

Minikrimp™

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Features

- Light weight, portable, compact all-in-one unit
- Handpump or air over hydraulic design
- Removable pusher design for easy die change out
- Reference page C-20 for information on available power units
- For use with 25, 26, 43, 81, and HY Series fittings
- Do not crimp stainless steel fittings

Specifications

- Dimensions: 6" wide, 13" deep, 15" high
- Weight: 42 lbs (with hand pump)
- Rating: 30 ton force @ 10,000 psi maximum
- Full Cycle Time: 30 seconds

Important

The Minikrimp was developed by Parker Hannifin Parflex Division but is compatible with Parker Hannifin Hose Products Division products. Refer to Crimpsource™ on www.parker.com/crimpsource (the online resource for hose crimp specifications for the complete line of Parker crimping machines). Any engineering and crimper performance issues pertaining to the Minikrimp should be directed to the Parflex Division, Technical Services Department, at (330) 296-2871 or fax, at (330) 296-8433.

Standard Equipment

Part Number		Description	Individual Part Number
94C- 001-PFD	94C- 002 -PFD		
●	●	Base unit	94C-080-PFD
●		Hand pump	015301
	●	Air over hydraulic pump kit with tubing and adapters	025411
●	●	Silver die ring	82C-R01-PFD

Optional Tooling

- Side Vise Mount (015736)
- Upright Table Mount (015306)
- Upright Vise Mount (015307)
- Black Die Ring (82C-R02-PFD)
- Connection Hose with Quick Coupling (015309)
- Bent Tube for Hand Pump Only (015308)
- Bent Tube for Air Over Hydraulic Pump Only (025349)

Note:

- For crimp instructions, see pages C-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.



Minikrimp™ Hose Die Selection Chart

Hose 7/08	Fittings	Hose/Die Selection and Crimp Diameters 7/08							Die Ring	
		-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK		
Die		80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16		
351TC 431 471ST 351ST 436 472TC 422 451TC 482T 424 451ST 482ST 426 471TC	43 Series	0.645	0.710	0.825	0.945	1.060	1.245	1.590	Silver	
		0.665	0.730	0.845	0.965	1.080	1.265	1.610		
421WC 304 601 302/301 341 604 301LT 381 881			0.685	0.750	0.865	0.985	1.100	1.285	1.630	Black
		0.705	0.770	0.885	1.005	1.120	1.305	1.650		
Die			80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	
213 285 293	26 Series	0.460	0.520	0.575	0.670	0.805	0.915	1.175	Silver	
		0.480	0.540	0.595	0.690	0.825	0.935	1.195		
201 225 266 206 244 221FR		0.500	0.560	0.615	0.710	0.845	0.955	1.215	Black	
	0.520	0.580	0.635	0.730	0.865	0.975	1.235			
Die							80C-V12	80C-V16		
811 811HT 881	81 Series						1.155 1.175	1.450 1.470	Silver	
Die		80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120			
AX	HY Series	0.595		0.745	0.850	0.980	1.130		Silver	
		0.575		0.725	0.830	0.960	1.110			
Die			80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170		
BXX		0.655		0.825	0.935	1.060	1.220		Black	
		0.635		0.805	0.915	1.040	1.200			



Parker Hannifin Corp.
Hose Products Division
30240 Lakeland Blvd.
Wickliffe, Ohio 44092

Caution: Read the operations and technical manual before attempting to operate this machinery. Keep hands clear of moving parts when operating machine.

NOTE: Do not use this machine to assemble stainless steel fittings with any hose listed on this chart

For a new decal, contact Parker at: 1-800-C-PARKER.

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Karrykrimp



Features

- Portable, compact rugged design
- Numerous power unit options available
- Pivoting pusher design for easy die change out
- For use with 25, 26, 43, 81, and HY Series fittings

Specifications

- Dimensions: 15" wide, 12" deep, 27" high
- Weight: 54 lbs (without power unit)
- Rating: 30 ton force @ 10,000 psi maximum
- Full Cycle Time: 30 seconds with electric pump
- Reference page C-20 for information on available power units

Standard Equipment

Part Number				Description	Individual Part Number
82C-001	82C-002	82C-061	82C-080		
●	●	●	●	Karrykrimp portable crimper (base unit)	82C-080
●	●	●	●	2 piece stand	832021
●				Hand pump	82C-OHP
●	●	●		Connection hose with quick coupling	82C-00L
●	●	●		Silver die ring	82C-R01
●	●	●		Black die ring	82C-R02
●	●			43 Series dies (sizes 1/4", 3/8", 1/2", 3/4" and 1")	80C-Axx

