

**Crimping using Minikrimp, Karrykrimp, Parkrimp 1, Karrykrimp 2 and PHastkrimp**

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

Hose  
A

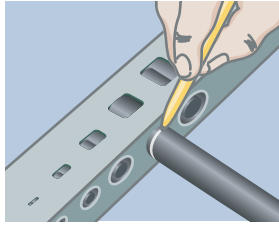
Fittings  
B

Parkrimp  
Equipment  
C

Accessories  
D

Technical  
E

**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.

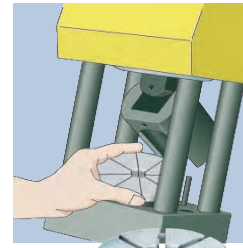


For 81 Series Shells with 88 Series Fittings

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**



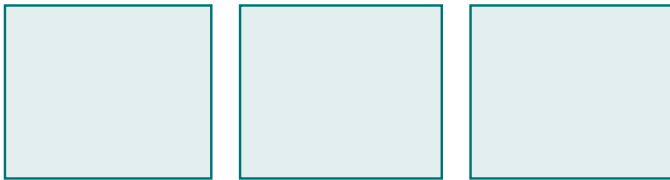
Pull pin at the top of pusher to swing it back. Place unitized die-train into base plate. See decal on crimpers for proper die set.

**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.

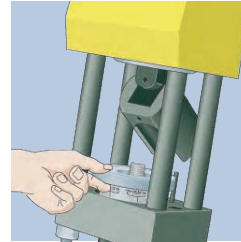
Color-Coded Unitized Die-Train

**3 Position the fitting**

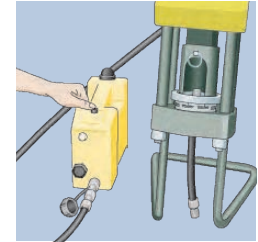


Position the hose and fitting in dies from below. Rest bottom of coupling on die step using the PARKALIGN® feature.

**4 Place die ring and crimp**



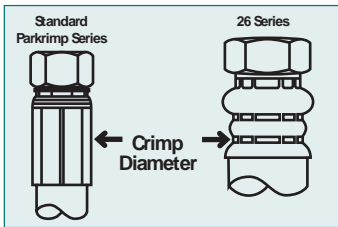
Place correct die ring on top of the dies. See decal on crimper for proper die ring.



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

**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 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 insertion depths**

Fitting Size	Fitting Series																	
	26		43		70		71		73		78		79		81		HY	
	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	2-7/8	73	—	—	1-11/16	43	—	—

For specific information on crimping, visit CrimpSource™ online at.