

# Crimping Equipment C



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 <p><b>Crimpers</b></p>	 <p>KrimpNODE™ C-6</p>	 <p>Karrykrimp C-7</p>	 <p>Karrykrimp Bench Mount C-7</p>	 <p>Karrykrimp 2 C-9</p>	 <p>Karrykrimp 2 Bench Mount C-9</p>
 <p>Parkrimp 1 C-11</p>	 <p>Parkrimp 2 C-13</p>	 <p>MiniKrimp C-15</p> <p>Hand Pump/Air Over Hydraulic Pump</p>	 <p><b>Portable Pumps</b></p>	 <p>82C-0HP C-17</p> <p>Hand Pump</p>	 <p>85C-0HP C-17</p> <p>Hand Pump</p>
 <p>82C-0EP E-17</p> <p>Electric Pump</p>	 <p>85C-0EP E-17</p> <p>Electric Pump</p>	 <p>82C-0AP E-17</p> <p>Air/Hydraulic Pump</p>	 <p><b>Hose Cut-Off Machines</b></p>	 <p>86C-220V and 86C-220V3 E-23</p>	 <p>TH3-EM3-110V E-23</p>
 <p><b>Hose Cleaning Kits</b></p>	 <p>TH6-10-HL-10-2 C-24</p> <p>Premium Hose Cleaning Kit</p>	 <p>TH6-10-EL-8 C-24</p> <p>Economy Hose Cleaning Kit</p>	 <p><b>Accessories</b></p>	 <p>Parker Clean Seal C-25</p>	 <p>871522 C-26</p> <p>Handycut - Hose Cut-Off Machine</p>
 <p>881540 C-26</p> <p>Push-Lok Cut-Off &amp; Assembly Tool</p>	 <p>TH9-1 C-26</p> <p>Hose Insertion Depth Blocks</p>	 <p>TH11-1 C-26</p> <p>Hose Cut-Off Tool</p>	 <p>432-115V C-27</p> <p>Hozemblem</p>	 <p>80C-0DR and 83C-0DR C-27</p> <p>Die Storage Racks</p>	 <p>80C-SDR C-27</p> <p>Swivel Die Rack</p>
 <p>TH2-7 E-27</p> <p>Fittings Push-On Stand</p>					

Notes

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# Hose Assemblies Are Easy With the Parkrimp System.

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Since its introduction in 1980, the Parkrimp family of crimping machines has led the industry in ease of use and rugged durability.

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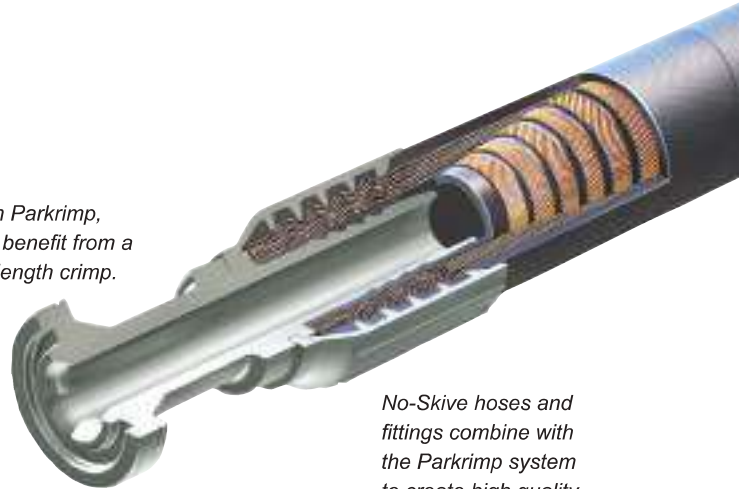
When it comes to hose assemblies, no one puts it all together like Parker. From high-volume productivity to portable on-site assembly, we offer a variety of crimping machines, No-Skive hoses, and No-Skive fittings to meet your needs.

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With Parkrimp equipment, anyone can make factory-quality hose assemblies quickly, easily, and cost effectively. Parkrimp machines are simple to operate and they're built to provide years of dependable service. Seven Parkrimp models – an entire family of crimpers – are available to meet your bench-mounted or portable needs, crimping straight or bent-stem fittings from 1/4" to 2" in diameter. Just use our No-Skive hoses and fittings to create leak-free hose assemblies whenever and wherever you need them.

The complete system from one source: No-Skive hose, No-Skive fittings, and crimping machines with worldwide availability and service.

*With Parkrimp, you benefit from a full length crimp.*

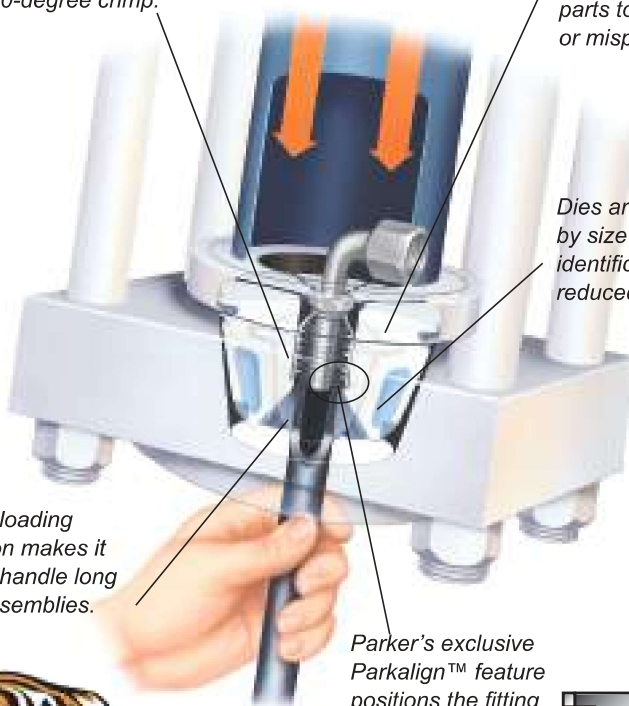


*No-Skive hoses and fittings combine with the Parkrimp system to create high quality, reliable hydraulic hose assemblies every time.*

*Our low profile design makes routing hose assemblies easy.*

*Eight segment crimp dies provide a smooth, even, 360-degree crimp.*

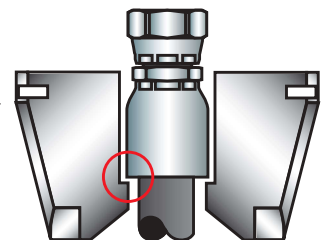
*Our linked crimp dies keep die segments together. No loose parts to mismatch or misplace.*



*Dies are color-coded by size for easy identification and reduced set-up time.*

*Bottom-loading operation makes it easy to handle long hose assemblies.*

*Parker's exclusive Parkalign™ feature positions the fitting in the dies perfectly every time.*



## Selecting the right die.

Once the proper Parker Hose and Fitting is selected that meets your application requirements, you will need to select the proper die to assemble them together.

Based on the hose size and approved fitting, select the proper color coded die, as called out in the chart below.

### Example:

Hose	387-4
Fitting	43 Series
Die Body Color	Silver
Die Cavity Color (-4)	<b>RED</b>

Based on the Parkrimp machine being used to assemble the hose and fitting, individual die part numbers and tooling selection for your assembly can be found in Section C of this catalog.

For general hose assembly instructions for all Parkrimp machines, please turn to pages C-19 and C-20. (An instructional video is a standard part of each Parkrimp machine shipped from the manufacturer.)

Parker Hose Products Division also offers a full line of crimping accessories, including conversion kits, cabinets, cut-off saws, push-on tables, die racks, and mandrel tool kits.



