

**Specializing in Smooth Bore PTFE Braided Hose
& Hose End Connections**

Toll-Free: (800) 877-6220
E-Mail orders to: sales@techflexhose.com / Fax orders to: (413) 592-0918
www.TechFlexHose.com

Size 3 PVC Jacketed Hose

Techflex Enterprises Introduces Size 3 PVC Jacketed Hose

Colors of examples shown below may not be precisely as viewed.
Available with either clear or opaque PVC jackets in a wide range of colors.

Please contact us for color samples in critical applications.

Minimum Quantities: 2,000 ft. per color.

Clear Blue PVC - CLRBLU



Clear PVC - CLRCLR



Clear Red PVC - CLRRED



Clear Green PVC - CLRGRN



Opaque Black PVC - OPQBLK



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Techflex Enterprises PTFE Smooth Bore Hose

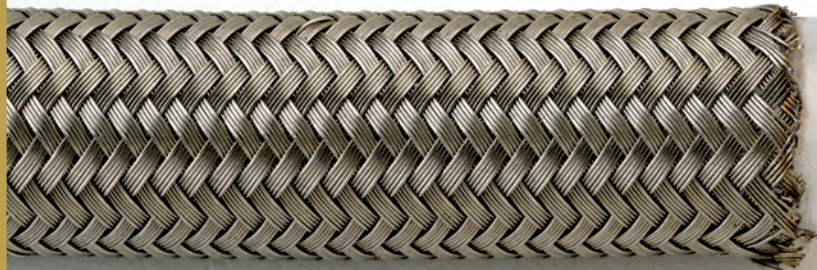
During the late 1930s at DuPont Laboratories, Polytetrafluoroethylene or PTFE was discovered. Since then, PTFE has proven to be a unique plastic for many varied applications.

At Techflex Enterprises our smooth bore PTFE tubing is reinforced with an outer braid of 304 stainless steel to produce a high quality hose that is:

- Flexible, strong and able to withstand thousands of flex cycles.
- Inert and resistant to most chemical attack with few exceptions.
- Heat resistant to a wide operating temperature range.

- -65°F to 450°F continuous service
- -100°F to 500°F intermittent service
- Non-sticking and non-wetting, providing for easier product flow, hose purging or cleaning.
- Ageless, PTFE is unaffected by weather, sunlight or time.
- Designed to meet your requirements.

Techflex Enterprises PTFE hose offers a solution to a variety of applications in the industrial, automotive, chemical, and pharmaceutical environments where temperature, chemical attack or risk of contamination restricts the use of alternative materials.



Hose Part Number	Hose Dash Size	Tube Wall (in.)	Average I.D. (in.)	Average O.D. (in.)	Working Pressure (psi)	70°F Burst Pressure (psi)	Min. Bend Radius (in.)*
S1003	-03	.040	0.125	0.250	3,000	12,000	1.5
S1004	-04	.040	0.187	0.320	3,000	12,000	1.7
S1005	-05	.040	0.250	0.375	3,000	12,000	2.5
S1006	-06	.040	0.312	0.435	2,500	10,000	3.5
S1008	-08	.043	0.406	0.565	2,000	8,000	5
S1010	-10	.047	0.500	0.656	1,500	6,000	6
S1012	-12	.047	0.625	0.780	1,250	5,000	7
S1016	-16	.047	0.875	1.030	1,000	4,000	9
S1016Z	-16	.047	0.875	1.100	1,250	5,000	7.3
S1020Z	-20	.050	1.125	1.350	1,000	4,000	11.0

* Bend Radius values at room temperature and static application.

Vacuum: Full vacuum for sizes -03 thru -12 at room temperature
(28 INCH/HG), -16 thru -20Z is (12 INCH/HG)

PVC coated hose: ask for availability

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Techflex Enterprises Fittings

Techflex Enterprises end fittings are permanently attached to the smooth bore PTFE hose by using a swaging or crimping process. Techflex Enterprises fittings incorporate a design that allows for multiple collars to be installed in alternating fashion on a random length of hose. The collars can then be paired and slid along the hose to be included with the desired hose length to be

cut. This method allows for greater ease of assembly and greater productivity.

Standard fitting materials are 300 series stainless steel, brass and carbon steel. Other materials may be available upon request.