Parkrimp 1



Features

- Compact bench mount design
- Engineered for optimal durability
- All in one crimper and power unit design
- For use with 25, 26, 43, 81, and HY Series fittings

Specifications

- Dimensions: 26" wide, 20" deep, 25" high
- Weight: 275 lbs (with power unit)
- Rating: 30 ton force @ 3,000 psi maximum
- Full Cycle Time: 20 seconds
- Hydraulic Fluid: AW32 oil
- **Note:** Includes a 115/230 volt, 1 phase, 60 hertz power unit wired for 115V. This unit comes with a 20 AMP male plug and must be run on a dedicated 20 AMP circuit.

Standard Equipment

Part Number			Description	Individual Part Number
80C-101	80C-061	80C-181		
●	●	●	Parkrimp 1 crimper with 115/230 volt, 1 phase, 60 Hz power unit wired for 115V	80C-181
●	●		Silver die ring	80C-R01
●	●		Black die ring	80C-R02
●			43 Series dies (sizes 1/4", 3/8", 1/2", 3/4" and 1")	80C-Axx

Note:

- For crimp instructions, see pages C-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.



Parkrimp 1/Karrykrimp Hose Die Selection Chart

PN: PK1/KK HOSE DECAL Hose 7/08			Fittings	Hose/Die Selection and Crimp Diameters						PN: PK1/KK MASTER DECAL 8/07		Die Ring
Die				-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	
Die				80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	
351TC	431	471ST	43 Series									
351ST	436	472TC		0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	Silver
422	451TC	482TC		0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990	
424	451ST	482ST										
426	471TC											
421WC	304	601		0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	Black
302/301	341	604	0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030		
301LT	381	881										
Die				80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16		
213	285	293	26 Series	0.460	0.520	0.575	0.670	0.805	0.915	1.175		Silver
				0.480	0.540	0.595	0.690	0.825	0.935	1.195		
201	221FR	266		0.500	0.560	0.615	0.710	0.845	0.955	1.215		Black
206	225	CAH	0.520	0.580	0.635	0.730	0.865	0.975	1.235			
Die								80C-V12	80C-V16	80C-V20		
811	811HT	881	81 Series					1.155	1.450	1.740	Silver	
									1.175	1.470		1.760
Die				80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120			
AX			HY Series	0.575		0.725	0.830	0.960	1.110		Silver	
				0.595		0.745	0.850	0.980	1.130			
Die					80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170		
BXX				0.635		0.805	0.915	1.040	1.200		Black	
				0.655		0.825	0.935	1.060	1.220			



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Caution: Read the operations and technical manual before attempting to operate this machinery. Do not operate this machine without guard in place. Keep hands clear of moving parts when operating machine.

NOTE: Do not use these machines to assemble 341-20, 451TC-20, 451ST-20 or any size stainless steel fittings.

For a new decal, contact Parker at: 1-800-C-PARKER.

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Karrykrimp 2



Features

- Portable, compact rugged design
- Numerous power unit options available
- Crimps both steel and stainless steel fittings
- For use with 25,26, 43, 70, 71, 73, 78, 81, and HY Series fittings

Specifications

- Dimensions: 14" wide, 15" deep, 30" high
- Weight: 100 lbs (without power unit)
- Rating: 60 ton force @ 10,000 psi maximum
- Full Cycle Time: 20 seconds with electric pump
- Reference page C-20 for information on available power units

Standard Equipment

Part Number	Description	Individual Part Number
85C-061		
●	Karrykrimp 2 portable crimper (base unit)	85C-080
●	2 piece stand	85C-STD
●	Connection hose with quick coupling	85C-00L
●	Silver die ring	85C-R01
●	Black die ring	85C-R02

Optional Tooling

- Die Kit (85C-KDA) Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1" and 1-1/4" and 70/71 Series dies in sizes 3/8", 1/2", 3/4", 1", 1-1/4" **ONLY**.

Note:

- For crimp instructions, see pages C-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.

