



# *Equipment* EQUIPMENT

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resource for hose crimp specifications.








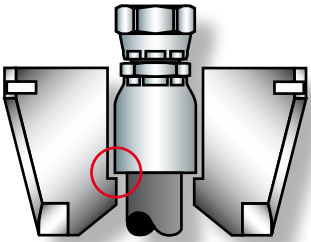






Minikrimp

Karrykrimp












Parkrimp 1

PHastkrimp

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Hose  
**A**Fittings  
**B**Equipment  
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Hose <b>A</b>
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Hose  
**A**

# Hose Assemblies Are Easy With the Parkrimp System.

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

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. What's more, 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.

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



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.

Fittings  
**B**Parkrimp  
Equipment  
**C**Accessories  
**D**Technical  
**E**

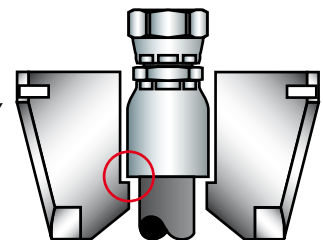
Eight segment crimp dies provide a smooth, even, 360-degree crimp.

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	451TC-4
Fitting	43 Series
Die Body Color	Silver
Die Cavity Color (-4)	RED

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 Series Die Body Color	70 & 71 Series Die Body Color	73, 78, S6 & 79 Series Die Body Color	76 Series Die Body Color	26 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
-5	PURPLE		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
-12	GREEN						
-16	BLACK						
-20	WHITE				N/A		
-24	RED				N/A		
-32	GREEN				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	

Reference pages C-6 through C-15 for specific tool information regarding hose, fitting, and crimper combinations.

A  
Hose

B  
Fittings

C  
Parker  
Equipment

D  
Accessories

E  
Technical

# Minikrimp™



## Features

- Light weight, portable, compact all-in-one unit
- Handpump or air over hydraulic design
- Removable pusher design for easy die change out
- Reference page C-20 for information on available power units
- For use with 25, 26, 43, 81, and HY Series fittings
- Do not crimp stainless steel fittings

## Specifications

- Dimensions: 6" wide, 13" deep, 15" high
- Weight: 42 lbs (with hand pump)
- Rating: 30 ton force @ 10,000 psi maximum
- Full Cycle Time: 30 seconds

## Important

The Minikrimp was developed by Parker Hannifin Parflex Division but is compatible with Parker Hannifin Hose Products Division products. Refer to CrimpSource™ on [www.parkerhose.com](http://www.parkerhose.com) (the online resource for hose crimp specifications for the complete line of Parker crimping machines). Any engineering and crimper performance issues pertaining to the Minikrimp should be directed to the Parflex Division, Technical Services Department, at (330) 296-2871 or fax, at (330) 296-8433.

## Standard Equipment

Part Number		Description	Individual Part Number
94C- 001-PFD	94C- 002 -PFD		
●	●	Base unit	94C-080-PFD
●		Hand pump	015301
	●	Air over hydraulic pump kit with tubing and adapters	025411
●	●	Silver die ring	82C-R01-PFD

## Optional Tooling

- Side Vise Mount (015736)
- Upright Table Mount (015306)
- Upright Vise Mount (015307)
- Black Die Ring (82C-R02-PFD)
- Connection Hose with Quick Coupling (015309)
- Bent Tube for Hand Pump Only (015308)
- Bent Tube for Air Over Hydraulic Pump Only (025349)








### 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.





## Minikrimp™ Hose Die Selection Chart

Hose			Fittings	Hose/Die Selection and Crimp Diameters 8/07							Die Ring
				- 4 RED	- 5 PUR	- 6 YEL	- 8 BLU	- 10 ORG	- 12 GRN	- 16 BLK	
Die				80C-A04	80C-A05	80C-A06	80C-A08	80C-A10	80C-A12	80C-A16	
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	 Silver
424	451ST	482ST		0.665	0.730	0.845	0.965	1.080	1.265	1.610	
426	471TC										
421WC	304	601	43 Series	0.685	0.750	0.865	0.985	1.100	1.285	1.630	 Black
302/301	341	604		0.705	0.770	0.885	1.005	1.120	1.305	1.650	
301LT	381	881									
Die				80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	
213	221FR	293	26 Series	0.460	0.520	0.575	0.670	0.805	0.915	1.175	 Silver
	285			0.480	0.540	0.595	0.690	0.825	0.935	1.195	
201	225	266		0.500	0.560	0.615	0.710	0.845	0.955	1.215	 Black
206	244			0.520	0.580	0.635	0.730	0.865	0.975	1.235	
Die									80C-V12	80C-V16	
811	811HT	881	81 Series						1.155 1.175	1.450 1.470	 Silver
Die				80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120		
AX			HY Series	0.595		0.745	0.850	0.980	1.130		 Silver
				0.575		0.725	0.830	0.960	1.110		
Die					80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170	
BXX				0.655		0.825	0.935	1.060	1.220		 Black
				0.635		0.805	0.915	1.040	1.200		



Parker Hannifin Corp.  
Hose Products Division  
30240 Lakeland Blvd.  
Wickliffe, Ohio 44092

Caution: Read the operations and technical manual before attempting to operate this machinery. Keep hands clear of moving parts when operating machine.

NOTE: Do not use this machine to assemble stainless steel fittings with any hose listed on this chart

For a new decal, contact Parker Catalog Services at: 1-800-C-PARKER.

## Karrykrimp



## Features

- Portable, compact rugged design
- Numerous power unit options available
- Pivoting pusher design for easy die change out
- For use with 25, 26, 43, 81, and HY Series fittings

## Specifications

- Dimensions: 15" wide, 12" deep, 27" high
- Weight: 54 lbs (without power unit)
- Rating: 30 ton force @ 10,000 psi maximum
- Full Cycle Time: 30 seconds with electric pump
- Reference page C-20 for information on available power units

## Standard Equipment

Part Number				Description	Individual Part Number
82C-001	82C-002	82C-061	82C-080		
●	●	●	●	Karrykrimp portable crimper (base unit)	82C-080
●	●	●		2 piece stand	832021
●				Hand pump	82C-0HP
●	●	●		Connection hose with quick coupling	82C-00L
●	●	●		Silver die ring	82C-R01
●	●	●		Black die ring	82C-R02
●	●			43 Series dies (sizes 1/4", 3/8", 1/2", 3/4" and 1")	80C-Axx

## Parkrimp 1



## Features

- Compact bench mount design
- Engineered for optimal 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

Part Number			Description	Individual Part Number
80C-101	80C-061	80C-181		
●	●	●	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
●			43 Series dies (sizes 1/4", 3/8", 1/2", 3/4" and 1")	80C-Axx

## 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 1/Karrykrimp Hose Die Selection Chart

PN: PK1/KK HOSE DECAL Hose 8/07			Fittings	Hose/Die Selection and Crimp Diameters					PN:PK1/KK MASTER DECAL 8/07				
Die				- 4 RED 80C-A04	- 5 PUR 80C-A05	- 6 YEL 80C-A06	- 8 BLU 80C-A08	- 10 ORG 80C-A10	- 12 GRN 80C-A12	- 16 BLK 80C-A16	- 20 WHT 80C-A20	Die Ring	
Die			43 Series										
351TC	431	471ST		0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970		
351ST	436	472TC		0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990		
422	451TC	482TC											
424	451ST	482ST											
426	471TC												
421WC	304	601	26 Series	0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010		
302/301	341	604		0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030		
301LT	381	881											
Die				80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16			
213	221FR	293	26 Series	0.460	0.520	0.575	0.670	0.805	0.915	1.175			
	285			0.480	0.540	0.595	0.690	0.825	0.935	1.195			
201	225	266	26 Series	0.500	0.560	0.615	0.710	0.845	0.955	1.215			
206	244	CAH		0.520	0.580	0.635	0.730	0.865	0.975	1.235			
Die									80C-V12	80C-V16	80C-V20		
811	811HT	881	81 Series						1.155	1.450	1.740		
									1.175	1.470	1.760		
Die				80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120				
AX			HY Series	0.575		0.725	0.830	0.960	1.110				
				0.595		0.745	0.850	0.980	1.130				
Die				80C-H605		80C-H775	80C-H885	80C-H1010	80C-H1170				
BXX				0.635		0.805	0.915	1.040	1.200				
			0.655		0.825	0.935	1.060	1.220					
			Parker Hannifin Corp. Hose Products Division 30240 Lakeland Blvd. Wickliffe, Ohio 44092				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: Do not use these machines to assemble 341-20, 451TC-20, 451ST-20 or any size stainless steel fittings.		

