

How to make Parkrimp® No-Skive hose assemblies with Parkrimp® 2

it's so easy
to crimp hose



www.easy-crimping.com



www.parker.com/crimpsource-euro

Advantages

- All hoses no-skive – reducing investment and labour costs, avoiding operational problems related to skiving.
- All fittings 1-piece – avoiding mismatching and risks due to wrong component selection.
- Crimping diameters given by dies – avoiding mistakes and operational risks due to incorrect crimper adjustment.
- Die sizes distinguished by colour, die sets chained – preventing errors and losses, sparing time.
- Parkalign® fitting positioning – guaranteed crimping along the entire fitting length, avoiding operational risks.

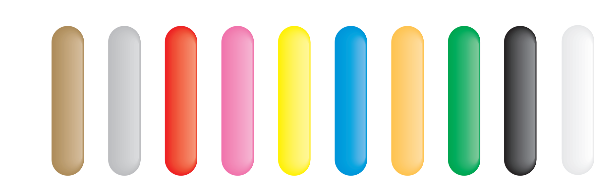
Parkrimp® No-Skive

- Trouble-free, Timesaving, Cost Saving and Safe!
- Just Cut, Clean and Crimp!

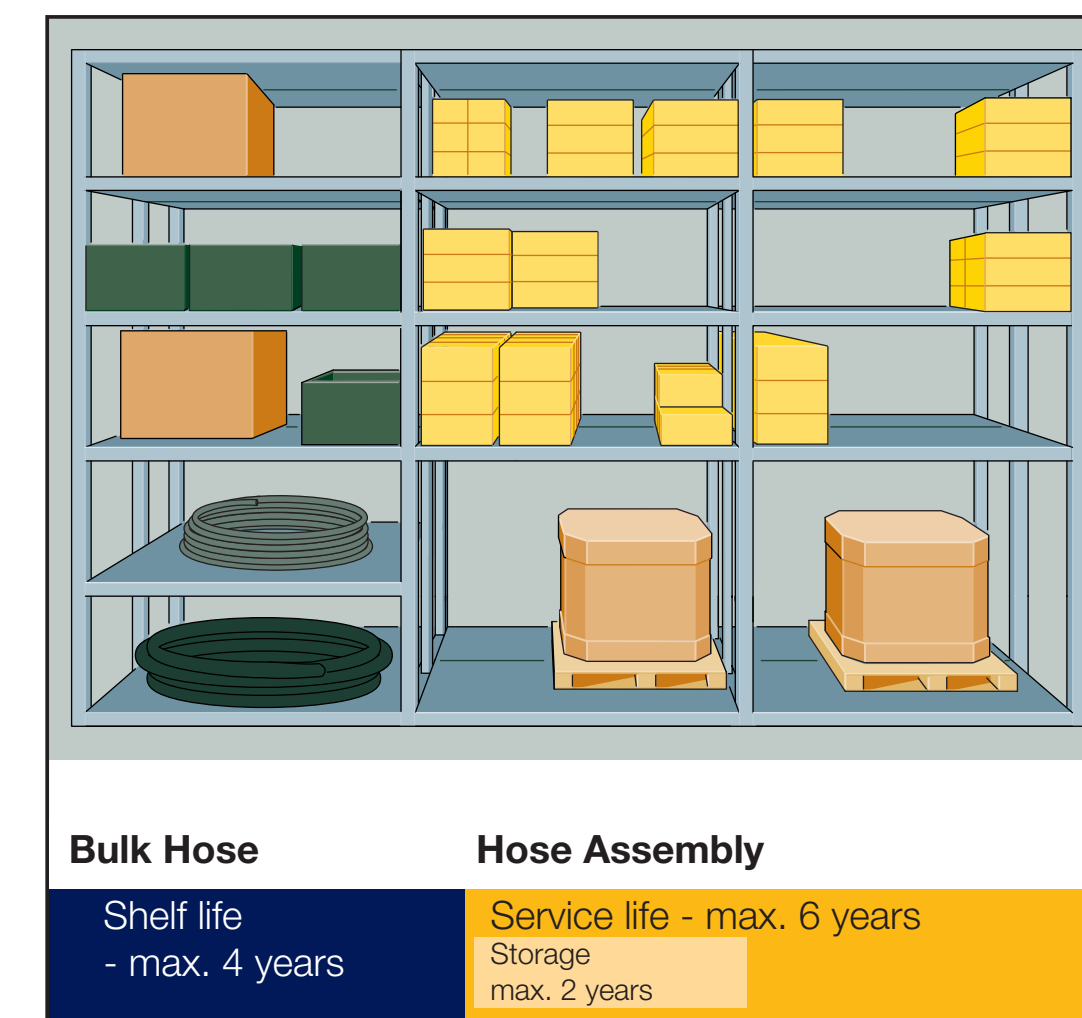
Parkrimp® colour-coded die sets



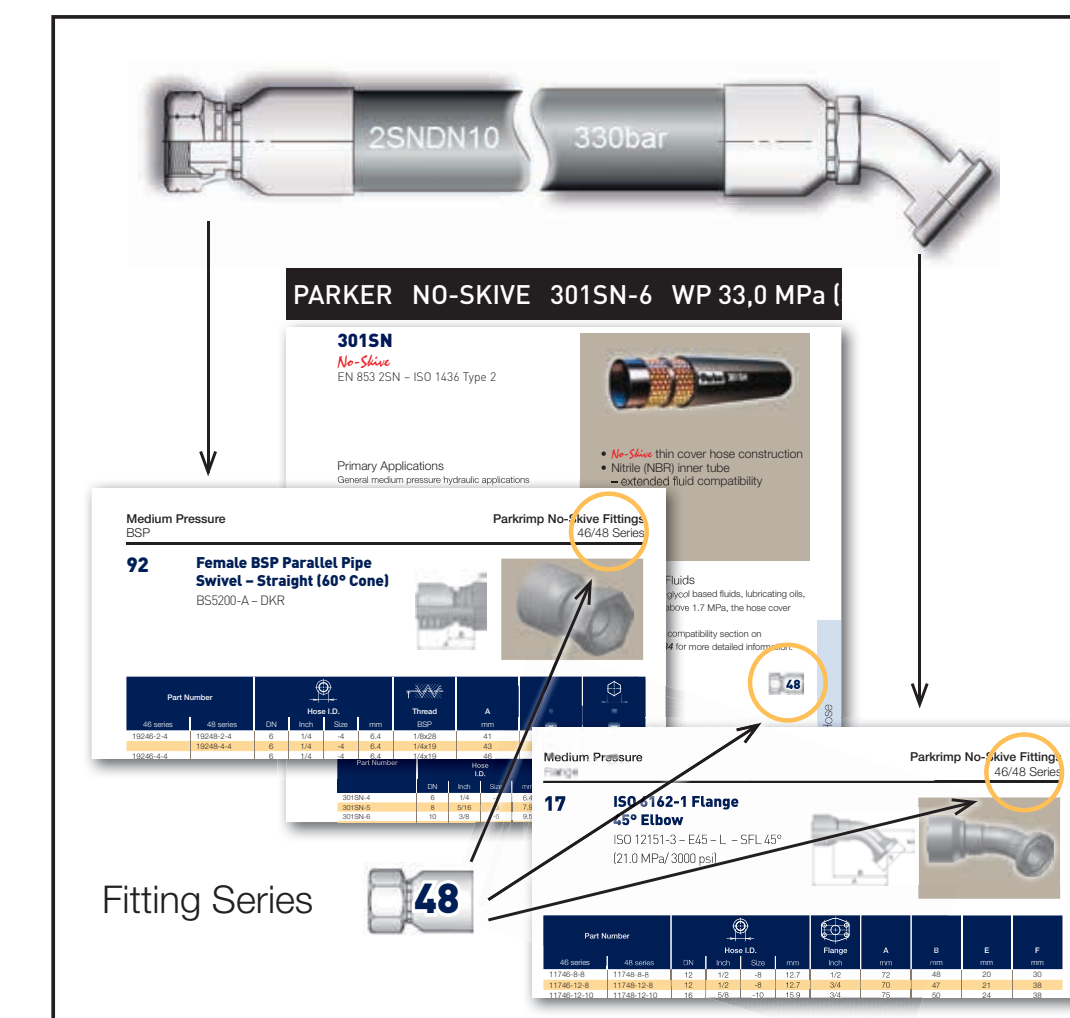
- Chain link keeps segments together