Hose Dash Size	Die Cavity Color Code	43 & 26 Series Die Body Color	77 Series Die Body Color	79 Series Die Body Color	76 Series Die Body Color	25 Series Die Body Color	81 Series Die Body Color
		Silver	Black	Olive Drab	Silver	Silver	Silver
-4	<b>RED</b>		N/A	N/A	N/A	N/A	N/A
-5	<b>PURPLE</b>		N/A	N/A	N/A	N/A	N/A
-6	<b>YELLOW</b>			N/A	N/A		N/A
-8	<b>BLUE</b>			N/A	N/A		N/A
-10	<b>ORANGE</b>			N/A	N/A	N/A	N/A
-12	<b>GREEN</b>			N/A		N/A	
-16	<b>BLACK</b>			N/A		N/A	
-20	<b>WHITE</b>				N/A	N/A	
-24	<b>RED</b>				N/A	N/A	
-32	<b>GREEN</b>				N/A	N/A	

Hose Dash Size	Die Cavity Color Code	HY Series Die Body Color
		Silver
-4	<b>BROWN</b>	
-5	<b>BROWN</b>	
-6	<b>BROWN</b>	
-8	<b>BROWN</b>	
-10	<b>BROWN</b>	
-12	<b>BROWN</b>	
-16	<b>BROWN</b>	

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

Reference pages C-6 through C-14 for specific tool information regarding hose, fitting, and crimper combinations. Be sure to check [www.parker.com/crimpsource](http://www.parker.com/crimpsource) for the most up to date information and crimp specifications.



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## KrimpNODE™

# Smarter Crimper. Smarter Choice.

Do you know where your crimpers are? Parker's Hose Products Division can help you take the guess work out of determining their location. Are your crimpers being used? Our new KrimpNODE™ sensor can track crimper usage and deliver this data, allowing you to analyze both usage and location.

If you have an existing crimper, order our KrimpNODE™ Retrofit Kit or if you need a new crimper, order one of our Parkrimp crimpers that come standard with KrimpNODE™.

KrimpNODE™ sensors can be added to existing crimpers via our KrimpNODE™ Retrofit Kit through any Parker Distributor.

Karrykrimp 2, Parkrimp 1, Parkrimp 2, and Phastkrimp 2 come standard with KrimpNODE™ sensor.

Activate, track and increase sales with Parker Hose Products KrimpNODE™.

**For anyone having existing crimpers that want to order the sensor to attach:**

Crimper	Sensor Retrofit Kit:
Parkrimp 1	PT# PKT26189
Parkrimp 2	PT#PKT26189
Karrykrimp 2	PT#PK26190



### Capability:

- Records crimper activity
- Real time connection to the cloud
- GPS position
- Unlimited capacity, all your crimpers can be monitored

### Features:

- Alerts/notifications via email or text
- Customizable dashboards

### Specifications:

- Available on Parkrimp1, Parkrimp2, Karrykrimp2, and Phastkrimp 2
- Retrofit kits available for installed units

#### Note:

- For crimp instructions, see pages C-19 and C-20.
- 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.

# Karrykrimp

The Karrykrimp is now available in a modular design with all the familiar Parkrimp System advantages.

The same unit now offers portability and bench mountability.



view on web page

## Capability

- Up to 1-1/4" ID 2 wire braided hose
- Up to 5/8" ID 4 wire spiral hose
- Only steel fittings

## Features

- Now comes standard with KrimpNODE  
See page C-6 for more information on KrimpNODE™
- Portable, compact rugged design
- Numerous portable power unit options available
- Pivoting pusher design for easy die change out
- Increased height enables longer bent tube fittings to be crimped
- For use with 25, 26, 43, 81, and HY Series fittings

## Specifications

- Dimensions: 15" wide, 12" deep, 30" high
- Weight: 70 lbs (without power unit)
- Rating: 30 ton force @ 10,000 psi maximum
- Crimp Cycle Time: 30 seconds 82C-0EP power unit (1/2" 43 Series)
- Reference pages C-16 and C-17 for information on available power units

## Standard Equipment

Part Number			Description	Individual Part Number
82C-CHD	82C-061L	82C-KKB		
●	●	●	Crimp Head	82C-CHD
		●	Bench Power Unit Assembly	*85C-ZMS
●	●	●	Silver Die Ring	82C-R01
●	●	●	Black Die Ring	82C-R02
	●		Hose Assembly	85C-00L
	●		Stand Assembly	85C-STD
		●	Hose Assembly	85C-03L

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

**Note:**

- For crimp instructions, see pages C-19 and C-20.
- 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.

# Karrykrimp Bench Mount



view on web page

## Capability

- Up to 1-1/4" ID 2 wire braided hose
- Up to 5/8" ID 4 wire spiral hose
- Only steel fittings

## Features

- Faster cycle times on bench mounted units
- Pivoting pusher design for easy die change out
- Compact bench mount design
- Increased height enables longer bent tube fittings to be crimped
- For use with 25, 26, 43, 81, and HY Series fittings

## Specifications

- Dimensions: 19" wide, 23" deep, 27-1/2" high
- Weight: 220 lbs
- Rating: 30 ton force @ 10,000 psi maximum
- Crimp Cycle Time: 8 seconds (1/2" 43 Series straight fittings)
- Full Stroke Crimp Time: 15 seconds
- Hydraulic Fluid: Enerpac Oil
- This unit is designed to make about 200 crimps per day and is not designed to be a production crimper. Exceeding these suggested production amounts will significantly reduce the life expectancy of the crimper components.

**\*Note:** Power unit is factory wired to operate at 115 volt. **A 20 amp dedicated circuit is required to operate at this voltage. Do not use extension cords to operate this machine.**

The electric motor is dual voltage, 50/60 HZ, suitable for 208-230/115 volt. The motor and control circuit can be rewired by a qualified electrician to operate at alternate voltage. See motor name plate and wiring diagrams.

## Optional Tooling

- Die Kit 43K-KDA (Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1" and 1-1/4" only)












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 Parker Hannifin Corporation Hose Products Division 30240 Lakeland Blvd. Wickliffe, Ohio 44092		Karrykrimp/Karrykrimp Bench Mount Hose Die Selection Chart								Die Ring
Fitting Series	HOSE	-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	
43 Series	Die Part Number	80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	
	GLOBAL CRIMP 187/187ST/TC (-8 THRU -16) 387/387ST/TC (-4 THRU -16), 487/487ST/TC (-4 THRU -12) 787/787ST/TC (-4 & -6), 797/797ST/TC (-4 & -6)	0.645 0.665	0.710 0.730	0.825 0.845	0.945 0.965	1.060 1.080	1.245 1.265	1.590 1.610	1.970 1.990	
	351ST/TC 422 426 431 436 451ST/TC 471ST/TC 472LT, 482ST/TC 777/777ST/TC (-6 THRU -10)									SILVER
	GLOBAL CRIMP 722/722ST/TC (-6 THRU -10)	0.685 0.705	0.750 0.770	0.865 0.885	0.985 1.005	1.100 1.120	1.285 1.305	1.630 1.650	2.010 2.030	
	302 421WC 722LT (-6 THRU -10) 881									BLACK
25 Series	Die Part Number			80C-Y06	80C-Y08					
	271			0.680 0.700	0.825 0.845					
26 Series	Die Part Number	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16		
	213 285 (-4, -6, -10) 293	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		
	201 225 266 206 226 SS25UL 221FR 244 285(-8 & -12)	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		
81 Series	Die Part Number						80C-V12	80C-V16	80C-V20	
	811 811HT 881						1.155 1.175	1.450 1.470	1.740 1.760	
HY Series	Die Part Number	80C-H595				80C-H1015	80C-H1170	80C-H1385		
	801 836 611HT (-4 THRU -12)	0.575 0.595				0.995 1.015	1.140 1.160	1.350 1.370		
	Die Part Number			80C-H735	80C-H860					
	801 836 611HT			0.755 0.775	0.890 0.910					
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: Do not use this machine to assemble stainless steel fittings.				
Information on this decal is subject to change without notice. For the most current crimp specifications, please visit Crimpsource at <a href="http://www.parker.com/crimpsource">www.parker.com/crimpsource</a> . New decals can be ordered at Parker website <a href="https://parker.cp.imtco.com/Account/Login">https://parker.cp.imtco.com/Account/Login</a> .						Decal Part Number: 82C-CRIMPDECAL REV. J				

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

## Karrykrimp 2

The Karrykrimp 2 is now available in a modular design with all the familiar Parkrimp System advantages.