For a new decal, contact Parker Catalog Services at: 1-800-C-PARKER.

Hose  
**A**Fittings  
**B**Parkrimp  
Equipment  
**C**Accessories  
**D**Technical  
**E**

## Karrykrimp 2



### Features

- Portable, compact rugged design
- Numerous power unit options available
- Crimps both steel and stainless steel fittings
- For use with 25, 26, 43, 70, 71, 73, 78, 81, and HY Series fittings

### Specifications

- Dimensions: 14" wide, 15" deep, 30" high
- Weight: 100 lbs (without power unit)
- Rating: 60 ton force @ 10,000 psi maximum
- Full Cycle Time: 20 seconds with electric pump
- Reference page C-20 for information on available power units

### Standard Equipment

Part Number	Description	Individual Part Number
85C-061		
●	Karrykrimp 2 portable crimper (base unit)	85C-080
●	2 piece stand	85C-STD
●	Connection hose with quick coupling	85C-00L
●	Silver die ring	85C-R01
●	Black die ring	85C-R02

### Optional Tooling

- Die Kit (85C-KDA) Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1" and 1-1/4" and 70/71 Series dies in sizes 3/8", 1/2", 3/4", 1", 1-1/4" **ONLY**.

#### 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.

## PHastkrimp



### Features

- Fast bench mounted unit
- Push button power on demand design
- Crimps both steel and stainless steel fittings
- For use with 25, 26, 43, 70, 71, 73, 78, 81, and HY Series fittings












### Specifications

- Dimensions: 24" wide, 33" deep, 38" high
- Weight: 550 lbs
- Rating: 60 ton force @ 4,200 psi maximum
- Full Cycle Time: 6 seconds
- Hydraulic Fluid: AW32 oil
- **Note:** The 230VAC, 3 phase, 60 Hz power unit can be rewired to 460VAC by a qualified electrician

### Standard Equipment

Part Number		Description	Individual Part Number
89C-061	89C-062		
●		PHastkrimp crimper with 230VAC, 3 phase, 60 Hz power unit wired for 230 volts	
	●	PHastkrimp crimper with 230VAC, 1 phase, 60 Hz power unit wired for 230 volts	
●	●	Silver die ring	85C-R01
●	●	Black die ring	85C-R02

## PHastkrimp/Karrykrimp 2 Hose Die Selection Chart

PN: PH/KK2 Hose Decal Hose- 8/07	Fittings	Hose/Die Selection and Crimp Diameters								PN: PH/KK2 Master Decal 8/07	
		- 4 RED 80C-A04	- 5 PUR 80C-A05	- 6 YEL 80C-A06	- 8 BLU 80C-A08	- 10 ORG 80C-A10	- 12 GRN 80C-A12	- 16 BLK 80C-A16	- 20 WHT 80C-A20	Die Ring	
Die											
351TC 431 471ST 351ST 436 472TC 422 451TC 482TC 424 451ST 482ST 426 471TC	43 Series	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		Silver
421WC 304 601 302/301 341 604 301LT 381 881		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		Black
Die				83C-D06	83C-D08	83C-D10					
701 F42 (-8 ONLY)	70 Series			0.990 1.010	1.140 1.160	1.260 1.280					Black
Die				83C-D06	83C-D08	83C-D10	83C-D12	83C-D16	83C-D20		
711 721 721TC 721ST 772TC 774	71 Series			0.950 0.970	1.100 1.120	1.220 1.240	1.355 1.375	1.695 1.715	2.025 2.045		Silver
Die							80C-L12	80C-L16			
731	73 Series						1.420 1.440	1.730 1.750			Silver
Die							80C-L12	80C-L16			
78C 781 782TC 782ST	78 Series						1.420 1.440	1.730 1.750			Silver
Die		80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16			
213 221FR 293 285	26 Series	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			Silver
201 225 266 206 244 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			Black
Die							80C-V12	80C-V16	80C-V20		
811 811HT 881	81 Series						1.155 1.175	1.450 1.470	1.740 1.760		Silver
Die		80C-H585		80C-H735	80C-H840	80C-H970	80C-H1120	80C-H1365			
AX	HY Series	0.575 0.595		0.725 0.745	0.830 0.850	0.960 0.980	1.110 1.130	1.355 1.375			Silver
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			Black



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Hose Products Division  
30240 Lakeland Blvd.  
Wickliffe, Ohio 44092

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. 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. 2. Do not use lubricant to assemble spiral hose and fittings.

For a new decal, contact Parker Catalog Services at: 1-800-C-PARKER.

Hose  
**A**Fittings  
**B**Parkrimp  
Equipment  
**C**Accessories  
**D**Technical  
**E**



Hose  
**A**

Fittings  
**B**

Parkrimp  
Equipment  
**C**

Accessories  
**D**

Technical  
**E**

# Superkrimp



### Features

- Easy to use table top design
- Engineered for optimal durability
- Crimps both steel and stainless steel fittings
- For use with 25, 26, 43, 70, 71, 73, 76, 78, 79, 81, and HY Series fittings

### Specifications

- Dimensions: 20" wide, 31" deep, 41" high
- Weight: 600 lbs
- Rating: 70 ton force @ 5,000 psi maximum
- Full Cycle Time: 20 seconds without adapter bowl  
15 seconds with adapter bowl
- Hydraulic oil: Enerpac oil

### Standard Equipment

Part Number		Description	Individual Part Number
88C-081	88C-082		
●		Superkrimp crimper with 230/460 volt, 3 phase, 50/60 Hz power unit wired for 230 volts	
	●	Superkrimp crimper with 230/460 volt, 1 phase, 50/60 Hz power unit wired for 230 volts	
●	●	Adapter bowl	83C-OCB
●	●	Spacer ring	83C-R02
●	●	Spacer Plate	83C-R02H

### Optional Tooling

- Die Kit (88C-KDA)


Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1" and 1-1/4" and 70/71 Series dies in sizes 3/8", 1/2", 3/4", 1", 1-1/4" and 1-1/2" **ONLY**.

