

THE NEW VALUE FRONTIER



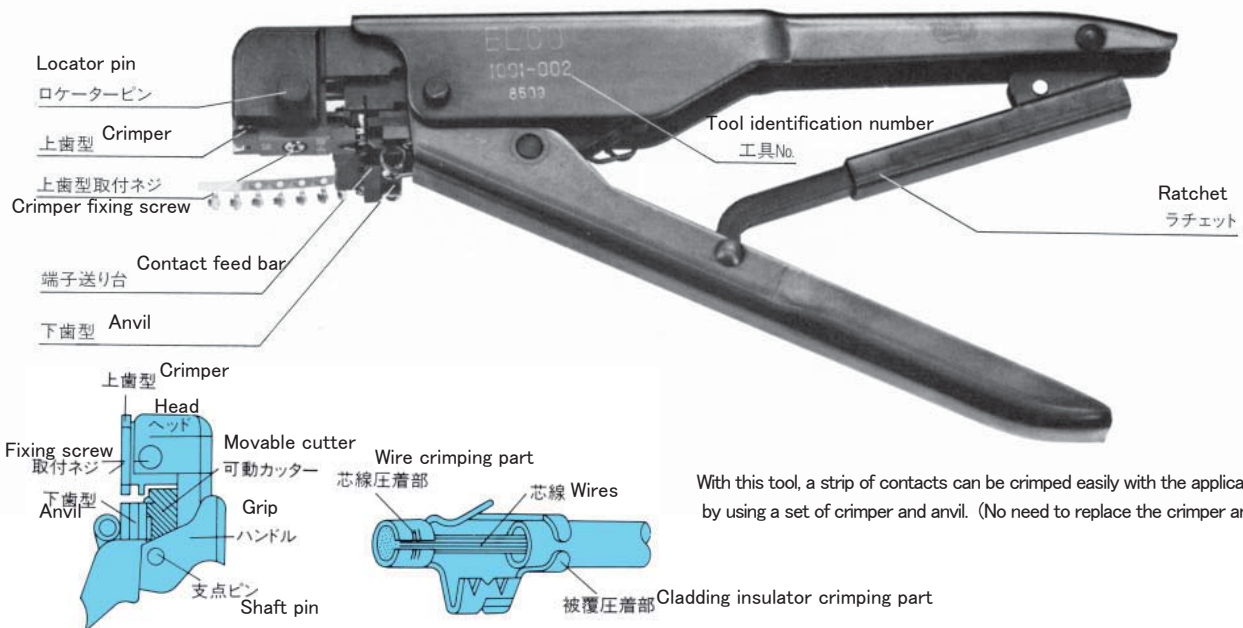
Instructions Manual
HAND CRIMPING TOOLS

This manual shows the appropriate crimping process by using the proprietary tools and quality control standards. Since the applicable range of tools and product specifications of connectors may not be met with each other, please contact us when using.



Type B

Structure of the Tool and Part Names



With this tool, a strip of contacts can be crimped easily with the applicable wire by using a set of crimper and anvil. (No need to replace the crimper and anvil.)

Example of Failure

Failure Item	Failure Description	Cause
1) Malformation of the crimped area (Wire barrel)	Pull strength is out of specification.	The wire size is out of the specification, or abrasion of the tool
2) Deformation of the terminal 1. Bend 2. Twist 3. Deformation of the barrel		The terminal is not set in position against the crimper and anvil.
3) Variation in crimp height	The crimping height of the tool is not fixed.	Occurred when grips are incompletely tightened (tightened half way) but in the position where they can be open due to the abrasion or deformation of the ratchet.

Selecting the appropriate crimper

1. Requisite blades are attached on top and bottom of the crimper.
2. The number of applicable size of the wire is engraved on the crimper.
3. Select the crimper to the size of the wire.
4. When replacing the crimper, pull out the locator pin.
(The locator pin can be pulled out with fingers easily.)
5. Install the appropriate crimper and fix it with the locator pin.

Procedures

1. Make sure that the tool number and the wire size are met.
2. Cut the strip of contacts in 20cm.
3. Insert the cut strip of contacts into the contact feed bar.
4. Feed the contacts to the proper position.
5. Strip the wire and insert the contact appropriately.
6. Close the grips until the latchet is released.
7. Open the grips to pick up the contact.
8. Feed the contact with stripped wire to the proper position.
9. Make sure that the shape of the crimped work is appropriate.

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