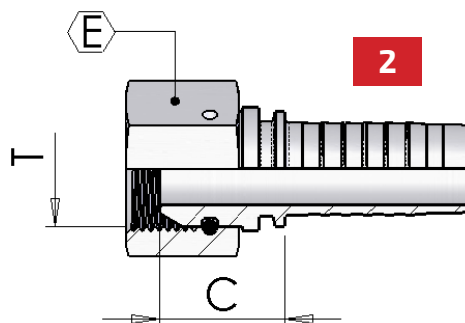
1	Type description	5	Applications	9	Marking	13	Min. bursting pressure
2	Features e Recommendations	6	Type Approval	10	Internal	14	Min. banding range
3	Product code	7	Order code	11	External	15	Hose weight per meter
4	Applicable Specs.	8	Note	12	Working pressure	16	Raccomanded ferrule

1

BSP Female 60° cone Thrust Wire

3

0050



4

Part number	Hose I.D.		dash size	Dimension		
	in	mm		threadT	hex E	cut-off C
0050-03-02	3/16	4.8	03	1/8-28	14	15
0050-03-04	3/16	4.8	03	1/4-19	19	17
0050-04-02	1/4	6.4	04	1/8-28	14	15
0050-04-04	1/4	6.4	04	1/4-19	19	17
0050-04-06	1/4	6.4	04	3/8-19	22	19
0050-04-08	1/4	6.4	04	1/2-14	27	22
0050-05-04	5/16	7.9	05	1/4-19	19	17
0050-05-06	5/16	7.9	05	3/8-19	22	19
0050-05-08	5/16	7.9	05	1/2-14	27	22
0050-06-04	3/8	9.5	06	1/4-19	19	17
0050-06-06	3/8	9.5	06	3/8-19	22	19
0050-06-08	3/8	9.5	06	1/2-14	27	22
0050-08-06	1/2	12.7	08	3/8-19	22	20
0050-08-08	1/2	12.7	08	1/2-14	27	23
0050-08-10	1/2	12.7	08	5/8-14	30	20
0050-08-12	1/2	12.7	08	3/4-14	32	27
0050-10-08	5/8	15.9	10	1/2-14	27	23
0050-10-10	5/8	15.9	10	5/8-14	30	20
0050-10-12	5/8	15.9	10	3/4-14	32	25
0050-12-08	3/4	19	12	1/2-14	27	24
0050-12-12	3/4	19	12	3/4-14	32	25
0050-12-16	3/4	19	12	1-11	38	26
0050-16-12	1	25.4	16	3/4-14	32	27
0050-16-16	1	25.4	16	1-11	38	27
0050-16-20	1	25.4	16	1.1/4-11	50	30
0050-20-20	1.1/4	31.8	20	1.1/4-11	50	32
0050-20-24	1.1/4	31.8	20	1.1/2-11	55	34
0050-24-24	1.1/2	38.1	24	1.1/2-11	55	34
0050-24-32	1.1/2	38.1	24	2-11	70	34

7



O-Ring

1

Type description

4

Order code

7

Note

2

Description

5

Inte. hose diameter

3

Product code

6

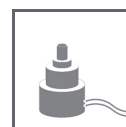
Main dimension



Agriculture



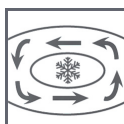
Cranes/Lifting



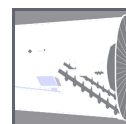
Hydraulic rams



Lifts



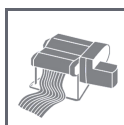
**Air Conditioning/
Refrigeration Systems**



Mining & Drilling



Test Benches



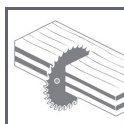
Food Industry



Ground movement



Chemistry



Wood Industry



Biological Oil



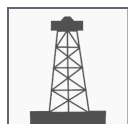
Compressors



Railway



Entertainment



Oil-Gas



Industry



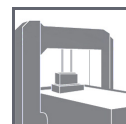
Jet Grouting



Elevators



Cleaning



Swaging Machines



Energy



Automatic Machines



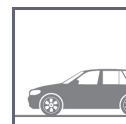
Hydraulic tools



Foundry-Steel Industry



Marine/Off Shore



Vehicles



Sewer system



Truck



Lift truck

System subject to
normal temperatures



System subject to low
temperatures



System subject to high
temperatures



Technical Info

Piece by piece, step by step.

I.M.M. Hydraulics fittings are made of carbon steel (11SMnPb37) or stainless steel AISI 316L controlled and certified.

At the end of their production process, carbon steel fittings undergo an iridescent trivalent zinc plating (minimum thickness 8 microns) - If required, there is also black zinc plating.

To order a tail and/or a stainless steel adaptor, it's sufficient to insert letter "X" before standard code

EXAMPLE CODE FOR CREATING ORDER

ESEMPIO CREAZIONE CODICE ARTICOLO PER ORDINE

Type		Hose Dash Size		Thread Dash Size	Note	Codice articolo P/N
0051	-	06	-	08	Standard	0051-06-08
0051	M	06	-	08	Multispiral	0051M06-08
0051	H	06	-	08	Inter-Lock	0051H06-08
0051	G	06	-	08	One Piece Wired Hoses	0051G06-08
0051	X	06	-	08	One Piece Spiral Hoses	0051X06-08
0051	W	06	-	08	Waterblast*	0051W06-08
0051	Y	06	-	08	Waterblast**	0051Y06-08
X0051	-	06	-	08	Stainless Steel / Inox	X0051-06-08

*, ** According to datasheet

Sealing features:

a – sealing thread: in this case the sealing is assured by the flattening of the thread edges when you screw male on the female.

b – with O-ring: this kind of connection, suitable for high pressure applications, is guaranteed by the compression of the seal into the corresponding component.

c – metal to metal: the two angled faces are wedged into one another by the tightening of the threaded nut and allow the sealing.

d – angle combined with O-ring: the seal is situated on the angled face of the fitting sealing and it is deformed simultaneously with the wedging of the angled faces.

On the following page are the main connection types with corresponding standards. The choice of the correct connection type depends on several aspects such as combination type, working pressure, temperatures, chemical compatibility, corrosion resistance, vibrations presence, etc.

Metric Connections (1)

Known as DIN or metric fittings, they guarantee the sealing thanks to sealing angled faces (metal to metal) or to the combination of metal to metal with O-ring seal. The angles of the sealing face are 24° with or without seal.

60° conical connections (2)

Known as BSP connections (British Standard Pipe) even known as "Whitworth thread" which can be parallel (BSPP) and conical (BSPT).

The sealing is assured by angled metal faces, with or without O-ring, with a 60° angle for both shapes.

BSPT Connections (3)

The sealing is guaranteed by the sealing thread. Since the sealing depends just on the threads deformation, it's suggested the use of a sealing material.

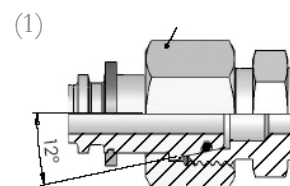
The difference of the NPT conical connection is on the thread shape which has a 55° angle.

Cone 37° - SAE J514 (4)

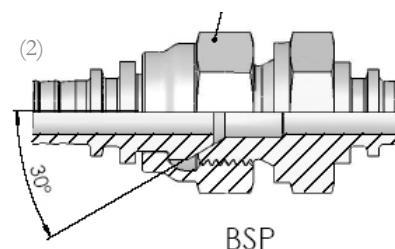
Known as JIC fittings, they guarantee the sealing through combination metal to metal with a 37° flare sealing surface without the deformation of the single component. The threads are UNF uprigh.

Flat sealing with O-ring - SAE J1435 (5)

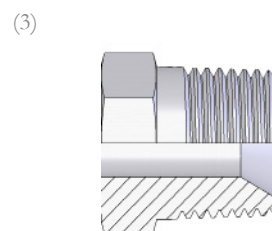
This kind of combination guarantees the best sealing with high pressures. The sealing is assured by the o-ring compression present on the male on the flat face of the female. The thread mechanically allows the combination.



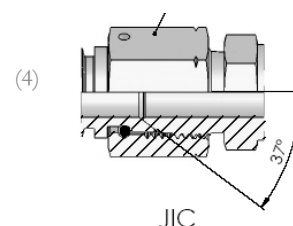
DKOL/DKOS



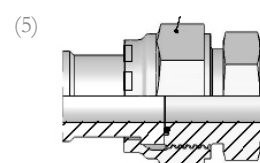
BSP



(3)



JIC



ORFS

SAE with O-ring – SAE J516 type BOSS

Male fitting equipped with UNF upright threads, a flat sealing surface and a O-ring. The sealing is assured by the O-ring seal of the male and the sealing surface of the female. It's compatible just with fittings type BOSS: SAE J1926.

NPTF/NPSM – SAE J516

The sealing is guaranteed by the sealing cone thread. The sealing faces are 30° angled, the thread has an angle of 60° different than BSPT connection.

24° Gas cone – French series

They are equipped with a 24° seal support face with upright metric threads. Similar to DIN fittings, they have a thinner thread.

JIS (Japanese Industrial Standard)

The metal to metal sealing system through 30° conical faces. They can be divided into:

- JIS Toyota: with cone on the female inverted than the BSP connections, thread BSPP;
- JIS Komatsu: as Toyota connections but with metric thread;
- JIS Nissan: completely similar to BSP connections, except some differences on the cone dimensions.

Safety Indicators, Attention and Notes

In this section are showed important safety indicators. They have been used three categories of indicators, listed in a decreasing order of importance.



WARNING: It is used in order to evidence potentially dangerous situations and/or procedures for health or life of the operator.



ATTENTION: It is used in order to evidence situations and/or procedures that can damage the functionality of the product.



NOTE: It is used in order to evidence important informations or callbacks to International Standards.

Purpose of the present handbook is to supply useful indications and advice for the correct choice, installation and maintenance of the assembly, in order to assure long life in service.

Safety warnings



WARNING: It could be dangerous for the safety and the health of the persons:

- an improper choice of the product;
- not corrected assembly or installation;
- the damaging of the hoses.

An opportune training, of which this handbook wants to be one of the instruments for the operators, the staff of the maintenance and persons who work with assembled hoses, is fundamental in order to avert eventual dangers.

The SAE J1273 or ISO / TR 17165-2 " Practical recommendations to use assembled hoses", to which this handbook makes reference, supplies profits indications in merit, in particular paragraph 4 lists some risks upgrade linked to hydraulic systems and connection under pressure.