The same unit now offers portability and bench mountability.



view on web page

### Capability

- Up to 1-1/4" ID 2 wire braided hose
- Up to 1-1/4" ID 4 wire spiral hose
- Up to 1" ID 6 wire spiral hose

### Features

- Now comes standard with KrimpNODE  
See page C-6 for more information on KrimpNODE™
- Portable, compact rugged design
- Numerous portable power unit options available
- Pivoting pusher design for easy die change out
- For use with 25,26, 43, 70, 71, 77, 81 and HY Series fittings

### Specifications

- Dimensions: 14" wide, 14" deep, 31-1/2" high
- Weight: 120 lbs (without power unit)
- Rating: 60 ton force @ 10,000 psi maximum
- Cycle Time: 15 seconds with 85C-0EP power unit (1/2" 43 series)
- Reference pages C-16 and C-17 for information on available power units

### Standard Equipment

Part Number			Description	Individual Part Number
85C-CHD	85C-061L	85C-KKB		
●	●	●	Crimp Head	85C-CHD
		●	Bench Power Unit Assembly	*85C-ZMS
●	●	●	Silver Die Ring	85C-R01
●	●	●	Black Die Ring	85C-R02
	●		Hose Assembly	85C-00L
	●		Stand Assembly	85C-STD
		●	Hose Assembly	85C-03L

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

**Note:**

- For crimp instructions, see pages C-19 and C-20.
- 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.

## Karrykrimp 2 Bench Mount



view on web page

### Capability

- Up to 1-1/4" ID 2 wire braided hose
- Up to 1-1/4" ID 4 wire spiral hose
- Up to 1" ID 6 wire spiral hose

### Features

- Faster cycle times on bench mounted units
- Pivoting pusher design for easy die change out
- Compact bench mount design
- For use with 25, 26, 43, 70, 71, 77, 81 and HY Series fittings

### Specifications

- Dimensions: 19" wide, 24" deep, 28" high
- Weight: 265 lbs
- Rating: 60 ton force @ 10,000 psi maximum
- Crimp Cycle Time: 15 seconds (1/2" 43 series straight fitting)
- Full Stroke Cycle Time: 24 seconds
- Hydraulic Fluid: Enerpac Oil
- This unit is designed to make about 200 crimps per day and is not designed to be a production crimper. Exceeding these suggested production amounts will significantly reduce the life expectancy of the crimper components.

**\*Note:** Power unit is factory wired to operate at 115 volt. **A 20 amp dedicated circuit is required to operate at this voltage. Do not use extension cords to operate this machine.**

The electric motor is dual voltage, 50/60 HZ, suitable for 208-230/115 volt. The motor and control circuit can be rewired by a qualified electrician to operate at alternate voltage. See motor name plate and wiring diagrams.

### Optional Tooling

- Die Kit KK2-KDA (Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1" and 1-1/4" and 77 Series dies in sizes 1/2", 5/8", 3/4" and 1" only.













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 Parker Hannifin Corporation Hose Products Division 30240 Lakeland Blvd. Wickliffe, Ohio 44092		Karrykrimp 2/Karrykrimp 2 Bench Mount Hose Die Selection Chart								Die Ring
Fitting Series	HOSE	-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	
43 Series	Die Part Number	80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	
	GLOBALCORE 187/187ST/TC (-8 THRU -20) 387/387ST/TC (-4 THRU -16), 487/487ST/TC (-4 THRU -12) 787/787ST/TC (-4 & -6), 797/797ST/TC (-4 & -6)	0.645 0.665	0.710 0.730	0.825 0.845	0.945 0.965	1.060 1.080	1.245 1.265	1.590 1.610	1.970 1.990	
	351ST/TC 422 426 431 436 451ST/TC 471ST/TC 472TC/LT 482ST/TC									SILVER
	GLOBALCORE 387/387ST/TC (-20 ONLY) 487/487ST/TC (-16 ONLY) 722/722ST/TC (-6 THRU -16)	0.685 0.705	0.750 0.770	0.865 0.885	0.985 1.005	1.100 1.120	1.285 1.305	1.630 1.650	2.010 2.030	
	302 421WC 722LT (-6 THRU -20) 881 722ST/TC (-20 ONLY)									BLACK
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-D20	
	721/721ST/TC			0.950 0.970	1.100 1.120	1.220 1.240	1.355 1.375	1.695 1.715	2.025 2.045	
NOTES		71 Series Size -20 Stainless Steel Fittings can not be Crimped on this Machine.								
77 Series	Die Part Number				80C-CS08	80C-CS10	80C-CS12	80C-CS16		
	GLOBALCORE 787/787ST/TC 797/797ST/TC (-8 THRU -12)				0.930 0.950	1.057 1.077	1.245 1.265	1.541 1.571		
NOTES		77 Series Size -16 Stainless Steel Fittings can not be Crimped on this Machine.								
25 Series	Die Part Number			80C-Y06	80C-Y08					
	271			0.680 0.700	0.825 0.845					
26 Series	Die Part Number	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16		
	213 285 293	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		
	201 225 266 206 226 SS25UL 221FR 244	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		
81 Series	Die Part Number						80C-V12	80C-V16	80C-V20	
	811 811HT 881						1.155 1.175	1.450 1.470	1.740 1.760	
HY Series	Die Part Number	80C-H595				80C-H1015	80C-H1170	80C-H1365		
	801 836 611HT (-4 THRU -12)	0.575 0.595				0.995 1.015	1.140 1.160	1.350 1.370		
	Die Part Number			80C-H735	80C-H860					
	801 836 611HT			0.755 0.775	0.890 0.910					
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 can be up to .010" greater than table listings.				
Information on this decal is subject to change without notice. For the most current crimp specifications, please visit Crimpsource at <a href="http://www.parker.com/crimpsource">www.parker.com/crimpsource</a> . New decals can be ordered at Parker website <a href="https://parker.cp.imtco.com/Account/Login">https://parker.cp.imtco.com/Account/Login</a> .						Decal Part Number: 85C-CRIMPDECAL REV. H				

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# Parkrimp 1



## Features

- Now comes standard with KrimpNODE  
See page C-6 for more information on KrimpNODE™
- Compact bench mount design
- Engineered for optimal reliability, consistency, and 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-061		
●	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

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

**Note:**

- For crimp instructions, see pages C-19 and C-20.
- 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.

## Capability

For use with 25, 26, 43, 81, and HY fittings.

