



# Parkrimp 2 Crimp Die Selection Chart

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

PN: PK2 HOSE DECAL 7/08 Hose	Fittings	Die Selection and Crimp Diameters						PN: PK2 MASTER DECAL 5/08								
		- 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 431 471ST	43 Series															
351ST 436 472TC																
422 451TC 482TC		0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	2.290	2.735					
424 451ST 482ST		0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990	2.310	2.755					
426 471TC																
Tools Required		Small Silver Die (80C-AXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-AXX)								
421WC 304 601	70 Series															
302/301 341 604																
301LT 381 881		0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	2.330	2.775					
		0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030	2.350	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	1.140	1.260											
			1.010	1.160	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 721ST 772ST	71 Series															
721TC 772TC 774																
		0.950	1.100	1.220	1.355	1.695	2.025	2.290	2.775							
		0.970	1.120	1.240	1.375	1.715	2.045	2.310	2.795							
Tools Required			Small Black Die (83C-DXX) and Adapter Bowl (83C-OCB)						Large Black Die (83C-AXX)							
Die						83C-L12	83C-L16	83C-L20	83C-L24	83C-L32						
731	73 Series					1.420	1.730	2.140	2.440	3.025						
						1.440	1.750	2.160	2.460	3.045						
Tools Required									Large Olive Drab (83C-LXX)							
Die							83C-U12	83C-U16								
761		76 Series					1.540	1.865								
						1.560	1.885									
Tools Required									Large Silver (83C-UXX)							
Die							83C-L12	83C-L16	83C-L20	83C-L24	83C-L32					
P35/78C 781 782ST	78/S6 Series						1.420	1.730	2.140	2.440	3.025					
782TC 782ST						1.440	1.750	2.160	2.460	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 792ST		79 Series					1.420	1.730	2.140	2.440						
F42 792ST						1.440	1.750	2.160	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
213 285 293	26 Series		0.460	0.520	0.575	0.670	0.805	0.915	1.175	1.420	1.670	2.160				
		0.480	0.540	0.595	0.690	0.825	0.935	1.195	1.440	1.690	2.180					
Tools Required			Small Silver Die (80C-EXX) and Adapter Bowl (83C-OCB)						Large Silver Die (83C-EXX)							
201 221FR 266			0.500	0.560	0.615	0.710	0.845	0.955	1.215	1.460	1.710	2.200				
206 225 CAH SS25UL			0.520	0.580	0.635	0.730	0.865	0.975	1.235	1.480	1.730	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 881	81 Series						1.155	1.450	1.740	2.010	2.430					
							1.175	1.470	1.760	2.030	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		0.725	0.830	0.960	1.110	1.355							
		0.595		0.745	0.850	0.980	1.130	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	HY Series	0.635		0.805	0.915	1.040	1.200	1.495								
		0.655		0.825	0.935	1.060	1.220	1.515								
Tools Required			Spacer Ring (83C-R02), Small Silver Die (80C-HXXX or 80C-HXXXX), and Adapter Bowl (83C-OCB)													



**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:**

Download from [www.hfeweb.com/technical-info/](http://www.hfeweb.com/technical-info/) or call 888.715.4673.

**Crimping instructions:**

[www.hfeweb.com/technical-info/](http://www.hfeweb.com/technical-info/)

On-site training available for Hose & Fittings, Etc's customers.



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