B = Brass

Z = Carbon Steel

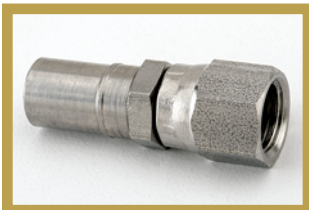
3 = 303 Stainless Steel

Male Pipe



Part Number	Hose Dash Size	Pipe Thread (NPT)	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TF102-03-x	-03	1/8-27	1.40	0.095	.96
TF102-04-x	-04	1/8-27	1.42	0.156	.98
TF104-04-x	-04	1/4-18	1.54	0.156	1.10
TF102-05-x	-05	1/8-27	1.42	0.201	1.10
TF104-05-x	-05	1/4-18	1.54	0.201	1.10
TF104-06-x	-06	1/4-18	1.62	0.265	1.10
TF106-06-x	-06	3/8-18	1.72	0.265	1.21
TF106-08-x	-08	3/8-18	1.90	0.359	1.28
TF108-08-x	-08	1/2-14	2.07	0.359	1.46
TF108-10-x	-10	1/2-14	2.16	0.453	1.49
TF112-12-x	-12	3/4-14	2.38	0.578	1.64
TF116-16-x	-16	1-11½	2.85	0.812	1.69
TF120-20-x	-20Z	1¼-11½	3.03	1.00	1.83

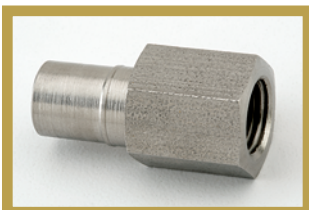
37°/45° Swivel



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TF603-03-x	-03	3/8-24	1.09	0.095	0.65
TF603-04-x	-03	7/16-20	1.11	0.156	0.67
TF604-04-x	-04	7/16-20	1.20	0.156	0.76
TF605-04-x	-05	7/16-20	1.20	0.201	0.76
TF605-05-x	-05	1/2-20	1.20	0.201	0.76
TF606-06-x ¹	-06	9/16-18	1.34	0.265	0.83
TF406-06-x ²	-06	5/8-18	1.34	0.265	0.83
TF608-08-x	-08	3/4-16	1.66	0.359	1.04
TF610-10-x	-10	7/8-14	1.69	0.453	1.02
TF612-12-x ¹	-12	1 1/16-12	1.91	0.578	1.17
TF412-12-x ²	-12	1 1/16-14	1.91	0.578	1.17
TF616-16-x	-16	1 5/16-12	2.34	0.812	1.18
TF616-16-x	-16Z	1 5/16-12	2.34	0.812	1.18
TF620-20-x	-20Z	1 5/8-12	3.30	1.00	2.064

¹ = 37° JIC seat ² = 45° SAE seat

Female Pipe

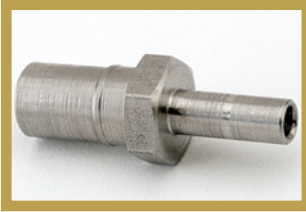


Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFF02-04-B	-04	1/8-27	1.17	0.156	0.73
TFF04-04-B	-04	1/4-18	1.17	0.156	0.73
TFF04-05-B	-05	1/4-18	1.17	0.201	0.73
TFF04-05-3	-05	1/4-18	1.17	0.201	0.73
TFF04-06-3	-06	1/4-18	1.34	0.265	0.83

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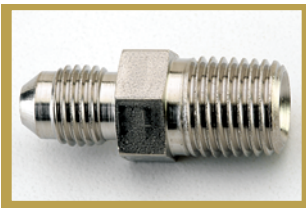
Techflex Enterprises Fittings

Tube End



Part Number	Hose Dash Size	Tube Size O.D. (in.)	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFT04-04-3	-04	1/4	1.61	0.156	1.17
TFT04-05-3	-05	1/4	1.61	0.180	1.17
TFT06-06-3	-06	3/8	1.75	0.265	1.23
TFT08-08-3	-08	1/2	2.17	0.359	1.56
TFT12-12-3	-12	3/4	2.35	0.578	1.61
TFT16-16-3	-16	1	2.743	0.812	1.153

Male Adapter JIC to NPT



Part Number	Hose Dash Size	JIC Thread	NPT Thread
TFMA02-03-3	-03	3/8-24	1/8-27
TFMA02-04-3	-04	7/16-20	1/8-27
TFMA04-04-3	-04	7/16-20	1/4-18
TFMA04-05-3	-05	1/2-20	1/4-18
TFMA06-06-3	-06	9/16-18	3/8-18
TFMA08-08-3	-08	3/4-16	1/2-14
TFMA10-10-3	-10	7/8-14	1/2-14
TFMA12-12-3	-12	1 1/16-12	3/4-14
TFMA16-16-3	-16	1 5/16-12	1-11 1/2

Power Trim



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFPT-90	-04	3/8-24	2.00	0.156	1.55
TFPT-00	-04	3/8-24	2.00	0.156	1.55

45° 90° SS Fitting



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TF90-04-3	-04	7/16-20	2.00	0.156	1.525
TF90-06-3	-06	9/16-18	2.20	0.265	1.70
TF90-08-3	-08	3/4-16	2.50	0.359	1.80
TF45-04-3	-04	7/16-20	2.70	0.156	2.25
TF45-06-3	-06	9/16-18	2.70	0.265	2.25
TF45-08-3	-08	3/4-16	3.30	0.359	2.70

Carbon Steel Paint Spray



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFPS	-05	1/4 NPSM	1.20	0.201	0.76