- 1" 1 and 2 wire braided hose
- 5/8" 4 spiral hose
- 3/8" Compact Spiral Hose

No Stainless Steel Fittings

**Crimp Cycle Time:** 15-20 seconds, depending on Pusher position. (1/2" 43 series straight fittings)

**Note:** Cycle times vary depending on hose, fitting styles and sizes.

This machine may require the use of the Molykote GN grease for larger hose and fittings. For best performance and longevity of crimper components, use the Molykote GN grease for all crimping.

This machine is designed to make about 200 crimps per day and is not designed for production use. Exceeding the suggested production amounts will significantly reduce the life expectancy of the machine components.

**80C-061 Includes:**

- Parkrimp 1 Crimper
- Die ring Silver
- Die ring Black
- No Dies - Order Separately



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

### Parkrimp 1 Hose Die Selection Chart

Fitting Series	HOSE	-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	Die Ring	
43 Series	Die Part Number	80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16			
	GLOBAL CORE 187/187ST/TC (-8 THRU -16) 387/387ST/TC 487/487ST/TC (-4 THRU -12) 787/787ST/TC (-4 & -6), 797/797ST/TC (-4 & -6)	0.645 0.665	0.710 0.730	0.825 0.845	0.945 0.965	1.060 1.080	1.245 1.265	1.590 1.610			SILVER
	351ST/TC 422 426 431 436 451ST/TC 471ST/TC 472LT 482ST/TC 777/777ST/TC (-6 & -10)										SILVER
	GLOBAL CORE 722/722ST/TC (-6 THRU -10) 421WC 302 722LT (-6 THRU -10) 881	0.685 0.705	0.750 0.770	0.865 0.885	0.985 1.005	1.100 1.120	1.285 1.305	1.630 1.650			BLACK
25 Series	Die Part Number			80C-Y06	80C-Y08						
	271			0.680 0.700	0.825 0.845					SILVER	
26 Series	Die Part Number	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16			
	213 285 (-4, -6, -10) 293	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	
	201 206 221FR 225 226 244 266 SS25UL 285 (-8 & -12)	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	
81 Series	Die Part Number						80C-V12	80C-V16	80C-V20		
	811 811HT 881						1.155 1.175	1.450 1.470	1.740 1.760	SILVER	
HY Series	Die Part Number	80C-H595		80C-H735	80C-H860	80C-H1015	80C-H1170				
	801 836 611HT (-4 THRU -12)	0.575 0.595				0.995 1.015	1.140 1.160	1.350 1.370		SILVER	
	Die Part Number			80C-H735	80C-H860						
	801 836 611HT			0.755 0.775	0.890 0.910					BLACK	

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: Do not use this machine to assemble stainless steel fittings.

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

Decal Part Number:  
82C-CRIMPDECAL  
REV. K

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

# Parkrimp 2



[view on web page](#)



## Capability

- Up to 2" ID 2 wire braided hose
- Up to 2" ID 4/6 wire spiral hose\*

## Features

- Now comes standard with KrimpNODE  
See page C-6 for more information on KrimpNODE™
- 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, 76, 77, 79, 81 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 Stroke: 30 seconds without adapter bowl
- Cycle Time: 20 seconds with adapter bowl
- Hydraulic oil: Enerpac oil

## Standard Equipment

Part Number		Description	Individual Part Number
83C-081	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

\*Can crimp 77 Series stainless steel fittings up to 1-1/2"

## Optional Tooling

- Die Kit PK2-KDA (Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1", 1-1/4" and 77 Series dies in sizes 1/2", 5/8", 3/4", 1", 1-1/4", 1-1/2" and 2" only)
- Die Kit 77K-KDA (Includes 77 Series dies in sizes 1/2", 5/8", 3/4", 1", 1-1/4", 1-1/2" and 2" only)

**⚠ WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

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Parker		Parkrimp 2 Hose Die Selection Chart												
Parker Hannifin Corporation Hose Products Division 30240 Lakeland Blvd. Wickliffe, Ohio 44092		HOSE			-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	-24 RED	-32 GRN
Fitting Series	Die Part Number	80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	80C-A16H	80C-A20H	83C-A24	83C-A32	
43 Series	GLOBAL CHOICE 187/187ST/TC (-8 THRU -32) 387/387ST/TC (-4 THRU -16) 487/487ST/TC (-4 THRU -12) 787/787ST/TC (-4 AND -6) 797/797ST/TC (-4 AND -6)	0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	1.610	1.990	2.290	2.735	
	351ST/TC 422 426 431 436 451ST/TC 471ST/TC, 472TC/LT, 482ST/TC, 777/777ST/TC (-6 THRU -16)													
	Tooling Required													
	GLOBAL CHOICE 387/387ST/TC (-20 ONLY) 487/487ST/TC (-16 ONLY) 722/722ST/TC (-6 THRU -16) 722LT (-6 THRU -20) 881 722ST/TC (-20 ONLY)	0.685 0.705	0.750 0.770	0.865 0.885	0.985 1.005	1.100 1.120	1.285 1.305	1.630 1.650	2.010 2.030	2.330 2.350	2.775 2.795			
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-D20	83C-D24	83C-D32			
	721/721ST/TC 722/722ST/TC/LT (-24 AND -32 ONLY)			0.950 0.970	1.100 1.120	1.220 1.240	1.355 1.375	1.695 1.715	2.025 2.045	2.290 2.310	2.775 2.795			
77 Series	Die Part Number				80C-CS08	80C-CS10	80C-CS12	83C-CS16	83C-CS20	83C-CS24	83C-CS32			
	GLOBAL CHOICE 387/387ST/TC (-20 THRU -32) 787/787ST/TC 487/487ST/TC (-20 THRU -32) 797/797ST/TC				0.930 0.950	1.057 1.077	1.245 1.265	1.541 1.561	1.970 1.990	2.320 2.340	2.865 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 0.700	0.825 0.845									
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 0.480	0.520 0.540	0.575 0.595	0.670 0.690	0.805 0.825	0.915 0.935	1.175 1.195	1.420 1.440	1.670 1.690	2.160 2.180			
	201 225 266 206 226 SS25UL 221FR 244 285 (-8 & -12)	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	1.460 1.480	1.710 1.730	2.200 2.220			
	Tooling Required													
81 Series	Die Part Number						80C-V12	80C-V16	80C-V20	83C-V24	83C-V32			
	811 811HT 881						1.155 1.175	1.450 1.470	1.740 1.760	2.010 2.030	2.430 2.450			
HY Series	Die Part Number			80C-H995			80C-H1015	80C-H1170	80C-H1365					
	801 836 611HT (-4 THRU -12)	0.575 0.595					0.995 1.015	1.140 1.160	1.350 1.370					
	Tooling Required													
	Die Part Number				80C-H735	80C-H860								
801 836 611HT				0.755 0.765	0.890 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 Crimp-source at <a href="http://www.parker.com/crimpsource">www.parker.com/crimpsource</a> . New decals can be ordered at Parker website <a href="https://parker.cp.imtco.com/Account/Login">https://parker.cp.imtco.com/Account/Login</a> .										Decal Part Number: 83C-CRIMPDECAL REV. L				

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

# Minikrimp

MiniKrimp™ is an all-in-one unit delivering the performance of a full-sized crimper. With no additional power source required for operation and a built-in carry handle, the MiniKrimp is easy to transport to remote locations and is ready to go at a moments notice.