Hose assembly selection



REMINDER: SAE J1273 clearly states that "...fittings of a producer are not generally compatible with hose supplied from another producer".

Normative reference: ISO 17165-2, SAE J1273, EN 982.

"Assembled hose" is defined the whole set of hydraulic hose with the fittings and the connectors. The characteristics of an assembly have to be:

- Flexibility: resistance to bending and torsion stress of the mechanical machines;
- Stability: for a corrected power transmission and flow control a lowest volumetric expansion/process foaming is necessary;
- Minimal flow resistance: the choice of correcting assembled (hoses and fittings) and the lay out must guarantee the maximum efficiency of the hydraulic circuit.



WARNING: The hydraulic fluid under pressure is dangerous and it can cause serious lesions and risks for the person.

Follow an indication for the correct hose selection in few simple passages:

Application:

It is necessary to define clearly:

- type of application required (high pressure line, suction line, pilot line...);
- where the hose will be installed (installation difficulty, heat source presence, external mechanical loads, delivery pump...);
- type of machinery (presence of pressure peaks , vibrations, flexibility etc...);
- special required performances (electric conductivity, abrasion resistance, flame-retardant etc...);
- required connections, screw thread;
- type of fluid and chemical compatibility;
- temperature and environmental conditions (salt water, presence of chemical agents, direct and extended exposure to the solar beams ...);
- eventual standard and/or local obligations.

Often for severe applications, the IMM High Performance line offers the best solution in order to guarantee a long life in service of the assembly. Generally they can be considered inside of a hydraulic circuit:

Pressure lines

- working pressure up to 400 bar and over;
- fluid high-speed until 8 m/s;
- several working conditions, with possible pressure peaks (especially in delivery pump) and vibrations;
- generally medium high pressure hoses are required.

Return lines

- working pressure up to 50-70 bar;
- moderate fluid speed ~ 3,0-4,0 m/s.

Suction lines

- necessary characteristic is the loadless resistance;
- generally used hoses of great diameter to reduce the pressure drops;
- low pressure; max 10 bar;
- moderate speed to avoid cavitation ~ 1,5 m/s;
- required loadless resistance until to -0,8/-0,9 bar;
- optimum solution is the chafing strip with steel spiral (rif. SAE 100 R4).

Pilot lines

- mean pressure line until to 100 bar;
- fluid speed mean-high ~ 5 m/s;
- compactness and high flexibility are indispensables to installation.

The IMM Pilot line enclose all these particulars with an extremely light hose line and reduced radius of curvature.

Hose size and flow rate

The dimension of components must be carried out to ensure a regular fluid flow rate, in order to reduce the number of pressure drop and to avoid excessive speed/turbulence of conveyed fluid. For the hose diameter selection it's possible to relate to nomogram attached in appendix. It's enough to know the maximum speed to convey and the flow rate of fluid.

The maximum speed advised for the fluids depend on the application:

- suction lines: 0,5-1,5 m/s;
- return lines: 1,5-3,5 m/s;
- pressure lines: 3,0-8,0 m/s;
- pilot lines: ~5,0 m/s.

The diameter of hose to be considered is that which makes the measure of internal diameter of the flexible hose. There are different way to indicate the measure of internal diameter:

dash size	Dimension SAE (Pollici - -Inch)	Diametro nominale	Riferimento EN DN
Rappresenta il numero di incrementi di 1/6			
-3	3/16	4,8	5
-8	8/16 - 1/2	12,7	12
-10	10/6 - 5/8	15,8	16

If it would be necessary to replace an assembly already installed on the hydraulic system, it is considered to be properly sized for an efficient functioning.

If you had to define a new system or you had to verify the efficiency of an existing one, it's possible to relate to the attached nomogram and proceed as follows:

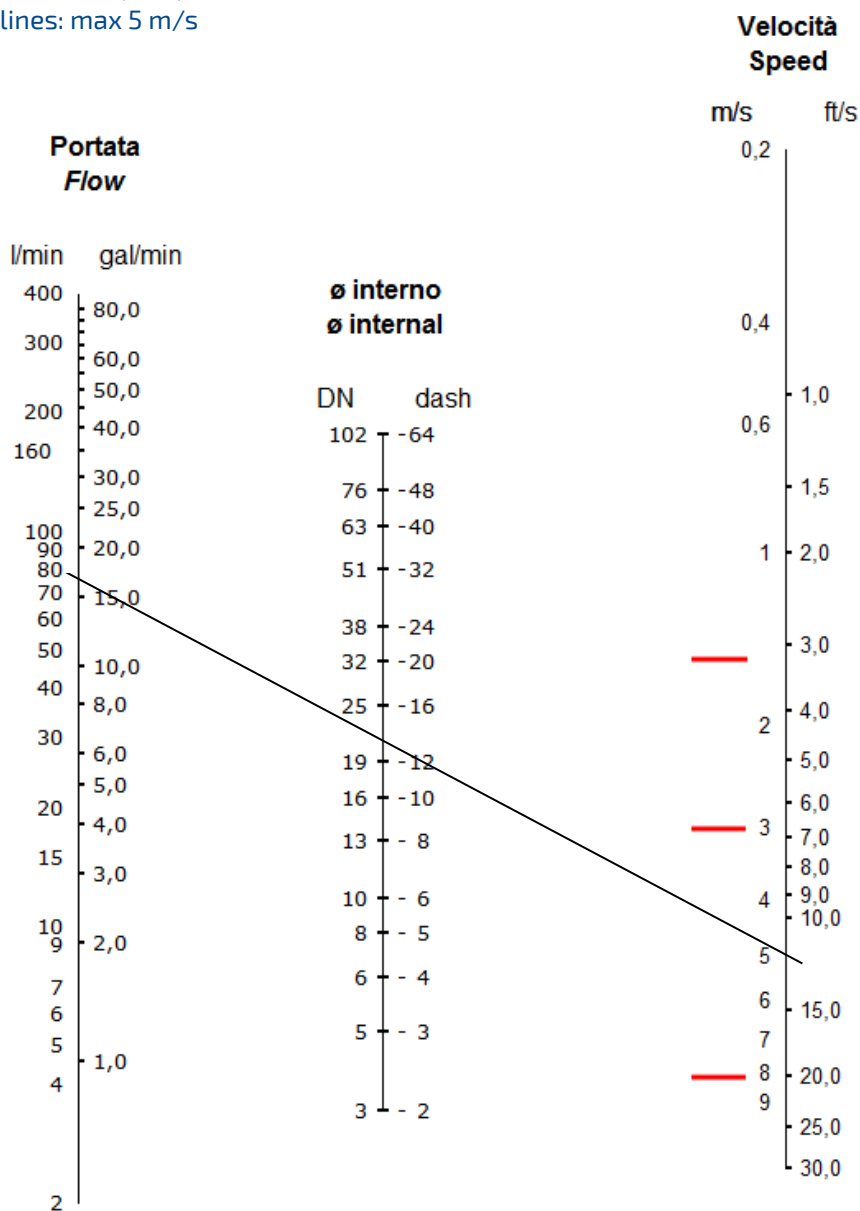
Recommended line speed:

Pressure lines: 3 - 8 m/s

Return line: 1,5 - 3 m/s

Suction lines: 0,5 - 1,5 m/s

Pilot lines: max 5 m/s



Pressure

To properly select the flexible hose and the fitting consider that the maximum working pressure for these components is similar or higher than the maximum system pressure.

It's necessary to consider both static working pressure and the so-called "pulsing" pressure when inside the system a pressure variation occurs with a not continuous attitude but a SINUSOIDALE one.

SAE J1927 Standard, gives a method to define life reduction of the flexible hose according to a specific hydraulic application, above all facing the pressure peaks and pulsing frequencies.



WARNING: Selection has to be made according to the maximum pressure reached by the system.

Pressure surges and peaks verification can be made just through specific device able to record short surges. Anyway, a first choice can be calibrated checking the safety valve placed on the plant in order to be assured against eventual pressure surges and peaks.

Hydraulics system classification can be made according the following pressure range:

- low pressures: up to 70÷110 bars (1500 PSI);
- medium-high pressures: 210÷245 (3000 – 5000 PSI);
- high-very high pressures: up to 420 bars and over (6000 PSI).

Fluid to convey

Fluid type: chemical identification, concentration, temperature, etc...

Flexible hose selection has to consider chemical compatibility of the conveying fluid.

The enclosed summarizing sheet gives information about compound type used for the production of the flexible hose, in this way, it's possible to verify the compatibility of the product with different fluid types (sheet...). The sheet concerning chemical resistance informs about the compatibility with several products.

Be careful about those applications which need to use fumes or dangerous and aggressive fluids.

To evaluate the use of pin-pricking covering in case of permeability of the fluid through the hose.

Temperature

The internal temperature of the conveying fluid must not at all overcome the advised temperature range stated on the product sheet.

Temperatures higher than the stated one, influence mechanical features of the rubber speeding up rubber ageing and compromising flexible hose life.

Temperatures lower than the suggested one can highly reduce the flexibility causing fragility of the rubber and possible cracks.

Generally, most of the compounds can work within a temperature range -40°C and $+100^{\circ}\text{C}$ with possible surges (peaks) up to 125°C .

The wide variety of variables in service can significantly alter the projected life.



ATTENTION: Work continuously at temperatures close to the limits of specified operating, reduce the hose life (SAE J1273, DIN 20066).

Special rubber compounds allow to make the temperature break much more longer.

For extreme temperatures refer to T products lines "High/Low temperature".



NOTE: As clearly detailed in the following paragraphs, the temperature of the external environment greatly influences the assembled product life. Avoid to install the assembled product near heat sources or provide to properly screen it.

An increase of 10°C above the maximum temperature may decrease hose life by half. Cracks can also be caused by flexing, especially at excessively low temperature.

Connection types

In order to get a long life of the assembly it's necessary to correctly select the connections to use.

It's important to follow information contained inside this catalogue to choose the right connection. For each hose is generally suggested the correct couplings (ferrule + insert) with corresponding swaging information. This combination is guaranteed by IMM thanks to several tests performed in laboratories and through test benches. IMM does not guarantee any combinations between flexible hose and fittings which do not follow the suggested indication detailed in this catalogue and not supplied by IMM.

"SAE J1273 clearly states that components coming from two different manufacturers are not usually compatible each other."

Choosing the correct connections remember to verify:

- the sealing capability at the requested working pressure;
- the corrosion resistance;
- the presence of vibration (flanges and O-ring are suggested in case of high vibrations);
- in case of O'ring the working temperatures (a specific material can be necessary for the sealing o'ring);
- the resistance to the fluid and to the environmental conditions.

