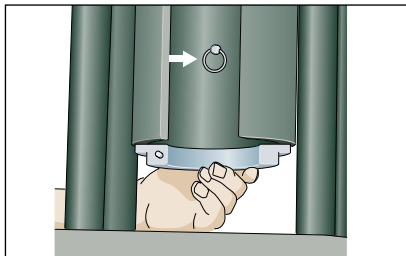


Assembly Instruction

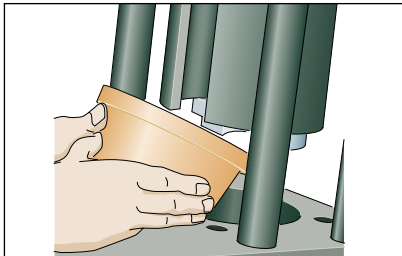
Parkrimp® 2 – 83CE

Parkrimp® fittings 26, 43, 70, 71, 73, 78 and 79 series size -4 to -32 (DN 06 to DN 50)

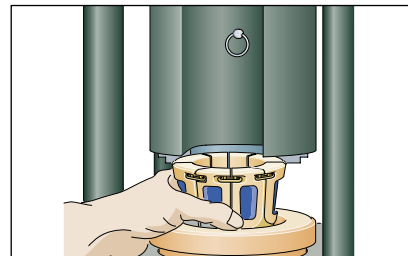
For one piece die sets 80C- ... and 83C- ... size -4 to -16



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).



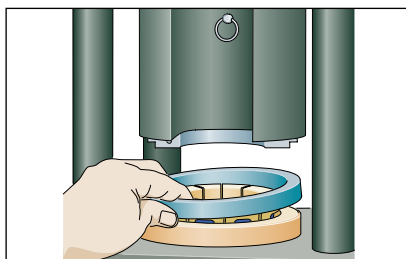
Carefully insert the adapter bowl into the base bowl. The adapter bowl must be tilted toward the back of the crimper during insertion.



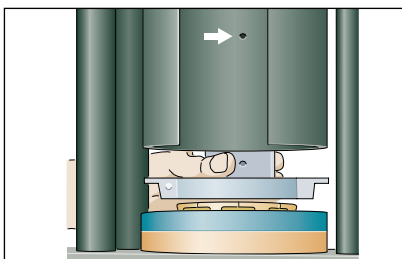
Insert the proper size and series die set into the adapter bowl.

Note: die sets are colour coded by size and have the fitting series and dash size stamped on the top.

Pay attention to die segment location.



When swaging 43 series fittings on 100R2, 100R3, 100R4 and 100R9 type hose, the black spacer ring must be placed.

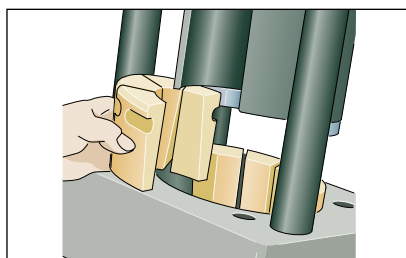


Lower the back half of the split die ring onto the dies by pulling the slide pin forward.

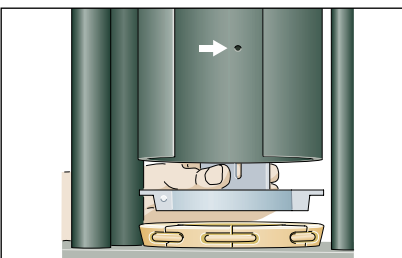


Insert the front half of the split die ring aligning the pin in the half with the hole in the front half.

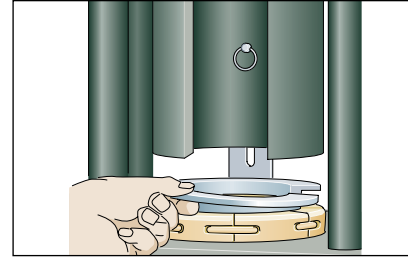
For two piece die sets 83C-... size -20 to -32



Insert the proper size 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 facilitate removal of bent tube fittings).



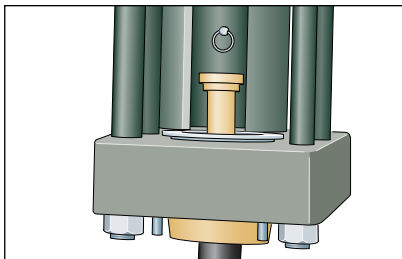
Lower the back half of the split die ring onto the dies by pulling the slide pin forward.



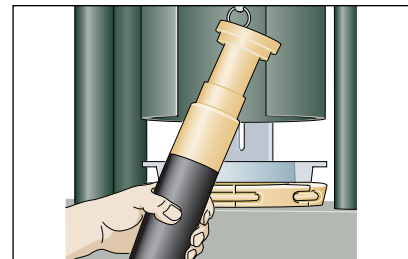
Insert the front half of the split die ring aligning the pin in the half with the hole in the front half.



Parkalign® feature
Position hose from below in dies.
Rest bottom of coupling on die step.



Turn on the pump by pressing the button on the left hand switch box. Lower the pusher by pressing the lower button on the right hand switch box. When the die ring contacts the base plate, the swaging is complete.



Push the black button at the top of the switch box to open dies and remove the finished assembly.

You do not have to remove any tooling to remove or insert 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.

Information about standard products or non-standard products can be found in the current price list. Dimensions shown may be changed at any time without prior notice.