Minikrimp - Hand Pump



Minikrimp - Air Over Hydraulic

## Capability

- Up to 1" ID 2 wire braided hose
- Only steel fittings

## Features

- Portable and lightweight crimper
- Generates 30 tons of force
- Easy set-up and operation
- Reduces inventory and saves time, leading to substantial cost savings
- No gauges to set – exclusive Parkalign feature positions the fitting correctly in the die set every time
- Available in adjustable Hand Pump or Air Over Hydraulic models
- Stand and/or mounting accessories available

## Specifications

### MiniKrimp™ - Hand Pump 94C-001-PFD

(Comes assembled and ready to use)

- 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

### MiniKrimp™ - Air Over Hydraulic Model 94C-002-PFD

(Comes assembled and ready to use)

- Dimensions: 6" wide, 12" deep, 15" high
- Weight: 45 lbs (with air/hydraulic pump)
- Rating: 30 ton force @ 10,000 psi maximum
- Full Cycle Time: 30 seconds

## Standard Equipment

### MiniKrimp - Hand Pump

Part Number	Description	Individual Part Number
94C-001-PFD	Crimper (Base)	94C-080-PFD
	Hand Pump	015301
	Silver Die Ring	82C-R01-PFD

### MiniKrimp - Air Over Hydraulic

Part Number	Description	Individual Part Number
94C-002-PFD	Crimper (Base)	94C-080-PFD
	Air/Hydraulic Pump	025399
	Silver Die Ring	82C-R01-PFD

## Additional Components

- Black Die Ring - 82C-R02-PFD
- Table Mount - 015306
- Upright Vise - Mount 015307
- Side Vise Mount - 015736
- Folding Stand - 94C-MKS

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).










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 Parker Hannifin Corporation Hose Products Division 30240 Lakeland Blvd. Wickliffe, Ohio 44092		<b>Minikrimp Hose Die Selection Chart</b>						
Fitting Series	HOSE	-4 RED	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	Die Ring
43 Series	Die Part Number	80C-A04	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	
	AG2R (-4 thru -16) 387/387TC/ST (-4 thru -12) 487/487TC/ST (-4 thru -12) 787/787TC/ST (-4 thru -6) 797/797TC/ST (-4 thru -6)	0.645 0.665	0.825 0.845	0.945 0.965	1.060 1.080	1.245 1.265	1.590 1.610	
	Tooling Required							
	722/722TC/ST (-6 through -10)		0.865 0.885	0.985 1.005	1.100 1.120			
	Tooling Required							
	Die Part Number	80C-P0660	80C-P06H	80C-P0945				
	HR2CR (-4 only) HR2C (-6 through -8)	0.650 0.670	0.785 0.805	0.935 0.955				
	Tooling Required							
	Die Part Number		80C-R0825	80C-A08	80C-A10	80C-A12		
	HTBR (-6 through -12)		0.815 0.835	0.945 0.965	1.060 1.080	1.245 1.265		
Tooling Required								
HY Series	Die Part Number		80C-P735H	80C-P0870				
	HR2C (-6 through -8)		0.725 0.745	0.860 0.860				
	Tooling Required							
<b>Caution:</b> 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 machines. The complete Parker safety guide can be viewed by going to <a href="http://www.parker.com/safety">www.parker.com/safety</a>					<b>Note:</b> Do not use this machine to assemble stainless steel fittings.			
Information on this decal is subject to change without notice. For the most current crimp specifications, please visit Crimpsource at <a href="http://www.parker.com/crimpsource">www.parker.com/crimpsource</a> . New decals can be ordered at Parker website <a href="https://parker.cp.imtco.com/Account/Login">https://parker.cp.imtco.com/Account/Login</a> .					Decal Part Number: 94C-PIONEER_CRIMPDECAL REV A			

 **WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

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### Hand Pump\*

Part No. 82C-0HP



*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ease of operation hand pump delivers 10,000 psi

Length: 23"  
 Width: 4"  
 Height: 5"  
 Port Size: 3/8" NPTF  
 Weight: 9 lbs  
 Hydraulic Fluid: Enerpac oil

### Hand Pump\*

Part No. 85C-0HP



*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ease of operation hand pump delivers 10,000 psi

Length: 29"  
 Width: 13"  
 Height: 11"  
 Port Size: 3/8" NPTF  
 Weight: 61 lbs  
 Hydraulic Fluid: Enerpac oil

### Electric Pump\*

Part No. 82C-0EP



*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ease of operation electric pump delivers 10,000 psi

Length: 13"  
 Width: 13"  
 Height: 15"  
 Port Size: 3/8" NPTF  
 Weight: 31 lbs  
 Hydraulic Fluid: Enerpac oil  
 Power Source: 115 volt, 1 phase, 50/60 Hz, 9 amp

### Electric Pump\*

Part No. 85C-0EP



*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Heavy duty electric pump delivers 10,000 psi at a faster cycle time

Length: 19"  
 Width: 11"  
 Height: 17"  
 Port Size: 3/8" NPTF  
 Weight: 59 lbs  
 Hydraulic Fluid: Enerpac oil  
 Power Source: 115 volt, 1 phase, 50/60 Hz, 20 amp

### Air/Hydraulic Pump\*

Part No. 82C-0AP



*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Lightweight pump operates with 80-110 psi shop air pressure and delivers 10,000 psi

Length: 15"  
 Width: 6"  
 Height: 6"  
 Intake Port Size: 1/4" NPTF  
 Output Port Size: 3/8" NPTF  
 Weight: 14 lbs  
 Hydraulic Fluid: Enerpac oil

**WARNING:** \*This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

#### Enerpac Warranty Statement

Enerpac products are warranted to be free of defects in materials and workmanship. Any product that does not conform to specification will be repaired or replaced at Enerpac's expense, anywhere in the world; simple as that! This warranty does not cover ordinary wear and tear, abuse, misuse, alterations, or the use of improper fluids. Determination of the authenticity of a warranty claim will be made only by Enerpac or its Authorized Service Centers.

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# www.parker.com/crimpsource

Crimpsource is the industry's most complete resource for crimper technical information. It contains all of the crimp specifications approved for Parker's rubber, industrial and thermoplastic hose:

- Crimp specs
- PDFs of technical manuals for easy downloading
- Parts lists
- Troubleshooting advice
- PDFs of crimper decals for immediate printing

Crimpsource provides easy access to all the specifications necessary to correctly fabricate a factory quality hose assembly.

A series of dropdown menus enables users to find what they need quickly and easily.

Choose your crimper, and then select the hose, fittings and current specifications needed to make hose assemblies.

You can also print a simple-to-follow data specification sheet or crimper decal.

B

C

## Crimpsource Home Page



D

**Parker** Crimp Specification  
Hose Products Division \*All units in inches

Hose Style: 387/387STTC    Coupling Style: 43    Crimper: Karykrimp 2    Hose Description: GlobalCore Hydraulic Hose 21 MPa/3000 psi Constant Working Pressure

Size	Crimper/Die	Die Ring	Crimp Diameter	Crimp Length	Hose Insertion	Drawing	
<b>Parker 43 Series Dies</b>							
-4	80C-A04		85C-R01	0.655	FULL	0.81	PKFull
-6	80C-A06		85C-R01	0.835	FULL	1.13	PKFull
-8	80C-A08		85C-R01	0.955	FULL	1.31	PKFull
-10	80C-A10		85C-R01	1.070	FULL	1.56	PKFull
-12	80C-A12		85C-R01	1.255	FULL	1.50	PKFull
-16	80C-A16		85C-R01	1.600	FULL	1.75	PKFull
-20	80C-A20		85C-R02	2.020	FULL	1.88	PKFull

## Crimping using Minikrimp, Karrykrimp 2 and Karrykrimp 2 Bench Mount

Parkrimp Fittings Series 25, 26, 43, 70, 71, 77, 81, HY

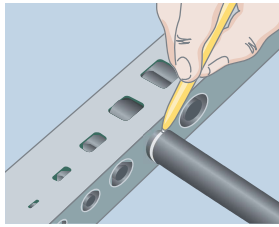
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### 1 Mark insertion depth and push on fitting



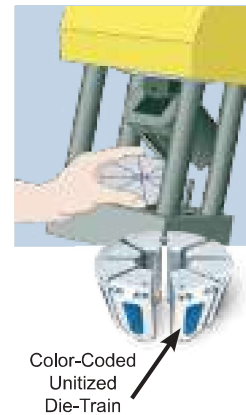
Mark the hose insertion depth and push hose into fitting until the mark on the hose is even with the end of the shell. Lubricate hose if necessary, however, **DO NOT lubricate if using spiral hose.** See Hose Insertion Depth table below.