Further advices

External environment

Ozon, UV radiations, heat or chemical agents can cause damages to the flexible hose and fittings reducing their life. It is important to evaluate the characteristics of the external environment (in terms of temperature, Ozon, chemical agents and/or solvents) in order to choose the proper external covering. Sometimes

it's suggested to choose the special lines (Harc, Long life, etc., which assure better performances with different and strict using conditions).

For particular requirements such as fire resistance, conductivity, etc., where the information of the catalogue are not enough detailed to select the hose, address to IMM technical service to get the necessary support.

Vibrations

Also vibrations can reduce the hose life.

Where it's necessary, make tests about hose vibrations to check amplitude and frequency.

In case, use collars or similar systems to reduce the effect.

Hose assembly preparation

Hose assembly length

Hose cut has to be performed correctly and with the proper device in order to have :

- square cutting surface, perpendicular to the hose axes;
- avoid to damage the reinforcement.

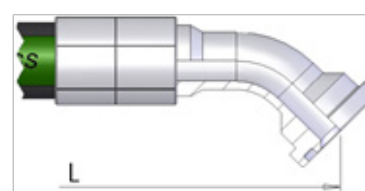
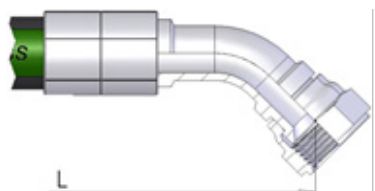
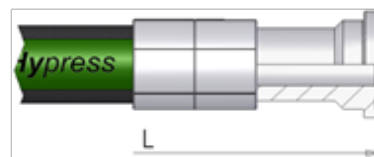
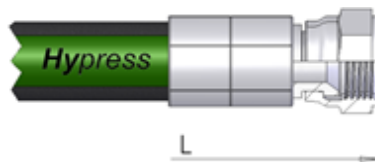


ATTENTION: Remember, a not squarely cut always causes:

- lack of sealing and assembly leaking;
- irregular rubber compression during the swaging and possible ferrule break.

As a suggestion, consider that for a spiral hose a lower cutting speed then braided hose is suggested (cutting blade rotation and cutting speed).

Hose assembly length has to be calculated according the following indication: (refers to SAE J 517 – 10):

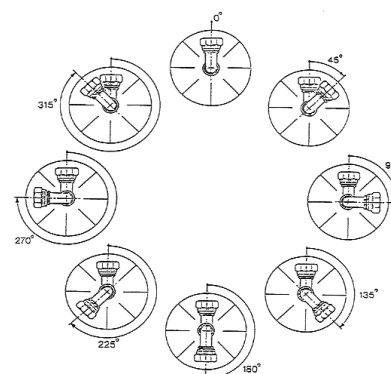


Several Standards (DIN 20066, EN 853 – 857, etc...) define the hose assembly length tolerances referring to the hose size and the total assembly length .

Following the indication inside DIN20066, EN 853, EN856, EN856 and equivalent ISO:

Lenght Lunghezza	up to DN25 fino a DN 25	from DN 32 to DN 50 da DN 32 a DN 50	from DN 60 to DN 100 da DN 60 a DN 100
fino a 630 mm	+7 / -3	+12 / -4	+25 / -6
631-1250 mm	+12 / -4	+20 / -6	+25 / -6
1251-2500 mm	+20 / -6	+25 / -6	+25 / -6
2501-8000 mm	+1,5% / -0,5%		
oltre 8000 mm	+3% / -1%		

Refer to the following picture to define the correct fitting orientation:



Keep straight the further end and rotate **clockwise** the closet end of the requested angle.



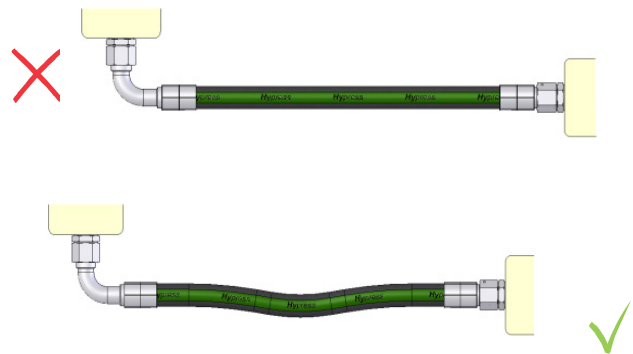
NOTE: Always consider the natural hose bend, in order to avoid mechanical stress on the hose.

Routings

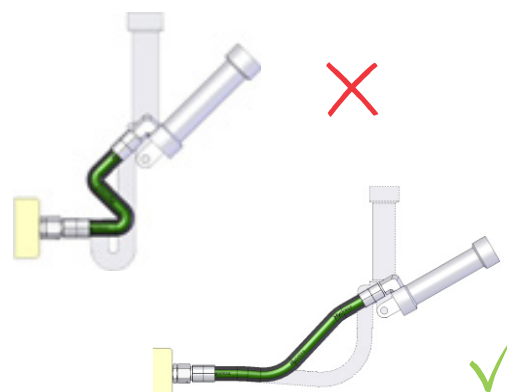
Follow some precaution mounting the hose assembly in order to avoid hose damage and compromise the sealing:

1-Hose assembly lenght

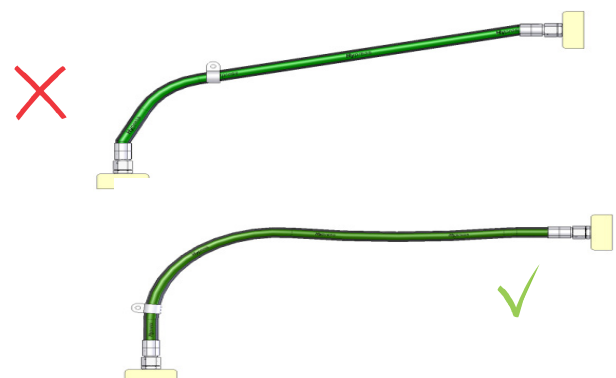
Provide the right lenght for the assembly. Over lenght will cause pressure loss. Short lenght could cause hose traction. Always consider some slack in the hose to allow shortening or elongation.



Hose lenght has to go along witht the machine movement, in order to avoid kinks and stress.



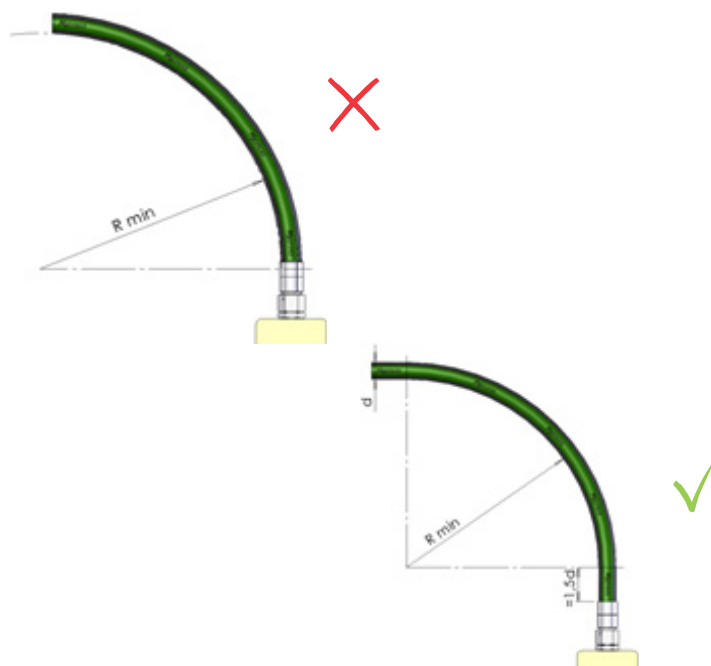
Consider hose lenght variation and define the right lenght and the correct clamping position to fix the assembly.



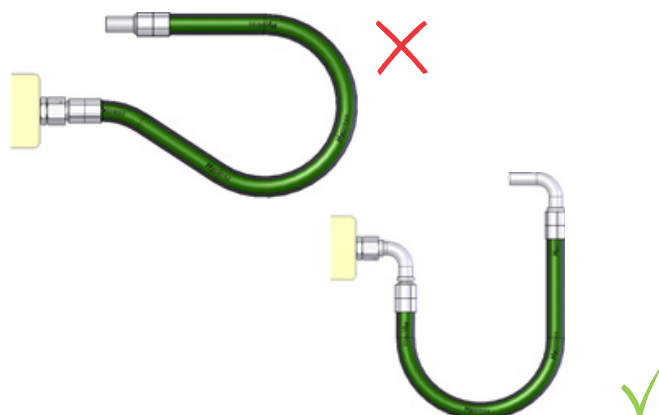
2-Minimum bend radius

Always consider the recommended minimum bend radius and provide sufficient hose so that the hose is not pulled or stressed. Installation with a tighter bend will reduce hose life.

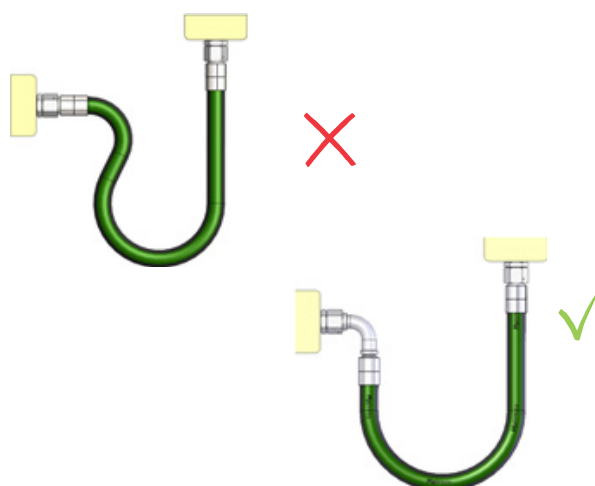
A minimum length of 1,5 times the external hose diameter is allowed (D) between hose fittings and the bend.



Use proper adapters and hose fitting termination, in order to avoid tight bend.