**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.


## Superkrimp Hose Die Selection Chart

PN: SK Hose Decal 8/07			Fittings	Die Selection and Crimp Diameters								PN: SK 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	43 Series	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)		70 Series	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					
711 721 721TC	721ST 772TC	772ST 774	71 Series	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					
Tools Required				Small Black Die (83C-DXX) and Adapter Bowl (83C-OCB)							Large Black Die (83C-DXX)				
Die							83C-L12	83C-L16							
731			73 Series					1.420 1.440	1.730 1.750						
Tools Required								Large Olive Drab (83C-LXX)							
Die							83C-U12	83C-U16							
761			76 Series					1.540 1.560	1.865 1.885						
Tools Required								Large Silver Die (83C-UXX)							
Die							83C-L12	83C-L16	83C-L20						
78C	781 782TC	782ST	78 Series					1.420 1.440	1.730 1.750	2.140 2.160					
Tools Required								Large Olive Drab (83C-LXX)							
Die							83C-L12	83C-L16							
791TC	792TC F42	792ST	79 Series					1.420 1.440	1.730 1.750						
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	26 Series	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	881	81 Series						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)												



Parker Hannifin Corp.  
Hose Products Division  
30240 Lakeland Blvd.  
Wickliffe, Ohio 44092

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

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For a new decal, contact Parker Catalog Services at: 1-800-C-PARKER.



# Parkrimp 2



## 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, 73, 76, 78, 79, 81, S6 and HY Series fittings

## Specifications

- Dimensions: 28" wide, 22" deep, 70" high
- Weight: 842 lbs (Head is 558 lbs and base is 284 lbs)
- Rating: 125 ton force @ 5,000 psi maximum
- Full 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-001	83C-081	83C-002	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
●		●		Die Kit Includes 43 Series dies in sizes 1/4", 3/8", 1/2", 3/4", 1", 1-1/4" dies and 70/71 Series dies in sizes 3/8", 1/2", 3/4", 1", 1-1/4", 1-1/2", 2" ONLY	83C-KDA

### 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 Hose Die Selection Chart

PN: PK2 Hose Decal 8/07			Die Selection and Crimp Diameters										PN: PK2 Master Decal 8/07			
Hose			Fittings	-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							83C-A16H	83C-A20H					
351ST	436	472TC		0.645	0.710	0.825	0.945	1.060	1.245	1.590	1.970	2.290	2.735			
422	451TC	482TC		0.665	0.730	0.845	0.965	1.080	1.265	1.610	1.990	2.310	2.755			
424	451ST	482ST														
426	471TC															
Tools Required				Small Silver Die (80C-AXX) and Adapter Bowl (83C-OCB)								Large Silver Die (83C-AXX)				
421WC	304	601		0.685	0.750	0.865	0.985	1.100	1.285	1.630	2.010	2.330	2.775			
302/301	341	604		0.705	0.770	0.885	1.005	1.120	1.305	1.650	2.030	2.350	2.795			
301LT	381	881														
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			70 Series			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			71 Series			83C-D06	83C-D08	83C-D10	83C-D12	83C-D16	83C-D20	83C-D24	83C-D32			
711	721ST	772ST								83C-D16H	83C-D20H					
721	727TC	774				0.950	1.100	1.220	1.355	1.695	2.025	2.290	2.775			
721TC						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-DXX)						
Die			73 Series						83C-L12	83C-L16	83C-L20	83C-L24	83C-L32			
731									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			76 Series						83C-U12	83C-U16						
761									1.540	1.865						
									1.560	1.885						
Tools Required				Large Silver (83C-UXX)												
Die			78 / S6 Series						83C-L12	83C-L16	83C-L20	83C-L24	83C-L32			
P35/78C	781	782ST							1.420	1.730	2.140	2.440	3.025			
	782TC								1.440	1.750	2.160	2.460	3.045			
Tools Required				* S6 Series Fittings to be used on P35-32 Only												
Die			79 Series						83C-L12	83C-L16	83C-L20	83C-L24				
791TC	792TC	792ST							1.420	1.730	2.140	2.440				
	F42								1.440	1.750	2.160	2.460				
Tools Required				Large Olive Drab (83C-LXX)												
Die			26 Series	80C-E04	80C-E05	80C-E06	80C-E08	80C-E10	80C-E12	80C-E16	83C-E20	83C-E24	83C-E32			
213	221FR	293		0.460	0.520	0.575	0.670	0.805	0.915	1.175	1.420	1.670	2.160			
	285			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	225	266		0.500	0.560	0.615	0.710	0.845	0.955	1.215	1.460	1.710	2.200			
	244	CAH		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			81 Series						80C-V12	80C-V16	80C-V20	83C-V24	83C-V32			
811	811HT	881							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			HY Series	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				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)													



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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 fitting



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.



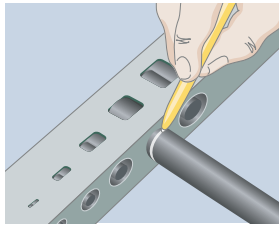
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For a new decal, contact Parker Catalog Services at: 1-800-C-PARKER.



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

Parkrimp Fittings Series 25, 26, 43, 70, 71, 73, 76, 78, S6, 81, HY

**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.

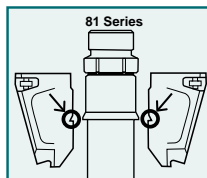
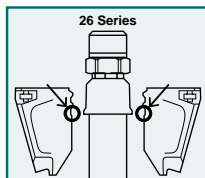
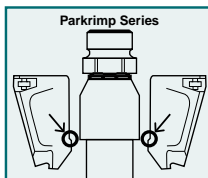
**2 Insert unitized die train**

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

**Note: Parkrimp 1 does not have a pin at the top of the pusher.**

**Important:** Lubricate the crimper's die bowl using a premium quality lithium-base grease.

Color-Coded Unitized Die-Train

**3 Position the fitting**

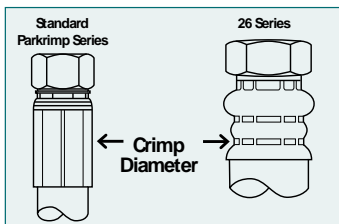
Position the hose and fitting in dies from below. Rest bottom of coupling on die step using the PARKALIGN® feature.

**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.

**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.

**Note:** Minikrimp, Karrykrimp & Karrykrimp 2 have several types of power sources, all of which are separate units from the crimping machine.

**Hose insertion depths**

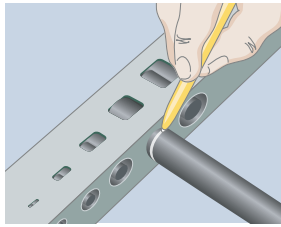
Fitting Size	Fitting Series																	
	26		43		70		71		73		78		79		81		HY	
	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm
-4	13/16	21	13/16	21	—	—	—	—	—	—	—	—	—	—	—	—	1-7/16	37
-5	13/16	21	15/16	24	—	—	—	—	—	—	—	—	—	—	—	—	—	—
-6	13/16	21	1-1/8	29	1-1/16	27	1-1/16	27	—	—	—	—	—	—	—	—	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 [www.parkerhose.com](http://www.parkerhose.com).

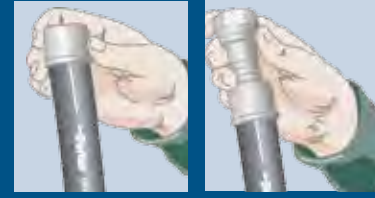


**Crimping using Superkrimp and Parkrimp 2**

Parkrimp Fittings Series 25, 26, 43, 70, 71, 73, 76, 78, S6, 81, HY

**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 on previous page.

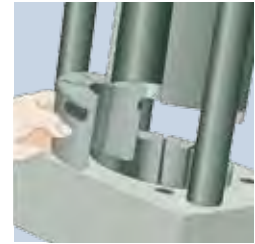
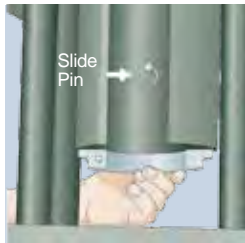
**For 81 Series Shells with 88 Series Fittings**

Place 81 Series 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.