PHastkrimp



Features

- Fast bench mounted unit
- Push button power on demand design
- Crimps both steel and stainless steel fittings
- For use with 25, 26, 43, 70, 71, 73, 78, 81, and HY Series fittings

Specifications

- Dimensions: 24" wide, 33" deep, 38" high
- Weight: 550 lbs
- Rating: 60 ton force @ 4,200 psi maximum
- Full Cycle Time: 6 seconds
- Hydraulic Fluid: AW32 oil
- **Note:** The 230VAC, 3 phase, 60 Hz power unit can be rewired to 460VAC by a qualified electrician

Standard Equipment

Part Number		Description	Individual Part Number
89C-061	89C-062		
●		PHastkrimp crimper with 230VAC, 3 phase, 60 Hz power unit wired for 230 volts	
	●	PHastkrimp crimper with 230VAC, 1 phase, 60 Hz power unit wired for 230 volts	
●	●	Silver die ring	85C-R01
●	●	Black die ring	85C-R02

PHastkrimp/Karrykrimp 2 Hose Die Selection Chart

PN: PH1/KK2 HOSE DECAL Hose 7/08	Fittings	Hose/Die Selection and Crimp Diameters								PN: PH/KK2 MASTER DECAL 8/07	Die Ring
		- 4 RED 80C-A04	- 5 PUR 80C-A05	- 6 YEL 80C-A06	- 8 BLU 80C-A08	- 10 ORG 80C-A10	- 12 GRN 80C-A12	- 16 BLK 80C-A16	- 20 WHT 80C-A20		
Die				83C-D06	83C-D08	83C-D10					
351TC 431 471ST 351ST 436 472TC 422 451TC 482TC 424 451ST 482ST 426 471TC	43 Series	0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	Silver	
		0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990		
421WC 304 601 302/301 341 604 301LT 381 881	43 Series	0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	Black	
		0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030		
Die				83C-D06	83C-D08	83C-D10					
701 F42 (-8 ONLY)	70 Series			0.990 1.010	1.140 1.160	1.260 1.280				Black	
Die				83C-D06	83C-D08	83C-D10	83C-D12	83C-D16	83C-D20		
711 721ST 772ST 721 772TC 774 721TC	71 Series			0.950 0.970	1.100 1.120	1.220 1.240	1.355 1.375	1.695 1.715	2.025 2.045	Silver	
Die							80C-L12	80C-L16			
731	73 Series						1.420 1.440	1.730 1.750		Silver	
Die							80C-L12	80C-L16			
78C 781 782ST 782TC	78 Series						1.420 1.440	1.730 1.750		Silver	
Die		80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16			
213 285 293	26 Series	0.460 0.480	0.520 0.540	0.575 0.595	0.670 0.690	0.805 0.825	0.915 0.935	1.175 1.195		Silver	
201 221FR 266 206 225 CAH 244 SS25UL			0.500 0.520	0.560 0.580	0.615 0.635	0.710 0.730	0.845 0.865	0.955 0.975	1.215 1.235		Black
Die							80C-V12	80C-V16	80C-V20		
811 811HT 881	81 Series						1.155 1.175	1.450 1.470	1.740 1.760	Silver	
Die		80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120	80C-H1365			
AX	HY Series	0.575 0.595		0.725 0.745	0.830 0.850	0.960 0.980	1.110 1.130	1.355 1.375		Silver	
Die			80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170	80C-H1465		
BXX	HY Series	0.635 0.655		0.805 0.825	0.915 0.935	1.040 1.060	1.200 1.220	1.495 1.515		Black	



Parker Hannifin Corp.
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Caution: Read the operations and technical manual before attempting to operate this machinery. Do not operate this machine without guard in place. Keep hands clear of moving parts when operating machine.

NOTE: 1. Stainless steel crimpers diameters are 0.010" greater than table listings with the exception of stainless steel HY series fitting which are 0.005" greater than the table listings. 2. Do not use lubricant to assemble spiral hose and fittings.

For a new decal, contact Parker at: 1-800-C-PARKER.

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Superkrimp



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Features

- Easy to use table top design
- Engineered for optimal durability
- Crimps both steel and stainless steel fittings
- For use with 25, 26, 43, 70, 71, 73, 76, 78, 79, 81, and HY Series fittings

Specifications

- Dimensions: 20" wide, 31" deep, 41" high
- Weight: 600 lbs
- Rating: 70 ton force @ 5,000 psi maximum
- Full Cycle Time: 20 seconds without adapter bowl
15 seconds with adapter bowl
- Hydraulic oil: Enerpac oil

Standard Equipment

Part Number		Description	Individual Part Number
88C-081	88C-082		
●		Superkrimp crimper with 230/460 volt, 3 phase, 50/60 Hz power unit wired for 230 volts	
	●	Superkrimp crimper with 230/460 volt, 1 phase, 50/60 Hz power unit wired for 230 volts	
●	●	Adapter bowl	83C-OCB
●	●	Spacer ring	83C-R02
●	●	Spacer Plate	83C-R02H

Optional Tooling

- Die Kit (88C-KDA)

Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1" and 1-1/4" and 70/71 Series dies in sizes 3/8", 1/2", 3/4", 1", 1-1/4" and 1-1/2" **ONLY**.