Laundry Flange



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFZ-TIRE FLANGE	-06			0.875	

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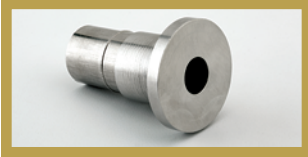
Techflex Enterprises Fittings

Laundry Flange Body



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFL06-06-B	-06		1.120	0.265	0.59

Flange Retainer



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TFFR-08	-08		2.43	0.359	1.43
TFFR-12	-12		2.43	0.578	1.43
TFFR-16	-16		2.58	0.812	1.50

Sanitary Tri-Clamp



Part Number	Hose Dash Size	Thread Size	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TF16-S16	-16		2.14	0.828	1.06

150 lb. ANSI Flange



Part Number	Hose Dash Size	# of Bolt Holes	Overall Length A (in.)	Nomical I.D. (in.)	Deduct Length D (in.)
TF1508	-08	4		3.50	2.38
TF1512	-12	4		3.88	2.75
TF1516	-16	4		4.25	3.12

Techflex Enterprises Smooth Bore Hose Assemblies

To order hose assemblies, provide the following:

1. Letter Prefix

TFB = Brass Fittings / TFZ = Carbon Steel Fitting
TF3 = Stainless Steel Fittings

2. Assembly Number

3. Length in Inches

Example: TFB905-82" (SS braided -5 hose with 1/2-20 Brass JIC Swivel each end 82" OAL.)

JIC Swivel x JIC Swivel

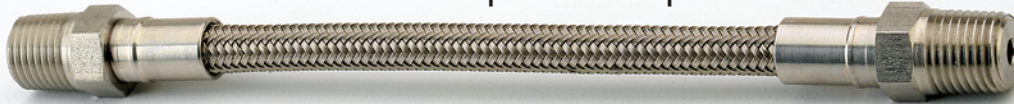


Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-3	5/32	TFx	903	3/8-24
-4	3/16	TFx	904	7/16-20
-5	1/4	TFx	905	1/2-20
-6	5/16	TFx	906	9/16-20
-8	11/32	TFx	908	3/4-16
-10	1/2	TFx	910	7/8-14
-12	5/8	TFx	912	1 1/16-12
-16	7/8	TFx	916	1 5/16-12
-16Z	7/8	TFx	916Z	1 5/16-12
-20Z	1.125	TFx	920Z	1 5/8-12

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Techflex Enterprises Smooth Bore Hose Assemblies

Male Pipe x Male Pipe



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-3	5/32	TFx	303	1/8-27
-4	3/16	TFx	304	1/8-27
-4	3/16	TFx	404	1/4-18
-5	1/4	TFx	305	1/4-18
-6	5/16	TFx	306	1/4-18
-6	5/16	TFx	406	3/8-18
-8	13/32	TFx	308	3/8-18
-8	13/32	TFx	408	1/2-14
-10	1/2	TFx	310	1/2-14
-12	5/8	TFx	312	3/4-14
-16	7/8	TFx	316	1-11.5
-16Z	7/8	TFx	316Z	1-11.5
-20Z	1.125	TFx	320Z	1 1/4-11.5

Male Pipe x JIC Swivel



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-3	5/32	TFx	103	1/8-27 - 3/8-24
-4	3/16	TFx	104	1/8-27 - 7/16-20
-4	3/16	TFx	204	1/4-18 - 7/16-20
-5	1/4	TFx	105	1/4-18 - 1/2-20
-6	5/16	TFx	106	1/4-18 - 9/16-18
-6	5/16	TFx	206	3/8-18 - 9/16-18
-8	13/32	TFx	108	3/8-18 - 3/4-16
-8	13/32	TFx	208	1/2-14 - 3/4-16
-10	1/2	TFx	110	1/2-14 - 7/8-14
-12	5/8	TFx	112	3/4-14 - 1 1/16-24
-16	7/8	TFx	116	1-11.5 - 1 5/16-12
-16Z	7/8	TFx	116Z	1-11.5 - 1 5/16-12
-20Z	1.125	TFx	120Z	1 1/4-11.5 - 1 5/8-12

Paint Spray

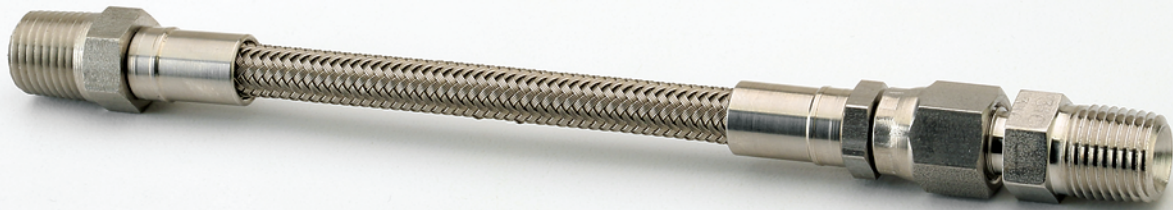


Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-5	1/4	TFx	P905	1/4-18 - 1/2-20

