

## Hyferset Pre-Setting Pressures for Ferulok Fittings<sup>1)</sup>

Tube Size	Wall Thickness — Steel							Wall Thickness — Stainless Steel						
	0.035	0.049	0.065	0.083	0.095	0.109	0.120	0.035	0.049	0.065	0.083	0.095	0.109	0.120
4	800	900	1,400	1,800	1,800	1,800		900	1,000	1,500	2,000	2,000	2,000	
6	900	1,400	800	2,000	2,000	2,000	2,200	1,000	1,500	2,000	2,000	2,000	2,000	2,500
8		1,600	2,000	2,500	2,700	3,000	3,200		1,800	2,200	3,000	3,000	3,500	3,500
10			2,200	2,700	3,000	3,500	3,500			2,500	3,000	3,500	4,000	4,000
12			2,700	3,000	3,500	3,500	4,000			3,000	3,500	4,000	4,000	4,500
14			3,000	3,500	3,500	4,000	4,500			3,000	4,000	4,000	4,500	5,000
16				3,500	4,000	4,500	5,000				4,500	4,500	5,000	5,000
18				4,000	4,500	4,500	5,000				4,500	5,000	5,000	5,500
20					4,500	5,000	5,500					5,000	6,000	6,000
24					5,500	6,000	7,000					6,500	7,000	7,000
28					7,000	7,500	8,000					7,500	8,000	8,500
32					8,500	9,000	10,000					9,500	10,000	10,000

Table V14 — Pre-Setting Pressures for Ferulok Fittings

1) Ferulok pre-setting dies are positive stop dies. Use of above pressures is optional.

## Hyferset Pre-Setting Pressures for EO Steel Fittings<sup>2)</sup>

Pre-Setting Pressures (psi) for EO2 Fittings					
Tube Size (mm)	Wall Thickness (mm)				
	1.0	1.5	2.0	2.5	3.0
6-L	650	650			
6-S	650	650			
8-L	900	900			
8-S	900	900			
10-L	1,350	1,350	1,550		
10-S	1,350	1,350	1,550		
12-L	1,750	1,750	1,750	1,750	
12-S	1,750	1,750	1,750	1,750	
14-S		2,000	2,000	2,200	2,200
15-L	1,800	1,800			
16-S		2,200	1,450	1,450	
18-L	2,000	2,000	2,000		
20-S			3,300	3,500	
22-L		3,100	3,100		
25-S				4,000	4,000
28-L		3,500	3,500		

Table V15 — Pre-Setting Pressures for EO Fittings

2) EO and EO-2 pre-setting dies are not positive stop style. Pre-setting must be done using pressures given in these charts.

## Hyferset Pre-Setting Pressures for EO-2 Steel Fittings<sup>2)</sup>

Hyferset Pre-Setting Pressures (psi) for EO-2 Fittings		
Size	Series	Any wall
6	L	1,150
6	S	1,150
8	L	1,450
8	S	1,450
10	L	2,450
10	S	2,450
12	L	2,800
12	S	2,800
14	S	3,500
15	L	2,800
16	S	3,900
18	L	3,200
20	S	5,600
22	L	4,950
25	S	6,400
28	L	5,600

Table V16 — Pre-Setting Pressures for EO-2 Fittings

2) EO and EO-2 pre-setting dies are not positive stop style. Pre-setting must be done using pressures given in these charts.

Dimensions and pressures for reference only, subject to change.