Note:

- For crimp instructions, see pages C-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.



Superkrimp Hose Die Selection Chart

PN: SK HOSE DECAL 7/08 Hose	Fittings	Die Selection and Crimp Diameters						PN: SK MASTER DECAL 8/07			
		-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	-24 RED	-32 GRN
Die		80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	83C-A24	83C-A32
351TC 431 471ST 351ST 436 472TC 422 451TC 482TC 424 451ST 482ST 426 471TC	43 Series	0.645	0.710	0.825	0.945	1.060	1.245	83C-A16H	83C-A20H	2.290	2.735
Tools Required		Small Silver Die (80C-AXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-AXX)			
421WC 304 601 302/301 341 604 301LT 381 881		0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	2.330	2.775
Tools Required		Spacer Ring (83C-R02), Small Silver Die (80C-AXX), and Adapter Bowl (83C-OCB)						Spacer Plate (83C-R02H) and Large Silver Die (83C-AXX)			
701 F42 (-8 ONLY)	70 Series	83C-D06		83C-D08	83C-D10						
Tools Required		0.990	1.140	1.260	Spacer Ring (83C-R02), Small Black Die (83C-DXX), and Adapter Bowl (83C-OCB)						
711 721ST 772ST 721 772TC 774	71 Series	83C-D06		83C-D08	83C-D10	83C-D12	83C-D16	83C-D20	83C-D24		
Tools Required		0.950	1.100	1.220	1.355	1.695	2.025	2.290	Large Black Die (83C-AXX)		
731	73 Series						83C-L12	83C-L16			
Tools Required							Large Olive Drab (83C-LXX)				
761	76 Series						83C-U12	83C-U16			
Tools Required							Large Silver Die (83C-UXX)				
78C 781 782ST 782TC	78 Series						83C-L12	83C-L16	83C-L20		
Tools Required							Large Olive Drab (83C-LXX)				
791TC 792TC F42 792ST	79 Series						83C-L12	83C-L16			
Tools Required							Large Olive Drab Die (83C-LXX)				
213 285 293	26 Series	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	83C-E20	83C-E24	83C-E32
Tools Required		0.460	0.520	0.575	0.670	0.805	0.915	1.175	1.420	1.670	2.160
201 221FR 266 206 225 CAH 244 SS25UL		0.480	0.540	0.595	0.690	0.825	0.935	1.195	1.440	1.690	2.180
Tools Required		Small Silver Die (80C-EXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-EXX)			
811 811HT 881	81 Series						80C-V12	80C-V16	80C-V20	83C-V24	83C-V32
Tools Required							Small Silver Die (80C-VXX) and Adapter Bowl (83C-OCB)		Large Silver Die (83C-VXX)		
AX	HY Series	80C-H585	80C-H735	80C-H840	80C-H970	80C-H1120	80C-H1365				
Tools Required		0.575	0.725	0.830	0.960	1.110	1.355				
Die		0.595	0.745	0.850	0.980	1.130	1.375				
BXX		80C-H605	80C-H775	80C-H885	80C-H1010	80C-H1170	80C-H1465				
Tools Required	0.635	0.805	0.915	1.040	1.200	1.495					
		0.655	0.825	0.935	1.060	1.220	1.515				
Tools Required	Spacer Ring (83C-R02), Small Silver Die (80C-HXXX or 80C-HXXXX), and Adapter Bowl (83C-OCB)										

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Caution: Read the operations and technical manual before attempting to operate this machinery. Do not operate this machine without guard in place. Keep hands clear of moving parts when operating machine.



NOTE: 1. The 83C-R12 split die ring is used for all crimping operations. 2. Stainless steel crimper diameters are 0.010" greater than table listings with the exception of stainless steel HY series fitting which are 0.005" greater than the table listings. 3. Do not use lubricant to assemble spiral hose and fittings.

For a new decal, contact Parker at: 1-800-C-PARKER.