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Techflex Enterprises Smooth Bore Hose Assemblies

Male Pipe x Male Pipe Union



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-3	5/32	TFx	703	1/8-27 - 1/8-27
-4	3/16	TFx	704	1/8-27 - 1/8-27
-4	3/16	TFx	804	1/4-18 - 1/4-18
-5	1/4	TFx	705	1/4-18 - 1/4-18
-6	5/16	TFx	706	1/4-18 - 1/4-18
-6	5/16	TFx	806	3/8-18 - 3/8-18
-8	13/32	TFx	708	3/8-18 - 3/8-18
-8	13/32	TFx	808	1/2-14 - 1/2-14
-10	1/2	TFx	710	1/2-14 - 1/2-14
-12	5/8	TFx	712	3/4-14 - 3/4-14
-16	7/8	TFx	716	1-11.5 - 1-11.5
-16Z	7/8	TFx	716Z	1-11.5 - 1-11.5
-20Z	1.125	TFx	720Z	1 1/4-11.5 - 1 1/4-11.5

Male Pipe Union x Male Pipe Union



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-3	5/32	TFx	503	1/8-27 - 1/8-27
-4	3/16	TFx	504	1/8-27 - 1/8-27
-4	3/16	TFx	604	1/4-18 - 1/4-18
-5	1/4	TFx	505	1/4-18 - 1/4-18
-6	5/16	TFx	506	1/4-18 - 1/4-18
-6	5/16	TFx	606	3/8-18 - 3/8-18
-8	13/32	TFx	508	3/8-18 - 3/8-18
-8	13/32	TFx	608	1/2-14 - 1/2-14
-10	1/2	TFx	510	1/2-14 - 1/2-14
-12	5/8	TFx	512	3/4-14 - 3/4-14
-16	7/8	TFx	516	1-11.5 - 1-11.5
-16Z	7/8	TFx	516Z	1-11.5 - 1-11.5
-20Z	1.125	TFx	520Z	1 1/4-11.5 - 1 1/4-11.5

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Techflex Enterprises Smooth Bore Hose Assemblies

Tube End x Tube End



Hose Size	Hose ID	Prefix	Assembly Number	Tube Size
-4	3/16	TFx	1004	1/4 O.D.
-5	1/4	TFx	1005	1/4 O.D.
-6	5/16	TFx	1006	3/8 O.D.
-8	13/32	TFx	1008	1/2 O.D.
-12	5/8	TFx	1012	3/4 O.D.
-16	7/8	TFx	1016	1" O.D.
-16Z	7/8	TFx	1016Z	1" O.D.

Techflex Enterprises 304 Stainless Steel 90° and 45° Assemblies

90° x 90°



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TF90	01	7/16-20
-6	5/16	TF90	02	9/16-18
-8	13/32	TF90	03	3/4-16

90° x JIC Swivel

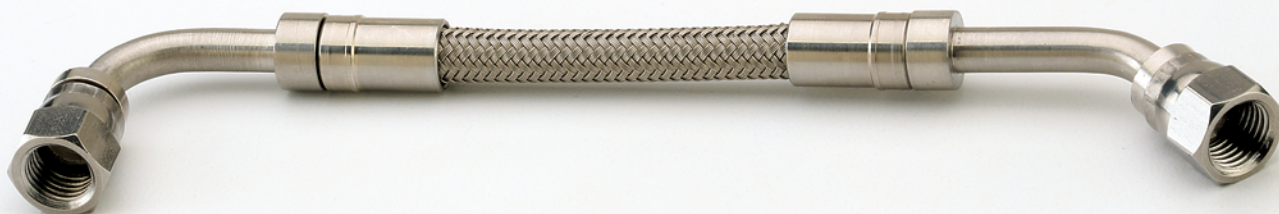


Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TF90	04	7/16-20
-6	5/16	TF90	05	9/16-18
-8	13/32	TF90	06	3/4-16

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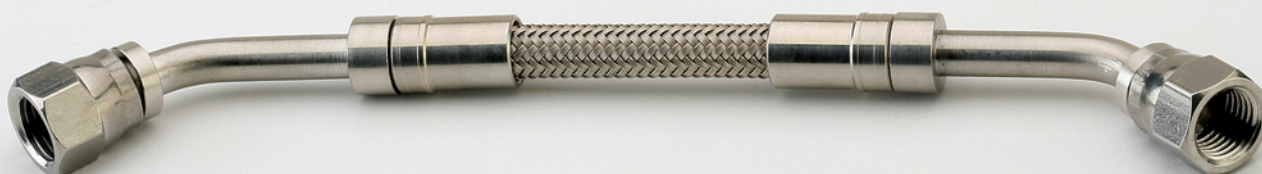
Techflex Enterprises 304 Stainless Steel 90° and 45° Assemblies

90° x 45°



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TF90	07	7/16-20
-6	5/16	TF90	08	9/16-18
-8	13/32	TF90	09	3/4-16

