KYOCERA Corporation

SPEC NUMBER. : **205-03-286**

取扱説明書

INSTRUCTION MANUAL

Series 1001

Hand Crimping Tool

O	EDN-119	2014/03/19	H.Nakamura		J.Obara
NO	EDN/DCN	DATE	PREPARED	CHECK	APPROVED

<Working procedure 1>

Selecting a crimper

1. Applicable wire sizes are indicated on a crimper.
2. Make sure that the indicated wire size meets the size of wire to be used actually.
3. Loosen the crimper fixing screw and select the applicable wire size.
4. Set the crimper. (Photo 1)
   For sizes from AWG 24 to 26: Set the wire crimper A to the lower position.
   For sixes from AWG 28 to 28: Set the wire crimper B to the lower position.
5. Set the spacer. (Photo 2)
6. For sizes from AWG 24 to 26, match the wire crimper A to the indication "24-26" of insulation crimper. (Photo 3)
7. Tighten the fixing screw with pushing the crimper upward. (Photo 4)

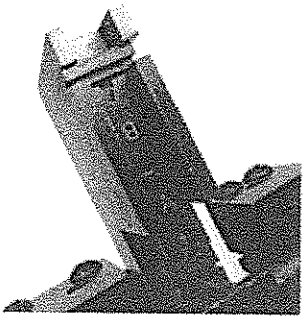


Photo 1
Set the wire crimper.

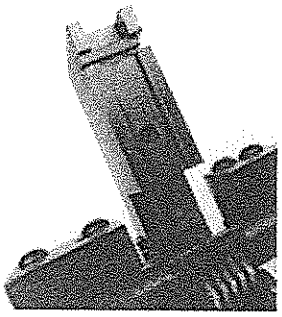


Photo 2
Set the spacer.

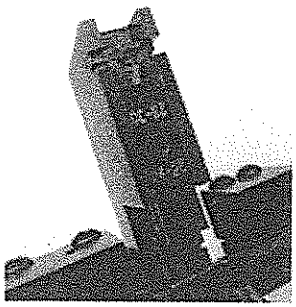


Photo 3
Set the insulator crimper.

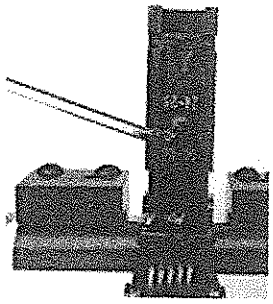
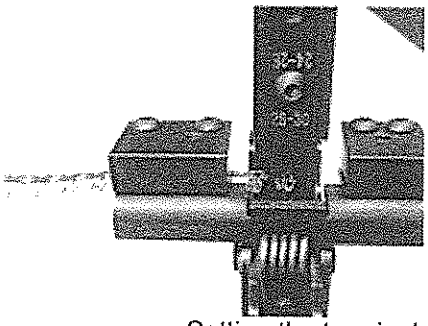


Photo 4
Tighten the fixing screw.

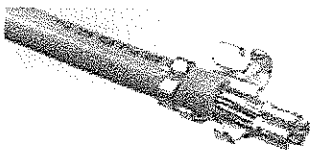
<Working procedure 2>



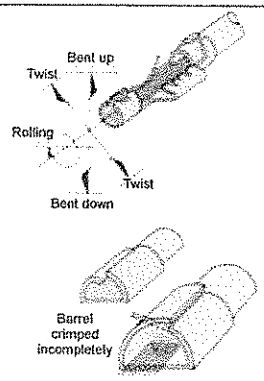
Setting the terminal.

Procedures:

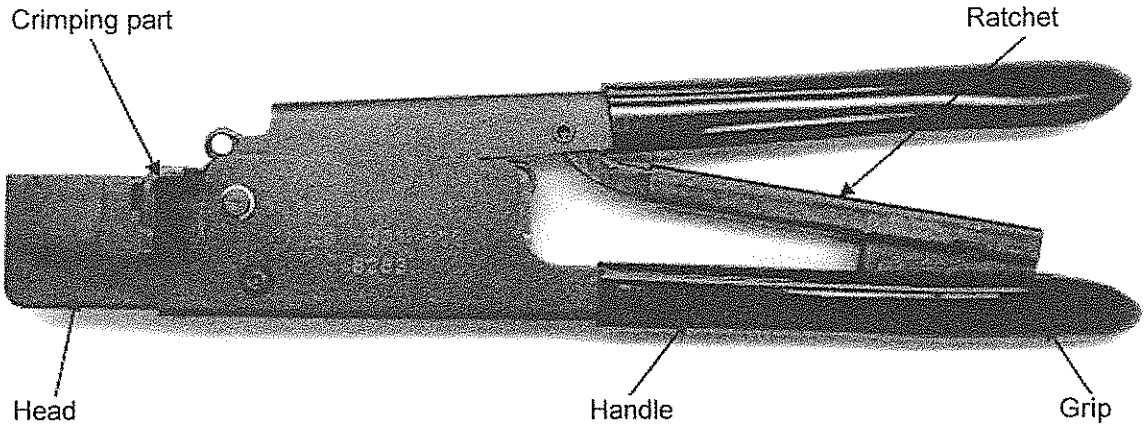
1. Place a certain length (20cm approx.) of the terminal on the guide, and set the part to be crimped to the center of the crimping position appropriately.
2. Slightly hit the wire stripped in the appropriate length against the movable cutter blade and do the positioning.
3. Close the handles slowly until the ratchet is released.
4. Open the handles and remove the crimped wire.
5. Make sure that the shape is right in accordance with the table of crimp conditions on the previous sheet.



Example of Failure

Failure item	Failure description	Cause
1) Erroneous shape of the crimped area (wire barrel)	The tensile strength is out of specification.	The wire size is out of specification, or abrasion of the tool.
2) Deformation of the terminal 1. Bent 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 position in the tool is not fixed.	Occurs under the state in which the handles can be returned even if they are closed incompletely due to abrasion or deformation of the ratchet.

■Part Names



■Basic specification

Part No.	06 1001 102
Weight	Approx. 420g
Dimensions	220 (W) x 70 (H) x 25 (D) mm

■Crimping conditions

Please make sure that the tensile strength of a contact crimped by using this tool satisfies the following value.

Position	AWG No. of applicable wire	Crimp height for reference (mm)		Tensile strength, minimum value (N)
		Core wire	Coated wire	
A	24	0.55 - 0.63	1.35 - 1.50	3.0
	26			2.0
B	28	0.49 - 0.57	1.20 - 1.35	1.0
	30			0.5
Strip length		3.0 – 3.8mm		

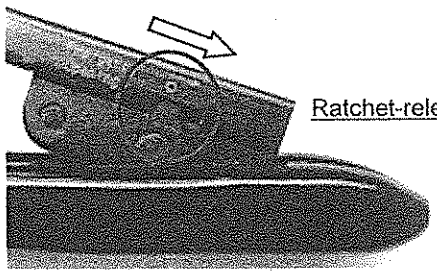
■Applicable contact and wires

For special wires, please consult us separately.

Contact	Wire			
	Style No.	AWG No.	Core wire [No. of wires / dia.(mm)]	External diameter of coated wire (mm)
60 8283 0513 XX 808	UL1061 strand	24	7/0.20	Ø 1.10
		26	7/0.16	Ø 0.98
		28	7/0.127	Ø 0.88
		30	7/0.102	Ø 0.80

<Instructions for use>

- When setting a contact into or removing it from the tool, do not hook the contact on the cable stopper or the anvil. Or the contact could be deformed.
- When binding wires, loosen the wires so that no stress could be applied to the contact directly.
- Set a contact in the right orientation.
- The ratchet is equipped so that the handles would not open until proper pressure is applied.
- In order to release the ratchet as an emergency measure against erroneous crimping, move the ratchet release lever in the direction as shown in the figure below.



<Routine check>

1) After use, lubricate the teeth part with machine oil or etc.
2) Make sure that the handles open/close smoothly without any clinging or biting at the anvil or the ratchet part.
3) If the impressing pressure of the ratchet is decreased during a long-term usage, adjust the ratchet. The ratchet unlock position could be changed by the ratchet adjustment screw and the fixing nut loosened and turned by using a "specialized tool". After adjusted, be sure to tighten the nut. Before use it in the process, make sure that the crimping operation is performed properly in a trial.