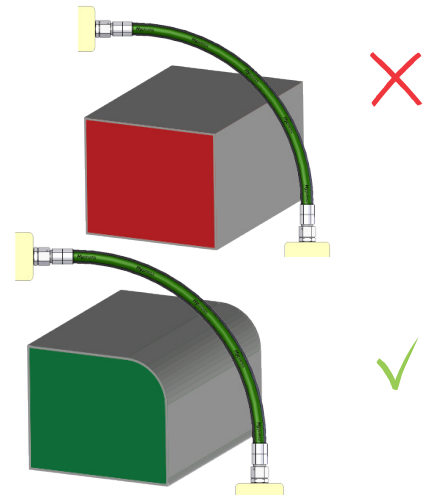


Too tight a bend may kink the hose, restrict or stop the fluid flow, or damage the hose reinforcement.

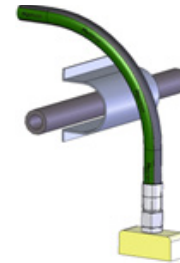


3-Hose protection

Protect hose against damage, abrasion and avoid contact with sharp and hard parts.

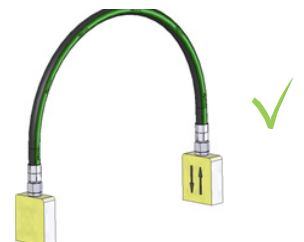
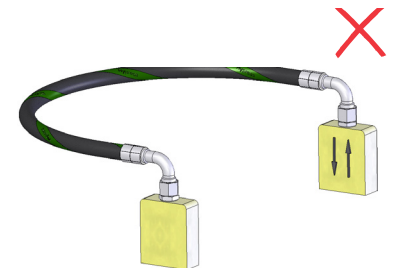


Isulate the hose assembly form heat source, using shield, fire sleeve, metal protection.

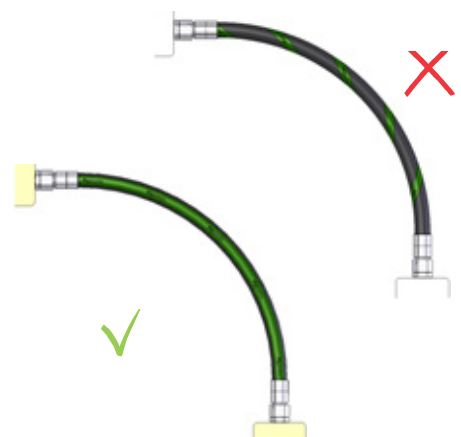


4-Hose movement

Take into consideration relative movement between the two connected part. Avoid hose torsion: during the application the hose has to flex in one single plane.

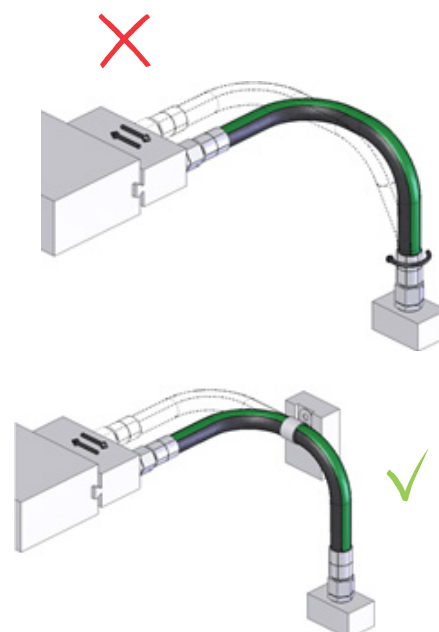


Do not install hose with a twist. Always consider the use of the right adaptor to avoid twist, swivel nut, swivel adaptors ...
To avoid torsion, use the brand line as straight guide.

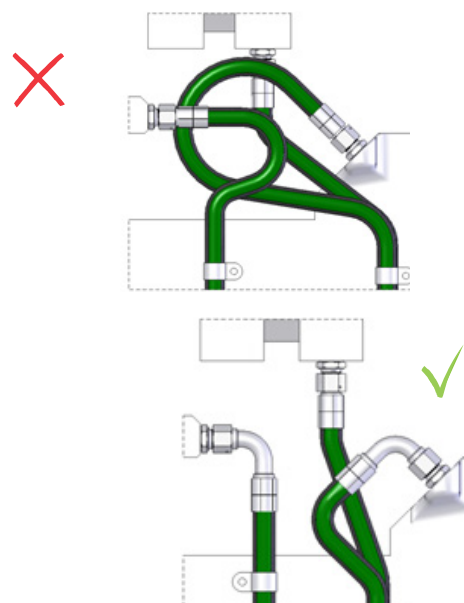


5-Routing

Whether the hose link two different planes, fix the assembly at change of plane, in order to allow flexion only in one plane.

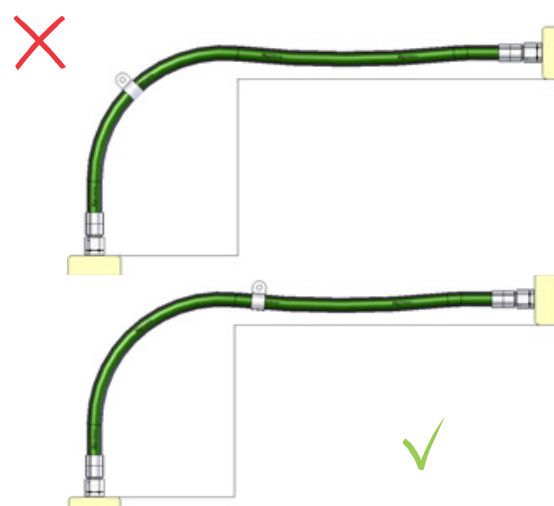


Always consider the use of 90° or 45° adaptors in order to have a better layout. The system will result easier to set up, easier to maintain, easier to check for leakage.



Always use clamps and wrapper to support long length assembly.

Fix properly long length assemblies, with the suitable clamps in order to avoid hose whipping and to stress fittings end.



A misalignment between sealing cone and thread causes "leakage".



Above the mentioned warning, always remember during the tightening:

- fasten the end without thightening;
- rotate the hose accordino the natural bend;
- thight the end avoding twisting ;
- mount hte ends wihtout damage the thread (follow the suggested tightening torque to guarantee the conformità of the thread);
- always verify that the surface is dry (it is necessari a higher value to guarantee the sealing on a wet surface);
- verify the lubrication and cleanless of the sealing surface;
- verify the presence of the O'ring where is requested.

Testing and inspection

Make an inspection to verify cut, abrasion, wear on the hose.

Perform the requested test if necessary (Rif. ISO 1402).

Clean the assembly using "pig" and sponge or flushing the assembly to reach high cleaning level.

Once the installation is completed let the air come out, increase the pressure up to the working rate and verify the sealing of the assembly.

In order to avoid injury during the final test:

- do not touch any part of the system during the proof test;
- keep away from the risky area ;
- decrease the pressure till the system is discharged before tightening the connection.

Cleaning hose

After assembling the hose and performed the necessary test, remove all possible contamination.

Be sure that the cleaning level fits the application.

Impurities and pollution could damage the system:

- block hydraulic components reducing the efficiency;
- wear the tube causing a premature failure
- lower heat dissipation.

The assembly can be cleaned using special "PIG" (sponge projectiles) fired by a compressed air circuit.

It is possible to use special machine to flush the assembly using water based fluid opportunely filtered.

It is possible, in this way, to gain high level of cleaning (refer to international Standard NAS 1638, ISO 4406, SAE479, BS5540/4).



NOTE: All the assembly should be protected by means of proper cap to avoid pollution.

Handling and storing

Rubber and plastic products can alter their characteristics during time. It is necessary to store hoses in order to control their ageing, implementing the FIFO (first-in, first-out), the manufacturing date of the hose and/or the assembly will give the priority.

Several Standards give useful indication on the storing:

ISO 2230 e ISO 8331, BS 5244, SAE J1273, DIN 7716, DIN 20066.

SAE J 517 :

- Rubber flexible hose or hose assembly have a total operative life of 40 quarters (ten years) being understood all the inspection and proof pressure to verify the conformity.
- Thermoplastic hoses have been considered to have unlimited duration.

Maximum hose storage depends on several parameters:

- Ambient – Temperature – Umidity

Goods has to be stored in dry and fresh area, without dust. Temperature generally between 5-25°C (do not exceed 38°C) and humidity around and not higher than 65%. Keep far from heat sources.

- Sunlight and rain

Hose should be protected form sunlight and UV sources. It is generally suggested to paint warehouse.

- Oxygen and Ozone

Hose should be protected form the circulating air and pace in closes box or by means of polyethylene envelope. High voltage electrical equipment should be avoided because of the harmful effect of ozone.

- Oil, solvents, fumes ...

Avoid contact with corrosive agents, detergent, and other organic liquids, Some metals could also affect the rubber (manganese, iron, copper).

- Narrow spaces and bending

The internal diameter of the coil/bobbin must be higher then double the minimum bending radius of the product (according the manufacturer indication).

Do not bend or pile the hose.

Avoid every mechanical stress (tension, compression) which can speed up the ageing.

- Protect the hose form insects and rodent.

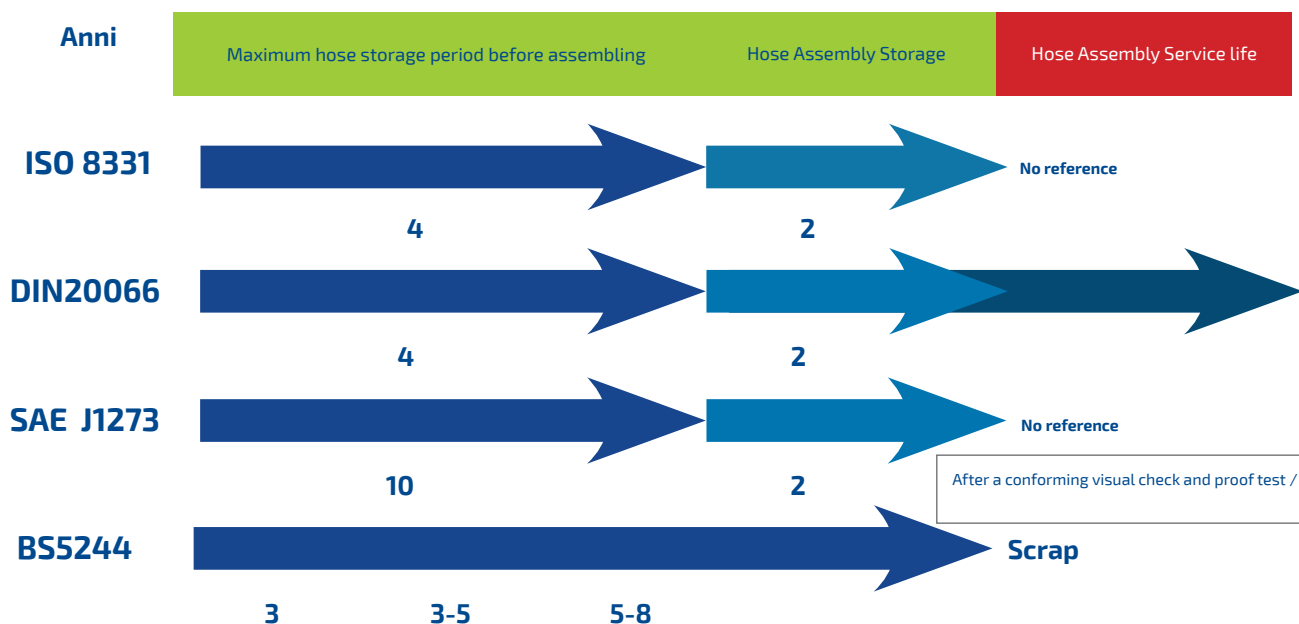


NOTE: Always check hoses integrity before deliver. It is recommended to perform further test on the hose in case of long lasting storing.