**2a If using large two-piece dies**

Insert the proper die set into the die bowl. (The die sets are in two halves of four dies each. Place one half in the back and one half in the front to accommodate bent tube fittings.) Reference decal on crimper for proper tool selection.

**2b If using small unitized dies**

With the pusher in the full up position, lift the back half of the split die ring. Lock it in the up position by pushing the slide pin in. (The slide pin is located inside the pusher at the back.)



Lubricate die bowl using a premium quality lithium-base grease. Carefully insert the adapter bowl, 83C-OCB, into the base bowl. The adapter bowl must be tilted toward the back of the crimper during insertion.



Color-Coded  
Unitized  
Die-Train

Lubricate die bowl using a premium quality lithium-base grease. Place unitized die-train into the adapter bowl. Select die and die ring by hose size and type. See decal on crimper for proper die set.

**Note:** Die sets have color-coded cavities indicating size and have the fitting series and dash size stamped on the top.

**3 Place spacer ring**

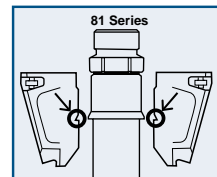
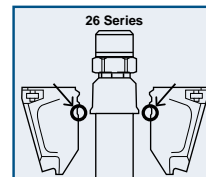
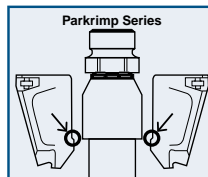
If required, place spacer ring on locating step of adapter bowl. Reference decal on crimper for tool selection.

**4 Position the split die ring**

Lower the back half of the split die ring onto the dies by pulling the slide pin forward.



Insert the front half of the split die ring aligning the pins in the back half with the hole in the front half.

**5 Position the fitting**

Position the hose and fitting in dies from below.

Rest bottom of coupling on die step using the PARKALIGN® feature.

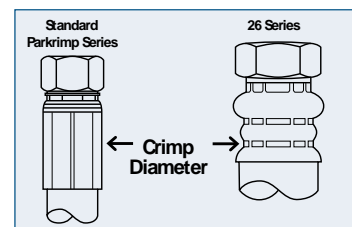
**6 Crimp hose**

Turn on the pump by pressing the "ON" switch. Pull the valve handle forward to bring the pusher down for crimping. When the split die ring contacts the base plate, the crimp is complete. Push the valve handle back to lift the pusher, open the dies, and release the finished assembly.

**Note:** You do not have to remove any tooling to insert or remove straight fittings. The front half of the split die ring and the front die train must be removed to insert and remove bent tube fittings.

**7 Measure crimp diameter**

Measure crimp diameter on the flat surfaces of the crimped shell, referenced in the illustration to the right. 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  
**A**Fittings  
**B**Parkrimp  
Equipment  
**C**Accessories  
**D**Technical  
**E**

## Assembling Twin Tough Rubber Hose

### Required Equipment:

Twin Tough hose, fittings, knife, tape measure, heat shrink sleeve, scissors, grease pencil, heat gun, and calipers.



### Set-up:

Position the bonded rubber hose so that it lies flat on a work surface with out tendency to twist or turn.

**Measure hose tear back length:** Measure and mark the length that the hoses are to be separated. A minimum of 12 inches is required for crimping the hose ends. An 18 inch tear back is recommended for use with hydraulic tools.



Note: If length of separation/tear back is specified from the threaded or swivel nut end of the coupling, then deduct the cut off allowance dimension for the specific style of coupling used. The cutoff allowance can be obtained from the hose fitting tables in the 4400 Catalog "B" dimension, or can be calculated by subtracting the insertion depth of the shell from the overall coupling length.

### Cut hose tear back to length:

Press the bonded hose assembly firmly and flat against the work surface with your free hand so that it does not move.

A.) Using a sharp blade, line up the center of the valley (web) formed by the hoses.



B.) To start the cut, place the blade in the center of that valley (web) drawing the knife toward you with constant pressure.



C.) Once you have a 1 to 2 inch starter cut, firmly pull each hose end apart to your required separation length.



Note: It is important that the knife blade be perpendicular to the hose during this procedure so the blade cuts only the centerline of the valley (web). EXTREME CARE MUST BE TAKEN TO AVOID CUTTING THROUGH THE COVER OF THE HOSES AND THEREBY EXPOSING THE HOSE REINFORCEMENT. If this occurs, the hose assembly must be discarded.

**Measure Separation:** It is suggested that the separation length be a minimum of 12 inches, which will be sufficiently long enough so that the crimping operation can be accomplished without risk of kinking the hoses.



**Stopping Separation:** Parker recommends installing a heat shrink sleeve of at least 2 inches with a 2 ½ ID at the termination of the separated hose to provide protection against tearing of the valley (web) or hose covers. This heat shrink sleeve should be placed on the hose assembly prior to the crimping of the hose fittings. Once you have your heat shrink sleeve in place, use a heat gun to shrink the sleeve in place.



**Note:** EXTREME CARE MUST BE TAKEN TO AVOID EXPOSING THE HOSE ASSEMBLY TO THE DIRECT HIGH TEMPERATURES OF THE HEAT GUN WHILE INSTALLING THE HEAT SHRINK SLEEVE. LONG EXPOSURE FROM A HEAT GUN MAY ADVERSLEY AFFECT THE HOSE INNERTUBE OR ITS COVER.

**Crimping Fittings:** All of your crimping information can be found on Crimp Source ([www.parker.com/crimpsource](http://www.parker.com/crimpsource)).

First, place your fittings onto each hose end making sure that both have been installed to the correct hose insertion depth. Choose the correct die and die ring. Place half of your hose assembly through the bottom of your Parkrimp crimper. Rest the bottom of the fitting on the die step using the Parkalign system. While lightly holding the hose assembly, operate your crimper pump so that the pusher on the crimper comes down in contact with the die ring until it bottoms out on the crimper base. Then release the pressure within the pump and remove the first half of your finished assembly. Always measure your hose assemblies for the correct crimp diameter. Now, repeat the crimping process on the other fitting.



**Note:** EXTREME CARE MUST BE TAKEN TO AVOID KINKING THE HOSE THAT IS NOT BEING CRIMPED DURING THIS PROCESS.

**Warning:** EXTREME CARE MUST BE TAKEN TO AVOID EXPOSING THE HOSE ASSEMBLY TO THE DIRECT HIGH TEMPERATURES OF THE HEAT GUN WHILE INSTALLING THE HEAT SHRINK SLEEVE. LONG EXPOSURE FROM A HEAT GUN MAY ADVERSLEY AFFECT THE HOSE INNERTUBE OR ITS COVER.

