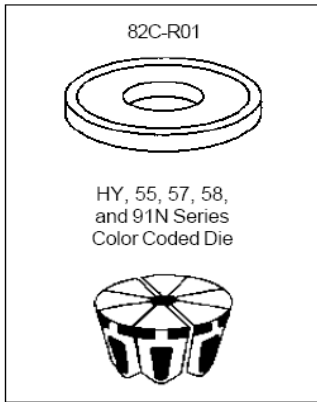




MiniKrimp Crimping Machine

Team Technical Services
6202 East Broadway Ave
Tampa, FL 33619
813-621-8725

The following tooling is used for crimping:



82C-R01 Silver Die Ring - to be used with HY, 55, 58, 57, and 91N Series fittings

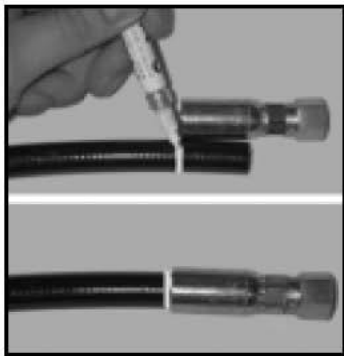
Note: There are 3 identification rings on the top of the 91 Series dies

929 PTFE Hose

HOSE SERIES - DASH SIZE	MAX WORKING PRESSURE	VACUUM RATING	MINIMUM BEND RADIUS	CRIMP DIE	CRIMP DIE COLOR	CRIMP DIAMETER
	PSI	INCHES/HG	INCHES			
929-4	3000	28	2.0	80C-T04N	Red	0.335 / 0.355
929-6	2500	28	4.0	80C-T06N	Yellow	0.470 / 0.490
929-8	2000	28	5.0	80C-T08N	Blue	0.565 / 0.585
929-12	1200	12	7.5	80C-T12N	Green	0.790 / 0.810
929-16	1250	14	9.0	80C-T16N	Black	1.100 / 1.120

Max Temp: 450°F

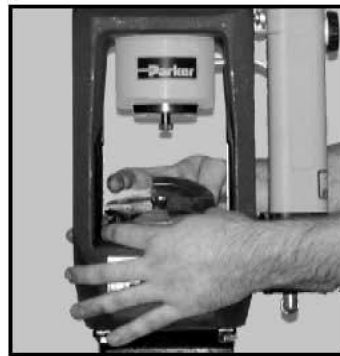
MiniKrimp™ Assembly Instructions for HY, 43, 55, 57, 58 and 91N Series Fittings



1. Place the hose next to the fitting and align it with the knurl marks in the fitting shell. Mark the length onto the hose. Push hose into the fitting until the mark on the hose is even with the end of the fitting shell (lubricate hose, if necessary).



2. Select proper die set. For Parflex hoses, see "Parflex Hose Crimp Assembly Tool Selection Chart" in this manual. **Note:** Die sets are color coded by size.



3a. Using a molybdenum disulfide type grease, apply a thin layer of grease to the die bowl.
3b. Place unitized die set into die bowl.



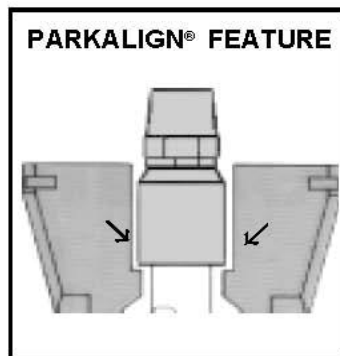
4. Place proper die ring on top of the selected die. See Parker PFD Catalog 4660 for proper die ring selection.



5. Slide pusher into place onto shoulder bolt.



6. Position the hose and fitting in dies from below.



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



8. While holding hose and fitting into position on die step, begin pumping hand pump until die ring contacts base plate.