



Parker

Material	Temperature	Pressure	Flow Rate	Viscosity
Aluminum	100-200	1000-2000	10-20	100-200
Steel	200-300	2000-3000	20-30	200-300
Copper	300-400	3000-4000	30-40	300-400
Brass	400-500	4000-5000	40-50	400-500
Cast Iron	500-600	5000-6000	50-60	500-600
Stainless Steel	600-700	6000-7000	60-70	600-700
Titanium	700-800	7000-8000	70-80	700-800
Inconel	800-900	8000-9000	80-90	800-900
Monel	900-1000	9000-10000	90-100	900-1000
Nickel	1000-1100	10000-11000	100-110	1000-1100
Carbon Steel	1100-1200	11000-12000	110-120	1100-1200
Low Alloy Steel	1200-1300	12000-13000	120-130	1200-1300
High Alloy Steel	1300-1400	13000-14000	130-140	1300-1400
Aluminum Alloy	1400-1500	14000-15000	140-150	1400-1500
Copper Alloy	1500-1600	15000-16000	150-160	1500-1600
Brass Alloy	1600-1700	16000-17000	160-170	1600-1700
Cast Iron Alloy	1700-1800	17000-18000	170-180	1700-1800
Stainless Steel Alloy	1800-1900	18000-19000	180-190	1800-1900
Titanium Alloy	1900-2000	19000-20000	190-200	1900-2000
Inconel Alloy	2000-2100	20000-21000	200-210	2000-2100
Monel Alloy	2100-2200	21000-22000	210-220	2100-2200
Nickel Alloy	2200-2300	22000-23000	220-230	2200-2300
Carbon Steel Alloy	2300-2400	23000-24000	230-240	2300-2400
Low Alloy Steel Alloy	2400-2500	24000-25000	240-250	2400-2500
High Alloy Steel Alloy	2500-2600	25000-26000	250-260	2500-2600
Aluminum Alloy Alloy	2600-2700	26000-27000	260-270	2600-2700
Copper Alloy Alloy	2700-2800	27000-28000	270-280	2700-2800
Brass Alloy Alloy	2800-2900	28000-29000	280-290	2800-2900
Cast Iron Alloy Alloy	2900-3000	29000-30000	290-300	2900-3000
Stainless Steel Alloy Alloy	3000-3100	30000-31000	300-310	3000-3100
Titanium Alloy Alloy	3100-3200	31000-32000	310-320	3100-3200
Inconel Alloy Alloy	3200-3300	32000-33000	320-330	3200-3300
Monel Alloy Alloy	3300-3400	33000-34000	330-340	3300-3400
Nickel Alloy Alloy	3400-3500	34000-35000	340-350	3400-3500
Carbon Steel Alloy Alloy	3500-3600	35000-36000	350-360	3500-3600
Low Alloy Steel Alloy Alloy	3600-3700	36000-37000	360-370	3600-3700
High Alloy Steel Alloy Alloy	3700-3800	37000-38000	370-380	3700-3800
Aluminum Alloy Alloy Alloy	3800-3900	38000-39000	380-390	3800-3900
Copper Alloy Alloy Alloy	3900-4000	39000-40000	390-400	3900-4000
Brass Alloy Alloy Alloy	4000-4100	40000-41000	400-410	4000-4100
Cast Iron Alloy Alloy Alloy	4100-4200	41000-42000	410-420	4100-4200
Stainless Steel Alloy Alloy Alloy	4200-4300	42000-43000	420-430	4200-4300
Titanium Alloy Alloy Alloy	4300-4400	43000-44000	430-440	4300-4400
Inconel Alloy Alloy Alloy	4400-4500	44000-45000	440-450	4400-4500
Monel Alloy Alloy Alloy	4500-4600	45000-46000	450-460	4500-4600
Nickel Alloy Alloy Alloy	4600-4700	46000-47000	460-470	4600-4700
Carbon Steel Alloy Alloy Alloy	4700-4800	47000-48000	470-480	4700-4800
Low Alloy Steel Alloy Alloy Alloy	4800-4900	48000-49000	480-490	4800-4900
High Alloy Steel Alloy Alloy Alloy	4900-5000	49000-50000	490-500	4900-5000