- No loose parts to mismatch or misplace.
- The crimped fitting provides 360 degree gripping power for greater impulse life



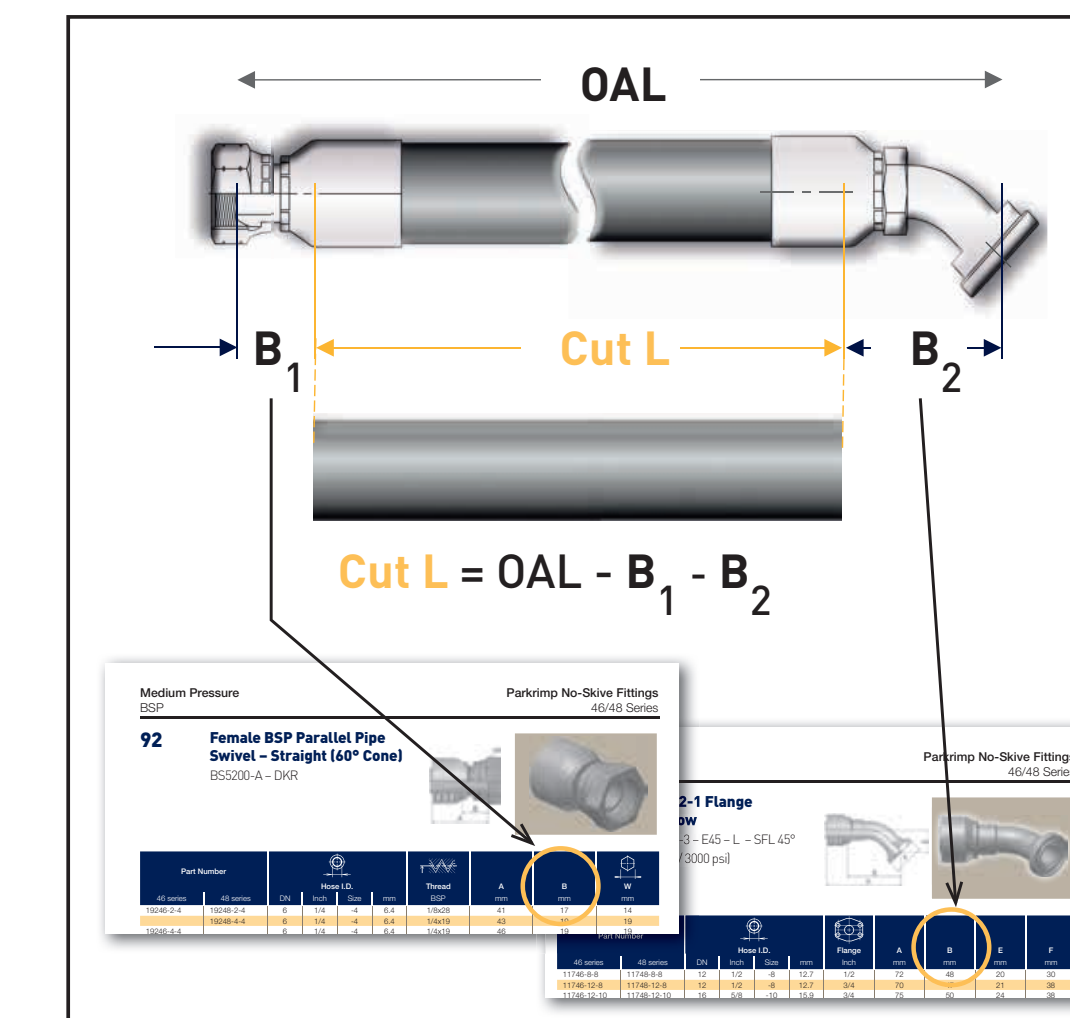
Hose ID size DN	Die sets	Part Number								
		16 series	26 series	43 series	46 series	48 series	70 series	73 series	77 series	
-4 6	red	80C-B04	80C-E04	80C-A04	80C-B04	80C-C04				
-5 8	violet	80C-B05	80C-E05	80C-A05	80C-B05	80C-C05				
-6 10	yellow	80C-B06	80C-E06	80C-A06	80C-B06	80C-C06	83C-D06			
-8 12	blue	80C-B08	80C-E08	80C-A08	80C-B08	80C-C08	83C-D08			80C-CS08
-10 16	orange	80C-B10	80C-E10	80C-A10	80C-B10	80C-C10	83C-D10			80C-CS10
-12 20	green	80C-B12	80C-E12	80C-A12	80C-B12	80C-C12	83C-D12	83C-L12 or 80C-L12		80C-CS12
-16 25	black	80C-B16	80C-E16	80C-A16 or 83C-A16H	80C-B16	80C-C16	83C-D16 or 83C-D16H	83C-L16 or 80C-L16		83C-CS16
-20 32	white		83C-E20	80C-A20 or 83C-A20H	80C-B20	80C-C20 or 83C-C20H		83C-L20		83C-CS20
-24 40	red		83C-E24	83C-A24		83C-C24		83C-L24		83C-CS24
-32 50	green		83C-E32	83C-A32		83C-C32		83C-L32		83C-CS32