45° x 45°



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TF45	01	7/16-20
-6	5/16	TF45	02	9/16-18
-8	13/32	TF45	03	3/4-16

45° x JIC Swivel



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TF45	04	7/16-20
-6	5/16	TF45	05	9/16-18
-8	13/32	TF45	06	3/4-16

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Techflex Enterprises Power Trim Assemblies



Power Trim 90° x 90°

Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFTP90	01	3/8-24



Power Trim 90° x 00° (Straight)

Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFTP90	02	3/8-24 - 3/8-24



Power Trim 90° x JIC Swivel

Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFTP90	03	3/8-24 - 7/16-20



Power Trim 00° (Straight) x 00° (Straight)

Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFTP00	01	3/8-24 - 3/8-24



Power Trim 00° (Straight) x JIC Swivel

Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFTP00	02	3/8-24 - 7/16-20

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Techflex Enterprises Steam Iron Smooth Bore Assemblies

Techflex Enterprises Steam Iron lines offer all the advantages of Teflon® - flexibility, durability, temperature cycling, non-aging, plus our unique outer braid construction which combines stainless steel and Dacron®. The Dacron® cover offered on Techflex Enterprises steam iron hose assemblies is resistant to steam and deterioration from

moisture while also providing good abrasion resistance. Techflex Enterprises' readily available stock color is red.

Operating Temperature:
+400° F

Operating Pressure:
280 PSI @ 400° F



Standard Lengths **	Part Number
3 ft.	TF3-SISB
4 ft.	TF4-SISB
5 ft.	TF5-SISB
6 ft.	TF6-SISB
7 ft.	TF7-SISB
8 ft.	TF8-SISB
10 ft.	TF10-SISB
** For other lengths, consult factory.	

Teflon® is a registered trademark of DuPont. Dacron® is a registered trademark of DuPont.

Steam Temperatures Application Data					
Temperatures of Saturated Steam at Various Pressures					
Lbs / Sq In Pressure	Degrees Fahrenheit	Degrees Centigrade	Lbs / Sq In Pressure	Degrees Fahrenheit	Degrees Centigrade
0	212.0	100.0	210	391.6	199.8
30	274.1	134.5	235	400.7	204.8
60	307.4	153.0	240	402.5	205.8
90	331.2	166.2	245	404.2	206.8
120	350.0	176.7	250	406.1	207.8
150	365.9	185.5	280	415.7	213.2
180	379.6	193.1	300	421.0	216.1
200	387.9	197.7	350	436.5	224.7

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Techflex Enterprises Laundry Series Smooth Bore

Male Pipe x Male Pipe (Brass)



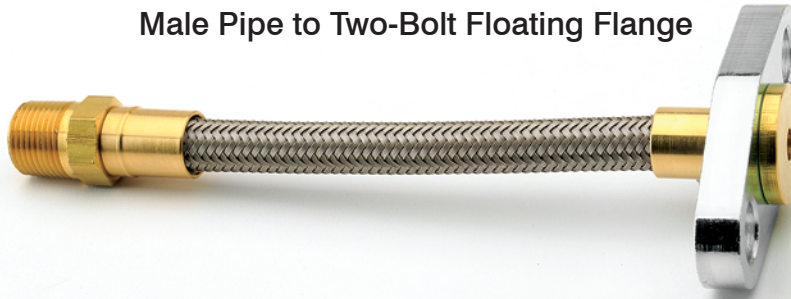
Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-6	5/16	TFB	306	1/4-18
-6	5/16	TFB	406	3/8-18

Male Pipe x Male Pipe Union (Brass)



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-6	5/16	TFB	706	1/4-18
-6	5/16	TFB	806	3/8-18

Male Pipe to Two-Bolt Floating Flange



Hose Size	Hose ID	Assembly Part Number	Thread Size
-6	5/16	TFLMF06-06 x Length	3/8 - 18

Two-Bolt Floating Flange Each End



Hose Size	Hose ID	Assembly Part Number	Thread Size
-6	5/16	TFLMF06-06 x 3/8' x Length	N/A

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Techflex Enterprises Female NPT Series

Female NPT x Female NPT



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFx	304FF	1/8-27
-4	3/16	TFx	404FF	1/4-18
-5	1/4	TFx	305FF	1/4-18
-6	5/16	TFx	306FF	1/4-18

Female NPT x Male NPT



Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFx	304MF	1/8-27 x 1/8-27
-4	3/16	TFx	404MF	1/4-18 x 1/4-18
-5	1/4	TFx	305MF	1/4-18 x 1/4-18
-6	5/16	TFx	306MF	1/4-18 x 1/4-18
-6	5/16	TFx	406MF	1/4-18 x 3/8-18