Hose manufacturing date

Assembling Hose

Service life



Hose: perform a proof test
assembly - perform proof test on all the as-
semblies

Preventive maintenance - according SAE J1273

A good preventive maintenance program can highly guarantee a reliable equipment in service, avoid injury and keep the system at its maximum efficiency.

Frequency of inspection

To define the frequency of the inspection always evaluate all the factor linked to the application and the past hystory of the machine.

Visual check (hose and fittings)

Visual inspect hose and fittings to evaluate:

- a. Leakage;
- b. Cover damage, cut or abrasion;
- c. Exposed Reinforcement;
- d. Hose dent, bent under the minimum allowed bending radius, or in torsion;
- e. Hose stiffend, or with hard/burnt cover;
- f. Cover spole, or with low adhesion;
- g. Fittings damaged or bad corroded;
- h. Fittings not properly tightened;
- i. Other possible non conformities.

Whenever, a non compliance has been detected, verify the assembly and eventually substitute it.

Visual check (hose and fittings)

During hose and fittings inspection, verify all the hydraulics components on the system in order to check:

- a. Connection sealings;
- b. Damage of the assemblies due to missing of guide, clamps or guard;
- c. Excessive dirt and debris around hose;
- d. Fluid: level, type, clearing ed absence if air.

If any of these conditions exsit, solve the problem.

Functional test

Functional test have to verify the correct system functioning.

Control the whole system behaviour under normal working pressure according the manufacturer indications.

Guidance safety - SAE J1273



WARNING: Improper selection, fabrication, installation, or maintenance of hose and hose assemblies for fluid-power systems may result in serious personal injury or property damage. These recommended practices can reduce the likelihood of component or system failure, thereby reducing the risk of injury or damage. It is important to consider all the aspects related to the application and to respect the following technical indication and suggestion inside this manual.

Listed are some potential conditions and situations that may lead to personal injury and/or property damage:

Fluid Injections

Fine streams of escaping pressurized fluid can penetrate skin and enter a human body.

These fluid injections may cause severe tissue damage and loss of limb. Consider various means to reduce the risk of fluid injections, particularly in areas normally occupied by operators.

Consider careful routing, adjacent components, warnings, guards, shields, and training programs.

Relieve pressure before disconnecting hydraulic or other lines. Tighten all connections before applying pressure.

Avoid contact with escaping fluids. Treat all leaks as though pressurized and hot enough to burn skin. Never use any part of your body to check a hose for leaks.

If a fluid-injection accident occurs, see a doctor immediately.

Do not delay or treat as a simple cut! Any fluid injected into the skin must be surgically removed within a few hours or gangrene may result.

Doctors unfamiliar with this type of injury should consult a knowledgeable medical source.

Whipping Hose

If a pressurized hose assembly blows apart, the fittings can be thrown off at high speed, and the loose hose can flail or whip with great force. This is particularly true in compressible-fluid systems. When this risk exists, consider guards and restraints to protect against injury.

Fire and Explosions from Conveyed Fluids

Most fluid-power media, including fire-resistant hydraulic fluids, will burn under certain conditions. Fluids which escape from pressurized systems may form a mist or fine spray which can flash or explode upon contact with an ignition source.

Consider selecting, guarding, and routing hose to minimize the risk of combustion (ref to Section 5 ISO 3457).

Fire and explosions from static-electric discharge

Fluid passing through hose can generate static electricity, resulting in static-electric discharge. This may create sparks that can ignite system fluids or gases in the surrounding atmosphere.

When this potential exists, select hose specifically designed to carry the static-electric charge to ground.

Electrical Shock

Electrocution could occur if hose conducts electricity through a person. Some application could require a non conductive hose in order to avoid electricity (rif. ISO 3949).

Some other require a hose with sufficient conductivity to carry the static-electric charge to ground.

Mechanisms controlled by fluid Power

Mechanisms controlled by fluids in hoses can become hazardous when a hose fails.

- Always install protective shield between operator and mechanical device;
- Do not work next to pressurized equipments;
- Do not touch system under pressure;
- Always use proper safety equipment, including eye protection, breathing apparatus, and adequate ventilation;
- Always appropriately trained staff to the preparation, assembly and use equipments;
- The user should design and implement a maintenance program that suits the specific application and each specific hose in that application.



ATTENTION: IMM advises to use only IMM hose and fittings.

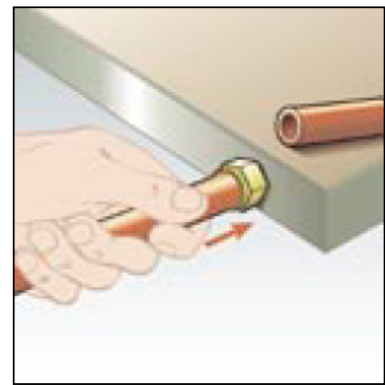
IMM does not guarantee any assembly product according to mentioned suggestions and technical specifications.

Unilock - Assembly Instructions

Cut the hose right angled with a sharp knife. If necessary it is possible to use a lubricant (water/soap solution with 5 % soap fluid and 95 % water) for easy assembly.



Insert fitting into hose until first barb is in hose. Place end of fitting against a flat object (bench, door, wall) and grip hose approximately at 2 centimetres from end and push with a steady force until end of hose is covered by red plastic collar.



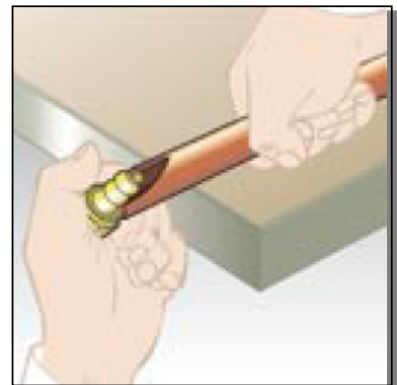
During assembly, please remind that UniLock fittings can be used just after a fully insertion, where the cutted end of the hose is completely concealed by the plastic collar.

Unilock - Disassembly Instructions

Cut lengthwise along a line around 2 centimetres with a 20° angle from the centre line of hose. Be careful not to nick fitting's barbs when cutting the hose.



Grip hose and give a sharp down-ward tug to get the fitting free.



Before re-use the fitting please check any damage sources. Damaged nipples can cause leakage.

IMM cover solutions

Hose cover is a critical aspect to correctly intercept customer's need and to properly meet application requirements.

I.M.M. provide all the solutions for the related applications.

Abrasion Resistant Cover Options



Super cover



Extra cover



Mega cover

Standard cover

Competitive and reliable solution for the hydraulic general application where the hose are not exposed to the sunlight directly and to the abrasion hose-to-hose and hose-to-metal. The standard cover has also a good behaviour at low temperature.

Super cover

Solution with double ozone and abrasion resistance compared to standard cover. Suitable for potential aggressive conditions like ground movement and high pressure washer application.

Low temperature cover

The special mix of polymers and additives makes this rubber compound able to work with external temperature up to -50°C having a reliable solution even in extreme conditions .

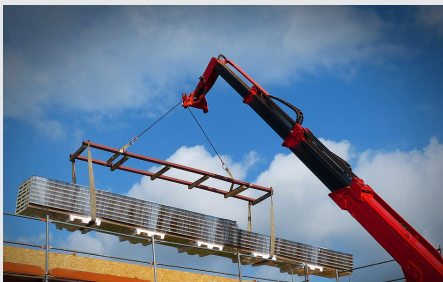
Extra cover

The superior hose cover has the best abrasion resistance and an excellent ozone resistance.

The cover can be used with profitability in the presence of :

- continuous flexing even with small bend radius combined with high abrasion: forklift masts and telescopic arms;
- direct exposure to sunlight: the hydraulic line mounted out of the machine body;
- the hose bundles subject to flexing and different pressure level: hose to connect the excavator arms;
- the hose exposed to hose-to-metal abrasion and to impact with external body.

The cover is not recommended in case of very low external temperature.



MSHA approved cover

The performance in terms of abrasion and ozone resistance and the MSHA approval make this cover a natural solution for any underground and open mining.

The combination of the high elasticity and the extreme ozone and UV resistance make the MSHA cover reliable in case of high sunlight and ozone exposition even with low hose bend radius.



High temperature cover

Special solution for hoses exposed to ambient temperature over 100°C. The HT cover is recommended for:

- application in engine compartment of truck e.g. power steering application
- injection moulding for the heating circuits
- foundry.

The special compound used to withstand high temperature is not recommended in case of high ozone concentration and/or sunlight exposure



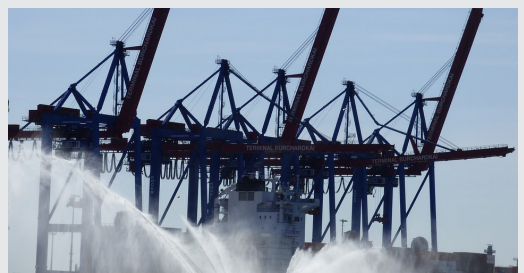
Mega cover

The UHMWPE is the best solution against hose abrasion. The cover allows to eliminate the hose-to-hose and the hose-to-external body abrasion.

In several cases this solution allows to replace an external hose protection as PU sleeve, Thermoplastic or steel wire springs, with high cost saving.

The good chemical stability, the ozone and UV resistance and the water resistance make this cover a good choice also in case of heavy working ambient, such as subsea application, in-oil application, snow gun application.