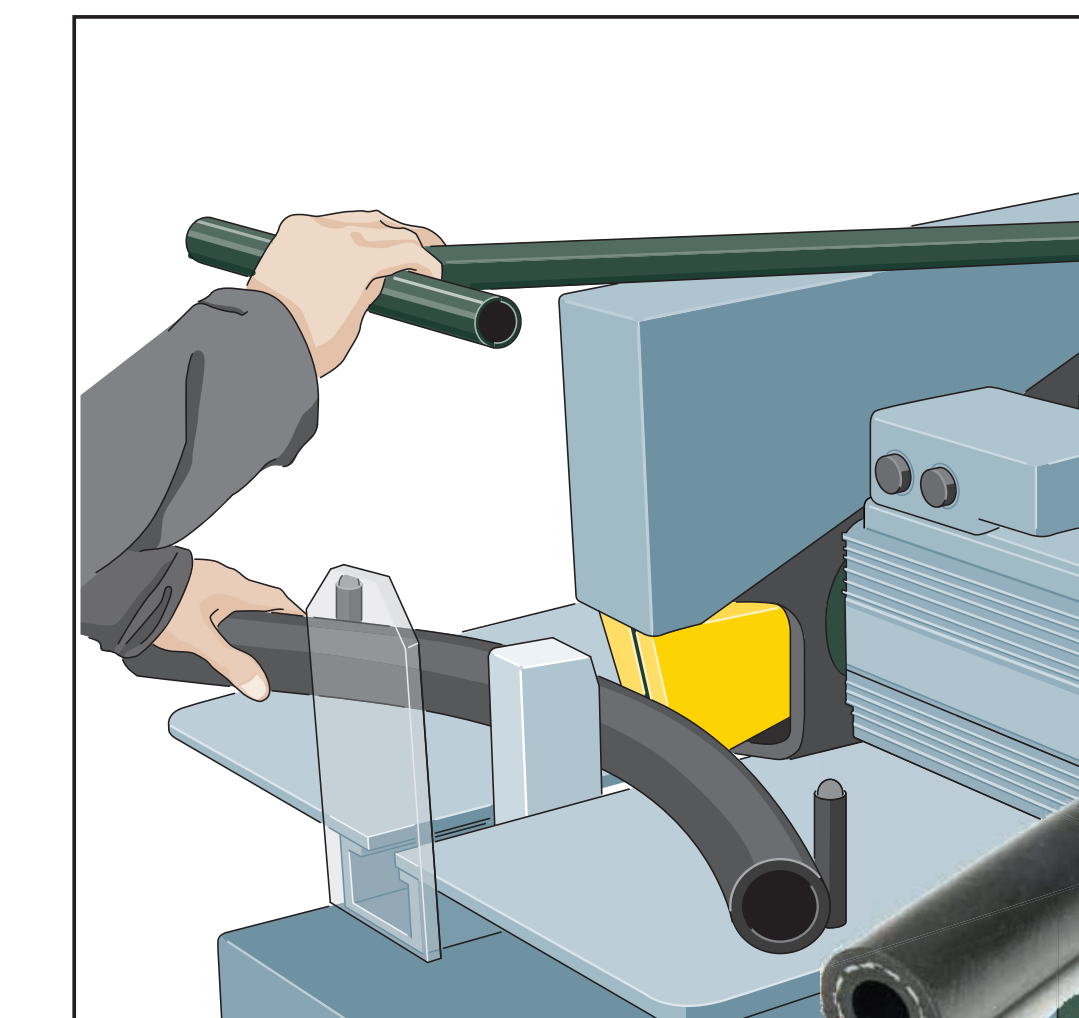
1. Store hoses and fittings in a clean, dry and dark room with stable temperature. Preferentially keep them in the original packaging.



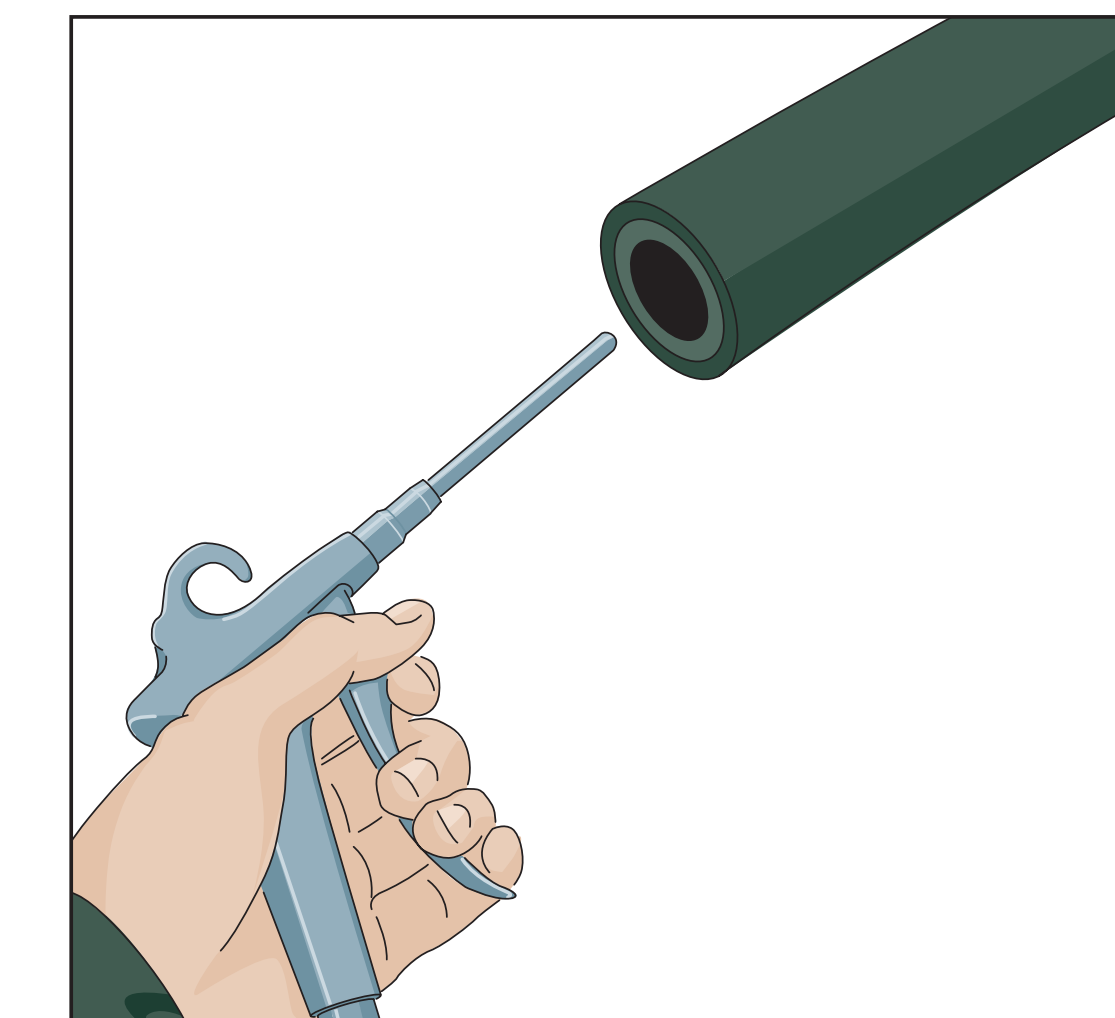
2. Specify Parker Components in CAT4400 acc. to the required parameters. Take care to select correct fitting series!



