



Equipment

EQUIPMENT

Visit Crimpsource at
www.parker.com/crimpsource, your online
resource for hose crimp specifications.



Minikrimp

Karrykrimp

Parkrimp 1

PHastkrimp








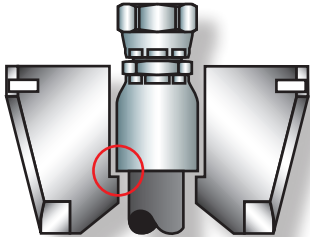




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<p>Karrykrimp C-6</p> 	<p>Parkrimp 1 C-6</p> 	<p>Karrykrimp 2 C-8</p> 
<p>DE30 C-10</p> 	<p>DE100 C-11</p> 	<p>TH8-D206 C-12</p> 
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Hose Assemblies Are Easy With the Parkrimp System.

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

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.

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.



Our low profile design makes routing hose assemblies easy.

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

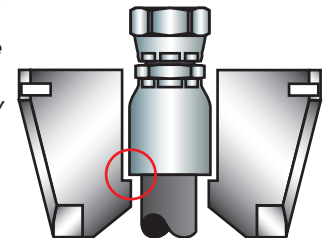
Eight segment crimp dies provide a smooth, even, 360-degree crimp.

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.



Be sure to check www.parker.com/crimpsource for the most up to date information and crimp specifications.

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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.

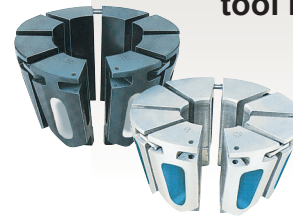
Example:

Hose	451TC-4
Fitting	43 Series
Die Body Color	Silver
Die Cavity Color (-4)	RED

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-14 and C-15. (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 Series Die Body Color	70 & 71 Series Die Body Color	73, 78, S6 & 79 Series Die Body Color	76 Series Die Body Color	26 Series Die Body Color	81 Series Die Body Color
		Silver	Black	Olive Drab	Silver	Silver	Silver
-4	RED		N/A	N/A	N/A		N/A
-5	PURPLE		N/A	N/A	N/A		N/A
-6	YELLOW			N/A	N/A		N/A
-8	BLUE			N/A	N/A		N/A
-10	ORANGE			N/A	N/A		N/A
-12	GREEN						
-16	BLACK						
-20	WHITE				N/A		
-24	RED				N/A		
-32	GREEN				N/A		

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

Reference pages C-6 through C-12 for specific tool information regarding hose, fitting, and crimper combinations.



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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-18 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-0HP
●	●	●		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-14 and C-15.
- 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
		- 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 351ST 436 472TC 422 451TC 482TC 424 451ST 482ST 426 471TC	43 Series	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	Silver	
421WC 304 601 302/301 341 604 301LT 381 881		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	2.010 2.030	Black	
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				
AX	HY Series	0.575 0.595		0.725 0.745	0.830 0.850	0.960 0.980	1.110 1.130			Silver	
Die		80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170				
BXX		0.635 0.655		0.805 0.825	0.915 0.935	1.040 1.060	1.200 1.220			Black	



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: 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



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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-18 for information on available power units

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**.

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

Note:

- For crimp instructions, see pages C-14 and C-15.
- 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/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
Die				- 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	
351TC	431	471ST	43 Series	0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	Silver
351ST	436	472TC		0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990	
422	451TC	482TC		0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	Black
424	451ST	482ST		0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030	
426	471TC											
421WC	304	601	70 Series			83C-D06	83C-D08	83C-D10				Black
302/301	341	604				0.990	1.140	1.260				
301LT	381	881			1.010	1.160	1.280					
Die			71 Series			83C-D06	83C-D08	83C-D10	83C-D12	83C-D16	83C-D20	Silver
711	721ST	772ST				0.950	1.100	1.220	1.355	1.695	2.025	
721	772TC	774			0.970	1.120	1.240	1.375	1.715	2.045		
Die			73 Series						80C-L12	80C-L16		Silver
731									1.420	1.730		
								1.440	1.750			
Die			78 Series						80C-L12	80C-L16		Silver
78C	781	782ST							1.420	1.730		
	782TC							1.440	1.750			
Die			26 Series	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16		Silver
213	285	293		0.460	0.520	0.575	0.670	0.805	0.915	1.175		
				0.480	0.540	0.595	0.690	0.825	0.935	1.195		
201	221FR	266	81 Series						80C-V12	80C-V16	80C-V20	Silver
206	225	CAH							1.155	1.450	1.740	
	244	SS25UL							1.175	1.470	1.760	
Die			HY Series	80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120	80C-H1365		Silver
AX				0.575		0.725	0.830	0.960	1.110	1.355		
				0.595		0.745	0.850	0.980	1.130	1.375		
Die					80C-H605	80C-H775	80C-H885	80C-H1010	80C-H1170	80C-H1465		Black
BXX			0.635		0.805	0.915	1.040	1.200	1.495			
					0.655	0.825	0.935	1.060	1.220	1.515		



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. 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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DE30

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Technical**Description**

The DE crimpers simplify the gauging aspects of crimping and the pusher retraction stop reduces cycle-time, enabling users to make hydraulic hose assemblies faster.

Strong, lightweight top and bottom plates, one-piece handle and base design and a new micrometer gauging mechanism are features that make the DE30 ideal for portable hose assembly. The DE30's four strain rods reinforce precision and durability while color-coded die sets make finding the right one easy. The crimper is easily customized with a choice of operational pumps, dies and a storage box.

Features

- Supersedes EC30 and K-16 crimpers
- 30 ton cylinder
- Four strain rods for greater durability and crimping precision
- New micrometer gauging mechanism for greater accuracy and reliability
- Improved one piece handle and base design for easier field and vehicle installation
- Strong and lightweight base plate and top plate for improved portability
- Color coded die rings make selection easy
- Detachable pusher and pusher plate

Capability

- Crimps through 1" ID 2-wire braid hose and 4-spiral wire hose with EN00-021 Die set kit and pusher

Power Source(s)

- Hand Pump (EC30-22, optional)
- Air hydraulic pump (EC30-23, optional)
- Electric hydraulic pump (P-116-10), ½ HP, 115 VAC, 60Hz

Dimensions

- 12.75" wide x 19" deep x 20" high

Weight

- 48 pounds (less pump and die sets)

Options

- Pump
 - Hand pump
 - Air powered hydraulic pump
 - Two-stage electric pump – ½ HP 115 VAC 60Hz
- Dies
 - Color coded split ring die sets
 - Color coded solid die ring set
 - Notched bent tube pusher plate
 - Die storage box
 - Quick disconnect fitting for pump hose

DE100



Description

The DE100 brings “do-all” power to users. Capable of crimping 2” SAE100R13 hose using standard die set included with the machine, this is a cost effective crimper available to hose assemblers today. Standard features include a coupling stop, pusher retraction stop, eleven standard color-coded die sets and a built-in pump with foot pedal.

Features

- Supersedes WB60, K-24 and K-601 crimpers
- 100-ton cylinder. Four strain rods for greater durability and crimping precision
- New micrometer gauging mechanism with limit switch for greater accuracy and reliability
- New simplified controller design with emergency stop and circuit breaker integrated with “on/off” power switch for added safety
- New pusher retraction stop for reduced cycle-time of same-assembly crimping
- New coupling stop attaches to standard pusher plate to ease locating couplings in die sets
- Color coded die rings make die selection easy
- Die storage shelving, detachable pusher, large pusher plate, standard pusher plate, notched bent tube pusher plate and small die cone base insert are included
- 10,000 psi two-stage electric pump with foot pedal included

Capability

- Crimps through 2” 2-wire braid hose with standard die sets
- Crimps through 2” 4-spiral wire hose with standard die sets
- Crimps through 2” 6-spiral wire hose with standard die sets

Power Source(s)

- 3 hp 220VAC 60hz, or 50hz\single phase

Dimensions

- 41” wide x 30” deep x 35” high

Weight

- 500 lbs. (approximate with standard die sets, pump and shelving)

Options

- (purchased separately)
- Additional color coded split die ring sets
 - Color coded solid die ring sets
 - KDB die sets

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TH8-D206



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Description

The TH8-D206 is a single-phase, 80-ton, bench mounted crimper. Available in 115 volt, the TH8-D206 replaces Parker's previous crimper model DE60 and, in most cases, can replace the DE100.

