

THE NEW VALUE FRONTIER



Instructions Manual
HAND CRIMPING TOOLS

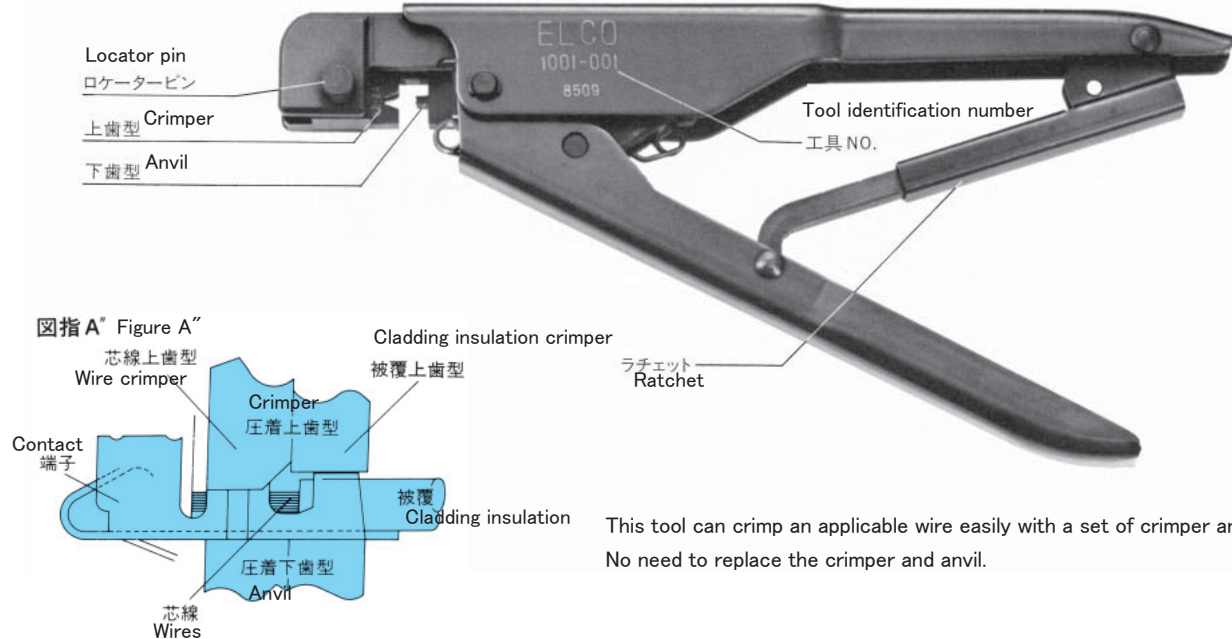
This manual shows the appropriate crimping process by using the proprietary tools and quality control standards. Since the applicable range of tools and product specifications of connectors may not be met with each other, please contact us when using.



HAND CRIMPING TOOLS

Type A

Structure of the Tool and Part Names



This tool can crimp an applicable wire easily with 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. Combine blades for the crimper so that chamfered planes are faced.
3. Select the crimper to the size of the wire.
4. The number of applicable size of the wire is engraved on the crimper.
5. When replacing the crimper, pull out the locator pin.
(The locator pin can be pulled out with fingers easily.)
6. 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. Open the grips fully.
3. Set the contact appropriately as shown in Figure A".
Note: The cladding insulation is placed at the side on which the engraved indications are shown.
4. Insert the stripped wire as shown in Figure A".
5. Close the grips fully until the ratchet is released.
6. Open the grips to pick up the contact.
7. Make sure that the crimped work is free from defect.