



# Superkrimp Crimp Die Selection Chart

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



| PN: SK HOSE DECAL 7/08<br>Hose                                                        |  |  | Fittings                                                                                                                                                                        | Die Selection and Crimp Diameters                                                                                                                                 |                |                |                |                                                                                                                    |                | PN: SK MASTER DECAL 8/07 |                                                                                                                                             |                |                |  |
|---------------------------------------------------------------------------------------|--|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------|----------------|--------------------------------------------------------------------------------------------------------------------|----------------|--------------------------|---------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------|--|
| Die                                                                                   |  |  |                                                                                                                                                                                 | - 4<br>RED                                                                                                                                                        | - 5<br>PUR     | - 6<br>YEL     | - 8<br>BLU     | - 10<br>ORG                                                                                                        | - 12<br>GRN    | - 16<br>BLK              | - 20<br>WHT                                                                                                                                 | - 24<br>RED    | - 32<br>GRN    |  |
| 351TC 431 471ST<br>351ST 436 472TC<br>422 451TC 482TC<br>424 451ST 482ST<br>426 471TC |  |  | 43 Series                                                                                                                                                                       | 80C-A04                                                                                                                                                           | 80C-A05        | 80C-A06        | 80C-A08        | 80C-A10                                                                                                            | 80C-A12        | 80C-A16                  | 80C-A20                                                                                                                                     | 83C-A24        | 83C-A32        |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 | 0.645<br>0.665                                                                                                                                                    | 0.710<br>0.730 | 0.825<br>0.845 | 0.945<br>0.965 | 1.060<br>1.080                                                                                                     | 1.245<br>1.265 | 1.590<br>1.610           | 1.970<br>1.990                                                                                                                              | 2.290<br>2.310 | 2.735<br>2.755 |  |
|                                                                                       |  |  |                                                                                                                                                                                 |  Small Silver Die (80C-AXX) and Adapter Bowl (83C-OCB)                           |                |                |                |                                                                                                                    |                |                          |  Large Silver Die (83C-AXX)                              |                |                |  |
| 421WC 304 601<br>302/301 341 604<br>301LT 381 881                                     |  |  |                                                                                                                                                                                 | 0.685<br>0.705                                                                                                                                                    | 0.750<br>0.770 | 0.865<br>0.885 | 0.985<br>1.005 | 1.100<br>1.120                                                                                                     | 1.285<br>1.305 | 1.630<br>1.650           | 2.010<br>2.030                                                                                                                              | 2.330<br>2.350 | 2.775<br>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                                                                                   |  |  | 70 Series                                                                                                                                                                       | 83C-D06                                                                                                                                                           |                | 83C-D08        | 83C-D10        |                                                                                                                    |                |                          |                                                                                                                                             |                |                |  |
| 701 F42 (-8 ONLY)                                                                     |  |  |                                                                                                                                                                                 | 0.990<br>1.010                                                                                                                                                    |                | 1.140<br>1.160 | 1.260<br>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                                                                                                                                     |                |                |  |
| 711 721 721TC<br>721ST 772TC 774                                                      |  |  |                                                                                                                                                                                 | 0.950<br>0.970                                                                                                                                                    |                | 1.100<br>1.120 | 1.220<br>1.240 | 1.355<br>1.375                                                                                                     | 1.695<br>1.715 | 2.025<br>2.045           | 2.290<br>2.310                                                                                                                              |                |                |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 |  Small Black Die (83C-DXX) and Adapter Bowl (83C-OCB)                            |                |                |                |                                                                                                                    |                |                          |  Large Black Die (83C-AXX)                               |                |                |  |
| Die                                                                                   |  |  | 73 Series                                                                                                                                                                       |                                                                                                                                                                   |                |                |                | 83C-L12                                                                                                            | 83C-L16        |                          |                                                                                                                                             |                |                |  |
| 731                                                                                   |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                | 1.420<br>1.440                                                                                                     | 1.730<br>1.750 |                          |                                                                                                                                             |                |                |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                |  Large Olive Drab (83C-LXX)       |                |                          |                                                                                                                                             |                |                |  |
| Die                                                                                   |  |  | 76 Series                                                                                                                                                                       |                                                                                                                                                                   |                |                |                | 83C-U12                                                                                                            | 83C-U16        |                          |                                                                                                                                             |                |                |  |
| 761                                                                                   |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                | 1.540<br>1.560                                                                                                     | 1.865<br>1.885 |                          |                                                                                                                                             |                |                |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                |  Large Silver Die (83C-UXX)     |                |                          |                                                                                                                                             |                |                |  |
| Die                                                                                   |  |  | 78 Series                                                                                                                                                                       |                                                                                                                                                                   |                |                |                | 83C-L12                                                                                                            | 83C-L16        | 83C-L20                  |                                                                                                                                             |                |                |  |
| 78C 781 782TC<br>782ST                                                                |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                | 1.420<br>1.440                                                                                                     | 1.730<br>1.750 | 2.140<br>2.160           |                                                                                                                                             |                |                |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                |  Large Olive Drab (83C-LXX)     |                |                          |                                                                                                                                             |                |                |  |
| Die                                                                                   |  |  | 79 Series                                                                                                                                                                       |                                                                                                                                                                   |                |                |                | 83C-L12                                                                                                            | 83C-L16        |                          |                                                                                                                                             |                |                |  |
| 791TC 792TC F42 792ST                                                                 |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                | 1.420<br>1.440                                                                                                     | 1.730<br>1.750 |                          |                                                                                                                                             |                |                |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 |                                                                                                                                                                   |                |                |                |  Large Olive Drab Die (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        |  |
| 213 285 293                                                                           |  |  |                                                                                                                                                                                 | 0.460<br>0.480                                                                                                                                                    | 0.520<br>0.540 | 0.575<br>0.595 | 0.670<br>0.690 | 0.805<br>0.825                                                                                                     | 0.915<br>0.935 | 1.175<br>1.195           | 1.420<br>1.440                                                                                                                              | 1.670<br>1.690 | 2.160<br>2.180 |  |
| Tools Required                                                                        |  |  |                                                                                                                                                                                 |  Small Silver Die (80C-EXX) and Adapter Bowl (83C-OCB)                         |                |                |                |                                                                                                                    |                |                          |  Large Silver Die (83C-EXX)                            |                |                |  |
| 201 221FR 266<br>206 225 CAH<br>244 SS25UL                                            |  |  |                                                                                                                                                                                 | 0.500<br>0.520                                                                                                                                                    | 0.560<br>0.580 | 0.615<br>0.635 | 0.710<br>0.730 | 0.845<br>0.865                                                                                                     | 0.955<br>0.975 | 1.215<br>1.235           | 1.460<br>1.480                                                                                                                              | 1.710<br>1.730 | 2.200<br>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<br>1.175                                                                                                     | 1.450<br>1.470 | 1.740<br>1.760           | 2.010<br>2.030                                                                                                                              | 2.430<br>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<br>0.595                                                                                                                                                    | 0.725<br>0.745 |                | 0.830<br>0.850 | 0.960<br>0.980                                                                                                     | 1.110<br>1.130 | 1.355<br>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<br>0.655                                                                                                                                                    | 0.805<br>0.825 |                | 0.915<br>0.935 | 1.040<br>1.060                                                                                                     | 1.200<br>1.220 | 1.495<br>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/)

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