Features

- Available in 115 volt, single-phase with standard 50/60 Hz motor
- 80 ton crimper with crimping capabilities greater than the DE60
- Capabilities include up to
 - 1 1/2" six-spiral
 - 2" four-spiral
 - Stainless steel fittings
- Tooling and crimp settings are the same as DE60 / DE100. Tooling is ordered separately.
- Adapter bowls made for the use of existing DE60 / DE100 dies

CRIMPSOURCE

Description

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:

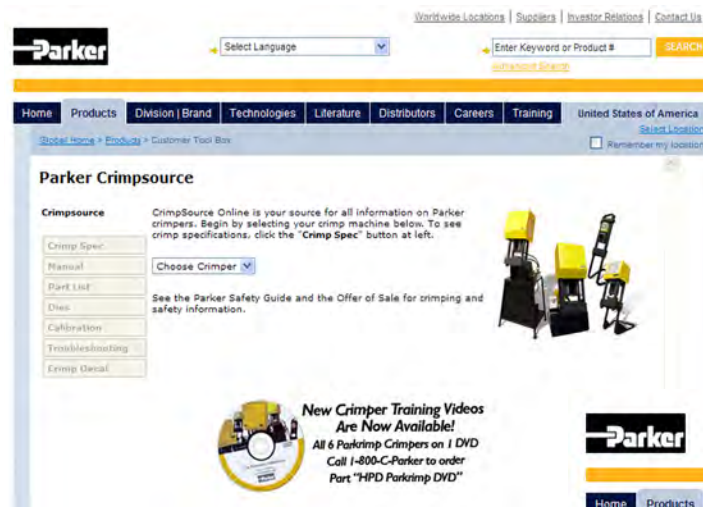
- Crimp specs
- PDFs of technical manuals for easy downloading
- Parts lists
- Troubleshooting advice
- PDFs of crimper decals

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

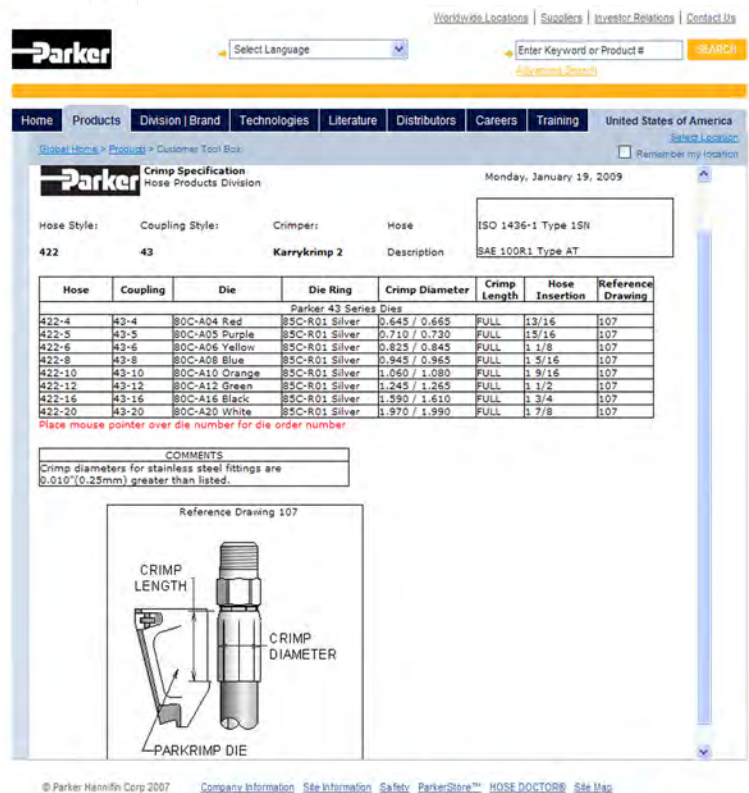
A series of dropdown menus enables users to find what they need quickly and easily.