Hose  
**A**Fittings  
**B**Parkrimp  
Equipment  
**C**Accessories  
**D**Technical  
**E**

Hose

A

**Hand Pump**

Part No. 82C-0HP

*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ease of operation hand pump delivers 10,000 psi

Length: 23"  
 Width: 4"  
 Height: 5"  
 Port Size: 3/8" NPTF  
 Weight: 9 lbs  
 Hydraulic Fluid: Enerpac oil

Fittings

B

**Electric Pump**

Part No. 82C-0EP

*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ease of operation hand pump delivers 10,000 psi

Length: 13"  
 Width: 13"  
 Height: 15"  
 Port Size: 3/8" NPTF  
 Weight: 31 lbs  
 Hydraulic Fluid: Enerpac oil  
 115 volt, 1 phase, 50/60 Hz, 9 amp

Parkrimp  
Equipment

C

**Hand Pump**

Part No. 85C-0HP

*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ease of operation hand pump delivers 10,000 psi

Length: 29"  
 Width: 13"  
 Height: 11"  
 Port Size: 3/8" NPTF  
 Weight: 61 lbs  
 Hydraulic Fluid: Enerpac oil

**Electric Pump**

Part No. 85C-0EP

*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Heavy duty electric pump delivers 10,000 psi at a faster cycle time

Length: 19"  
 Width: 11"  
 Height: 17"  
 Port Size: 3/8" NPTF  
 Weight: 59 lbs  
 Hydraulic Fluid: Enerpac oil  
 115 volt, 1 phase, 50/60 Hz, 20 amp

Accessories

D

**Air/Hydraulic Pump**

Part No. 82C-0AP

*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Lightweight pump operates with 80-150 psi shop air pressure and delivers 10,000 psi

Length: 15"  
 Width: 6"  
 Height: 6"  
 Intake Port Size: 1/4" NPTF  
 Output Port Size: 3/8" NPTF  
 Weight: 14 lbs  
 Hydraulic Fluid: Enerpac oil

**Vehicle Battery-Powered Pump**

Part No. 85C-12V

*(for use with the Minikrimp, Karrykrimp and Karrykrimp 2)*

Ideal unit for Parker Mobile Hose Preplacement Service, Delivering 10,000 psi.

Length: 12"  
 Width: 8"  
 Height: 19.5"  
 Weight: 67 lbs  
 Hydraulic Fluid: ISO-46

Technical

E

**Enerpac Warranty Statement**

Enerpac products are warranted to be free of defects in materials and workmanship. Any product that does not conform to specification will be repaired or replaced at Enerpac's expense, anywhere in the world; simple as that! This warranty does not cover ordinary wear and tear, abuse, misuse, alterations, or the use of improper fluids. Determination of the authenticity of a warranty claim will be made only by Enerpac or its Authorized Service Centers.





## Hydraulic Press Kit

Part No. 8PC-001

For use with 26, 43, 81 and HY Series Fitting ONLY

### Specifications

- Required Height from Press Base to Press Ram: 10 inches
- Required Width of Bowl Diameter: 5 inches
- Bowl Rating: 30 tons force maximum
- Minimum Required Press Capacity: Hose Size 1/4" to 1/2" needs a 20 ton press  
Hose size 5/8" to 1-1/4" needs a 30 ton press

### Standard Equipment

Part Number 8PC-001	Description	Individual Part Number
●	Bowl Assembly	8PC-030
●	Pusher	8PC-00P
●	Silver Die Ring	81C-R01
●	Black Die Ring	81C-R02
●	43 Series dies in 1/4", 3/8", 1/2", 3/4" and 1"	80C-Axx



## Weatherhead Conversion Kit

Part No. 8WC-001

For use with 26, 43, 81 and HY Series Fitting ONLY

Convert **Weatherhead T-400 crimper** to utilize Parker Parkrimp No-Skive fittings.

### Standard Equipment

Part Number 8WC-001	Description	Individual Part Number
●	Bowl Assembly	8PC-030
●	Pusher	8WC-00P
●	Silver Die Ring	81C-R01
●	Black Die Ring	81C-R02
●	43 Series Dies in 1/4", 3/8", 1/2" and 3/4"	80C-Axx



## Gates Conversion Kit

Part No. 8GC-002

For use with 26, 43, 81 and HY Series Fitting ONLY

Convert **Gates 701, 703 and 707 bottom loading crimpers** to utilize Parker Parkrimp No-Skive fittings.

### Standard Equipment

Part Number 8GC-002	Description	Individual Part Number
●	Bowl Assembly	8PC-030
●	Silver Die Ring	81C-R01
●	Black Die Ring	81C-R02
●	43 Series Dies in 1/4", 3/8", 1/2", 3/4" and 1"	80C-Axx

#### Notes:

- For additional information and operating instructions, visit the Parker Hose Products Division website at [www.parkerhose.com](http://www.parkerhose.com).
- For crimping instructions, see pages C-16 and C-17.
- Hose assemblies must be inspected for cleanliness and free of all foreign particles.



**Hose Cut-Off Machine**

Part No. 332T-115V

**Features**

- For quick, easy cutting of spiral reinforced hose up to 1-1/4" I.D.
- Moving parts shielded by guards

**Specifications**

- Dimensions: 13" wide x 26" long x 22" high
- Shipping Weight: 71 lbs.

**Standard Equipment**

Part Number 332T-115V	Description	Individual Part Number
●	Hose Cut-Off Machine with 1-1/2 HP, 3450 RPM, 115/230V single phase electric motor wired for 115V	
●	Scalloped Cutting Blade (8" with 5/8" arbor size)	24398

**Optional Equipment**

- Smooth Cutting Blade (580661)

**Hose Cut-Off Machine - Karrykut**

Part No. 631075

**Features**

- Portable saw for cutting on the job
- Unique clamp system spreads hose as it cuts to prevent blade binding
- Cuts multi-braided wire reinforced hose including 4 spiral construction up to 1-1/4" I.D.

**Specifications**

- Dimensions: 16" wide x 12" long x 19" high
- Shipping Weight: 58 lbs.

**Standard Equipment**

Part Number 631075	Description	Individual Part Number
●	Power saw with 115volt (13 amp) universal AC motor	631140
●	Universal clamp attachment (can be used with any portable power saw unit having a 5/8" arbor, 8" blade capacity)	631076
●	Cutting blade (8" with 5/8" arbor size)	580661

**Hose Cut-Off Machine**

Part No. 239 and 339

**Features**

- Designed for heavy duty use
- Cuts multi-braided wire reinforced hose including 6 spiral construction up to 2" I.D.

**Specifications**

- Dimensions: 22" wide x 42" long x 24" high
- Shipping Weight: 115 lbs.

**Standard Equipment**

Part Number 239	339	Description	Individual Part Number
●		Hose Cut-Off Machine with 230V single phase motor	
	●	Hose Cut-Off Machine with 3 HP motor 230V, 3 phase, 60 cycle	
●	●	Scalloped Cutting Blade (10" with 3/4" arbor size)	24248

**Optional Equipment**

- Smooth Cutting Blade (15960)

**Hose Cut-Off Tool - Handykut**

Part No. 871522

**Features**

- Portable tool for efficient cutting of hose
- Can be positioned onto a flat surface by clamps or by locking it in a vise, properly align the hose in a radius and cut it with a hacksaw

**Specifications**

- Dimensions: 6" wide x 18" long x 6" high
- Shipping Weight: 10 lbs.

## Push-Lok Cut-Off & Assembly Tool

Part No. 881540



### Features

- Combined hose cutter and toggle action press that cuts and assembles Parker Push-Lok in sizes 1/4" through 3/4" I.D.

### Specifications

- Dimensions: 16" long
- Shipping Weight: 4 lbs.

## Hose Cut-Off Tool

Part No. 316



### Features

- Small in size and easy to use
- Quick cutting of textile reinforced hose
- Ruggedly built for years of trouble-free service

### Specifications

- Dimensions: 15" long
- Shipping Weight: 6 lbs.

## Hose Cut-Off Tool

Part No. TH11-1



### Features

- Designed for quick, easy cutting of textile reinforced hose.
- Squarely cuts Push-Lok hose in sizes 1/4" through 3/4" I.D.

### Specifications

- Dimensions: 8" long
- Shipping Weight: 0.3 lbs.