3. Specify Cut Length as overall length of the assembly OAL minus fitting dimensions B1 and B2 (find in CAT4400).



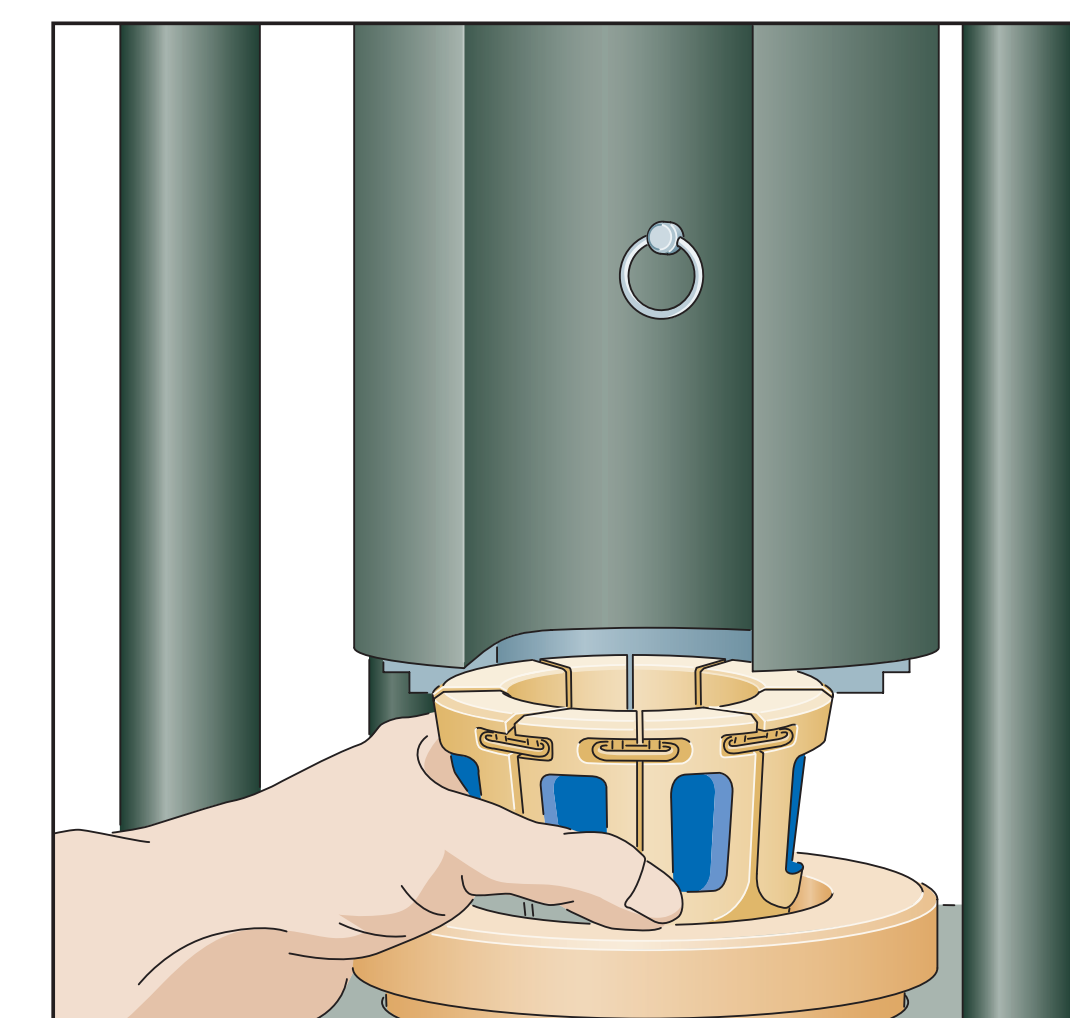
4. Cut the hose with a specialized cutting machine and sharp cutting blade. The cut end has to be smooth and even, free of burrs and debris, hose layers unseparated.