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.



Crimpsource Home Page



Crimpsource Spec Page

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

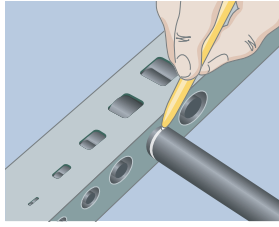
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1 Mark insertion depth and push on fitting



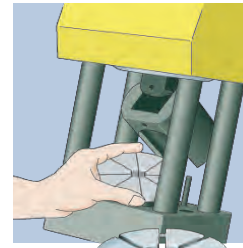
Mark the hose insertion depth and push hose into fitting until the mark on the hose is even with the end of the shell. Lubricate hose if necessary, however, **DO NOT lubricate if using spiral hose.** See Hose Insertion Depth table below.



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



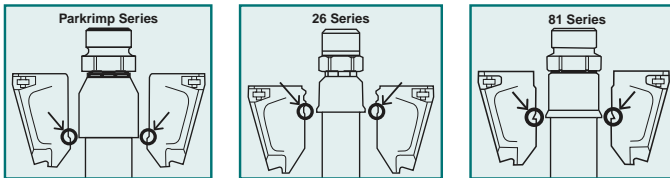
Pull pin at the top of pusher to swing it back. Place unitized die-train into base plate. See decal on crimpers for proper die set.

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.

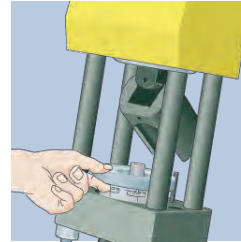
Color-Coded Unitized Die-Train

3 Position the fitting

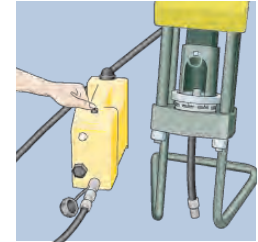


Position the hose and fitting in dies from below. Rest bottom of coupling on die step using the PARKALIGN® feature.

4 Place die ring and crimp



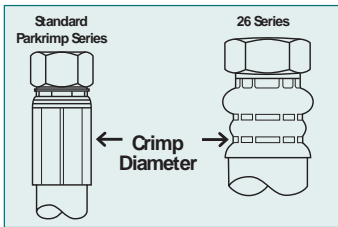
Place correct die ring on top of the dies. See decal on crimpers for proper die ring.



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	—

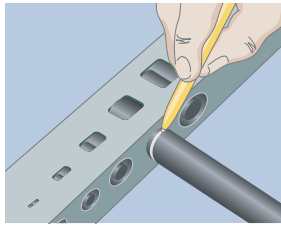
For specific information on crimping, visit Crimpsource™ online at www.parker.com/crimpsource.



Crimping using Superkrimp and Parkrimp 2

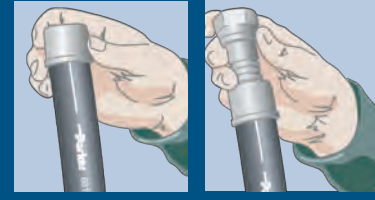
Parkrimp Fittings Series 25, 26, 43, 70, 71, 73, 76, 78, S6, 81, HY

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

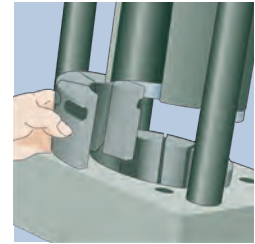


Place 81 Series Shell onto end of hose and make sure the end of the shell lines up with the Insertion Depth mark.

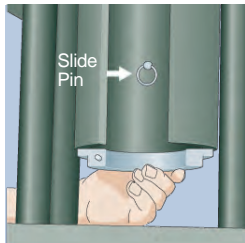
Push hose onto the 88 Series fitting until the shell bottoms against the fitting's stop ring or hex. Lubricate hose if necessary.