## Hose & Tubing Cutter

Part No. HTC



### Features

- Heavy duty steel construction & insulated grip
- Special V-block design & blade

### Multiple capabilities

- Up to 1" hose/tubing OD
- Non-wire reinforced thermoplastic hose & tubing
- Non-wire reinforced rubber hose & tubing

### Advantages/Benefits

- Durable & portable; weighs only 12 ounces
- Ensures a straight, clean cut
- Cutting edge first punctures, then cuts
- Minimal flattening of hose/tubing during cutting
- Straight/square cut enhances fitting retention
- Easily adjustable blade provides two cutting surfaces- doubles blade life
- Versatile; one tool for multiple applications- Air tools, auto repair shops, beverage dispensers, laboratories, many general industrial and commercial applications

Hose

A

Fittings

B

Equipment  
Fabrication

C

Accessories

D

Technical

E

## Hose Insertion Depth Blocks

Part No. TH9-1-XXX



### Features

- For quick easy marking of hose insertion depth
- Ensures accuracy and increased productivity

### Available Blocks

Part Number	Description
TH9-1-26A	26 Series -4 through -10
TH9-1-26B	26 Series -12 through -32
TH9-1-43A	43 Series -4 through -10
TH9-1-43B	43 Series -12 through -32
TH9-1-70	70 Series -6 through -20
TH9-1-71	71 Series -6 through -32
TH9-1-73	73 Series -12 through -32
TH9-1-78	78 Series -12 through -32
TH9-1-HY	HY Series -4 through -16

### Optional Parts

- Insertion Depth Marking Stand (TH9-1-STD)

## Hozemblem

Part No. 432-115V



### Features

- Power machine to facilitate the attachment of field attachable fittings
- Handles all hose and fittings up to 4 spiral wire, in sizes 3/16" through 2" I.D., including bent tube elbows
- Comes with vise, all adapters, foot switch and safety guard with 115V, 30 amp, universal AC motor

### Specifications

- Shipping Weight: 141 lbs.

### Optional Parts

- Mounting stand (662451)

## Fitting Push-On Stand

Part No. TH2-7



### Features

- Quickly and easily pushes fittings onto hose
- Boosts productivity and quality
- Eliminates the need of rubber mallets and oils to get fittings onto the end of the hose for crimping
- Standard with straight tooling required for sizes 1/4" through 2" for all crimped fittings, 82 Series Push-Lok and 88 Series field attachable fittings

### Specifications

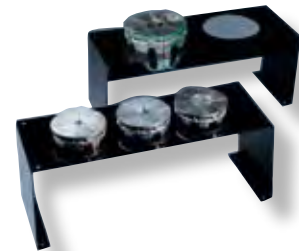
- Shipping Weight: 200 lbs.

### Optional Tooling

- Elbow Pusher Set (TH2-7-ELS)

## Die Storage Racks

Part No. 80C-0DR and 83C-0DR



### Features

- Modular die rack designed to hold small and large Parkrimp dies
- Can be bolted together to a work bench horizontally or vertically

### Standard Equipment

Part Number		Description
80C-0DR	83C-0DR	
●		Storage of three sets of small dies
	●	Storage of two sets of large dies

## Swivel Die Rack

Part No. 80C-SDR



### Features

- Holds up to 30 Parkrimp dies of any size
- Powder-coated, heavy-duty steel construction
- Consists of a base unit and up to five circular holders
- Floor or bench mounted

### Standard Equipment

Part Number	Description
80C-SDR-SM	Swivel Die Rack and Small Die Holder
80C-SDR-LG	Swivel Die Rack and Large Die Holder
80C-SDR-BASE	Swivel Die Rack Base

## Hose Perforator

Part No. 601069



### Features

- Small hand tool to prick minute holes in the rubber cover
- To be used in gaseous applications where the pressure exceeds 250 psi
- Driven into the cover every few inches of length either striking the hose or by a rolling action over the hose cover
- Not generally necessary to perforate the hose on all sides

### Specifications

- Shipping Weight: 2 lbs.

## Hoze Oil

Part No. Hoze-Oil



### Features

- Reduces torque and eliminates waste lubrication
- Use hose oil with the recommended hose assembly instructions

## Accrolube

Part No. Accrolube



### Features

- High efficiency lubricant used for stainless steel field attachable fittings
- Contains Teflon to reduce the wear between metal surfaces, protects against corrosion and ultimately eliminates galling

**Mandrel Tool Kit - 22 Series**

Part No. 652200

**Features**

- For assembly of Parker 22 Series field attachable fittings
- One of each part listed below is included in the kit

**Standard Equipment**

Hose I.D.	Dash Size	SAE (JIC) 37°	SAE 45°
3/16	-4	●	●
1/4	-5	●	●
5/16	-6	●	●
13/32	-8	●	●
1/2	-10	●	●
5/8	-12	●	●

**Assembly Tools - 22 Series**

Part No. 652201

**Features**

- For assembly of Parker 22 Series field attachable fittings
- One of each part listed below is included in the kit

**Standard Equipment**

Hose I.D.	Dash Size	SAE (JIC) 37°	SAE 45°
7/8	-16	●	●
1-1/8	-20	●	●
1-3/8	-24	●	●
1-13/16	-32	●	

**Mandrel Tool Kit - 23 Series**

Part No. 2727 and 2726

**Features**

- For assembly of Parker 23 Series field attachable fittings
- Part No. 2727 is for JIC 37° flared fittings
- Part No. 2726 is for SAE 45° and PTT 30° flared fittings

**Standard Equipment**

Hose I.D.	Dash Size	2727	2726
3/16	-4	●	●
1/4	-5	●	●
5/16	-6	●	●
13/32	-8	●	●
1/2	-10	●	●
5/8	-12	●	●
7/8	-16	●	●

**Mandrels - 25 Series**

(For 271 Transportation Hose)

Part No. TH2-7M25-6 and TH2-7M25-8

Hose  
**A**Fittings  
**B**Equipment  
Mandrel Kits  
**C**Accessories  
**D**Technical  
**E**



## HM 200 Ecoline / HM 200

With this series Uniflex offers machines with all the well-known Uniflex advantages for novices and low volume production. This leads to the highly effective combination of operator-friendliness with traditional precision, reliability and efficiency.



HM 200



HM 200 Ecoline  
also Ecoline/DC Option

Technical Data	HM200 Ecoline	HM200
Crimp Force	1300/130	1300/130
No Grease: 20% less friction	✓	✓
Control	Ecoline	Control A
SAE R13 / 1 Piece	1 1/2"	1 1/2"
SAE R12 / 2 Pieces	1 1/4"	1 1/4"
SAE R13 / 2 Pieces	1"	1"
SAE R15 / 2 Pieces	1"	1"
Industrial	2"	2"
Elbows	1 1/2"	1 1/2"
Max Press Range	70mm	70mm
Opening	+30mm	+30mm
Opening without dies	100mm	100mm
Speed (mm/sec)		
Close	3,5	3,5
Crimp	3,5	3,5
Open	5,9	5,9
Noise Level	69 dBA	69 dBA
Drive	3 kW**	3 kW
Oil	40 l (DC 4 l)	40 l
L-B-H/L-W-H/L-I-H(mm)	420x535x520	800x530x630
Power Unit (DC) L-W-H (mm)	300x450x560 (450x270x230)	—
Weight	88 kg	140 kg
QDS 239 B	✓	✓
<b>Options</b>		
12/24 Volt	✓	—
1 Phase	2,2 kW	✓

\* According to the fitting

\*\* According to the power unit

Type of Dies	239
Ø mm	mm
6,8	40
9	50
12	50
14	60
16	60
17	60
19	60
20	60
22	60
24	60
26	75
28	75
32	75
36	75
40	75
44	75
47	75
50	75
54	75
57	75
62	75

Package = machine + PB Ø 17,20,24,28,32,40,44,50

### Standard



QDS 239 B



QDC 239.4

### Options



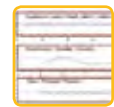
UNIMATiControl B



UNIMATiControl E



PS



PFM



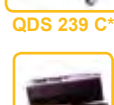
TA (A)



QDS 239 C\*



QDS 239 R\*



PTS\*



TUU/TUS\*



LsUS/LUF

We reserve the right to make technical changes without notice

# HM 290 / HM 290 Ecoline

A long-lived and well tested machine is the HM 290. The users of the machine enjoy the high crimp force, which makes it possible to use the HM 290 flexible in your workshop.