A new MSHA approved UHMWPE cover is available.



IMM cover key features

Abrasion Resistance according to
ISO 6945 (F= 25N – 2000 cycles):

EN std. Target: 0,50 g loss

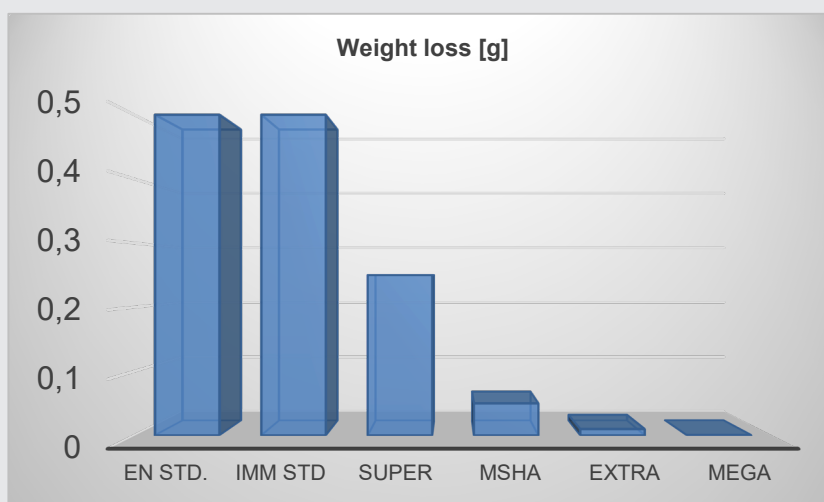
IMM std. Cover: EN std.

IMM Super cover: x 2 EN std

IMM Extra cover: x 50 EN std

IMM MSHA cover: x 10 EN std.

IMM Mega cover: not measurable



Ozone Resistance according to
ISO 7326 (50 pphm – T=40°)

EN std. Target: 72 h

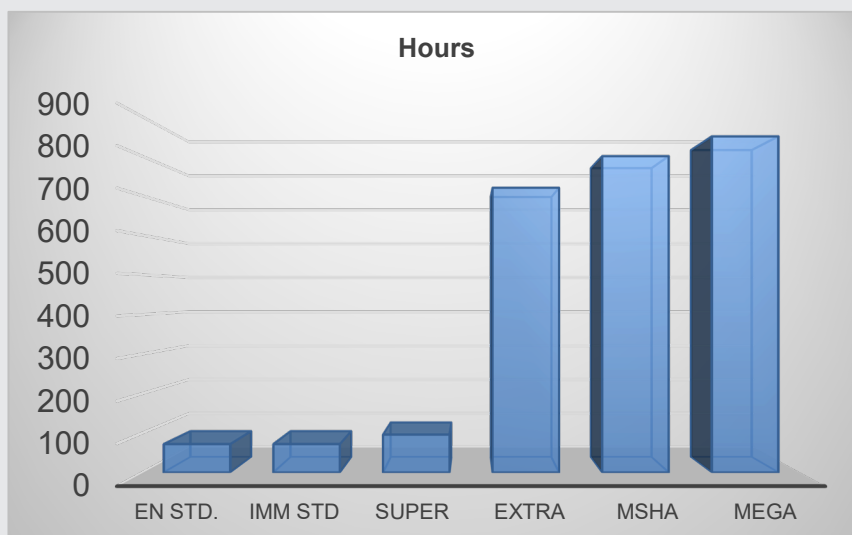
IMM std. cover: EN std.

IMM Super Cover: better than EN std.

IMM Extra cover: x 10 EN std.

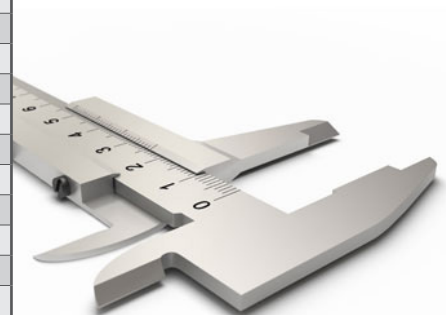
IMM MSHA cover: > 10 EN std.

IMM Mega cover: > 10 EN std.



Thread Diameter

Type	thread	dash	male (mm)		female (mm)	
			max	min	max	min
BSP	1/8-28	02	9,7	9,5	8,8	8,6
Metric	M10x1	10	9,9	9,8	9,1	8,9
UNF	7/16-20	04	11,0	10,9	10,0	9,7
Metric	M12x1,5	12	11,9	11,7	10,6	10,4
UNF	1/2-20	05	12,6	12,5	11,6	11,3
BSP	1/4-19	04	13,1	12,9	11,8	11,4
Metric	M14x1,5	14	13,9	13,7	12,6	12,4
UNF	9/16-18	06	14,2	14,0	13,0	12,8
UNF	5/8-18	07	15,8	15,6	14,6	14,4
Metric	M16x1,5	16	15,9	15,7	14,6	14,4
BSP	3/8-19	06	16,6	16,4	15,3	15,0
UN	11/16-16	09	17,4	17,2	16,1	15,7
Metric	M18x1,5	18	17,9	17,7	16,6	16,4
UNF	3/4-16	08	19,0	18,8	17,6	17,3
Metric	M20x1,5	20	19,9	19,7	18,6	18,4
UN	13/16-16	11	20,5	20,4	19,2	18,9
BSP	1/2-14	08	20,9	20,7	19,1	18,6
Metric	M22x1,5	22	21,9	21,7	20,6	20,4
UNF	7/8-14	10	22,1	21,9	20,6	20,3
BSP	5/8-14	10	22,9	22,6	21,1	20,6
UNS	1-14	13	25,3	25,1	23,8	23,4
Metric	M26x1,5	26	25,9	25,7	24,6	24,4
BSP	3/4-14	12	26,4	26,2	24,6	24,1
UN	1.1/16-12	12	26,9	26,7	25,1	24,7
Metric	M30x1,5	30	29,9	29,7	28,6	28,4
Metric	M30x2	30	29,9	29,7	28,2	27,8
UN	1.3/16-12	14	30,1	29,8	28,3	27,9
UN	1.5/16-12	16	33,2	33,0	31,4	31,0
BSP	1-11	16	33,2	32,9	30,9	30,3
Metric	M36x2	36	35,9	35,7	34,2	33,8
UN	1.7/16-12	15	36,4	36,2	34,6	34,2
Metric	M38x1,5	38	37,9	37,7	36,6	36,4
UN	1.5/8-12	20	41,2	40,9	39,4	39,0
BSP	1.1/4-11	20	41,9	41,6	39,5	39,0
Metric	M42x2	42	41,9	41,7	40,2	39,8
UN	1.11/16-12	21	42,8	42,5	41,0	40,6
Metric	M45x1,5	45	44,9	44,7	43,6	43,4
Metric	M45x2	45	44,9	44,7	43,2	42,8
UN	1.7/8-12	24	47,5	47,3	48,7	45,3
BSP	1.1/2-11	24	47,8	47,4	45,4	44,8
UN	2-12	32	50,7	50,5	48,9	48,5
Metric	M52x2	52	51,9	51,7	50,2	49,8
BSP	2-11	32	59,6	59,3	57,2	56,7
UN	2.1/2-12	32	63,4	63,2	61,6	61,2



Manufacturing Standards

Description	Standards
Gas / BSP	BS 5200 ; ISO 8434-6 ; ISO 12151-6
Metrico 24° / Metric 24°	DIN 3861; DIN 3865 ; ISO 8434-1 ; ISO 8434-4 ; ISO12151-2
Metrico 60° / Metric 60°	DIN 7631; DIN 3863
ORFS	SAE J1453 ; ISO 8434-3 ; ISO12151-1
NPT	SAE J514
Jic 37°	SAE J514 ; ISO 8434-2 ; ISO 12151-5
SAE Flange 3000 Series	SAE J518 ; ISO 6162-1 ; ISO 12151-3
SAE Flange 6000 Series	SAE J518 ; ISO 6162-2 ; ISO 15151-3
Occhi / Banjos	DIN 7642
JIS	JIS B 8363

Recommended installation torque

BSPP					
		with O-RING		without O-RING	
inch	dash	Nm	Lb.ft	Nm	Lb.ft
	size				
1/8	02	15	11	20	15
1/4	04	20	15	25	18
3/8	06	27	20	34	25
1/2	08	47	35	59	44
5/8	10	56	41	85	63
3/4	12	80	59	118	87
1	16	109	80	137	101
1 1/4	20	133	98	167	123
1 1/2	24	164	121	206	152
2	32	196	145	245	181

JIC 74°					
inch	dash	Nm	Nm	Lb.ft	Lb.ft
	size	min	max	min	max
7/16	04	15	17	11	13
1/2	05	19	22	14	16
9/16	06	27	30	20	22
5/8	07	40	45	30	33
3/4	08	59	65	44	48
7/8	10	68	79	50	58
1 1/16	12	107	119	79	88
1 3/16	14	128	140	94	103
1 5/16	16	158	170	117	125
1 5/8	20	215	237	159	175
1 7/8	24	254	288	187	212
2 1/2	32	339	384	250	283

SAE J518					
Code 61 Flange Half Bolt					
inch	dash	Nm	Nm	Lb.ft	Lb.ft
	size	min	max	min	max
1/2	08	15	19	11	14
3/4	12	21	29	15	21
1	16	27	35	20	26
1 1/4	20	35	46	26	34
1 1/2	24	46	58	34	43
2	32	54	66	40	49
2 1/2	40	79	91	58	67

SAE J518					
Code 62 Flange Half Bolt					
inch	dash	Nm	Nm	Lb.ft	Lb.ft
	size	min	max	min	max
1/2	08	15	19	11	14
3/4	12	25	33	18	24
1	16	42	50	31	37
1 1/4	20	62	75	46	55
1 1/2	24	116	133	86	98
2	32	199	216	147	159

Metric / Metric			
mm	dash	Nm	Lb.ft
	size		
M12-1.5	12	23	17
M14-1.5	14	26	19
M16-1.5	16	30	22
M18-1.5	18	41	30
M20-1.5	20	53	39
M22-1.5	22	76	56
M24-1.5	24	88	65
M26-1.5	26	106	78
M30-2	30	116	86
M36-2	36	133	98
M42-2	42	151	111
M45-2	45	173	128
M52-2	52	202	149

JIS 60°			
inch	dash	Nm	Lb.ft
	size		
1/4	04	25	18
3/8	06	34	25
1/2	08	59	44
5/8	10	85	63
3/4	12	118	87
1	16	137	101
1 1/4	20	167	123
1 1/2	24	206	152
2	32	245	181