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.

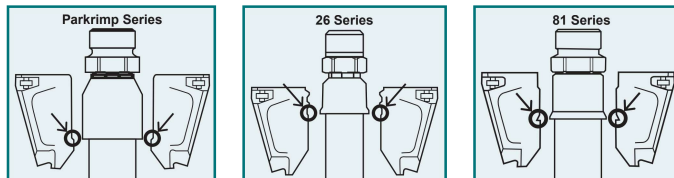
### 2 Insert unitized die train



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

**Important:** Lubricate the crimper's 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

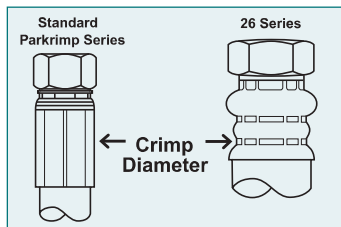


Place correct die ring on top of the dies. See decal on crimper for proper die ring.



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

### 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 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.

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

### Hose insertion depths

Fitting Size	Fitting Series																		
	25		26		43		70		71		77		79		81		HY		
	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	
-4	-	-	0.81	21	0.81	21	-	-	-	-	-	-	-	-	-	-	-	1.38	35
-5	-	-	0.81	21	0.94	24	-	-	-	-	-	-	-	-	-	-	-	1.41	36
-6	0.88	22	0.81	21	1.13	29	1.06	27	1.06	27	-	-	-	-	-	-	-	1.35	34
-8	0.88	22	0.81	21	1.31	33	1.31	33	1.25	32	1.36	34,6	-	-	-	-	-	1.44	37
-10	-	-	0.88	22	1.56	40	1.38	35	1.31	33	1.53	38,9	-	-	-	-	-	1.46	37
-12	-	-	0.88	22	1.50	38	1.50	38	1.44	37	1.78	45,2	2.18	56	1.12	29	1.55	39	
-16	-	-	1.00	25	1.75	44	1.81	46	1.75	44	2.13	54,1	2.31	59	1.25	32	1.69	43	
-20	-	-	1.00	25	1.88	48	1.75	44	1.81	46	2.51	63,8	2.81	71	1.31	33	-	-	
-24	-	-	1.06	27	1.44	37	-	-	2.31	59	2.67	67,7	-	-	1.31	33	-	-	
-32	-	-	1.25	32	1.81	46	-	-	2.44	62	3.05	77,5	-	-	1.69	43	-	-	

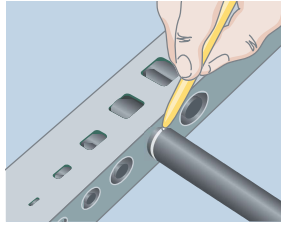
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## Crimping using Parkrimp 2

Parkrimp Fittings Series 25, 26, 43, 70, 71, 77, 81, HY

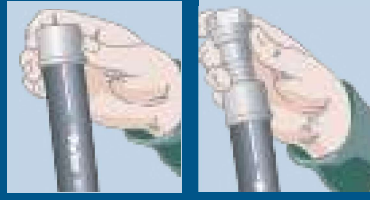
B

### 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

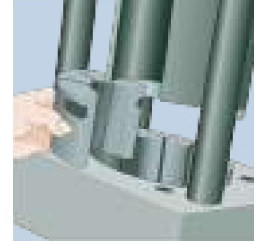


Place 81 Series Shell onto end of hose and make sure the end of the shell lines up with the Insertion Depth mark.

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

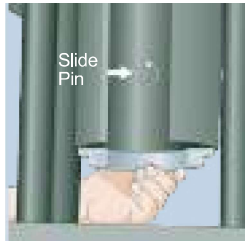
### 2a If using large two-piece dies

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.



C

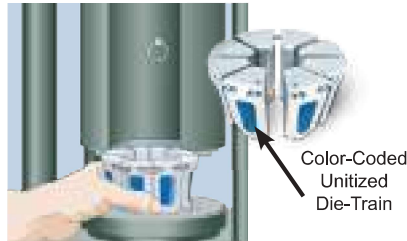
### 2b If using small unitized dies



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.

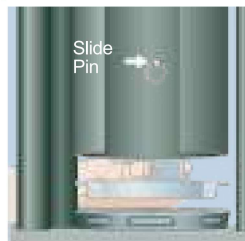
### 3 Place spacer ring



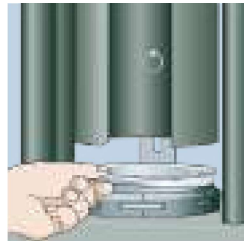
If required, place spacer ring on locating step of adapter bowl. Reference decal on crimper for tool selection.

D

### 4 Position the split die ring

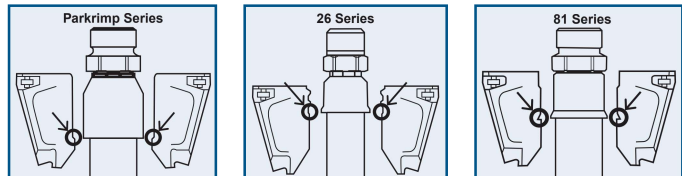


Lower the back half of the split die ring onto the dies by pulling the slide pin forward.



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

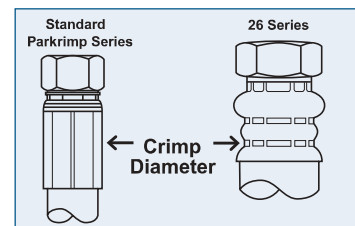
Turn on the pump by pressing the "ON" switch. Pull the valve handle forward to bring the pusher down for crimping. When the split die ring contacts the base plate, the crimp is complete. Push the valve handle back to lift the pusher, open the dies, and release the finished assembly.

**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.

# Assembling Twin Tough Rubber Hose

## Required Equipment:

Twin Tough hose, fittings, knife, tape measure, heat shrink sleeve, scissors, grease pencil, heat gun, and calipers.



## Set-up:

Position the bonded rubber hose so that it lies flat on a work surface without tendency to twist or turn.

**Measure hose tear back length:** Measure and mark the length that the hoses are to be separated. A minimum of 12 inches is required for crimping the hose ends. A 24 inch tear back is recommended for use with hydraulic tools.



Note: If length of separation/tear back is specified from the threaded or swivel nut end of the coupling, then deduct the cut off allowance dimension for the specific style of coupling used. The cutoff allowance can be obtained from the hose fitting tables in the 4400 Catalog "B" dimension, or can be calculated by subtracting the insertion depth of the shell from the overall coupling length.

## Cut hose tear back to length:

Press the bonded hose assembly firmly and flat against the work surface with your free hand so that it does not move.

A.) Using a sharp blade, pierce the center of the valley (web) formed by the hoses.



B.) To start the cut, place the blade in the center of that valley (web) drawing the knife with constant pressure.