HM 290

HM 290 Ecoline  
Ecolone / DC Options

Technical Data	HM290 Ecoline	HM290
Crimp Force	2400/240	2400/240
Control	Ecoline	Control A
SAE R13 / 1 Piece	2"	2"
SAE R12 / 2 Pieces	2"	2"
SAE R13 / 2 Pieces	1 1/2"	1 1/2"
SAE R15 / 2 Pieces	1 1/2"	1 1/2"
Industrial	3"	3"
90° Elbows	2"	2"
Max Press Range	111mm	111mm
Opening	+45mm	+45mm
Opening without dies	162mm	162mm
Speed (mm/sec)		
Close	3,5	3,5
Crimp	2	2
Open	20	20
Die profile	232L/239L	232L/239L
Noise Level	69 dBA	69 dBA
Drive	3 kW	3 kW
Oil	40 l (DC 4 l)	40 l
L-W-H(mm)	420x490x520	800x530x670
Power Unit (DC) L-W-H (mm)	300x450x560 (450x270x230)	—
Weight	150 kg	208 kg
<b>Options</b>		
12/24 Volt	✓	—
Fast & Force (H)	—	✓ 5,5 kW

	239 L 232 L***
	232.23L
Ø mm	
6,8	40
9	70
12	70
14	70
16	70
17	70
19	70
20	70
22	70
24	70
26	70
28	85
32	85
36	85
40	85
44	85
47	110
50	110
54	110/118
57	110/118
62	110/118
67	118
71	118
74	118
78	118
84	118
86	118
90	118
96	118
103	118

## Standard

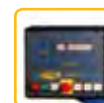


QDS 239 B



QDC 239.4

## Options



UNIMATICControl B



UNIMATICControl E



PS



TA (A)



QDS 239 R\*



QDS 239 C\*



PTS\*



PTS\*



TUU/TUS\*



SHS\*

\* According to the fitting  
\*\* 2,2 kW 1~

\*\*\*Intermediate dies not required

Package = machine +PB Ø 17,20,24,28,32,40,44,50

We reserve the right to make technical changes without notice

# HM 380i B

Utilising all of the Uniflex technological advantages, combined with a master die length of 126mm and tool re-enforcement, guarantees the quality your customers demand, particularly for the most recently developed ultra heavy fittings.



Technical Data	HM 380iB Ecoline 380 iHB
Crimp Force (kN/Ton)	3400/340
No Grease	20% less friction
Control	UNIMATICControl B
SAE R13*	2"
SAE R15*	3"
Industrial	4"(6")**
Max Press Range	Without dies
Opening	+70mm
Opening without dies	215mm
Speed (mm/sec)	Standard / H model
Close	23 / 29
Crimp	1,6 / 2,1
Open	23 / 29
Die profile	237 L & 239 L
Noise Level	62 dBA
Drive	4 kW Standard / 5,5 kW H Model
Oil	100 l
L-W-H(mm)	1200 x 600 x 1600
Weight	750kg

\*According to the fitting

\*\*Without flange

	239 L 237 L ***
	237.239.2L2
Ø mm	mm
6,8	40
9	70
12	70
14	70
16	70
17	70
19	70
20	70
22	70
24	70
26	70
28	85
32	85
36	85
40	85
44	85
47	110
50	110
54	110/118
57	110/118
62	110/118
67	118
71	118
74	118
78	118
84	118
86	118
90	118
96	118
103	118
106	126
111	126
116	126
121	126
126	126
131	126

\*\*\*Intermediate dies not required

HM3.../Package =  
machine +PB Ø 17,20,24,28,32,40,44,50,57,71+237.239.212

## Standard



QDC 239.4



UNIMATICControl B



TA (A)

## Options



UNIMATICControl E



UNIMATICControl E



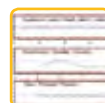
UTS



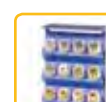
PS



PTS System



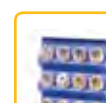
PFM



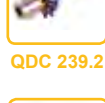
QDS 239 C



PFC



QDS 239 S



QDC 239.2



QDS 239 R\*



SHS



LUS/LUF

We reserve the right to make technical changes without notice

## P 160

The Uniflex Hydrostatic Test Benches make the efficient and safe final inspection of hose lines practical and fast. In the case of a leakage the emitting fluid will flow back into the tank without any loss of testing fluid. Due to the use of a special water-oil emulsion, the assembly is not only tested, but at the same time protected against corrosion. By connecting the optional test report unit all results may be recorded continuously.



P 160



Stainless steel – VA

Only one of two options possible

Technical Data	P 160
Test Pressure	120-1300 bar
Drive	Intensifier
Flow	1,1 l/min
Capacity	7 bar, 20 NI/min
Tank Dimension	1590 x 795 x 370mm
Test bench dimension	2210 x 950 x 1325mm
Reservoir Capacity	100 l
Alternative Drive	0,38 kW 400 V-50 Hz-3~
Paint	Blue / Grey
Weight	210kg empty
Noise Level	72 dBA
<b>Accessories</b>	Operating Manual / Suction Filter / Air Preparation Unit
Steck-O-Adapter DN 4/6/8/10/12/G 1/2" 405.901	✓
Stec-O-Adapter DN 4/6/8/10/12/G 1/2" 405.901	✓
Anticorrosive additive	EM 10 I

Options	P 110	P160
High Pressure	—	1300-3000 bar
Low Pressure	—	20-120 bar
Fat Filling Pump 405.904	—	4 l/min
Stainless steel tank	✓	✓
Cleaning Unit 403.903	—	✓
UNIMATICControl E	—	✓