Parkrimp 2



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Features

- Easy to use vertical design
- Crimps full range of Parker hoses from 1/4" through 2" I.D.
- Crimps both steel and stainless steel fittings
- For use with 25, 26, 43, 70, 71, 73, 76, 78, 79, 81, S6 and HY Series fittings

Specifications

- Dimensions: 31" wide, 24" deep, 77" high
- Weight: 842 lbs (Head is 558 lbs and base is 284 lbs)
- Rating: 125 ton force @ 5,000 psi maximum
- Full Cycle Time: 30 seconds without adapter bowl
20 seconds with adapter bowl
- Hydraulic oil: Enerpac oil

Standard Equipment

Part Number				Description	Individual Part Number
83C-001	83C-081	83C-002	83C-082		
●	●	●	●	Parkrimp 2 crimper head assembly	83C-080
●	●			Parkrimp 2 stand assembly with 230/460 volt, 3 phase, 50/60 Hz power unit (wired for 230 volt)	83C-S40
		●	●	Parkrimp 2 stand assembly with 230 volt, 1 phase, 50/60 Hz power unit	83C-S20
●	●	●	●	Adapter bowl	83C-OCB
●	●	●	●	Spacer ring	83C-R02
●	●	●	●	Spacer Plate	83C-R02H
●		●		Die Kit Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1", 1-1/4" dies and 70/71 Series dies in sizes 3/8", 1/2", 3/4", 1", 1-1/4", 1-1/2", 2" ONLY	83C-KDA

Note:

- For crimp instructions, see pages C-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.



Parkrimp 2 Hose Die Selection Chart

PN: PK2 HOSE DECAL 7/08 Hose	Fittings	Die Selection and Crimp Diameters										PN: PK2 MASTER DECAL 5/08	
		- 4 RED	- 5 PUR	- 6 YEL	- 8 BLU	- 10 ORG	- 12 GRN	- 16 BLK	- 20 WHT	- 24 RED	- 32 GRN		
Die		80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	80C-A24	80C-A32		
351TC 431 471ST 351ST 436 472TC 422 451TC 482TC 424 451ST 482ST 426 471TC	43 Series	0.645	0.710	0.825	0.945	1.060	1.245	83C-A16H	83C-A20H	2.290	2.735		
Tools Required		Small Silver Die (80C-AXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-AXX)					
421WC 304 601 302/301 341 604 301LT 381 881		0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	2.330	2.775		
Tools Required		Spacer Ring (83C-R02), Small Silver Die (80C-AXX), and Adapter Bowl (83C-OCB)						Spacer Plate (83C-R02H) and Large Silver Die (83C-AXX)					
701 F42 (-8 ONLY)	70 Series		83C-D06	83C-D08	83C-D10								
Tools Required			0.990	1.140	1.260								
			1.010	1.160	1.280								
Tools Required		Spacer Ring (83C-R02), Small Black Die (83C-DXX), and Adapter Bowl (83C-OCB)											
711 721ST 772ST 721 772TC 774	71 Series		83C-D06	83C-D08	83C-D10	83C-D12	83C-D16	83C-D20	83C-D24	83C-D32			
Tools Required			0.950	1.100	1.220	1.355	1.695	2.025	2.290	2.775			
			0.970	1.120	1.240	1.375	1.715	2.045	2.310	2.795			
Tools Required		Small Black Die (83C-DXX) and Adapter Bowl (83C-OCB)						Large Black Die (83C-AXX)					
731	73 Series					83C-L12	83C-L16	83C-L20	83C-L24	83C-L32			
Tools Required						1.420	1.730	2.140	2.440	3.025			
						1.440	1.750	2.160	2.460	3.045			
Tools Required								Large Olive Drab (83C-LXX)					
761	76 Series					83C-U12	83C-U16						
Tools Required						1.540	1.865						
						1.560	1.885						
Tools Required								Large Silver (83C-UXX)					
P35/78C 781 782ST 782TC	78/S6 Series					83C-L12	83C-L16	83C-L20	83C-L24	83C-L32			
Tools Required						1.420	1.730	2.140	2.440	3.025			
						1.440	1.750	2.160	2.460	3.045			
Tools Required		*S6 Series Fittings to be used on P35-32 Only						Large Olive Drab (83C-LXX)					
791TC 792TC F42 792ST	79 Series					83C-L12	83C-L16	83C-L20	83C-L24				
Tools Required						1.420	1.730	2.140	2.440				
						1.440	1.750	2.160	2.460				
Tools Required								Large Olive Drab (83C-LXX)					
213 285 293	26 Series	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	83C-E20	83C-E24	83C-E32		
Tools Required		0.460	0.520	0.575	0.670	0.805	0.915	1.175	1.420	1.670	2.160		
		0.480	0.540	0.595	0.690	0.825	0.935	1.195	1.440	1.690	2.180		
201 221FR 266 206 225 CAH 244 SS25UL		Small Silver Die (80C-EXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-EXX)					
Tools Required		0.500	0.560	0.615	0.710	0.845	0.955	1.215	1.460	1.710	2.200		
		0.520	0.580	0.635	0.730	0.865	0.975	1.235	1.480	1.730	2.220		
Tools Required		Spacer Ring (83C-R02), Small Silver Die (80C-EXX), and Adapter Bowl (83C-OCB)						Spacer Plate (83C-R02H) and Large Silver Die (83C-EXX)					
811 811HT 881	81 Series					80C-V12	80C-V16	80C-V20	83C-V24	83C-V32			
Tools Required						1.155	1.450	1.740	2.010	2.430			
						1.175	1.470	1.760	2.030	2.450			
Tools Required		Small Silver Die (80C-VXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-VXX)					
AX	HY Series	80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120	80C-H1365					
Tools Required		0.575		0.725	0.830	0.960	1.110	1.355					
		0.595		0.745	0.850	0.980	1.130	1.375					
BXX		80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170	80C-H1465					
Tools Required		0.635		0.805	0.915	1.040	1.200	1.495					
		0.655		0.825	0.935	1.060	1.220	1.515					
Tools Required		Spacer Ring (83C-R02), Small Silver Die (80C-HXXX or 80C-HXXXX), and Adapter Bowl (83C-OCB)											

