

READ THESE INSTRUCTIONS COMPLETELY BEFORE USING THIS TOOL!

Preface

The Operating Instructions must always be within reach of the hand crimping tool. This Crimp System Tool may be used only for the intended application and in strict compliance with all applicable safety rules, regulations and practices. It must be properly maintained, undamaged and in good working order. Unauthorized modification is prohibited and voids the manufacturer's warranty. Always wear safety glasses with side shields and other appropriate personal protective equipment.



**MISUSE MAY CAUSE PERSONAL INJURY. KEEP OUT OF REACH OF CHILDREN!
NEVER INSERT FINGERS BETWEEN THE JAWS OF THE TOOL!**

Application

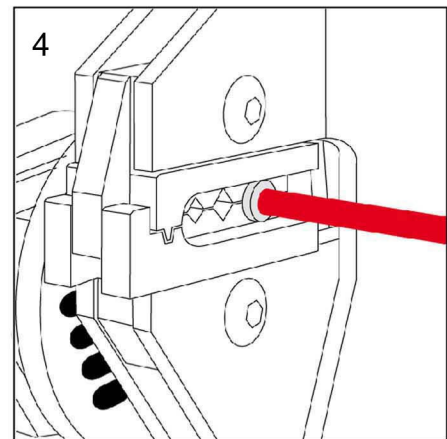
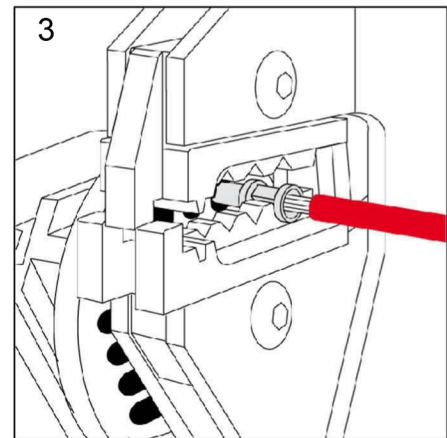
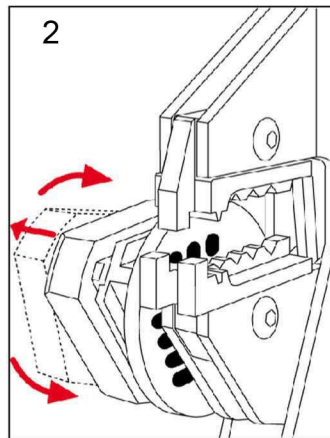
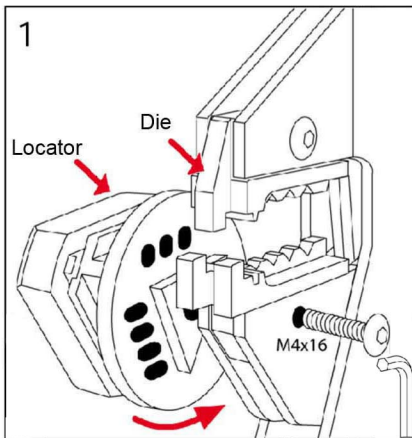
The Crimp System Tool has been developed for optimal crimping of a large variety of connectors and terminals by using interchangeable crimping dies.

Description

This Crimp System Tool is comprised of the basic tool with adjustment dial and quick release, a set of dies, two setscrews for the dies and positioning feature. Positioning aids can be attached for the respective connector. The crimping force can be adjusted (refer to "Adjustment of the Jaw Spread"). The ratchet has six steps and automatically opens after the sixth step has been passed (principle of compulsory completion). To prevent damage to the crimping die or connector, the built-in quick release (lock) enables the tool to be opened prematurely in the event of failed crimping.



Crimp System Tool for turned contacts



Refer to steps 1-5 (see Diagrams 1-4)

If the tool you are using does not have a locator, skip step 3

1. Align the crimping dies and the locator (Diagram 1)
2. Strip the cable for 7.5 ~ 8.0 mm length
3. Pull and rotate the locator into the desired position: (Diagram 2)
 - position HE/HA for 16A crimp contacts
 - position HND for 10A crimp contacts (up to 2.5 mm² / AWG14)
4. Slot location in the die and in the locator is based on the size of the wire (Diagram 3). Use the following chart to select the correct slot.

Slot on locator	Slot on die	Wire Size	
		mm ²	AWG
-1	-1	014 - 1.0	26 - 18
1.5	1.5	1.5	16
2.5	2.5	2.5	14
4	4	4.0	12

Male and female contacts use the same slot in the die set and in the locator.