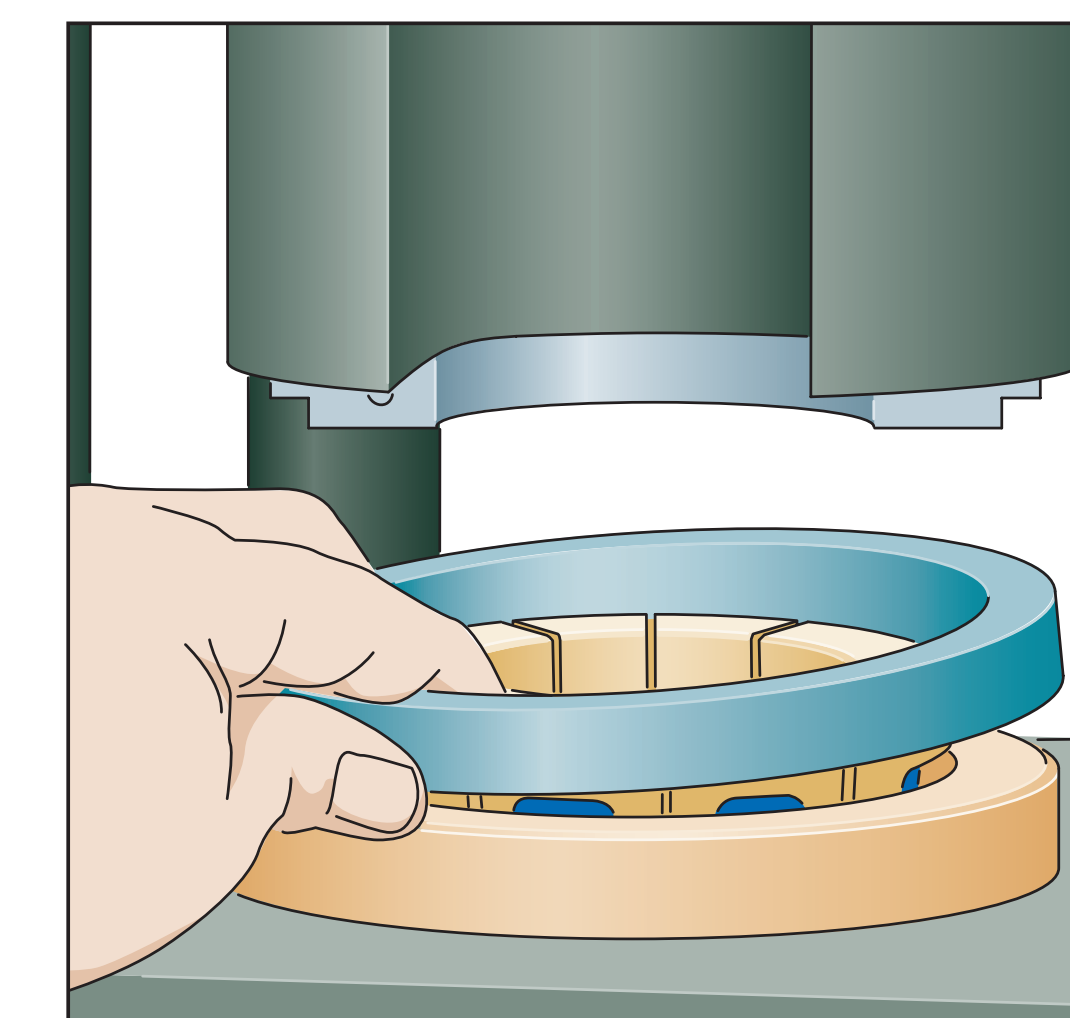
5. Clean the hose with compressed air (min. 3 sec. from both ends).



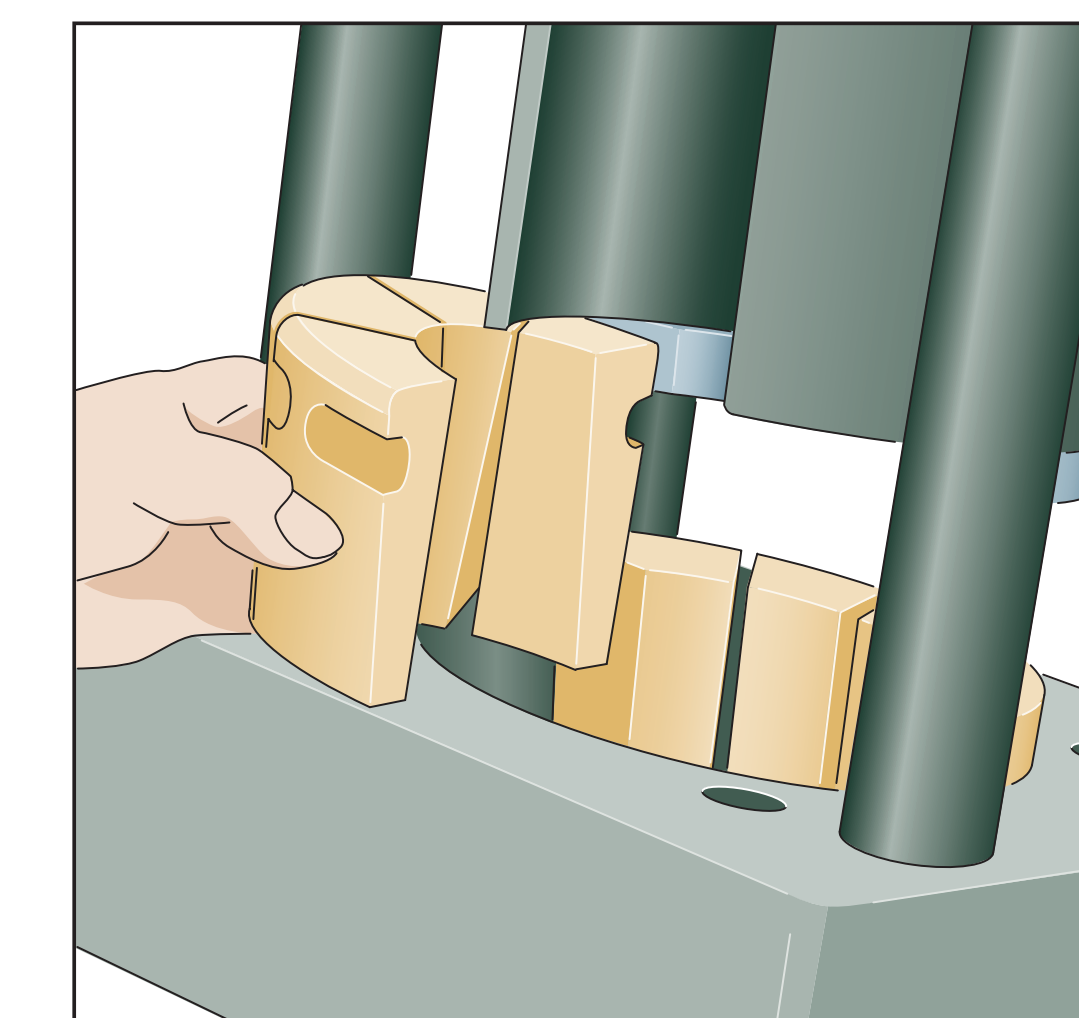
6. Mark the Insertion Depth acc. to the Crimp Dimensions wallchart or www.parker.com/crimpsource-euro and push the hose onto the fitting up to the mark. If necessary, slightly lubricate the nipple end with hydraulic oil.