Female NPT x JIC Swivel

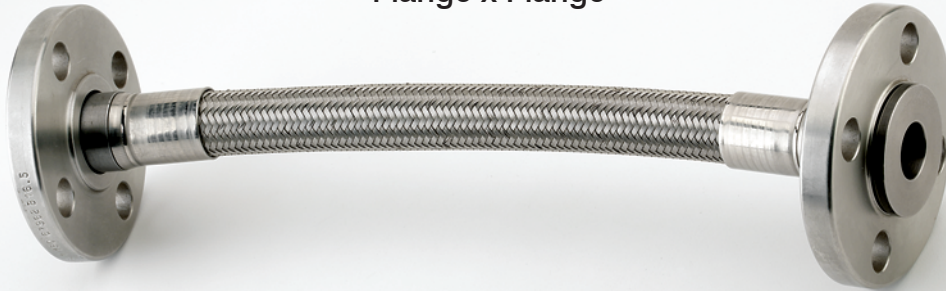


Hose Size	Hose ID	Prefix	Assembly Number	Thread Size
-4	3/16	TFx	304JF	1/8-27 x 7/16-20
-4	3/16	TFx	404JF	1/4-18 x 7/16-20
-5	1/4	TFx	305JF	1/4-18 x 1/2-20
-6	5/16	TFx	306JF	1/4-18 x 9/16-18
-6	5/16	TFx	406JF	1/4-18 x 5/8-18

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Techflex Enterprises Flange Retainer Smooth Bore

Flange x Flange



Hose Size	Hose ID	Assembly Part Number
-08	13/32	TFFR08 x Length
-12	5/8	TFFR12 x Length
-16	7/8	TFFR16 x Length

Flange x Male NPT

Hose Size	Hose ID	Assembly Part Number	Thread Size
-08	13/32	TFFRM08 x Length	1/2-14
-12	5/8	TFFRM12 x Length	3/4-14
-16	7/8	TFFRM16 x Length	1-11½

Flange x JIC Swivel

Hose Size	Hose ID	Assembly Part Number	Thread Size
-08	13/32	TFFRJ08 x Length	3/4-16
-12	5/8	TFFRJ12 x Length	1 1/16-12
-16	7/8	TFFRJ16 x Length	1 5/16-12



Sanitary Tri-Clamp Assembly (Tri-Clamp x Tri-Clamp)

Hose Size	Hose ID	Assembly Part Number
-16	7/8	TFTC16 x Length

Techflex Enterprises Specialty Services

Custom materials such as Aluminum, Inconel, Monel and Hastelloy 276 may be made per customer request. We offer outside braiding

services. Contact us in regard to any product that may not be found in this catalog.

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Ordering Hose Assemblies

For Hose Assemblies made to your order, follow the instructions below.

Base P/N	TFx	Assembly #	Overall Length
	1	2	3

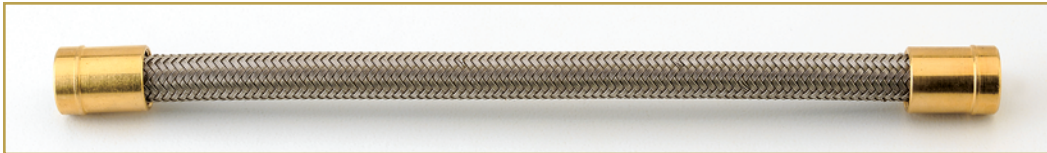
(1) TFx = TFB: Brass Fittings / TFZ: Carbon Steel Fittings / TF3: Stainless Steel Fittings

(2) Follow assembly charts for assembly number. (3) Overall Length (OAL) is always in INCHES.

Note: Critical measurements for JIC assemblies, measure Seat to Seat and note on purchase order.

Hose Assembly Procedures

1. Calculate the Hose Cut Length by subtracting the combined Fitting Deduct Lengths for the end fittings from the desired Finished Assembly Length.
2. Wrap masking tape around the hose at the approximate cutting location. Accurately mark the desired Hose Cut Length on the masking tape and cut the hose.
 - Masking tape is used to accurately mark the determined Hose Cut Length and to hold the braid wire in position during hose cutting.
 - Abrasive or steel cutting wheels provide satisfactory hose cuts.
3. Install both swage collars in alternate positions on the hose with the shoulder of each collar close to each hose end.



4. Install the correct Hose Expander (P/N: T200020-xx) in a rotary chuck. Slide the collar flush with the hose end and push the hose end fully onto the rotating Hose Expander. To prevent damage to the PTFE liner, the rotary chuck must not exceed 400 RPM. (See figures 1 and 2.)
5. Force the Insert Stem into the hose, all the way to the Stem Shoulder. Then, slide the Swage Collar to the main body of the Insert. (See figure 3.)

