

DADCO offers a portable hydraulic crimping unit, 90.720, to create hose assemblies by crimping hose adapters onto DADCO hose. The Karrykrimp Assembly offered by DADCO includes a Parker Karrykrimp Crimping Machine with stand, hose, pump and die ring.

Part No.	Components
HZ921474	Karrykrimp Machine
HZ921475	Karrykrimp Hose 6 feet / 72 inches
HZ921476	Karrykrimp Pump air / hydraulic foot pump
HZ921477	82C-R01 Die Ring



### How to Use the Karrykrimp

The following procedure explains how to use the Karrykrimp Assembly to crimp a hose adapter onto DADCO hose. For more information on hose adapters refer to DADCO's Linked Systems Catalog. Refer to *Constructing a SEAL-LOK Hose Assembly* (Bulletin B00120D) or *Constructing a MINILink® Hose Assembly* (Bulletin B11110B) for instructions on assembling the hose and adapter prior to using the Karrykrimp Assembly. For information on how to assemble the Karrykrimp Machine refer to the *Parker Karrykrimp Technical Manual* included with the machine.

Part No.	Crimp Die	Crimp Diameter mm inch
90.700 (Y-700)	Mini-Crimp - 90.710.8 <i>No Ring Required</i>	7.00 - 7.25 .276 - .285
90.705 (Y-705)	Mini-Crimp - 90.710.8 <i>No Ring Required</i>	7.00 - 7.25 .276 - .285
90.500 (Y-500)	80C-P03 Gray Die <i>82C-R01 Ring</i>	12.19 - 12.70 .480 - .500
90.400 (Y-400)	80C-P04 Red Die <i>82C-R01 Ring</i>	14.22 - 14.73 .560 - .580
90.250 (Y-250)	80C-P04J Red Die <i>82C-R01 Ring</i>	13.59 - 14.10 .535 - .555

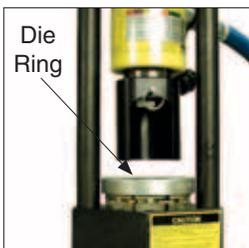
**NOTE:** Before using the Karrykrimp Assembly, make sure that you have the appropriate crimp die.



1. Remove the pin from the pusher in the Karrykrimp Machine and move the pusher back.



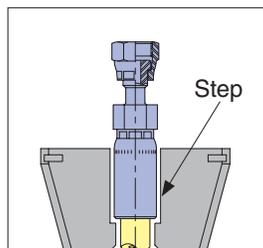
2. Place the crimp die into the base cavity. Note: The crimp dies are color-coded by size for easier identification.



3. Reposition the pusher and replace the pin. Place the die ring on top of the crimp die.



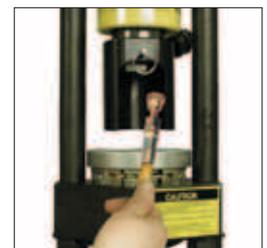
4. Position the hose and adapter into the crimp die from below.



5. Rest the bottom of the hose adapter on the step of the crimp die.



6. Actuate until the die ring contacts the base plate. **CAUTION: Keep hands clear of Karrykrimp machine during operation.**



7. Release the pressure and remove the finished hose adapter. Verify diameter of crimped section is correct; refer to chart.