


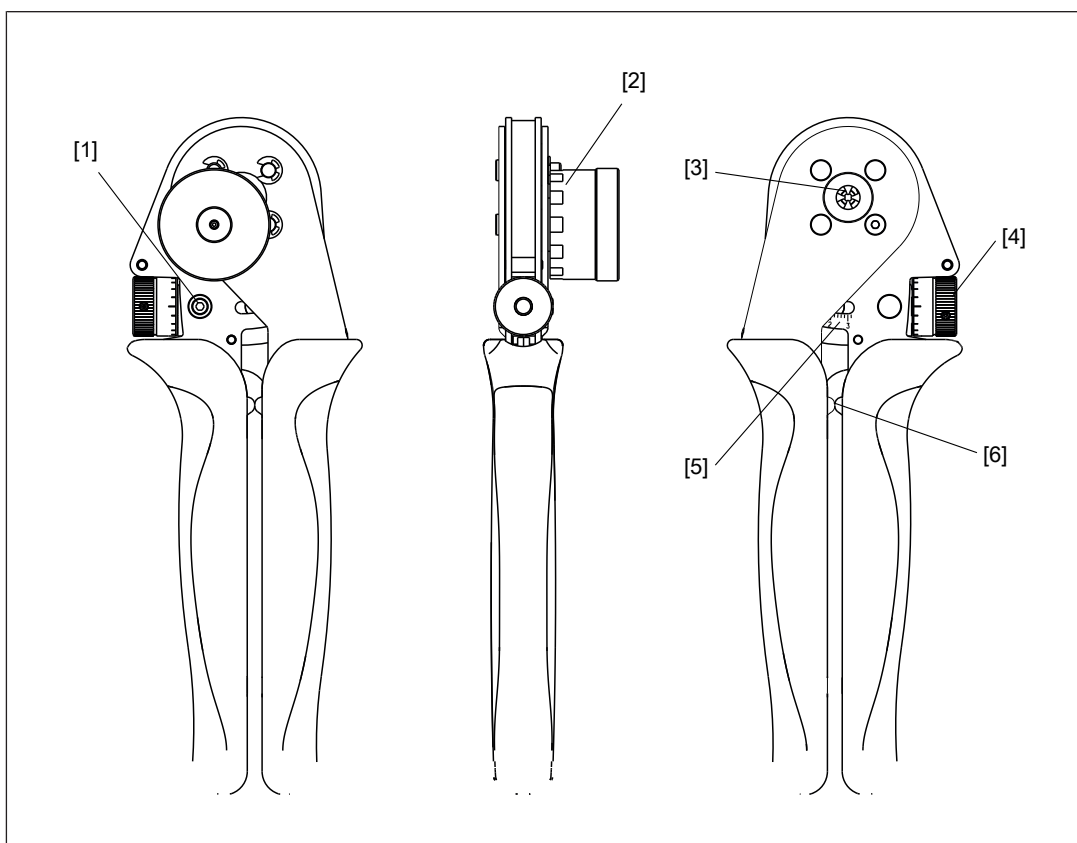
## Crimping Tool

### General

The four-mandrel crimping tool MicroCrimp is a manual crimping tool manufactured to the state of the art and in accordance with recognised safety regulations. The tool may only be used when in perfect technical condition. The four-mandrel crimping tool is used for crimping turned pin and socket contacts and is only intended for use for the purpose described in the operating manual.

Design	Profile	Capacity		Length mm	Weight g
		mm <sup>2</sup>	AWG		
Chromium-plated		0.08-2.5	28-13	175	820

Any unauthorised modification of the manual crimping tool or any use not in accordance with its intended purpose excludes the manufacturer from any liability for the resulting damage.



### Legend

- [1] Clamping screw for locking the crimp measurement
- [2] Locator
- [3] Crimping point/crimping mandrel
- [4] Adjustment wheel for setting the crimp measurement

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[5] Metric scale with 0.2 mm division for approximate setting

[6] End stop

### Mode of operation

- ▶ Loosen the clamping screw.
- ▶ Refer to the attached matrix for the crimp measurement and locator setting for the connector that will be crimped.
- ▶ Set the crimp measurement (crimping depth of the crimping mandrel) via the adjustment wheel.
- ▶ Fix the tool setting via the clamping screw.
- ▶ Lift and rotate to bring the locator into the position defined through the matrix.
- ▶ Feed prepared cable into the connector.
- ▶ Insert the contact with the cable into the tool's crimping point, as far as the stop point (the contact is positioned precisely through the locator).
- ▶ Close the tool until it is unlocked via the catch.
- ▶ Open the tool and remove the crimped contact from the tool.