Hose
A

Fittings
B

Parkrimp Equipment
C

Accessories
D

Technical
E



Parker Hannifin Corp.
Hose Products Division
30240 Lakeland Blvd.
Wickliffe, Ohio 44092

Caution: Read the operations and technical manual before attempting to operate this machinery. Do not operate this machine without guard in place. Keep hands clear of moving parts when operating machine.



NOTE: 1. The 83C-R12 split die ring is used for all crimping operations. 2. Stainless steel crimper diameters are 0.010" greater than table listings with the exception of stainless steel HY series fitting which are 0.005" greater than the table listings. 3. Do not use lubricant to assemble spiral hose and fittings.

For a new decal, contact Parker at: 1-800-C-PARKER.



Crimping using Minikrimp, Karrykrimp, Parkrimp 1, Karrykrimp 2 and PHastkrimp

Parkrimp Fittings Series 25, 26, 43, 70, 71, 73, 76, 78, S6, 81, HY

A Hose

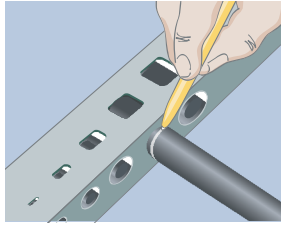
B Fittings

C Parkrimp Equipment

D Accessories

E Technical

1 Mark insertion depth and push on fitting



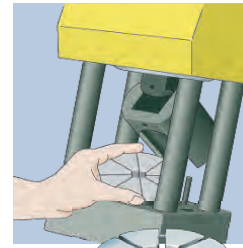
Mark the hose insertion depth and push hose into fitting until the mark on the hose is even with the end of the shell. Lubricate hose if necessary, however, **DO NOT lubricate if using spiral hose.** See Hose Insertion Depth table below.



Place shell onto end of hose and make sure the end of the shell lines up with the Insertion Depth mark.

Push hose onto the 88 Series fitting until the shell bottoms against the fitting's stop ring or hex. Lubricate hose if necessary.

2 Insert unitized die train



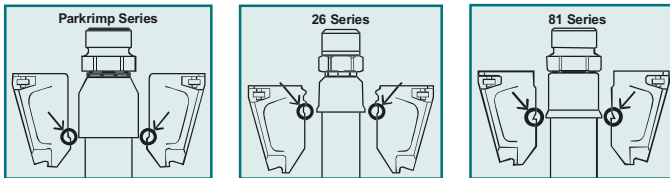
Color-Coded Unitized Die-Train

Pull pin at the top of pusher to swing it back. Place unitized die-train into base plate. See decal on crimpers for proper die set.

Note: Parkrimp 1 does not have a pin at the top of the pusher.