ORFS			
inch	dash	Nm	Lb.ft
	size		
9/16	06	25	18
11/16	09	38	28
13/16	11	57	42
1	13	90	66
1 3/16	14	130	96
1 7/16	15	170	125
1 11/16	21	200	148
2 1/2	32	240	177

SAE Seal-Lok			
inch	dash	Nm	Lb.ft
	size		
1/4	04	10	12
3/8	06	18	20
1/2	08	32	35
5/8	10	46	50
3/4	12	65	70
1	16	92	100
1 1/4	20	125	140
1 1/2	24	130	165

Conversion Unit

unit	da	a	coeff.
	from	to	
lunghezza lenght	m metro meters	ft foot	3.281
lunghezza lenght	mm millimetro millimeters	n inch	0.03934
area	m ² metro quadro square meter	in ² square inch	1550
volume	l litro liters	gal gallon (UK)	0.264
peso mass	kg kilogrammo kilogramme	lb pound	2.205
coppia torque	N·m newton/metro newton/meters	lb/ft pound/foot	0.7374
velocità speed	m/s metro/secondo meters/second	ft/s feet per second	3.281
portata flow rate	l/min litro per minuto/liters per minute	gal/min gallon per minute	0.264
pressione pressure	bar (105N/m ²)	psi pound/square inch	14.503
temperatura temperature	C° celsius	°F fahrenheit	°C(9/5)+32

Pressure conversion factors

METRIC TO PSI			
1 kPa = 0.145 psi			
bar	Mpa	kPa	psi
40	4	4000	580
50	5	5000	725
60	6	6000	870
70	7	7000	1015
80	8	8000	1160
90	9	9000	1305
100	10	10000	1450
200	20	20000	2900
300	30	30000	4350
400	40	40000	5800
500	50	50000	7250
600	60	60000	8700
700	70	70000	10150
800	80	80000	11600
900	90	90000	13050
1000	100	100000	14500
2000	200	200000	29000
3000	300	300000	43500

PSI TO METRIC			
1 psi = 6.89 kPa			
psi	kPa	Mpa	bar
500	3445	3,4	34
600	4134	4,1	41
700	4823	4,8	48
800	5512	5,5	55
900	6201	6,2	62
1000	6890	6,9	69
2000	13780	13,8	138
3000	20670	20,7	207
4000	27560	27,6	276
5000	34450	34,5	345
6000	41340	41,3	413
7000	48230	48,2	482
8000	55120	55,1	551
9000	62010	62,0	620
10000	68900	68,9	689
20000	137800	137,8	1378
30000	206700	206,7	2067
40000	275600	275,6	2756

Thread Codes

	Gas BSP	Metric		Jic SAE / UN UNF	ORFS UN UNF UNS	NPTF
02	1/8"-28					1/8"-27
04	1/4"-19			7/16"-20		1/4"-18
05				1/2"-20		
06	3/8"-19			9/16"-18	9/16"-18	3/8"-18
07				5/8"-18		
08	1/2"-14			3/4"-16		1/2"-14
09					11/16"-16	
10	5/8"-14	M10x1	M10x1,5	7/8"-14		
11					13/16"-16	
12	3/4"-14	M12x1.5		1.1/16"-12		3/4"-14
13					1"-14	
14		M14x1.5		1.3/16"-12	1.3/16"-12	
15					1.7/16"-12	
16	1"-11	M16x1.5		1.5/16"-12		1"-11.1/2
18		M18x1.5				
20	1.1/4"-11	M20x1.5		1.5/8"-12		1.1/4"-11.1/2
21					1.11/16"-12	
22		M22x1.5				
24	1.1/2"-11	M24x1.5		1.7/8"-12		1.1/2"-11.1/2
26		M26x1.5				
30		M30x1.5	M30x2			
32	2"-11			2.1/2"-12	2"-12	2"-11.1/2
36		M36x1.5	M36x2			
38		M38x1.5				
40	2.1/2"-11					
42		M42x2				
45		M45x1.5	M45x2			
52		M52x1.5	M52x2			

ID hose size identification

SAE	ISO ref		R5	
dash	mm	inches	mm	inches
-2	3,2	1/8	-	-
-3	5	3/16	-	-
-4	6,4	1/4	4,8	3/16
-5	8	5/16	6,4	1/4
-6	10	3/8	7,9	5/16
-	-	13/32	-	-
-8	12,5	1/2	10,3	13/32
-10	16	5/8	12,7	1/2
-12	19	3/4	15,9	5/8
-14	-	7/8	-	-
-16	25	1	22,2	7/8
-	-	1,1/8	-	-
-20	31,5	1,1/4	28,6	1,1/8
-	-	1,3/8	-	-
-24	38	1,1/2	34,9	1,3/8
-	-	1,13/16	-	-
-32	51	2	46	1,3/16
-36	-	2,1/4	-	-
-40	64	2,1/2	60,3	2,3/8
-48	76	3	-	-
-56	89	3,1/2	-	-
-64	102	4	-	-

Chemical resistance table

Resistenza Resistance	Nome chimico Chemical name	NBR	CR	NBR/PVC	PTFE
Fluidi idraulici Petroleum based oil		1	3	2	1
Benzine diesel Diesel fuel		1	2	2	1
Emulsioni olio - acqua Emulsioni olio - acqua		1	1	1	1
Emulsioni acqua glicole Water glycol emulsions		1	1	1	1
Esteri fosforici Phosphate esters		5	4	4	1
Permeabilità gas Gas permeation		3	3	3	3
Res. Agenti atmosferici Weathering		5	2	2	1
Ozono/ Ozone		3	1	2	1
Calore/ Heat		3	3	3	1
Bassa temperatura Flame resistance		4	3	3	3
Resistenza alla fiamma Flame resistance		5	1	2	1
Bio oil		1	5	4	1

Legend/Legend:

1- Excellent

2- Very

3- Good

4- Sufficient

5- Poor

























These values are for guidance only and they are related to the hose liner. Several factors in working operations could affect hose service life. For details concerning specific fluid, contact IMM Technical department. The outer cover of the hose is intended to protect the reinforcement layer(s) from mechanical influences (abrasion, weathering, etc), cover compounds are not designed to exhibit the same chemical resistance as the tube compounds. I.M.M. Hydraulics should be consulted about the compatibility of the cover, should the application involve the extended exposure or immersion in a liquid: anyway the hydraulic hoses of the IMM product range are not designed in general for immersion in the service fluid. This type of special applications should be avoided or carefully studied with additional external protections for the hoses, selection of special hose types, e.g. with thermoplastic cover and validation on the specific application. The turbulence of the fluid, the high temperature and nature of the fluid as well as other elements may impact the properties or integrity of the hose cover material (the cover compound of the hose is designed to resist to oil drops and external agents, not immersion in the service fluid). For more detailed information contact I.M.M. Hydraulics.





















Polymer based compound:

NBR	TF50017 - TFE002K - TFD0021 - TFE001K - TFD0011 - TFA201K - TFA202K - TFS0006 - TFS0003 - TFD03TE - TFD02TE TF50004 - TFDH021B - TFDH011B - TFDL021N - TFDL011N - THE003K - THE002K - THD0021 - THE102K - THE101K TFEM02KN - TFDG4SH - TFDG015 - TFE0P10 - TFN002K - TFB002K - TFN001K - TFB001K - THE01K - THE012K TFDE011 - THE0M2K - TFS0005 - TFS00JG - THE001K
CR	TF5M013 - TFD45H - TFD45P - TFSM012 - TFD011B - TFSM015N - THM04SPN - THM04SHN
PTFE	TF00T1 - TF00TP1 - TF00T2 - TF00THP - TF00LTC

REFERENCE STANDARD	Max Working Pressure of main connections/Pressione Max di esercizio delle principali connessioni (design factor 4:1)							
	CONNECTION							
ISO 8434-6		Thread Size	1/8	1/4		3/8	1/2	5/8
	BSP 60° cone with o-ring	MAX WP		400		400	350	350
	BSP 60° cone without o-ring	MAX WP	350	350		350	315	315
ISO 8434-2	37° flared (JIC)	Thread size		7/16-20	1/2-20	9/16-18	3/4-16	7/8-14
		MAX WP		350	350	350	310	240
ISO 8434-3	O-ring face seal (ORFS)	Thread size		9/16-18	5/8-18	11/16-16	13/16-16	1-14
		MAX WP		630	630	630	630	400
ISO 8434-1	24° cone light series	Thread size	M12X1.5 (6L)	M14X1.5 (8L)	M16X1.5 (10L)	M18X1.5 (12L)	M22X1.5 (15L)	M26X1.5 (18L)
		MAX WP	415	400	350	330	275	250
	24° cone heavy series	Thread size	M16X1.5(8S)	M18X1.5 (10S)	M20X1.5 (12S)	M22X1.5 (14S)	M24X1.5 (16S)	M30X2 (20S)
		MAX WP	630	630	630	630	420	420
SAE J518 ISO 6162-1 ISO 6162-2		Flange size					1/2	
	Flanged 3000 PSI (Code 61)	MAX WP					350	
	Flanged 6000 PSI (Code 62)	MAX WP					420	
SAE J514	NPTF (dry seal pipe)	Thread size	1/8	1/4		3/8	1/2	5/8
		MAX WP	345	275		275	240	
JIS B 8363	BSP 60° inverted cone (Toyota)	Thread size		1/4		3/8	1/2	5/8
		MAX WP		345		345	345	275
	BSP 60° inverted cone (Komatsu)	Thread size		M14X1.5	M16X1.5	M18X1.5	M22X1.5	M24X1.5
		MAX WP		345	345	345	345	280