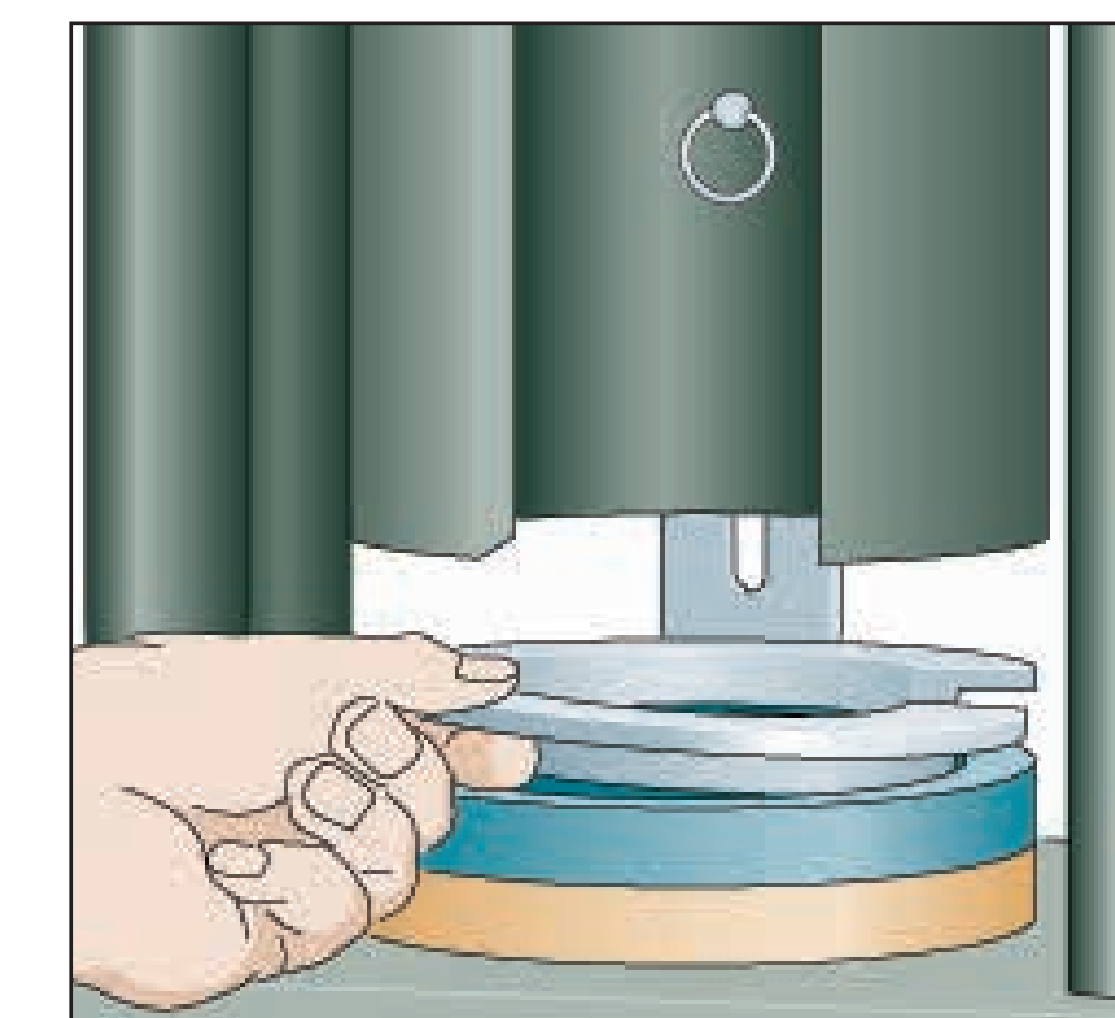
7. In www.parker.com/crimpsource-euro or in the Crimp Dimensions wallchart check the need of using adapter bowl, spacer ring and spacer plate and select the correct die set. Lift the half of the split-die-ring, secure it with the pin and insert the die set into the greased (!) adapter bowl



8. If the spacer ring is required, place it on the adapter bowl. If the spacer plate is required, place it on the base plate around the adapter bowl.



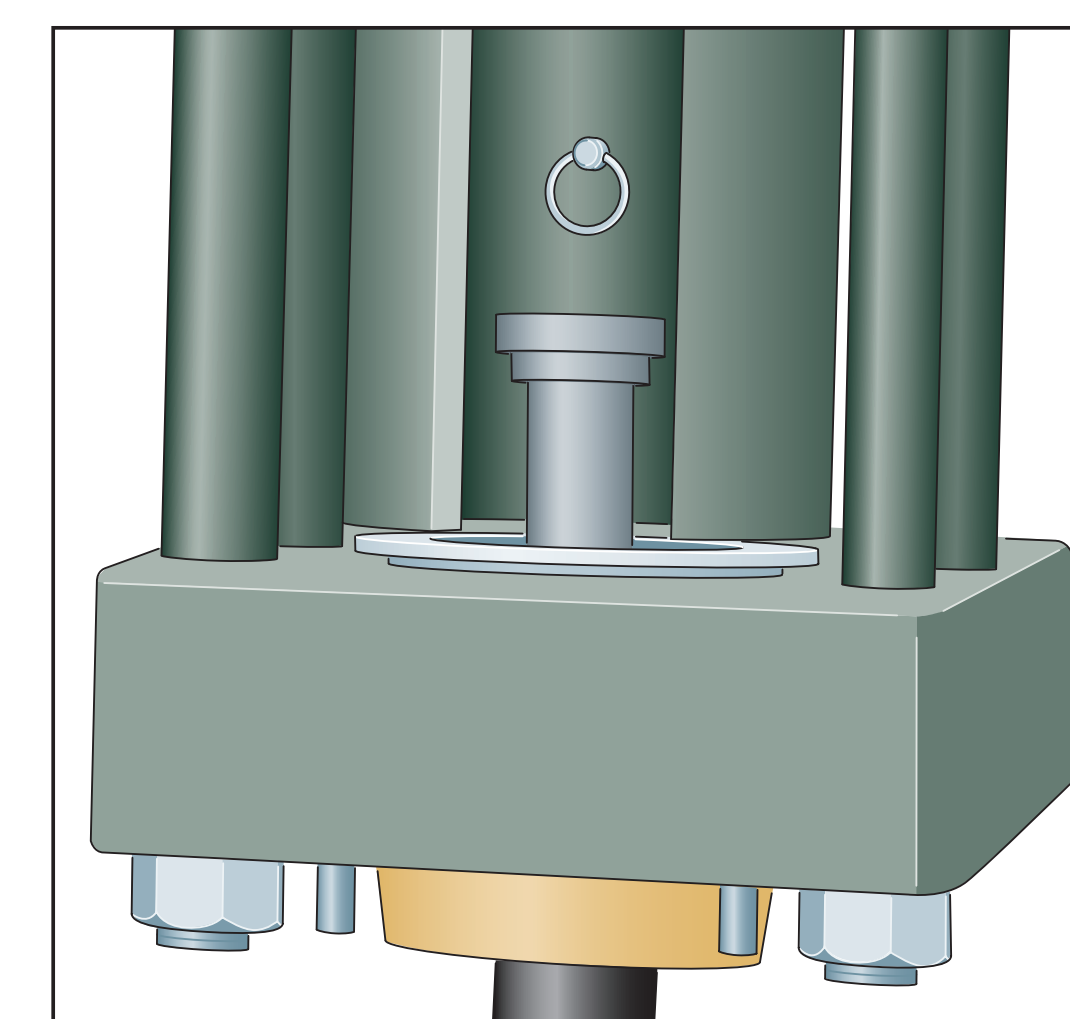
9. 2-piece die sets (series 83C – see the Crimp Dimensions wallchart or www.parker.com/crimpsource-euro) are inserted directly into the greased (!) base plate bowl. If the spacer plate is required, place it on the base plate around the dies.



