



HOSE ASSEMBLY INSTRUCTIONS Compact Spiral™ Hose

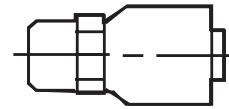
STEP 1 Select Hose & Fittings



6,000 psi



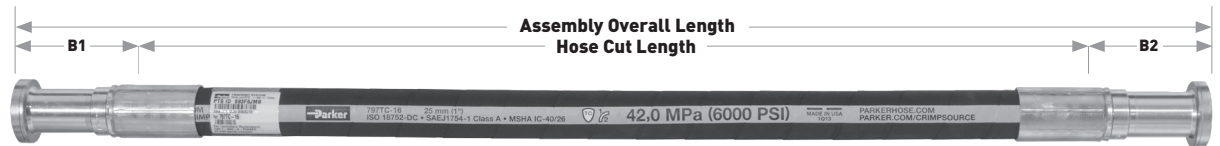
5,000 psi



Parkrimp 77 Series

RECOMMENDED: When choosing a fitting configuration, consider ease of installation and flow requirements.

STEP 2 Calculate Hose Cut Length



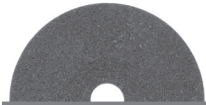
EQUATION: HOSE CUT LENGTH = ASSEMBLY OVERALL LENGTH - (B1+ B2)

RECOMMENDED: Calculate the hose cut length using equation above. The "B" dimension can be found in the catalog fitting table. A high-pressure assembly can expand up to +1% or contract by -1% while under pressure.

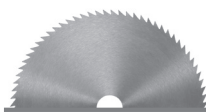
STEP 3 Cut Spiral Hose



Parker 339 Saw



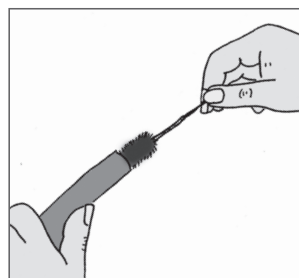
Abrasive Blade
Part # 39AB10



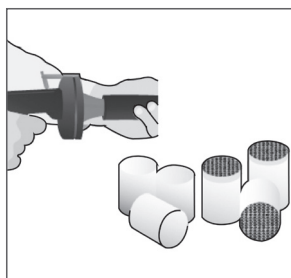
Metal Blade
Part # 24248

SLOW & STEADY	
Cut Feed Time	
HOSE SIZE 8 TO 16 ≥ 5 SECONDS	HOSE SIZE 20 TO 32 ≥ 10 SECONDS

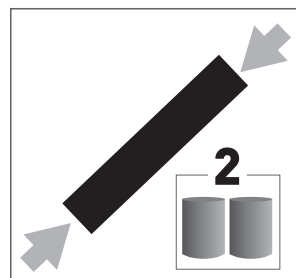
STEP 4 Clean Hose



A. Bottle Brush
Each Hose End



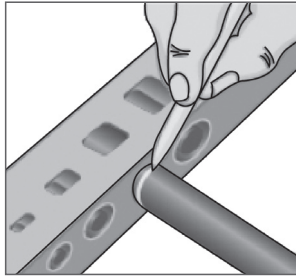
B. Ultra Clean



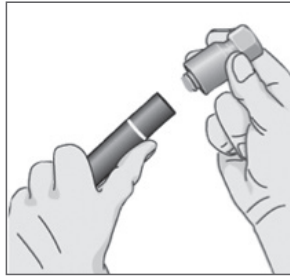
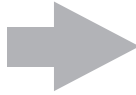
C. One Pellet -
Each Direction

RECOMMENDED: Cleanliness requirements below the ISO 4406 rating of 16/14/12 may require a solvent flush. Contact your local Parker representative if solvent flushing is required.

STEP 5 Insert Hose & Fitting



Mark Insertion Depth



Install Fitting



Use the Parker Fitting Push-On Stand if more force is needed to install fittings on hoses up to size -32.

STEP 6 Crimp

parker.com/crimpsource



Karrykrimp 2
Sizes: [-8 to -12]

Hose Style: 787TC / 797TC

Coupling Style: 77

Crimper: Karrykrimp 2

SIZE	DIE	DIE RING	CRIMP DIMENSIONS	CRIMP LENGTH	HOSE INSERTION	DRAWING
PARKRIMP 77 SERIES DIES						
-8	80C-CS08	85C-R02	0.940	FULL	1.36	PK77
-10	80C-CS10	85C-R02	1.067	FULL	1.53	PK77
-12	80C-CS12	85C-R02	1.255	FULL	1.78	PK77

COMMENTS: Crimp Diameter Tolerance is +/- 0.010" (0.25mm). Do not use any lubricant to assemble spiral hose and fittings.



Parkrimp 2
Sizes: [-8 to -32]

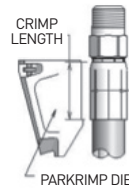
Hose Style: 797TC

Coupling Style: 77

Crimper: Parkrimp 2

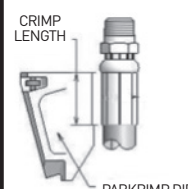
SIZE	DIE	SPACER PLATE	SPACER RING	ADAPTER BOWL	CRIMP DIAMETER	CRIMP LENGTH	HOSE INSERTION	DRAWING
-8	80C-CS08		83C-R02	83C-OCB	0.940	FULL	1.36	PK77
-10	80C-CS10		83C-R02	83C-OCB	1.067	FULL	1.53	PK77
-12	80C-CS12		83C-R02	83C-OCB	1.255	FULL	1.78	PK77
-16	83C-CS16	83C-R02H			1.551	FULL	2.13	PK77
-20	83C-CS20	83C-R02H			1.980	FULL	2.51	PK77
-24	83C-CS24	83C-R02H			2.330	FULL	2.67	PK77
-32	83C-CS32	83C-R02H			2.875	BUBBLE	3.05	PK77-32

Full Crimp



PARKRIMP DIE

Bubble Crimp



PARKRIMP DIE

**BUBBLE CRIMP
OK**

STEP 7 Attach a PTS Label

parker.com/pts

