



Parkrimp 2 Crimp Die Selection Chart

TIP: Attach this chart to your Parker Parkrimp 2 crimper for reference.

P/N: P12 HOSE DECAL 1988			Fittings	Die Selection and Crimp Diameters						P/N: P12 MASTER DECAL 1988			
Die	Part	Part		1/8" BORE 83C-R12	1/4" BORE 83C-R14	3/8" BORE 83C-R16	1/2" BORE 83C-R18	3/4" BORE 83C-R20	1" BORE 83C-R22	1 1/2" BORE 83C-R24	2" BORE 83C-R26	2 1/2" BORE 83C-R28	3" BORE 83C-R30
3317C 3317P 422 424 426	421 426 427C 428 429	427C 427P 4627C 4627P 4628	43 Series	0.940 0.940	0.710 0.720	0.620 0.640	0.940 0.960	1.000 1.000	1.240 1.260	1.300 1.310	1.800 1.800	2.200 2.210	2.710 2.710
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
4278C 4627C 4628P	324 340 380	327 354 380		0.680 0.700	0.750 0.770	0.800 0.820	0.900 0.920	1.000 1.120	1.200 1.300	1.400 1.400	2.000 2.000	2.700 2.770	2.770 2.770
Tools Required				Spacer Ring (83C-R02), Small Silver Die (83C-R10), and Adapter Bowl (83C-OCB)						Spacer Ring (83C-R02), Large Silver Die (83C-R30), and Adapter Bowl (83C-OCB)			
Die			70 Series	83C-R10 0.900 1.000						83C-R30 2.200 2.200			
Tools Required				Spacer Ring (83C-R02), Small Silver Die (83C-R10), and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
711 721 727C	721C 727C 727C	722C 724	71 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			73 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			76 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			78/56 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			79 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			26 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			81 Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die			HY Series	83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			
Die				83C-R10 0.900 0.970						83C-R30 2.200 2.270			
Tools Required				Small Silver Die (83C-R10) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-R30)			



NOTE:

Use the 83C-R12 split die ring for all crimping operations. Stainless steel crimp diameters are 0.010" greater than table listings with the exception of stainless steel HY series fittings which are 0.005" greater than the table listings. Do NOT use lubricants to assemble spiral hose and fittings.

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.

Additional Crimp Die Selection Charts:

Downloaded from www.hfweb.com/technical-info/ or call 888.715.4673.

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Parkrimp 2 Manual

Michael Brown



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