P 160 Package =  
machine + Steck-O Adapter 405.901 & 405.902, EM 10 L

### Standard



QDS 239 B

### Options



UNIMATICControl E



600.901 5µm

We reserve the right to make technical changes without notice

## UNIFLEX HOSE CUTTING MACHINES



EM 3 DC - 12 Volt



EM 3 Ecoline



TM G Ø



Technical data	EM 10	EM 3	EM 2	EM 6	EM6B	EM 50	EM 8	EM 8B	EM 110
Workshop SAE R13 & SAE R15*	—	1 1/4"	1 1/4"	1 1/2"	1 1/2"	2"	2"	2"	2 1/2"
Production SAE R13 & SAE R15*	—	3/4"	3/4"	1"	1"	1 1/4"	1 1/2"	1 1/2"	2"
SAE R12	5/8"	1 1/4"	1 1/4"	1 1/2"	1 1/2"	2"	2"	2"	2"
Industrial	1 1/4"	1 1/2"	1 1/2"	2"	2"	2 1/2"	4"	4"	4"
Max outside Ø mm	45	80	80	65	65	80	120	120	125
Cooling system	—	—	—	—	—	Standard	—	—	Optional
Noise Level (dBA)	60	60	60	60	60	60	60	60	69
Brake Motor	=	✓	✓	✓	✓	✓	✓	✓	✓
Suction connection Ø mm	30	80	80	80	80	80	80	80	100
Drive	1,1 kW 1 Ph	3 kW	3 kW	3 kW	3 kW	4,4 kW	5 kW	5kW	7,5 kW
Cutting blade (mm)	160 x 2,5 x 20	275 x 3 x 30	275 x 3 x 30	300 x 3 x 30	300 x 3 x 30	350 x 3 x 50	400 x 3 x 50	400 x 3 x 50	520 x 4 x 120
L-W-H (mm)	36 x 340 x 310	650 x 420 x 300	650 x 420 x 300	780 x 540 x 670	780 x 540 x 670	700 x 680 x 390	900 x 635 x 550	900 x 635 x 550	800 x 780 x 1700
Weight	8	50	65	73	88	69	130	145	280
<b>Options</b>									
12 Volt / 24 Volt	—	✓ 1 1/4" SAE R12	—	—	—	—	—	—	—
Hydropneumatic	—	—	—	—	—	✓ EM 50 P	✓ EM 8 P	✓ EM 8 BP	Standard
Brushing DN 5-6-8-10-12-16-19-25-31-38-51	—	—	Standard	—	Standard	—	—	Standard	—
Bench	✓	✓	✓	✓	✓	✓	✓	✓	Standard
V-Shape	—	—	—	—	—	—	—	—	✓

\*with special cutting blade

We reserve the right to make technical changes without notice



## HM200 ECOLINE DIE SELECTION CHART

Please Note:

Intermediate die is not required for HM200 ECOLINE

		239-17	239-20	239-24	239-28	239-32	239-36	239-40	239-44	239-50	239-57	239-62
HOSE PART NUMBER	421	-4	-6	-8/-10		-12		-16				
	421FS	-4		-8		-12						
	421SN									-20	-24	
	426	-4	-6	-8		-12		-16		-20	-24	
	431	-4/-5	-6	-8/-10		-12		-16				
	436		-6	-8/-10		-12		-16				
	471ST	-4	-6	-8/-10		-12		-16				
	451TC	-4	-6									
	472TC									-20	-24	
	481	-4	-6	-8		-12		-16				
	482			-8								
	301	-4	-6	-8	-10	-12		-16				
	301LT	-4	-6									
	301MH									-20	-24	
	304	-4	-5/-6	-8	-10	-12		-16		-20	-24	
	341		-6	-8		-12		-16		-20		
	351ST	-4	-5/-6	-8	-10	-12		-16				
	381	-4	-5/-6	-8	-10	-12		-16				
	421WC	-4	-6	-8								
	601	-4	-6	-8		-12		-16				
	CM2HP	-4	-6	-8								
	372			-6	-8	-12		-16				
	701			-6	-8	-10	-12					
	721TC		-6	-8	-10	-12		-16		-20	-24	
	731					-12		-16		-20	-24	
	772TC		-6	-8	-10	-12		-16		-20	-24	
	774					-12		-16		-20	-24	
	782ST					-12		-16		-20	-24	
	791TC					-12		-16				
	CM4SHP							-16				
	CM4TC					-12		-16	-20			

## HM290 DIE SELECTION CHART

Please Note:

Intermediate die required up to and including PB239L-50

Intermediate die can be used with die sets PB239L-54 / -57 / 62

Intermediate die not required from die set PB239L-67 and upwards

Intermediate Die Part Number - 232.239 L

		PB239L-17	PB239L-20	PB239L-24	PB239L-28	PB239L-32	PB239L-36	PB239L-40	PB239L-44	PB239L-50	PB239L-57	PB239L-62	PB239L-67
HOSE PART NUMBER	421	-4	-6	-8/-10		-12		-16					
	421FS	-4		-8		-12							
	421SN									-20	-24		-32
	426	-4	-6	-8		-12		-16		-20	-24		-32
	431	-4/-5	-6	-8/-10		-12		-16					
	436		-6	-8/-10		-12		-16					
	471ST	-4	-6	-8/-10		-12		-16					
	451TC	-4	-6										
	472TC									-20	-24		-32
	481	-4	-6	-8		-12		-16					
	482			-8									
	301	-4	-6	-8	-10	-12		-16					
	301LT	-4	-6										
	301MH									-20	-24		-32
	304	-4	-5/-6	-8	-10	-12		-16		-20	-24		-32
	341		-6	-8		-12		-16		-20			
	351ST	-4	-5/-6	-8	-10	-12		-16					
	381	-4	-5/-6	-8	-10	-12		-16					
	421WC	-4	-6	-8									
	601	-4	-6	-8		-12		-16					
	CM2HP	-4	-6	-8									
	372			-6	-8	-12		-16					
	701			-6	-8	-10	-12						
	721TC		-6	-8	-10	-12		-16		-20	-24		-32
	731					-12		-16		-20	-24		
	772TC		-6	-8	-10	-12		-16		-20	-24		-32
	774					-12		-16		-20	-24		-32
	782ST					-12		-16		-20	-24		-32
	791TC					-12		-16		-20	-24		
	CM4SHP							-16					
	CM4TC					-12		-16	-20				
	P35												
	R42												

Hose  
**A**Fittings  
**B**Equipment  
**C**Accessories  
**D**Technical  
**E**

## HM380IB DIE SELECTION CHART

## Please Note:

Intermediate die required up to and including PB239L-50

Intermediate die can be used with die sets PB239L-54 / -57 / 62

Intermediate die not required from die set PB239L-67 and upwards

Intermediate Die Part Number - 237.239 L

		PB239L-17	PB239L-20	PB239L-24	PB239L-28	PB239L-32	PB239L-36	PB239L-40	PB239L-44	PB239L-50	PB239L-57	PB239L-62	PB239L-67
<b>HOSE PART NUMBER</b>	421	-4	-6	-8/-10		-12		-16					
	421FS	-4		-8		-12							
	421SN									-20	-24		-32
	426	-4	-6	-8		-12		-16		-20	-24		-32
	431	-4/-5	-6	-8/-10		-12		-16					
	436		-6	-8/-10		-12		-16					
	471ST	-4	-6	-8/-10		-12		-16					
	451TC	-4	-6										
	472TC									-20	-24		-32
	481	-4	-6	-8		-12		-16					
	482			-8									
	301	-4	-6	-8	-10	-12		-16					
	301LT	-4	-6										
	301MH									-20	-24		-32
	304	-4	-5/-6	-8	-10	-12		-16		-20	-24		-32
	341		-6	-8		-12		-16		-20			
	351ST	-4	-5/-6	-8	-10	-12		-16					
	381	-4	-5/-6	-8	-10	-12		-16					
	421WC	-4	-6	-8									
	601	-4	-6	-8		-12		-16					
	CM2HP	-4	-6	-8									
	372			-6	-8	-12		-16					
	701			-6	-8	-10	-12						
	721TC		-6	-8	-10	-12		-16		-20	-24		-32
	731					-12		-16		-20	-24		
	772TC		-6	-8	-10	-12		-16		-20	-24		-32
	774					-12		-16		-20	-24		-32
	782ST					-12		-16		-20	-24		-32
	791TC					-12		-16		-20	-24		
	CM4SHP							-16					
	CM4TC					-12		-16	-20				
	P35												
	R42												