2a If using large two-piece dies

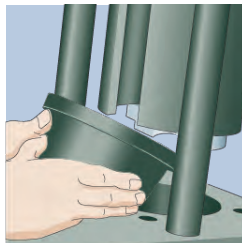
Insert the proper die set into the die bowl. (The die sets are in two halves of four dies each. Place one half in the back and one half in the front to accommodate bent tube fittings.) Reference decal on crimper for proper tool selection.



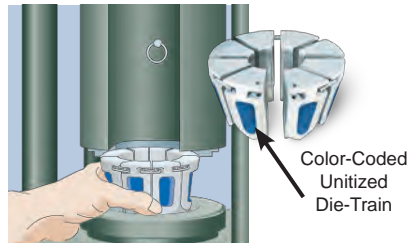
2b If using small unitized dies



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.

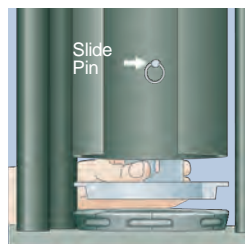
Note: Die sets have color-coded cavities indicating size and have the fitting series and dash size stamped on the top.

3 Place spacer ring

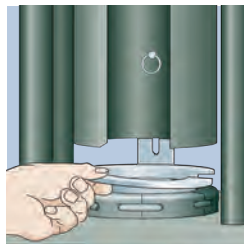


If required, place spacer ring on locating step of adapter bowl. Reference decal on crimper for tool selection.

4 Position the split die ring

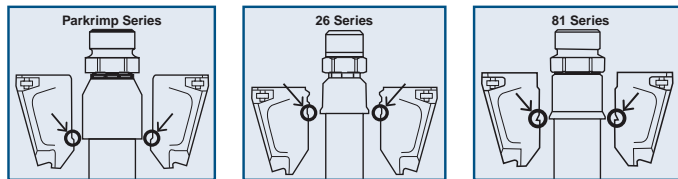


Lower the back half of the split die ring onto the dies by pulling the slide pin forward.



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

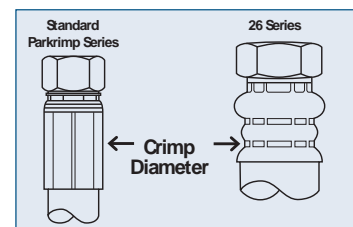
Turn on the pump by pressing the "ON" switch. Pull the valve handle forward to bring the pusher down for crimping. When the split die ring contacts the base plate, the crimp is complete. Push the valve handle back to lift the pusher, open the dies, and release the finished assembly.

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
B

Parkrimp Equipment
C

Accessories
D

Technical
E

Assembling Twin Tough Rubber Hose

Hose
A

Required Equipment:

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



Fittings
B

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.



Parkrimp Equipment
C

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.

Accessories
D

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.



Technical
E

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.

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.



Stopping Separation: Parker recommends installing a heat shrink sleeve of at least 2 inches in length with the appropriate I.D. (Table 1) 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.



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 ADVERSLEY AFFECT THE HOSE INNERTUBE OR ITS COVER.

Crimping Fittings: All of your crimping information can be found on Crimpsource (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 ring. 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
A

Fittings
B

Parkrimp Equipment
C

Accessories
D

Technical
E

A Hose

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

B Fittings

Electric Pump

Part No. 82C-0EP



(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)
Ease of operation hand pump delivers 10,000 psi

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

Electric Pump

Part No. 85C-0EP



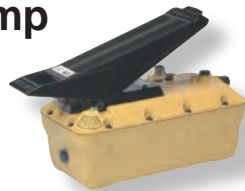
(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)
Heavy duty electric pump delivers 10,000 psi at a faster cycle time

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

C Parkrimp Equipment

Air/Hydraulic Pump

Part No. 82C-0AP



(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)
Lightweight pump operates with 80-150 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

Vehicle Battery-Powered Pump

Part No. 85C-12V



(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)
Ideal unit for Parker Mobile Hose Preplacement Service, Delivering 10,000 psi.

Length: 12"
Width: 8"
Height: 19.5"
Weight: 67 lbs
Hydraulic Fluid: ISO-46

D Accessories

E Technical

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.