C.) Once you have a 1 to 2 inch starter cut, firmly pull each hose end apart to your required separation length.



Note: It is important that the knife blade be perpendicular to the hose during this procedure so the blade cuts only the centerline of the valley (web). **EXTREME CARE MUST BE TAKEN TO AVOID CUTTING THROUGH THE COVER OF THE HOSES AND THEREBY EXPOSING THE HOSE REINFORCEMENT.** If this occurs, the hose assembly must be discarded.

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**Measure Separation:** It is suggested that the separation length be at least 12 inches, so the crimping operation can be accomplished without risk of kinking the hoses.



B

**Stopping Separation:** Parker recommends installing a heat shrink sleeve of at least 2 inches in length at the termination of the separated hose to provide protection against tearing of the valley (web) or hose covers. This heat shrink sleeve should be placed on the hose assembly prior to the crimping of the hose fittings. Once you have your heat shrink sleeve in place, use a heat gun to shrink the sleeve in place.



C

Note: EXTREME CARE MUST BE TAKEN TO AVOID EXPOSING THE HOSE ASSEMBLY TO THE DIRECT HIGH TEMPERATURES OF THE HEAT GUN WHILE INSTALLING THE HEAT SHRINK SLEEVE. LONG EXPOSURE FROM A HEAT GUN MAY ADVERSELY AFFECT THE HOSE INNER TUBE OR ITS COVER.

D

**Crimping Fittings:** All of your crimping information can be found on Crimpsource ([www.parker.com/crimpsource](http://www.parker.com/crimpsource)).

First, place your fittings onto each hose end making sure that both have been installed to the correct hose insertion depth. Choose the correct die and die rings. Place half of your hose assembly through the bottom of your Parkrimp crimper. Rest the bottom of the fitting on the die step using the Parkalign system. While lightly holding the hose assembly, operate your crimper pump so that the pusher on the crimper comes down in contact with the die ring until it bottoms out on the crimper base. Then release the pressure within the pump and remove the first half of your finished assembly. Always measure your hose assemblies for the correct crimp diameter. Now, repeat the crimping process on the other fitting.



Note: EXTREME CARE MUST BE TAKEN TO AVOID KINKING THE HOSE THAT IS NOT BEING CRIMPED DURING THIS PROCESS.

## Hose Cut-Off Machine

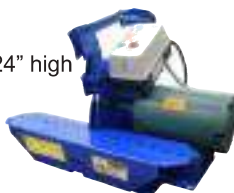
Part No. 86C-220V

### Features

- Engineered for workshop, retail, or production use
- Cuts hoses with less friction, no heat, and less debris
- Vacuum port eliminates any very small amount of smoke or debris created
- Comes standard with a Parker branded advanced scallop blade
- Cuts wire reinforced hoses including 6 heavy wire constructions up to 2" ID

### Specifications

- Dimensions: 27" wide X 16.5" long X 24" high (when handle is at the highest point)
- Shipping Weight: 108 lbs



[view on web page](#)

### Standard Equipment

Part Number	Description	Individual Part Number
86C-220V		
●	Hose cut off machine with 220V single phase motor	
●	Parker branded advanced scallop blade- 10" OD x .125 THK X 40 mm arbor	HYD10X125X40

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

## Hose Cut-Off Machine

Part No. 86C-220V3

### Features

- Engineered for workshop, retail, or production use
- Cuts hoses with less friction, no heat, and less debris
- Vacuum port eliminates any very small amount of smoke or debris created
- Comes standard with a Parker branded advanced scallop blade
- Cuts wire reinforced hoses including 6 heavy wire constructions up to 2" ID

### Specifications

- Dimensions: 27" wide X 16.5" long X 24" high (when handle is at the highest point)
- Shipping Weight: 108 lbs



[view on web page](#)

### Standard Equipment

Part Number	Description	Individual Part Number
86C-220V3		
●	Hose cut off machine with 220V three phase motor	
●	Parker branded advanced scallop blade- 10" OD x .125 THK X 40 mm arbor	HYD10X125X40

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

## Hose Cut-Off Machine

Part No. TH3-EM3-110V

### Features

- Engineered for workshop or production use
- Comes with a vacuum port to remove smoke and debris while cutting
- Comes standard with a diamond-coated cutting blade
- Cuts wire reinforced hoses including 6 heavy spiral constructions up to 1 1/4" I.D.

### Specifications

- Dimensions: 17" wide, 21" long and 12" high
- Shipping Weight: 95 lbs.



[view on web page](#)

### Standard Equipment

Part Number	Description	Individual Part Number
TH3-EM3-110V		
●	Hose cut-off machine with 110V single phase motor	
●	Industrial diamond coated cutting blade	TM-V
	Cutting blade with inclined slots	TM-G
	Flat cutting blade	TM-F

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

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## Premium Hose Cleaning Kit



[view on web page](#)

Part No. TH6-10-HL-10-2 (10 Nozzle Kit)

B

## Economy Hose Cleaning Kit



[view on web page](#)

Part No. TH6-10-EL-8 (8 Nozzle Kit)

C

### Features

- Capable of cleaning 1/4" through 2" hose, tube or pipe
- The launcher is supplied with a Full-Flow Quick Release Coupling and unique 360° Rotary Plug for proper air flow and non-fatigue operator use
- Unique Safety Release Bar that locks the faceplate into a closed position for firing Ultra Clean projectiles

D

### Nozzles Included in Kits

End Type	Size	Nozzle Part Number*	Projectile Part Number†	Projectile Quantity†
Hose	1/4"	TH6-10-H06	TH6-10-P10	100
Hose	5/16"	TH6-10-H08	TH6-10-P12	100
Hose	3/8"	TH6-10-H10	TH6-10-P14	100
Hose	1/2"	TH6-10-H13	TH6-10-P18	100
Hose	5/8"	TH6-10-H16	TH6-10-P22	50
Hose	3/4"	TH6-10-H19	TH6-10-P26	50
Hose	1"	TH6-10-H25	TH6-10-P33	40
Hose	1-1/4"	TH6-10-H32	TH6-10-P40	30
Hose	1-1/2"	TH6-10-H38	TH6-10-P50	20
Hose	2"	TH6-10-H50	TH6-10-P60	15

\*Nozzles are not available individually

†Projectiles sold separately

### Additional Available Nozzles

End Type	Size	Nozzle Part Number	Projectile Part Number†	Projectile Quantity†
JIC	1/4"	TH6-10-J06	TH6-10-P06	100
JIC	3/8"	TH6-10-J10	TH6-10-P12	100
JIC	1/2"	TH6-10-J13	TH6-10-P16	100
JIC	5/8"	TH6-10-J16	TH6-10-P22	50
JIC	3/4"	TH6-10-J19	TH6-10-P26	50
JIC	1"	TH6-10-J25	TH6-10-P33	40
JIC	1-1/4"	TH6-10-J32	TH6-10-P40	30
JIC	1-1/2"	TH6-10-J38	TH6-10-P50	20
JIC	2"	-	TH6-10-P60	15

†Projectiles sold separately

### Features

- Capable of cleaning 1/4" through 1-1/4" hose, tube or pipe
- Has a quarter-turn locking ring for easy nozzle change and projectile loading
- The launcher is constructed of durable brass and aluminum internals, strong plastic handle, and anodized aluminum firing head and locking ring.
- Ideal for mobile and job site applications because of its size and portability



### Air Requirements

- 80 PSI (5.5 Bar) minimum to 110 PSI (7.5 Bar) maximum
- 1/2" I.D. air hose
- 5 micron filter and regulator with gauge are strongly suggested
- Requires a 1/2" I.D. air hose with 80 PSI (minimum) / 110 PSI (maximum), and it is strongly recommended that you use a 5 micron filter and regulator with a gauge.