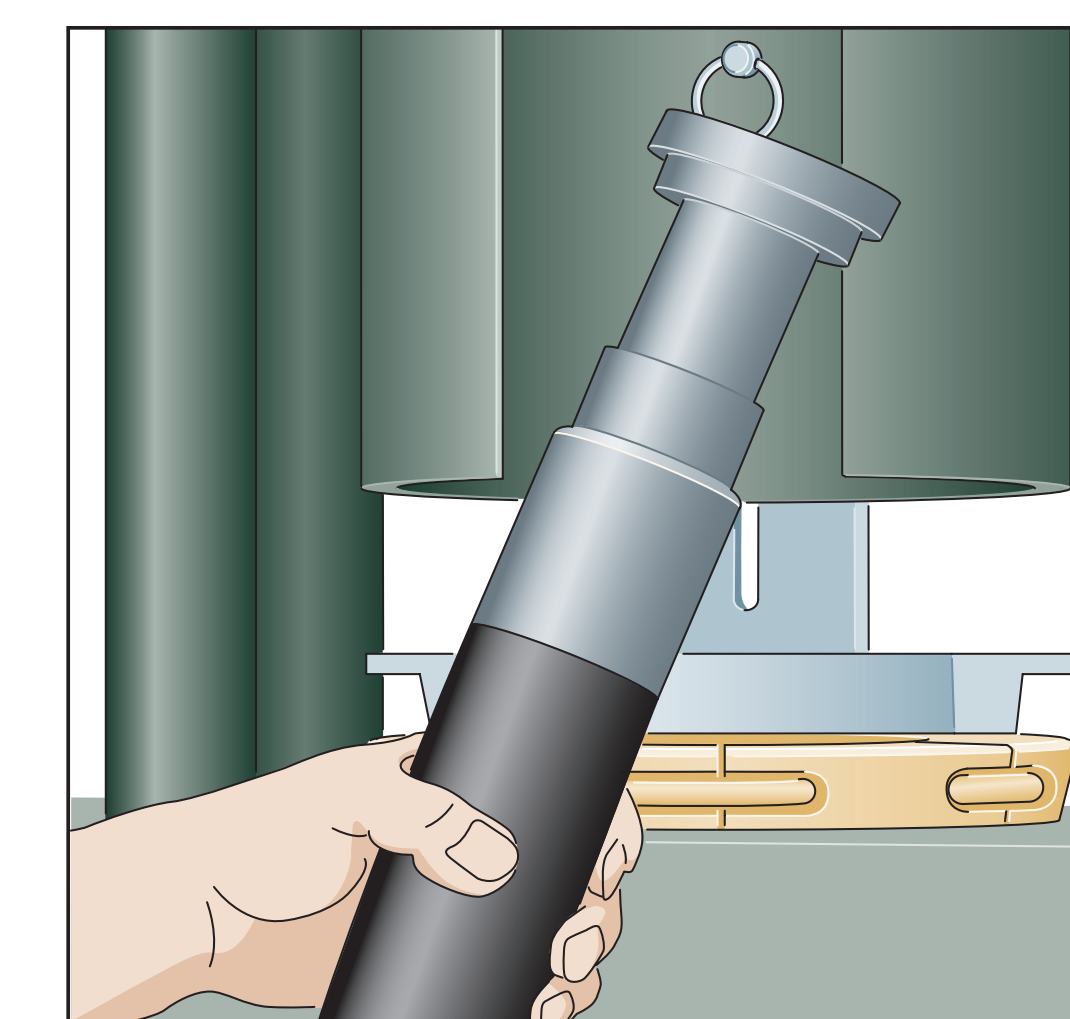
10. Lower the back half of the split die ring by pulling the pin forward, add the front half of the ring and align them on the top of the dies (the same process whether or not the adapter bowl, spacer ring and spacer plate are used).