REFERENCE STANDARD	Max Working Pressure of main connections/Pressione Max di esercizio delle principali connessioni (design factor 4:1)							
	CONNECTION							
ISO 8434-6		Thread Size	3/4	1	1.1/4	1.1/2	2	
	BSP 60° cone with o-ring	MAX WP	315	250	200	160	125	
	BSP 60° cone without o-ring	MAX WP	250	200	160	125	80	
ISO 8434-2	37° flared (JIC)	Thread size	1.1/16-12	1.5/16-12	1.5/8-12	1.7/8-12	2-1/2-12	
		MAX WP	240	210	170	140	105	
ISO 8434-3	O-ring face seal (ORFS)	Thread size	1.3/16-12	1.7/16-12	1.11/16-12	2-12		
		MAX WP	400	400	250	250		
ISO 8434-1	24° cone light series	Thread size	M30X2 (22L)	M36X2 (28L)	M45X2 (35L)	M52X2 (42L)		
		MAX WP	215	165	125	100		
	24° cone heavy series	Thread size	M36X2 (25S)	M42X2 (30S)	M52X2 (38S)			
		MAX WP	420	420	420			
SAE J518 ISO 6162-1 ISO 6162-2		Flange size	3/4	1	1.1/4	1.1/2	2	
	Flanged 3000 PSI (Code 61)	MAX WP	350	350	280	210	210	
	Flanged 6000 PSI (Code 62)	MAX WP	420	420	420	420	420	
SAE J514	NPTF (dry seal pipe)	Thread size	3/4	1	1.1/4	1.1/2	2	
		MAX WP	210	170	150	140	140	
JIS B 8363	BSP 60° inverted cone (Toyota)	Thread size	3/4	1	1.1/4	1.1/2		
		MAX WP	275	205	170	105		
	BSP 60° inverted cone (Komatsu)	Thread size	M30x1.5	M33X1.5	M36X1.5	M42X1.5		
		MAX WP	280	205	170	105		

HOSE CHART																						
HOSE REFERENCE			Size	03	04	05	06	08	10	12	16	20	24	32	40	48	COVER		HOSE OPERATING TEMP			
			DN	5	6	8	10	12	16	19	25	31	38	51	63	78						
Hose		Code	Reference Standard	MAX WORKING PRESSURE [bar]													ABRASION RESISTANCE LEVEL		Temp Range [°C]			
International Standard	Hypress 1SN	TFD0011	EN 853-SAE 100R1AT-ISO 1436	250	225	215	180	160	130	105	88	63	50	40					-40 ÷ 100			
	Hypress 2SN	TFD0021	EN 853-SAE 100R2AT-ISO 1436	415	400	350	330	275	250	215	165	125	90	80					-40 ÷ 100			
	Hypress 1SC	TFE001K	EN 857-ISO 11237		225	215	180	160	130	105	88								-40 ÷ 120			
	Hypress 2SC	TFE002K	EN 857-SAE 100R16-ISO 11237		400	350	330	275	250	215	165								-40 ÷ 120			
	EASY K 1SC	TFA201K	EN 857-ISO 11237		225	215	180	160	130	105	88							STD	-40 ÷ 100			
	EASY K 2SC	TFA202K	EN 857-ISO 11237		400	350	330	275	250	215	165							STD	-40 ÷ 100			
	Hypress 4SP	TFDM4SP	EN 856-ISO 3862		450	445	415	350	280	210	185	165							MSHA	-40 ÷ 100		
	Hypress 4SP	TFD04SP	EN 856-ISO 3862		450	445	415	350	280	210	185	165							-40 ÷ 100			
	Hypress 4SH	TFDM4SP	EN 856-ISO 3862							420	385	350	300	250					MSHA	-40 ÷ 100		
	Hypress 4SH	TFD04SH	EN 856-ISO 3862							420	385	350	300	250					-40 ÷ 100			
	Hypress R12	TFDM012	EN 856-SAE 100R12-ISO 3862				280	280	280	280	280	210	176	176					MSHA	-40 ÷ 121		
	SAE 100R3	TFS0003	SAE 100R3-ISO 4079	103	86	83	78	69	60	52	39	26						STD	-40 ÷ 100			
	Hypress 2TE	TFD02TE	EN 854	80	75	68	63	58	50	45	40	35						STD	-40 ÷ 100			
	Hypress 3TE	TFD03TE	EN 854	160	145	130	110	93	80	70	55	45	40	33				STD	-40 ÷ 100			
	Unilock	TFS0006	SAE 100R6	34	28	28	28	28	24	21	12							STD	-40 ÷ 100			
	SAE 100R5	TFS0005	SAE 100R5		210	210	157	140	122	105	56	43	35	24				STD	-40 ÷ 100			
	Hypress R17	TFS0017	ISO 11237-SAE 10017	210	210	210	210	210	210	210	210								-40 ÷ 100			
Hypress R13	TFSM013	EN 856-SAE 100R13-ISO 3862							350	350	350	350	350					MSHA	-40 ÷ 121			
Hypress R15	TFSM015	SAE 100R15-ISO 3862							420	420	420	420	420					MSHA	-40 ÷ 121			
High performance	Compressor	TFDC011B	EN 853-SAE 100R2AT-ISO 1436		225	215	180	160	130	105	88	63	50	40				STD	-40 ÷ 135			
	HyCelsius 1SN	TFDH011	EN 853-SAE 100R1AT-ISO 1436		225	215	180	160	130	105	88	63	50	40				STD	-40 ÷ 135			
	HyCelsius 2SN	TFDH021	EN 853-SAE 100R2AT-ISO 1436		400	350	330	275	250	215	165	125	90	80	30			STD	-40 ÷ 135			
	HyFreeze 1SN	TFDL011	EN 853-SAE 100R1AT-ISO 1436		225	215	180	160	130	105	88	63	50	40				STD	-50 ÷ 100			
	HyFreeze 2SN	TFDL021	EN 853-SAE 100R2AT-ISO 1436		400	350	330	275	250	215	165	125	90	80				STD	-50 ÷ 100			
	HyOzone	TFEM02K	EN 857-SAE 100R16-ISO 11237		400	350	330	275	250	215	165								MSHA	-40 ÷ 120		
	Pilot	TFE0P10	IMM Specs	100	100	100	100	100											-40 ÷ 100			
	Pilot Plus 150	TFE0P15	IMM Specs	150	150	150	150	150											-40 ÷ 120			
	Kaizen 2SN	THD0021	EN 853-SAE 100R2AT-ISO 1436	420	420	360	350	290	250	215	175	140	125	90					-40 ÷ 120			
	Hipac 1SC	THE001K	EN 857-ISO 11237		250	250	250	200	150	150	110	100	90	75	50	40			-40 ÷ 120			
	Hipac 2SC	THE002K	EN 857-SAE 100R16-ISO 11237		430	400	350	310	280	240	210	160	150	100	80	65			-40 ÷ 120			
	Hipac 3SC	THE003K	IMM Specs			500	475	420	380	315									-40 ÷ 120			
	LongLife 1SC	THE101K	EN 857-ISO 11237		250	250	250	200	150	150									-40 ÷ 120			
	LongLife 2SC	THE102K	EN 857-SAE 100R16-ISO 11237		430	400	350	310	280	240	185								-40 ÷ 120			
	Marathon	THE0M2K	EN 857-SAE 100R16-ISO 11237		450	420	385	350	350	280	250								-40 ÷ 120			
	HyGreen R15	TFGD015	SAE 100R15-ISO 3862							420	420	420	420	420					-40 ÷ 121			
	Bio - Flex	THDB4SH	EN 856-ISO 3862							420									-40 ÷ 100			

HOSE CHART																				
HOSE REFERENCE			Size	03	04	05	06	08	10	12	16	20	24	32	40	48	COVER	HOSE OPERATING TEMP		
			DN	5	6	8	10	12	16	19	25	31	38	51	63	78				
Hose	Code	Reference Standard	MAX WORKING PRESSURE [bar]														ABRASION RESISTANCE LEVEL	Temp Range [°C]		
Jet 1SN/1SC	TFN0011/ TFN001K/ TFB0011/ TFB001K	ISO 7751		250	250	250	250										STD	-40 ÷ 135	Solution for applications	
Jet 2SN/2SC	TFN0021/ TFN002K/ TFB0021/ TFB002K	ISO 7751		400	400	400	400										STD	-40 ÷ 135		
Jet Plus 1SN/1SC	THN0011/ THN001K/ THB0011/ THB001K	ISO 7751		250	250	250	250										STD	-40 ÷ 135		
Jet Plus 2SN/ 2SC	THN0021/ THN002K/ THB0021/ THB002K	ISO 7751		400	400	400	400										STD	-40 ÷ 135		
SewerJet 280	TSWR280	ISO 7751				280	280		280	280	280							-40 ÷ 70		
Hyblast 10k	TFW0070	IMM Specs								700								-10 ÷ 70		
Hyblast 12k	TFW0085	IMM Specs		850		850	850		850	850								-10 ÷ 70		
Hyblast 15k	TFW0110	IMM Specs		1100		1100	1100		1000									-10 ÷ 70		
Hyblast 18k	TFW0125	IMM Specs				1250	1200											-10 ÷ 70		
Hyblast 20k	TFW0145	IMM Specs				1450	1450		1350									-10 ÷ 70		
LongLift 1SC	THL101K	EN 857-ISO 11237		250	250	250	200	150	150									-40 ÷ 120		
LongLift 2SC	THL102K	EN 857-SAE 100R16-ISO 11237		430	400	350	310	280	240	185								-40 ÷ 120		
LongLife Dual 1SC	T2E101K	EN 857-ISO 11237		250		250	250											-40 ÷ 120		
LongLife Dual 2SC	T2E102K	EN 857-SAE 100R16-ISO 11237		430		350	310											-40 ÷ 120		
Railway	TFDE011	EN 853*SAE 100R1AT-ISO 1436		225	215	180	160	130	105	88							STD	-40 ÷ 100		
Power Lift 1SC	THE0L1K	EN 81-20									50	50	45					-40 ÷ 100		
PowerLift 2SC	THE0L2K	EN 81-20										50	50					-40 ÷ 100		
HyJack	THE2J2K	IMM Specs		760	725													-40 ÷ 100		
SnowStorm 1SC	THEPS1K	IMM Specs									100	100	100					-40 ÷ 100		
Hytruck 200	TTRK200	IMM Specs								200	200							-40 ÷ 100		
Hytruck 250	TTRK250	IMM Specs								250	250							-40 ÷ 100		
Hytruck 350	TTRK300	IMM Specs								350	350							-40 ÷ 100		
MegaDrill	THEMMDR	EN 857-Mae 100R16-ISO 11237								350	350 (210)						 MSHA	-40 ÷ 100		
MegaJet	TFS04JG	IMM Specs									550	450	450	420				-40 ÷ 100		
MegaJet	THS00JG	IMM Specs									600	550	500	480				-40 ÷ 100		
BOP Firescre- en 5000	TBOP350	IMM Specs												350			STD	-40 ÷ 121		

1-Refer to dedicated section for extended Temperature Range information

2-UNMWPE cover available as alternative (MEGA COVER)

3-Ask technical office for cover different configuration request



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