## Parker Clean Seal

Parker's Clean Seal cap is a simple, easy and clean alternative to cap your hose and fitting assemblies. The Clean Seal cap enables a secure fit due to an easy to use heat shrink system. Reduce your cap complexity as one Clean Seal cap will seal multiple end configurations and sizes, eliminating many unique traditional caps.

The Clean Seal process utilizes heat shrink technology to cover the end of a hose assembly. The heat shrink technology eliminates problems due to re-contamination issues. When traditional caps and plugs are forced onto assemblies, plastic debris and particles shred off into your hose, ultimately causing re-contamination.

### Product Features:

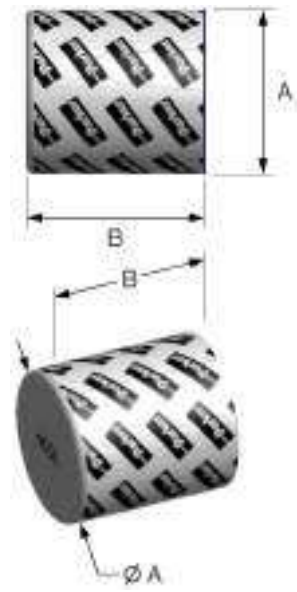
- For use on fittings up to -24 (1-1/2")
- Fits straight and elbow fittings
- Easy pull tab removal
- Reduced environmental impact compared to traditional caps
  - Less plastic used
  - More crushable
- Multiple hoses can be capped at one time



[view on web page](#)

### Cap Part Numbers

Packaged		Bulk		Sizing	
Parker P/N (Package)	Package Quantity	Parker P/N (Bulk)	Bulk Quantity	Hex Sizes Covered (in mm)	Hex Sizes Covered (in inches)
PCS-2023P	810	PCS-2023B	23,400	12mm to 18mm	.47" to .71"
PCS-2030P	810	PCS-2030B	23,400	12mm to 18mm	.47" to .71"
PCS-2224P	810	PCS-2224B	23,500	16mm to 21mm	.63" to .83"
PCS-2527P	800	PCS-2527B	17,600	18mm to 23mm	.71" to .91"
PCS-2540P	800	PCS-2540B	17,600	18mm to 23mm	.71" to .91"
PCS-2840P	720	PCS-2840B	15,200	22mm to 26mm	.87" to 1.02"
PCS-3133P	640	PCS-3133B	12,240	24mm to 29mm	.94" to 1.14"
PCS-3140P	640	PCS-3140B	12,240	24mm to 29mm	.94" to 1.14"
PCS-3440P	640	PCS-3440B	10,240	27mm to 32mm	1.07" to 1.26"
PCS-3840P	560	PCS-3840B	7,800	30mm to 36mm	1.09" to 1.42"
PCS-4345P	480	PCS-4345B	6,240	32mm to 41mm	1.26" to 1.61"
PCS-4650P	480	PCS-4650B	5,760	34mm to 44mm	1.34" to 1.73"
PCS-5260P	400	PCS-5260B	4,400	41mm to 50mm	1.62" to 1.97"
PCS-5860P	400	PCS-5860B	3,600	49mm to 56mm	1.93" to 2.20"
PCS-6760P	320	PCS-6760B	2,560	55mm to 65mm	2.16" to 2.56"



**PCS-4650B**

"A" "B" B=Bulk  
P=Package

"A" and "B" dimensions in mm. Shorter length capsules recommended for elbow/bent fittings.

### Equipment Part Numbers

UC-CSS-230V	UC-HL1910E	UC-HG-STAND	UC-1.5HD
Production Heat Shrink machine with timer 	Electric heat gun with case 	Flex vacuum pumpstand for heat gun 	95mm diffuser for 1-1/2" heat gun connection 



A

## Hose Cut-Off Tool - Handykut

Part No. 871522



view on web page

### Features

- Portable tool for efficient cutting of hose
- Can be positioned onto a flat surface by clamps or by locking it in a vise, properly align the hose in a radius and cut it with a hacksaw

### Specifications

- Dimensions: 6" wide x 18" long x 6" high
- Shipping Weight: 10 lbs.

B

## Push-Lok Cut-Off & Assembly Tool

Part No. 881540



view on web page

### Features

- Combined hose cutter and toggle action press that cuts and assembles Parker Push-Lok in sizes 1/4" through 3/4" I.D.

### Specifications

- Dimensions: 16" long
- Shipping Weight: 4 lbs.

**⚠ WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

C

## Hose Insertion Depth Blocks

Part No. TH9-1-XXX



view on web page

### Features

- For quick easy marking of hose insertion depth
- Ensures accuracy and increased productivity

### Available Blocks

Part Number	Description
TH9-1-26A	26 Series -4 through -10
TH9-1-26B	26 Series -12 through -32
TH9-1-43A	43 Series -4 through -10
TH9-1-43B	43 Series -12 through -32
TH9-1-77	77 Series -8 through -32
TH9-1-HY	HY Series -4 through -16

**⚠ WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

D

## Hose Cut-Off Tool

Part No. TH11-1



view on web page

### Features

- Designed for quick, easy cutting of textile reinforced hose.
- Squarely cuts Push-Lok hose in sizes 1/4" through 3/4" I.D.

### Specifications

- Dimensions: 8" long
- Shipping Weight: 0.3 lbs.

## Hozemblem

Part No. 432-115V



[view on web page](#)

### Features

- Power machine to facilitate the attachment of field attachable fittings
- Handles all hose and fittings up to 4 spiral wire, in sizes 3/16" through 2" I.D., including bent tube elbows
- Comes with vise, all adapters, foot switch and safety guard with 115V, 30 amp, universal AC motor

### Specifications

- Shipping Weight: 141 lbs.

### Optional Parts

- Mounting stand (662451)

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

## Swivel Die Rack

Part No. 80C-SDR-XXXX



[view on web page](#)

### Features

- Holds up to 30 Parkrimp dies of any size
- Powder-coated, heavy-duty steel construction
- Consists of a base unit and up to five circular holders
- Floor or bench mounted

### Standard Equipment

Part Number	Description
80C-SDR-SM	Swivel Die Rack and Small Die Holder
80C-SDR-LG	Swivel Die Rack and Large Die Holder
80C-SDR-BASE	Swivel Die Rack Base

## Die Storage Racks

Part No. 80C-0DR and 83C-0DR



[view on web page](#)

### Features

- Modular die rack designed to hold small and large Parkrimp dies
- Can be bolted together to a work bench horizontally or vertically

### Standard Equipment

Part Number		Description
80C-0DR	83C-0DR	
●		Storage of three sets of small dies
	●	Storage of two sets of large dies

## Fitting Push-On Stand

Part No. TH2-7



[view on web page](#)

### Features

- Quickly and easily pushes fittings onto hose
- Boosts productivity and quality
- Eliminates the need of rubber mallets and oils to get fittings onto the end of the hose for crimping
- Standard with straight tooling required for sizes 1/4" through 2" for all crimped fittings, 82 Series Push-Lok and 88 Series field attachable fittings

### Specifications

- Requires a minimum of 80 psi
- Shipping Weight: 200 lbs.

### Optional Tooling

- Elbow Pusher Set (TH2-7-ELS)
- -32 Monoblock Elbow Pusher Set (TH2-7-ELSH)

**WARNING:** This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov).