Hydraulic Press Kit

Part No. 8PC-001

For use with 26, 43, 81 and HY Series Fitting ONLY

Specifications

- Required Height from Press Base to Press Ram: 10 inches
- Required Width of Bowl Diameter: 5 inches
- Bowl Rating: 30 tons force maximum
- Minimum Required Press Capacity: Hose Size 1/4" to 1/2" needs a 20 ton press
Hose size 5/8" to 1-1/4" needs a 30 ton press

Standard Equipment

Part Number	Description	Individual Part Number
8PC-001		
●	Bowl Assembly	8PC-030
●	Pusher	8PC-00P
●	Silver Die Ring	81C-R01
●	Black Die Ring	81C-R02
●	43 Series dies in 1/4", 3/8", 1/2", 3/4" and 1"	80C-Axx

Weatherhead Conversion Kit

Part No. 8WC-001

For use with 26, 43, 81 and HY Series Fitting ONLY

Convert *Weatherhead T-400 crimper* to utilize Parker Parkrimp No-Skive fittings.

Standard Equipment

Part Number	Description	Individual Part Number
8WC-001		
●	Bowl Assembly	8PC-030
●	Pusher	8WC-00P
●	Silver Die Ring	81C-R01
●	Black Die Ring	81C-R02
●	43 Series Dies in 1/4", 3/8", 1/2" and 3/4"	80C-Axx



Gates Conversion Kit

Part No. 8GC-002

For use with 26, 43, 81 and HY Series Fitting ONLY

Convert *Gates 701, 703 and 707 bottom loading crimpers* to utilize Parker Parkrimp No-Skive fittings.

Standard Equipment

Part Number	Description	Individual Part Number
8GC-002		
●	Bowl Assembly	8PC-030
●	Silver Die Ring	81C-R01
●	Black Die Ring	81C-R02
●	43 Series Dies in 1/4", 3/8", 1/2", 3/4" and 1"	80C-Axx



Notes:

- For additional information and operating instructions, visit the Parker Hose Products Division website at www.parkerhose.com.
- For crimping instructions, see pages C-14 and C-15.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.

Hose
A

Fittings
B

Equipment Conversion Kits
C

Accessories
D

Technical
E

A Hose

B Fittings

C Equipment Cut-Off Machines

D Accessories

E Technical

Hose Cut-Off Machine

Part No. 332T-115V



Features

- For quick, easy cutting of spiral reinforced hose up to 1-1/4" I.D.
- Moving parts shielded by guards

Specifications

- Dimensions: 13" wide x 26" long x 22" high
- Shipping Weight: 71 lbs.

Standard Equipment

Part Number	Description	Individual Part Number
332T-115V		
●	Hose Cut-Off Machine with 1-1/2 HP, 3450 RPM, 115/230V single phase electric motor wired for 115V	
●	Scallop Cutting Blade (8" with 5/8" arbor size)	24398

Optional Equipment

- Smooth Cutting Blade (580661)

Hose Cut-Off Machine - Karrykut

Part No. 631075



Features

- Portable saw for cutting on the job
- Unique clamp system spreads hose as it cuts to prevent blade binding
- Cuts multi-braided wire reinforced hose including 4 spiral construction up to 1-1/4" I.D.

Specifications

- Dimensions: 16" wide x 12" long x 19" high
- Shipping Weight: 58 lbs.

Standard Equipment

Part Number	Description	Individual Part Number
631075		
●	Power saw with 115volt (13 amp) universal AC motor	631140
●	Universal clamp attachment (can be used with any portable power saw unit having a 5/8" arbor, 8" blade capacity)	631076
●	Cutting blade (8" with 5/8" arbor size)	580661

Hose Cut-Off Machine

Part No. 239 and 339



Features

- Designed for heavy duty use
- Cuts multi-braided wire reinforced hose including 6 spiral construction up to 2" I.D.

Specifications

- Dimensions: 22" wide x 42" long x 24" high
- Shipping Weight: 115 lbs.