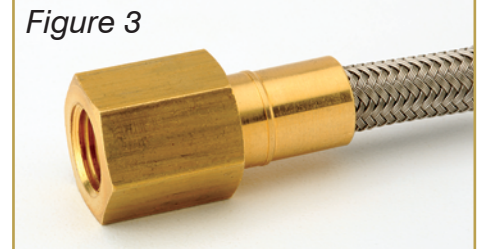
Figure 1



Figure 2



Figure 3



6. Lubricate the Swage Collar with Coconut Oil (*light film only*.)
7. Select the proper Swage Die set (P/N: TFSDx-xx). Install both Swage Die halves, including the prepared hose end, into the Die Base Plate (P/N: T2000017). (See figure 4.)
8. Place the required fitting Swage Stop (P/N: T200021-xx) on the swage die surface. (See figure 5.)
9. Energize the swaging ram face until it contracts the Swage Stop (swage is complete), then retract the ram. (See figure 6.)

Figure 4

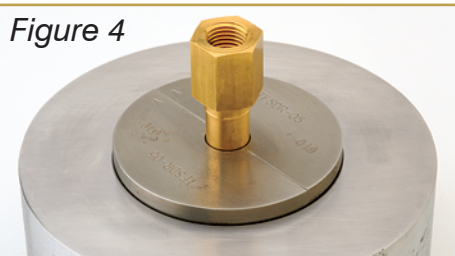


Figure 5

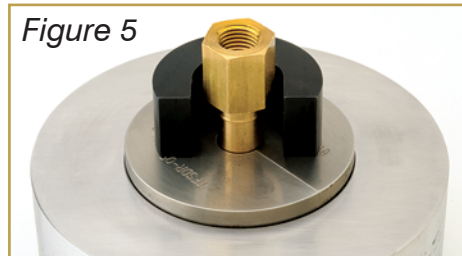
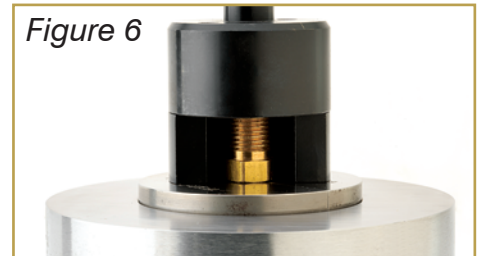


Figure 6

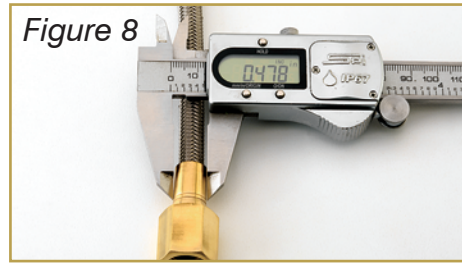
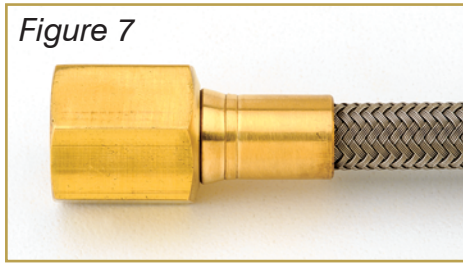


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Hose Assembly Procedures, continued

10. Remove the Swage Stop, then the Swage Die, from the base plate. Inspect the swaged end for possible defects. (See figure 7.)

11. Verify the correct Swage Diameter by measuring the Swaged Collar diameter directly next to the die-half segment lines. Be careful not to measure the raised lines. (See figure 8.)



.040 WALL PTFE Smooth Bore Hose Crimp Chart										
Hose Dash Size:	-03	-04	-05	-06	-08	-10	-12	-16	-16Z	-20Z
Swage Collar O.D. (in):*	0.308	0.382	0.468	0.533	0.632	0.739	0.883	1.194	1.194	1.423

* Swage Tolerance = +.004 / - .000; measured on the split die axis.
Replace Swage Die when measurement exceeds + .004.

12. Repeat steps 4 through 12 for the remaining hose end.

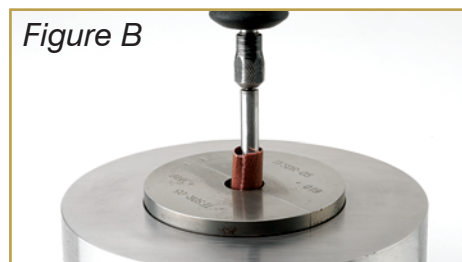
Swage Die Maintenance

Swaging problems are greatly reduced when a clean Swage Die is used. For proper cleaning, a strip of 500 grit emery or crocus cloth wrapped around a rotating arbor is recommended.

a. Place the Swage die to be cleaned in the Die Base plate.

b. Insert the 1/4" Cleaning Arbor (P/N: T200019) into a hand grinder or drill motor with the split end out.

c. Secure a strip of 500 grit paper in the split end of the Cleaning Arbor and wrap a small amount around the end of the arbor. (See figure A.)



d. Place the Cleaning Arbor with the emery cloth into the Swage Die and energize the motor. (See figure B.)

e. Oscillate the Cleaning Arbor within the Swage Die for approximately 5 seconds, then stop.

f. Remove the Swage Die halves from the Base Plate for inspection. The internal die surface should be cleaned to a near mirror finish.

g. Repeat the cleaning process when Swaged Collars begin to show a non-bright or matted surface finish.