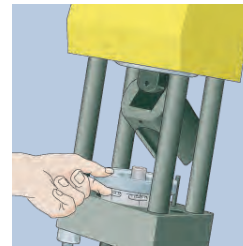
Important: Lubricate the crimpers die bowl using a premium quality lithium-base grease.

3 Position the fitting

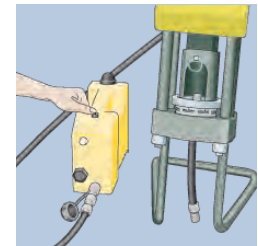


Position the hose and fitting in dies from below. Rest bottom of coupling on die step using the PARKALIGN® feature.

4 Place die ring and crimp



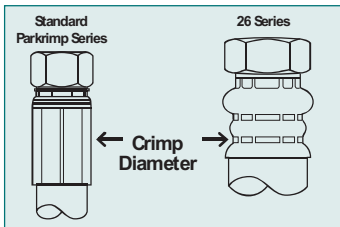
Place correct die ring on top of the dies. See decal on crimpers for proper die ring.



Position pusher by replacing the pin and operate pump until the die ring bottoms out. Release pressure within the pump — remove finished assembly.

Note: Minikrimp, Karrykrimp & Karrykrimp 2 have several types of power sources, all of which are separate units from the crimping machine.

5 Measure crimp diameter



Measure crimp diameter on the flat surfaces of the crimped shell, referenced in the illustration to the left. Reference decal on crimpers for crimp diameters. Never use hose assemblies with incorrect crimp diameters.

Important: Hose assemblies must be inspected for cleanliness and free of all foreign particles.

Hose insertion depths

Fitting Size	Fitting Series																								
	26		43		70		71		73		78		S6		79		81		HY						
	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm					
-4	13/16	21	13/16	21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1-7/16	37			
-5	13/16	21	15/16	24	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—			
-6	13/16	21	1-1/8	29	1-1/16	27	1-1/16	27	—	—	—	—	—	—	—	—	—	—	—	—	—	1-1/2	40		
-8	13/16	21	1-5/16	33	1-5/16	33	1-1/4	32	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1-9/16	40	
-10	7/8	22	1-9/16	40	1-3/8	35	1-5/16	33	—	—	1-7/8	47	—	—	—	—	—	—	—	—	—	—	—	1-9/16	40
-12	7/8	22	1-1/2	38	1-1/2	38	1-7/16	37	1-7/8	48	1-7/8	48	—	—	2-3/16	56	1-1/8	29	1-5/8	40	—	—	—	—	
-16	1	25	1-3/4	44	1-13/16	46	1-3/4	44	2	51	2	51	—	—	2-5/16	59	1-1/4	32	1-3/4	43	—	—	—	—	
-20	1	25	1-7/8	48	1-3/4	44	1-13/16	46	2-1/2	64	2-1/2	64	—	—	2-13/16	71	1-5/16	33	—	—	—	—	—	—	
-24	1-1/16	27	1-7/16	37	—	—	2-5/16	59	2-7/16	62	2-7/16	62	—	—	—	—	—	—	1-5/16	33	—	—	—	—	
-32	1-1/4	32	1-13/16	46	—	—	2-7/16	62	2-13/16	71	—	—	3-1/2	88	—	—	—	—	1-11/16	43	—	—	—	—	

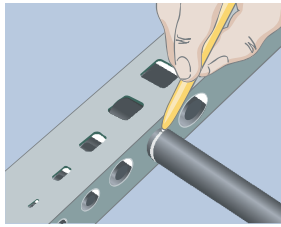
For specific information on crimping, visit Crimpsource™ online at www.parker.com/crimpsource.



Crimping using Superkrimp and Parkrimp 2

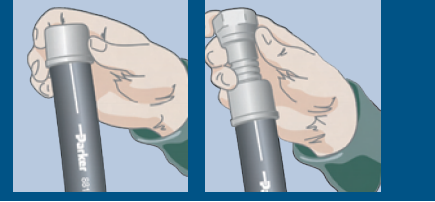
Parkrimp Fittings Series 25, 26, 43, 70, 71, 73, 76, 78, S6, 81, HY

1 Mark insertion depth and push on fitting



Mark the hose insertion depth and push hose into fitting until the mark on the hose is even with the end of the shell. Lubricate hose if necessary, however, **DO NOT** lubricate if using spiral hose. See Hose Insertion Depth table on previous page.