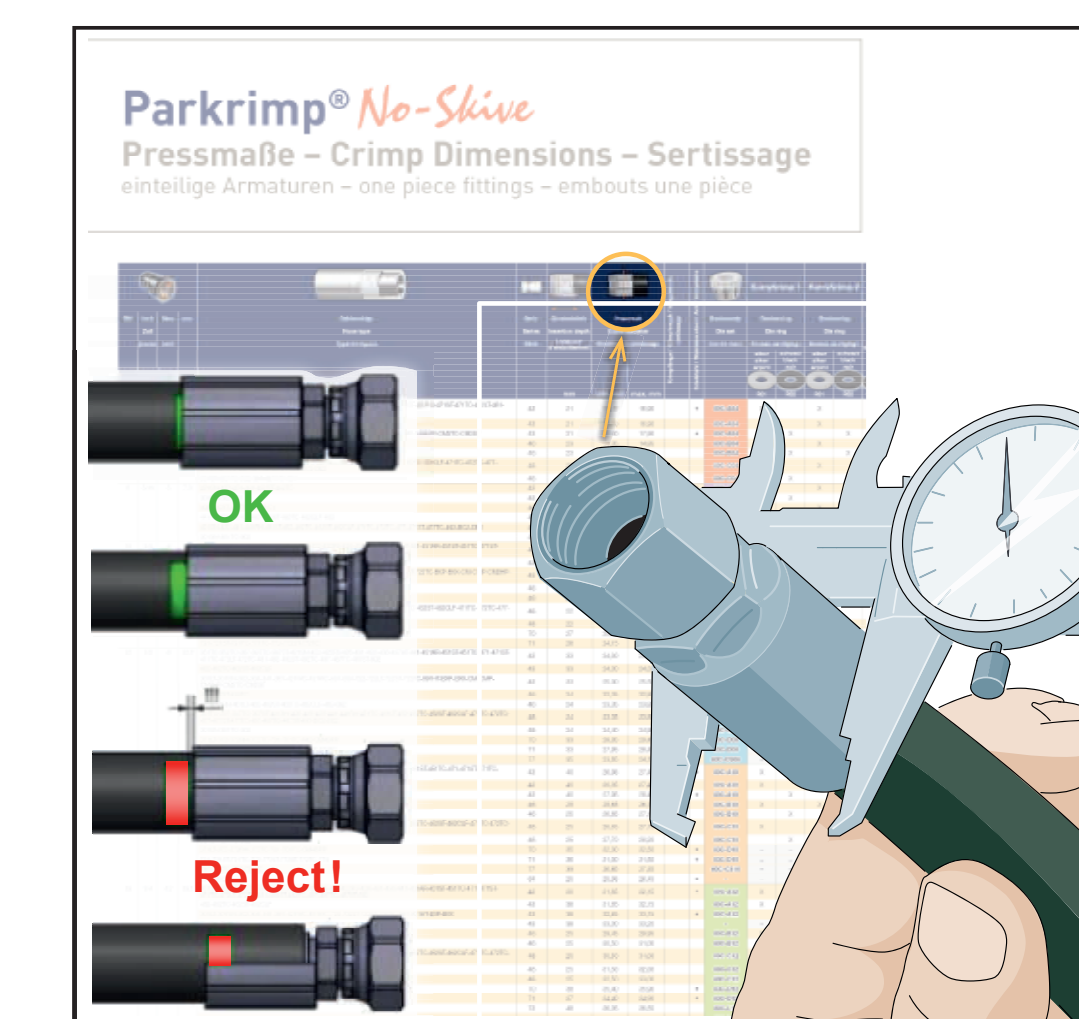
11. Insert the hose with fitting from below, align the dies and rings and pull the hose with fitting lightly down to rest the shell onto the Parkalign® step inside the die set.



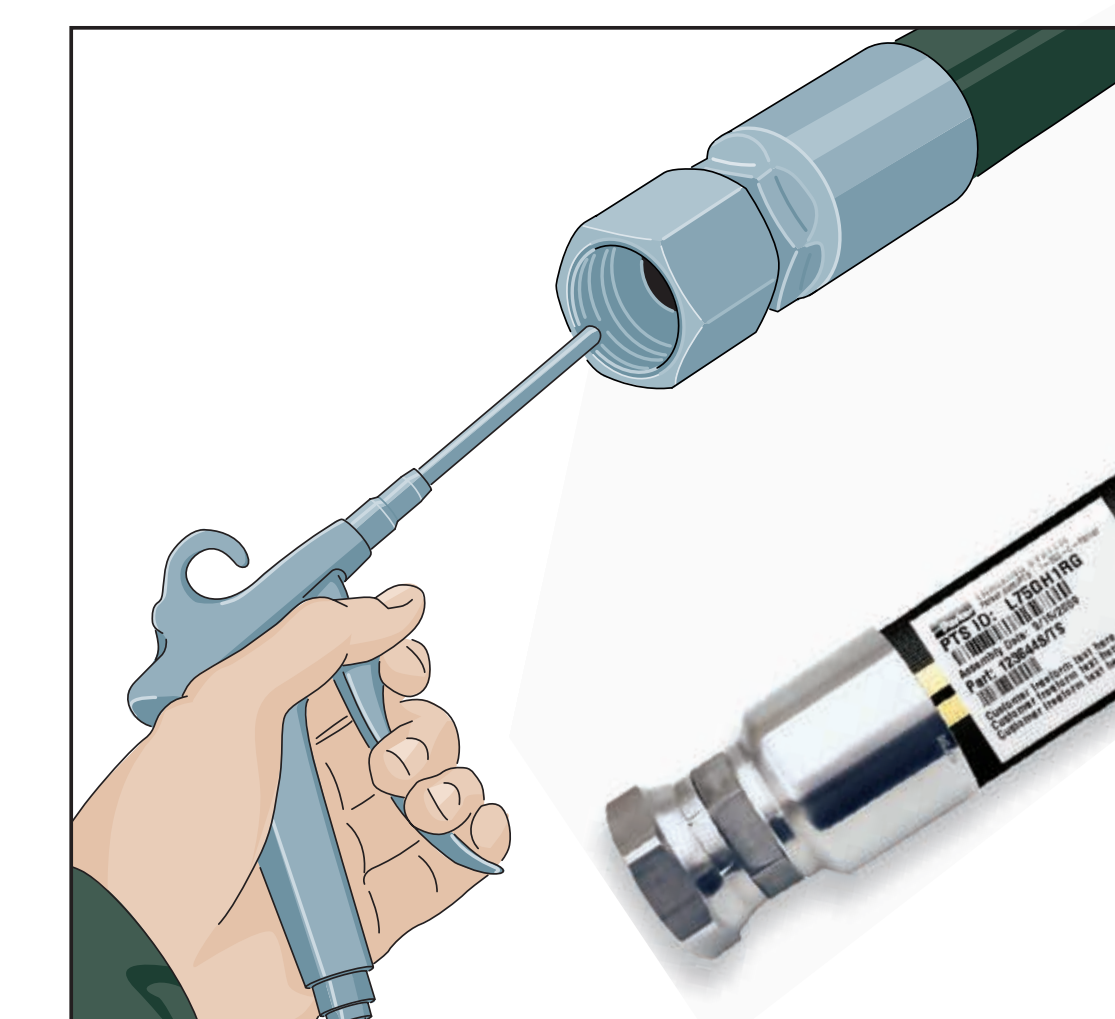
12. Hold lightly the hose so that the fitting sits for the whole time on the Parkalign® and operate the pump until the die split ring entirely bottoms the spacer ring (or the top of the adapter bowl, spacer plate or base plate).



13. Release the pump pressure and remove the finished hose assembly. For elbow fittings or big jump sizes removing of the front half of the 2-piece dies (series 83C) may be needed.



14. Measure the crimp diameter on the flat surfaces in the middle of the shell and check the value against the Crimp Dimensions wallchart or www.parker.com/crimpsource-euro. Check also the insertion depth. If crimp diameter or insertion depth are wrong reject the assembly!



15. Clean the assembly with compressed air and cap or wrap it with shrink film. We strongly recommend to mark the hose assembly with Parker PTS label and record it in the Parker Tracking System (see www.parker.com/pts)



ENGINEERING YOUR SUCCESS.