Techflex Enterprises Tooling

Swage Die



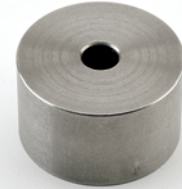
Part Number	Hose Dash Size
TFSDR-03	-03
TFSDR-04	-04
TFSDR-05	-05
TFSDR-06	-06
TFSDR-08	-08
TFSDR-10	-10
TFSDR-12	-12
TFSDR-16	-16
TFSDR-20	-20Z

Hose Expander



Part Number	Hose Dash Size
T200020-03	-03
T200020-04	-04
T200020-05	-05
T200020-06	-06
T200020-08	-08
T200020-10	-10
T200020-12	-12
T200020-16	-16
T200020-20	-20Z

Tube End Pusher



Part Number	Tube O.D. (in.)
T200023-04	1/4
T200023-06	3/8
T200023-08	1/2

Ram Face Plate (Coll-o-Crimp)



Part Number
T200016-06
T200016-12

Swage Stop



Part Number	NPT End	Swivel End
T200021-02	1/8	-03
T200021-04	1/4	-04, -05
T200021-06	3/8	-06, -06S
T200021-08	1/2	-08, -10
T200021-12	3/4	-12, -12S
T200021-16	1	-16

45° and 90° Fitting Swage Pusher



Part Number
T200018

1/8 NPT Pusher



Part Number
T200022

Ram Head Adapter (Coll-o-Crimp)



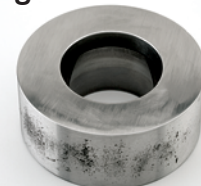
Part Number
T200015

Swage Die Polishing Arbor



Part Number
T200019

Swage Die Base Plate



Part Number
T200017

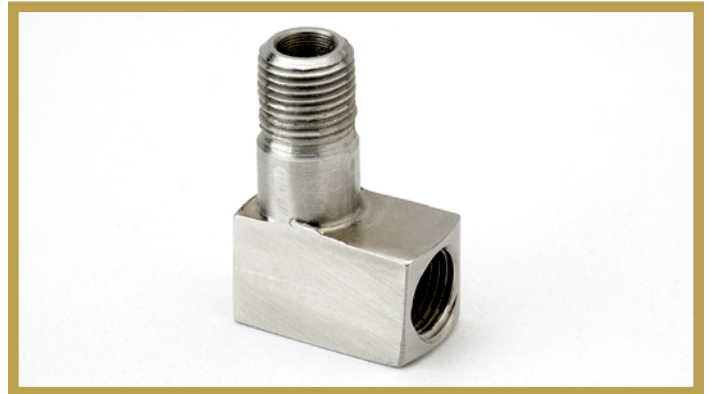
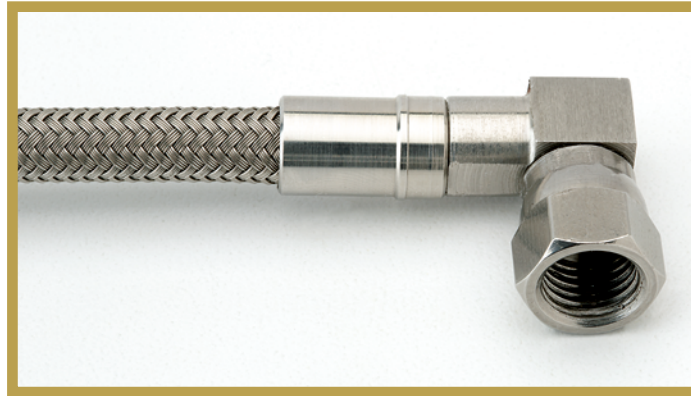
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Application Safety Information

This catalog is intended as a guide for selecting the proper hose and end fittings for conveying a variety of industrial gases and fluids. For steam or chemical applications that may cause injury, this product should be selected and handled by personnel trained in the safe handling of the materials being conveyed.

Intermixing of hose or fittings not specifically engineered by Techflex Enterprises may result in the fabrication of an unsafe hose assembly. Warranty of this product is contingent that only Techflex Enterprises fittings and hose are used and assembled using factory recommended tooling and procedures.

Manufactured in our Massachusetts facility, Techflex Enterprises fittings and hose are produced at the highest quality. Our braided hose inner core is produced using virgin PTFE with a 304SS outer braid. All fitting materials are RoHS2 compliant. Standard fitting materials are 303, 304, 316SS, Carbon Steel and Brass. Custom materials such as Aluminum, Inconel, Monel and Hastelloy 276 may be made per customer request. We offer outside braiding services. Techflex Enterprises has been an ISO compliant manufacturing facility since 2004.



The Techflex Warranty

Techflex Hose is warranted to be free from defects in materials and workmanship for a period of one year from the date of purchase.

This warranty applies to all Techflex hose that is properly used, installed, and maintained within the specified parameters.

For more warranty information, contact your sales representative.



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