For 81 Series Shells with 88 Series Fittings

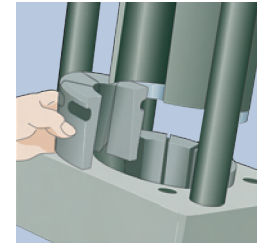


Place 81 Series Shell onto end of hose and make sure the end of the shell lines up with the Insertion Depth mark.

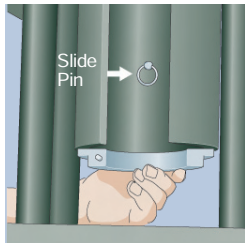
Push hose onto the 88 Series fitting until the shell bottoms against the fitting's stop ring or hex. Lubricate hose if necessary.

2a If using large two-piece dies

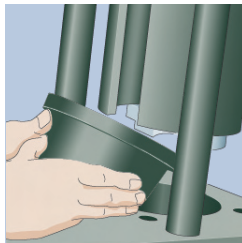
Insert the proper die set into the die bowl. (The die sets are in two halves of four dies each. Place one half in the back and one half in the front to accommodate bent tube fittings.) Reference decal on crimper for proper tool selection.



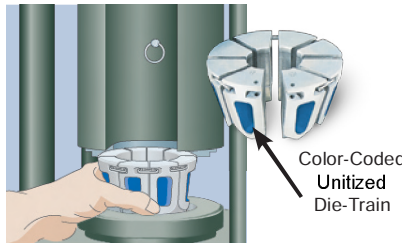
2b If using small unitized dies



With the pusher in the full up position, lift the back half of the split die ring. Lock it in the up position by pushing the slide pin in. (The slide pin is located inside the pusher at the back.)



Lubricate die bowl using a premium quality lithium-base grease. Carefully insert the adapter bowl, 83C-OCB, into the base bowl. The adapter bowl must be tilted toward the back of the crimper during insertion.



Lubricate die bowl using a premium quality lithium-base grease. Place unitized die-train into the adapter bowl. Select die and die ring by hose size and type. See decal on crimper for proper die set.

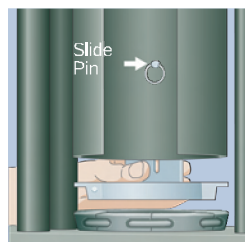
Note: Die sets have color-coded cavities indicating size and have the fitting series and dash size stamped on the top.

3 Place spacer ring

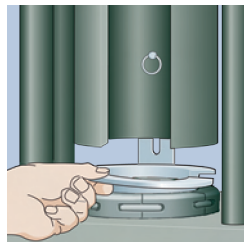


If required, place spacer ring on locating step of adapter bowl. Reference decal on crimper for tool selection.

4 Position the split die ring

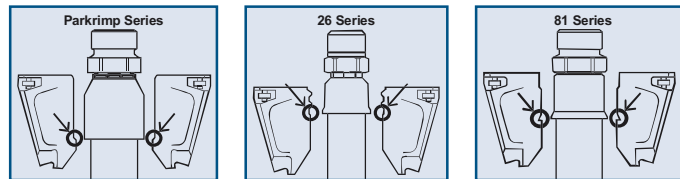


Lower the back half of the split die ring onto the dies by pulling the slide pin forward.



Insert the front half of the split die ring aligning the pins in the back half with the hole in the front half.

5 Position the fitting



Position the hose and fitting in dies from below. Rest bottom of coupling on die step using the PARKALIGN® feature.

6 Crimp hose

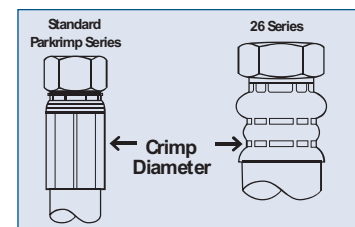
Turn on the pump by pressing the "ON" switch. Pull the valve handle forward to bring the pusher down for crimping. When the split die ring contacts the base plate, the crimp is complete. Push the valve handle back to lift the pusher, open the dies, and release the finished assembly.

Note: You do not have to remove any tooling to insert or remove straight fittings. The front half of the split die ring and the front die train must be removed to insert and remove bent tube fittings.



7 Measure crimp diameter

Measure crimp diameter on the flat surfaces of the crimped shell, referenced in the illustration to the right. Reference decal on crimper for crimp diameters. Never use hose assemblies with incorrect crimp diameters.



Important: Hose assemblies must be inspected for cleanliness and free of all foreign particles.

Hose
A

Fittings
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Parkrimp Equipment
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Accessories
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Technical
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