



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

Parkrimp 2 Hose Die Selection Chart

Fitting Series	HOSE	-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	-24 RED	-32 GRN
43 Series	Die Part Number	80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16 83C-A16H	80C-A20 83C-A20H	83C-A24	83C-A32
	GLOBALCORE 487/487ST/TC/CP (-4 THRU -12) 187/187ST/TC (-8 THRU -32) 787/787ST/TC/CP (-4 AND -6) 387/387ST/TC (-4 THRU -16) 797/797ST/TC/CP (-4 AND -6)	0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	2.290	2.735
	351ST/TC, 422, 426, 431, 436, 451ST/TC, 471ST/TC 472TC/LT, 482ST/TC, 777/777ST/TC/CP (-6 THRU -16)	0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990	2.310	2.755
	TOOLING REQUIRED										
	GLOBALCORE 387/387ST/TC/CP (-20 ONLY) 487/487ST/TC/CP (-16 ONLY) 722/722ST/TC (-6 THRU -16)	0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	2.330	2.775
302 421WC 722LT (-6 THRU -20) 881 722ST/TC (-20 ONLY)	0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030	2.350	2.795	
TOOLING REQUIRED											
NOTES	Crimp Diameter range for 722/722LT/ST/TC Size -16 is 1.630/1.660. Crimp Diameter range for 722/722LT/ST/TC Size -20 is 2.010/2.040.										
71 Series	Die Part Number	83C-D06		83C-D08	83C-D10	83C-D12	83C-D16 83C-D16H	83C-D20 83C-D20H	83C-D24	83C-D32	
	721/721ST/TC 722/722ST/TC/LT (-24 AND -32 ONLY)	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	
TOOLING REQUIRED											
77 Series	Die Part Number	80C-CS08			80C-CS10	80C-CS12	83C-CS16	83C-CS20	83C-CS24	83C-CS32	
	GLOBALCORE 387/387ST/TC (-20 THRU -32) 787/787ST/TC/CP 487/487ST/TC/CP (-20 THRU -32) 797/797ST/TC/CP	0.930			1.057	1.245	1.541	1.970	2.320	2.865	
		0.950			1.077	1.265	1.561	1.990	2.340	2.885	
TOOLING REQUIRED											
NOTES	Crimp Diameter range for 387/387ST/TC Size -32 is 2.860/2.885. 77 SERIES SIZE -32 STAINLESS STEEL FITTINGS CAN NOT BE CRIMPED ON THIS MACHINE.										
25 Series	Die Part Number	80C-Y06		80C-Y08							
	271	0.680		0.825							
		0.700		0.845							
TOOLING REQUIRED											
26 Series	Die Part Number	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	83C-E20	83C-E24	83C-E32
	213 285 (-4, -6, -10) 293	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
	TOOLING REQUIRED										
	201 225 266 206 226 SS25UL 221FR 244 285 (-8 & -12)	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	
TOOLING REQUIRED											
81 Series	Die Part Number	80C-V12					80C-V16	80C-V20	83C-V24	83C-V32	
	811 811HT 881	1.155					1.450	1.740	2.010	2.430	
	1.175					1.470	1.760	2.030	2.450		
TOOLING REQUIRED											
HY Series	Die Part Number	80C-H595			80C-H1015		80C-H1170	80C-H1365			
	801 836 611HT (-4 THRU -12)	0.575			0.995		1.140	1.350			
		0.595			1.015		1.160	1.370			
	TOOLING REQUIRED										
	Die Part Number	80C-H735		80C-H860							
801 836 611HT	0.755		0.890								
	0.775		0.910								
TOOLING REQUIRED											

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

Note: Stainless steel crimp diameters may be up to 0.010" greater than table listings. Do not use lubricant to assemble spiral hose and fittings.



83C-R12 Split Die ring is used for all crimping operations



80C-xxx/83C-xxx small dies and 83C-OCB adapter bowl used on sizes -4 thru -20



83C-R02 Spacer Ring used with adapter bowl when called out above



83C-xxx Large dies used on sizes -16 thru -32



83C-R02H Spacer Plate used when called out above

Information on this decal is subject to change without notice. For the most current crimp specifications, please visit Crimpsource at www.parker.com/crimpsource.
New decals can be ordered at Parker website - <https://parker.cp.imtco.com>

Decal Part Number : 83C-CRIMPDECAL
REV. M