**CAUTION**  
This machine is designed for use with hydraulic fluid. Do not use other fluids. Do not use this machine for applications not intended by the manufacturer. Do not use this machine for applications where the pressure exceeds the rated pressure. Do not use this machine for applications where the temperature exceeds the rated temperature. Do not use this machine for applications where the viscosity exceeds the rated viscosity. Do not use this machine for applications where the flow rate exceeds the rated flow rate. Do not use this machine for applications where the pressure, temperature, viscosity, or flow rate exceeds the rated values. Do not use this machine for applications where the pressure, temperature, viscosity, or flow rate exceeds the rated values. Do not use this machine for applications where the pressure, temperature, viscosity, or flow rate exceeds the rated values.

# Equipment

Parkrimp Crimpers Die Selection Charts  
Pumps Hose Assembly Equipment

# Hose Assemblies Are Easy With the Parkrimp System.

A

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

B

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.

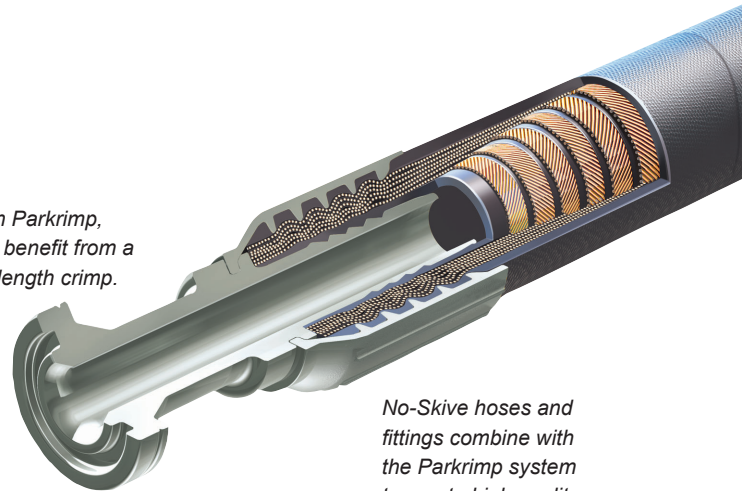
With Parkrimp equipment, anyone can make factory-quality hose assemblies quickly, easily, and cost effectively. Parkrimp machines are simple to operate and they're built to provide years of dependable service. Seven Parkrimp models – an entire family of crimpers – are available to meet your bench-mounted 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.

D

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

E

With Parkrimp, you benefit from a full length crimp.

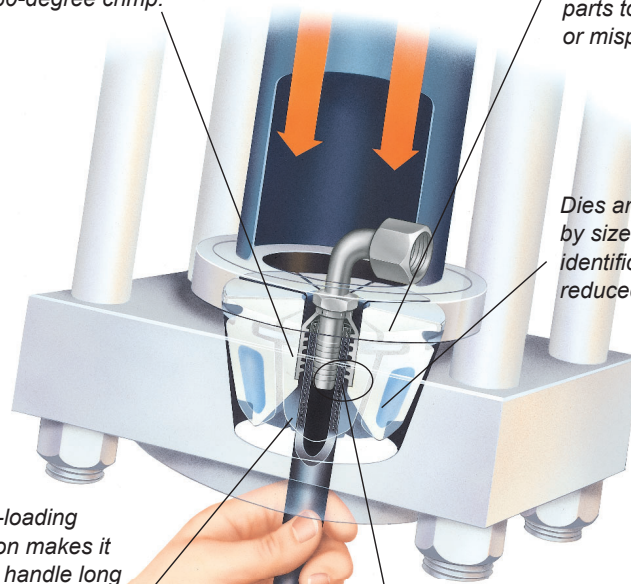


No-Skive hoses and fittings combine with the Parkrimp system to create high quality, reliable hydraulic hose assemblies every time.