Male crimp contact

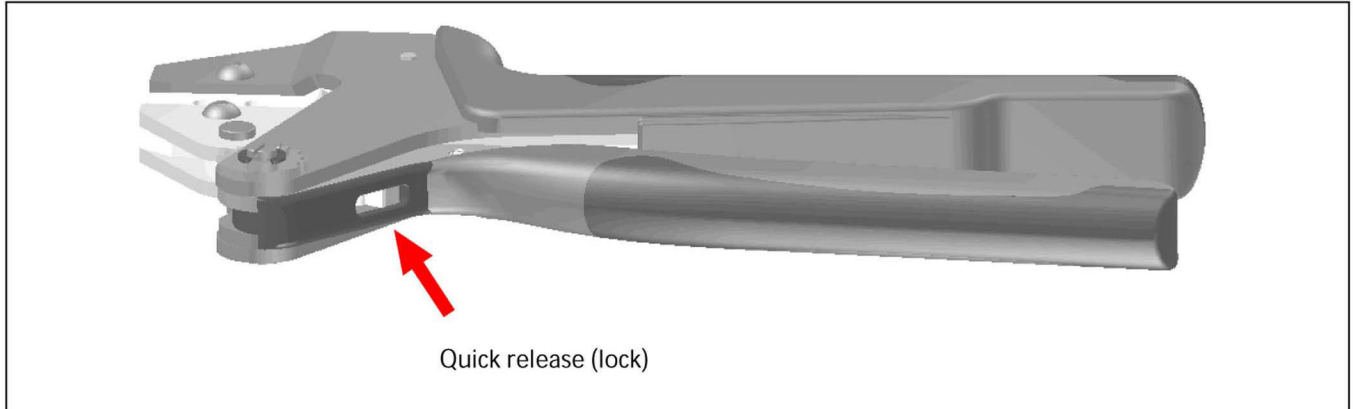


Female crimp contact

5. Close the handles of the tool until they open automatically (Diagram 4)

Quick release (lock)

For quick release of the lock: the lock will open automatically at the end of the crimping process. If the crimping process is interrupted, the handles of the tool must be pressed together a little and the lock pushed with an appropriate tool (e.g. screw driver).

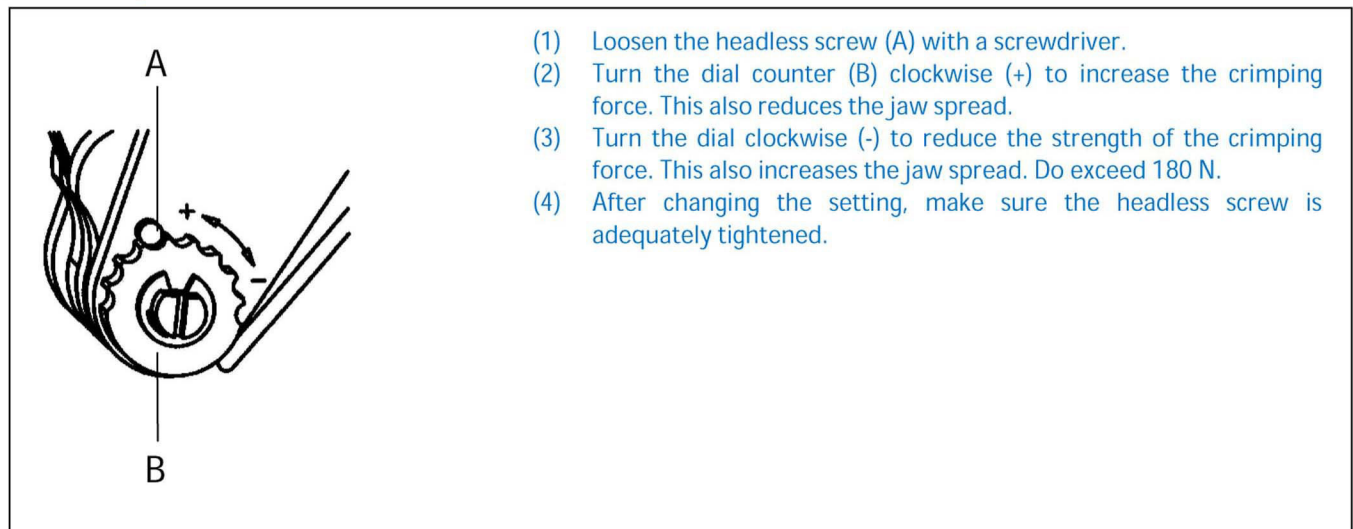


Adjustment of the jaw spread

The crimp system tool's crimping strength is factory set. The hand force idle travel is 130 – 180 N. The tool and die set are designed to provide optimum crimping within this range. However, if the setting is not ideal for the connector manufacturer's specifications (opening and torque), one of the following problems could be the reason:

- a) Wear and tear due to excessive use of the tool • Try adjusting the crimping strength
- b) Worn dies • To avoid damage, the die set must be replaced

CAUTION: The crimping height (opening) should be regularly checked by qualified technical personnel and set as described in the following:



Warranty

The crimp system tool is subject to thorough quality control before leaving the factory. The enclosed general terms and conditions of warranty apply.

Before using the crimp system tool, make sure it is in a clean and proper operating state. Always remove crimping residue. Protect the joints by keeping them clean and lubricated by applying light machine oil to them regularly. Check the bolts regularly to ensure that the lock washers and headless screw, securing the adjustment dial, are intact and tight. All other maintenance should be performed by the manufacturer.

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