#### NOTICE

Do not crimp the plug gauge or other comparable objects, to avoid damaging the tool. Always avoid crimping solid materials (e.g. steel) with a hardness greater than 35 HRC.

### Changing the locator

- ▶ Use an SW 2.5 mm Allen key to loosen the central hexagon socket screw on the assembled locator; if necessary use a second Allen key on the opposite side for resistance.
- ▶ Remove locator.
- ▶ Attach optional locator in the reverse sequence.

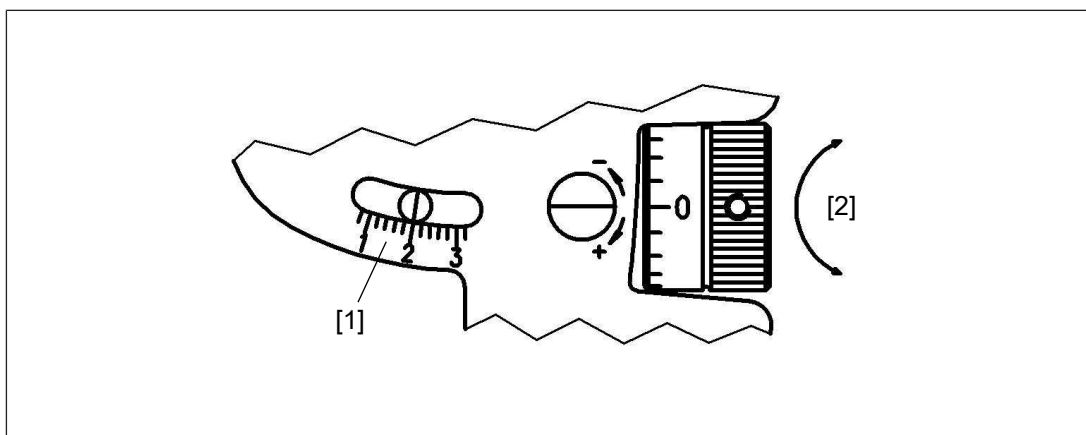
### Setting the crimp measurement

The crimp measurement (crimping depth of the crimping mandrel) is set via the adjustment wheel, as described below. All clockwise infeed movements (reduce crimp measurement) and anti-clockwise infeed movements (increase crimp measurement) are set via the adjustment wheel:

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### Infeed accuracy

Rotation of adjustment wheel	Infeed
1 graduation line on the adjustment wheel	1/100mm infeed
1 rotation of adjustment wheel	0.2 mm infeed; read off adjustment wheel, scale
5 rotations of adjustment wheel	1 mm infeed; read off adjustment wheel, scale



### Legend

- [1] Scale with 1 mm and 0.2 mm graduation
- [2] Adjustment wheel with 0.01 graduation for fine-tuning
- + Crimp measurement larger
- Crimp measurement smaller

### Check (teach) using 1.0 mm plug gauge

Before starting work, check the tool's default setting (crimp measurement 1.0 mm).

- ▶ Use the adjustment wheel to set the measurement to 1.0 mm (default setting). Note that the crimp measurement must always be taken from a higher value (e.g. from 1.05 to 1.00 mm).
- ▶ Close the tool and feed the 1.0 mm plug gauge between the crimping mandrels. Please note the following:
  - If there is no play when moving the plug gauge between the mandrels – there is no deviation in measurement, the tool is ready for use immediately.
  - If there is play when moving the plug gauge between the mandrels or it cannot even be fed into the tool – then there is a deviation in measurement. This deviation in measurement can be determined via the fine-tuning (+/-) on the adjustment wheel. When the crimp measurement is checked, if the tool is outside the tolerance required by the contact manufacturers, the manufacturer of the tool should be contacted for testing.

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### NOTICE

The crimping tool should only be calibrated by authorised staff, as an improper calibration could lead to faulty crimp connections.

### Maintenance and repair

Before starting work, the manual crimping tool must be in a clean and proper state. Remove any crimping residues from between the crimping jaws and from the locator. Make sure that all of the pins are secured by retaining rings.

The four-mandrel crimping tool should only be repaired by the manufacturer of the tool or by an authorised specialist workshop.

### Order reference

Product type	Features	Order no.
Crimping Tool	Crimping tool for cross-sections of 0.08 - 2.5 mm <sup>2</sup>	380 071