Standard Equipment

Part Number		Description	Individual Part Number
239	339		
●		Hose Cut-Off Machine with 230V single phase motor	
	●	Hose Cut-Off Machine with 3 HP motor 230V, 3 phase, 60 cycle	
●	●	Scallop Cutting Blade (10" with 3/4" arbor size)	24248

Optional Equipment

- Smooth Cutting Blade (15960)

Hose Cut-Off Machine

Part No. TH3-50



Features

- Standard 14" scalloped blade
- Front plate with useable pins easily holds in place for a straight cut
- Clear face shield

Specifications

- 4.2 HP/115 volts 20 amp 1PH 50/60 cycle motor (a 20 amp dedicated circuit is recommended)
- Dimensions - 22-1/2" wide x 18-1/4" long x 23-1/2" high
- Shipping weight - 65 lbs.
- Blade size - 14" x 0.125" x 1"

Saw Part Number: TH3-50

- Optional Equipment:
- Scalloped Cutting Blade (TH3-50-1)
- Smooth Bevel Cutting Blade (TH3-50-2)

Push-Lok Cut-Off & Assembly Tool

Part No. 881540



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.

Hose Cut-Off Tool

Part No. 316



Features

- Small in size and easy to use
- Quick cutting of textile reinforced hose
- Ruggedly built for years of trouble-free service

Specifications

- Dimensions: 15" long
- Shipping Weight: 6 lbs.

Hose
A

Fittings
B

Equipment Cut-Off Machines
C

Accessories
D

Technical
E

Hose Cut-Off Tool

Part No. TH11-1



Features

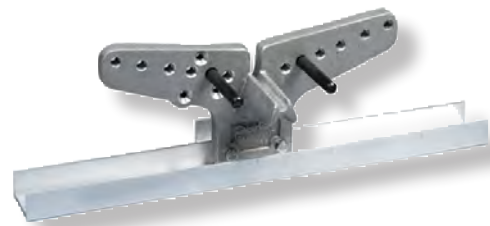
- Designed for quick, easy cutting of textile reinforced hose.
- Squarely cuts Push-Lok hose in sizes 1/4" through 3/4" I.D.

Specifications

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

Hose Cut-Off Tool - Handykut

Part No. 871522



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.

A
Hose

B
Fittings

C
Equipment Fabrication

D
Accessories

E
Technical

Hose Insertion Depth Blocks

Part No. TH9-1-XXX



Features

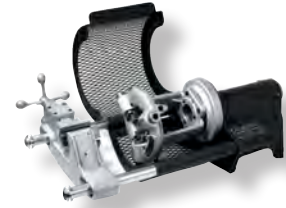
- For quick easy marking of hose insertion depth
- Ensures accuracy and increased productivity

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
TH9-1-70	70 Series -6 through -20
TH9-1-71	71 Series -6 through -32
TH9-1-73	73 Series -12 through -32
TH9-1-78	78 Series -12 through -32
TH9-1-HY	HY Series -4 through -16

Hozenbler

Part No. 432-115V



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)

Fitting Push-On Stand

Part No. TH2-7



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

- Shipping Weight: 200 lbs.

Optional Tooling

- Elbow Pusher Set (TH2-7-ELS)

Die Storage Racks

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



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

Swivel Die Rack

Part No. 80C-SDR-XXXX



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

Hose Perforator

Part No. 601069



Features

- Small hand tool to prick minute holes in the rubber cover
- To be used in gaseous applications where the pressure exceeds 250 psi
- Driven into the cover every few inches of length either striking the hose or by a rolling action over the hose cover
- Not generally necessary to perforate the hose on all sides

Specifications

- Shipping Weight: 2 lbs.

Hose Oil

Part No. Hose Oil



Features

- Reduces torque and eliminates waste lubrication
- Use hose oil with the recommended hose assembly instructions

Accrolube

Part No. Accrolube



Features

- High efficiency lubricant used for stainless steel field attachable fittings
- Contains Teflon to reduce the wear between metal surfaces, protects against corrosion and ultimately eliminates galling

Hose
A

Fittings
B

Equipment Accessories
C

Accessories
D

Technical
E

A Hose

B Fittings

C Equipment Mandrel Kits

D Accessories

E Technical

Mandrels - 25 Series

(For 271 Transportation Hose)

Part No. TH2-7M25-6 and TH2-7M25-8