Our low profile design makes routing hose assemblies easy.

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

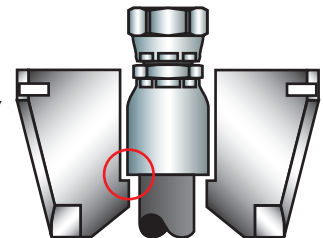
Our linked crimp dies keep die segments together. No loose parts to mismatch or misplace.



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.

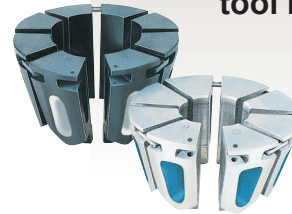
**Example:**

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-16 and C-17. (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	RED		N/A	N/A	N/A	N/A	N/A
-5	PURPLE		N/A	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	N/A
-12	GREEN			N/A		N/A	
-16	BLACK			N/A		N/A	
-20	WHITE				N/A	N/A	
-24	RED				N/A	N/A	
-32	GREEN				N/A	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	

**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-10 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.

A

B

C

D

E



# 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

- 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-13 and C-14 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-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.

# 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)

SCAN FOR CRIMPSOURCE



## 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

- 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-13 and C-14 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-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.
- Parker Hannifin will not accept responsibility for the operation of, or provide warranty coverage for, a crimper that is operated by a power unit other than equipment supplied by Parker Hannifin for the express purpose of operating the crimper.

## 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.

SCAN FOR CRIMPSOURCE



# Parkrimp 1



[view on web page](#)

## Crimping Capabilities:

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

- Up to 1" ID 1 and 2 spiral hose
- Up to 5/8" ID 4 spiral hose
- Up to 3/8" ID 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

## Features

- 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

●	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).

SCAN FOR CRIMPSOURCE



**Note:**

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

# Parkrimp 2



[view on web page](#)

A

B

C

D

E

## Capability

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

## Features

- Easy to use vertical design
- Crimps full range of Parker hoses from 1/4" through 2" I.D.\*
- Crimps both steel and stainless steel fittings\*
- For use with 25, 26, 43, 70, 71, 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 Cycle Time: 30 seconds without adapter bowl, 20 seconds with adapter bowl
- Hydraulic oil: Enerpac oil

## Standard Equipment

Part Number		Description	Individual Part Number
83C-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).

SCAN FOR CRIMPSOURCE



# Phastkrimp 2

## Capability

- Up to 1-1/4" ID 1 and 2 wire hose
- Up to 1-1/4" ID 4 spiral hose
- Up to 1" ID compact spiral hose

## Features

- Designed to make approx. 200 crimps per day
- For use with 25, 26, 43, 77, 81, and HY fittings

## Specifications

- Dimensions: Length 32", width 22", height 38"
- Weight: 530 lbs. with oil
- Rating: 64 tons cylinder force @ 4,500 psi
- Crimp Cycle Time: 7-10 seconds, depending on Pusher position (1/2" 43 series straight fittings).
- Hydraulic oil: ISO Grade 46AW, 5 gallon reservoir capacity
- 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.
- This machine requires the use of the Molykote GN (TH18-100-59) Grease shipped with the 77 Series, -16 die (83C-CS16).



[view on web page](#)

Part Number		Description	Individual Part Number
89CR-061	89CR-062		
●	●	Crimp Head Assembly	89CR-CHD
●		Phastkrimp 2 230 V, 3 phase, 60 HZ	89CR-HPS-3P
	●	Phastkrimp 2 230 V, 1 phase, 60 HZ	89CR-HPS-1P
●	●	Silver die ring	85C-R01
●	●	Black die ring	85C-R02

## 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).

**⚠ 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).

SCAN FOR CRIMPSOURCE

