

# Parkrimp 2 Hose Die Selection Chart

PN: PK2 Hose Decal 8/07			Die Selection and Crimp Diameters										PN: PK2 Master Decal 8/07	
Hose			-4 RED	-5 PUR	-6 YEL	-8 BLU	-10 ORG	-12 GRN	-16 BLK	-20 WHT	-24 RED	-32 GRN		
Die			80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	80C-A20	83C-A24	83C-A32		
351TC 351ST 422 424 426	431 436 451TC 451ST 471TC	471ST 472TC 482TC 482ST	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	2.290 2.310	2.735 2.755		
Tools Required			Small Silver Die (80C-AXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-AXX)					
421WC 302/301 301LT	304 341 381	601 604 881	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	2.330 2.350	2.775 2.795		
Tools Required			Spacer Ring (83C-R02), Small Silver Die (80C-AXX), and Adapter Bowl (83C-OCB)						Spacer Plate (83C-R02H) and Large Silver Die (83C-AXX)					
Die			83C-D06		83C-D08	83C-D10								
701 F42 (-8 ONLY)			0.990 1.010		1.140 1.160	1.260 1.280								
Tools Required			Spacer Ring (83C-R02), Small Black Die (83C-DXX), and Adapter Bowl (83C-OCB)											
Die			83C-D06		83C-D08	83C-D10	83C-D12	83C-D16	83C-D20	83C-D24	83C-D32			
711 721 721TC	721ST 727TC	772ST 774	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			
Tools Required			Small Black Die (83C-DXX) and Adapter Bowl (83C-OCB)						Large Black Die (83C-DXX)					
Die			83C-L12				83C-L16	83C-L20	83C-L24	83C-L32				
731			1.420 1.440				1.730 1.750	2.140 2.160	2.440 2.460	3.025 3.045				
Tools Required			Large Olive Drab (83C-LXX)											
Die			83C-U12				83C-U16							
761			1.540 1.560				1.865 1.885							
Tools Required			Large Silver (83C-UXX)											
Die			83C-L12				83C-L16	83C-L20	83C-L24	83C-L32				
P35/78C	781 782TC	782ST	1.420 1.440				1.730 1.750	2.140 2.160	2.440 2.460	3.025 3.045				
Tools Required			* S6 Series Fittings to be used on P35-32 Only Large Olive Drab (83C-LXX)											
Die			83C-L12				83C-L16	83C-L20	83C-L24					
791TC 792TC F42			1.420 1.440				1.730 1.750	2.140 2.160	2.440 2.460					
Tools Required			Large Olive Drab (83C-LXX)											
Die			80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	83C-E20	83C-E24	83C-E32		
213	221FR 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	1.420 1.440	1.670 1.690	2.160 2.180		
Tools Required			Small Silver Die (80C-EXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-EXX)					
201 206	225 244	266 CAH	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		
Tools Required			Spacer Ring (83C-R02), Small Silver Die (80C-EXX), and Adapter Bowl (83C-OCB)						Spacer Plate (83C-R02H) and Large Silver Die (83C-EXX)					
Die			80C-V12				80C-V16	80C-V20	83C-V24	83C-V32				
811 811HT			1.155 1.175				1.450 1.470	1.740 1.760	2.010 2.030	2.430 2.450				
Tools Required			Small Silver Die (80C-VXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-VXX)					
Die			80C-H585	80C-H735	80C-H840	80C-H970	80C-H1120	80C-H1365						
AX			0.575 0.595	0.725 0.745	0.830 0.850	0.960 0.980	1.110 1.130	1.355 1.375						
Tools Required			Small Silver Die (80C-HXXX or 80C-HXXXX) and Adapter Bowl (83C-OCB)											
Die			80C-H605	80C-H775	80C-H885	80C-H1010	80C-H1170	80C-H1465						
BXX			0.635 0.655	0.805 0.825	0.915 0.935	1.040 1.060	1.200 1.220	1.495 1.515						
Tools Required			Spacer Ring (83C-R02), Small Silver Die (80C-HXXX or 80C-HXXXX) and Adapter Bowl (83C-OCB)											

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.The 83C-R12 split die ring is used for all crimping operations. 2.Stainless steel crimper 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. 3.Do not use lubricant to assemble spiral hose and fittings.

Hose  
A  
Fittings  
B  
Parkrimp Equipment  
C  
Accessories  
D  
Technical  
E

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