

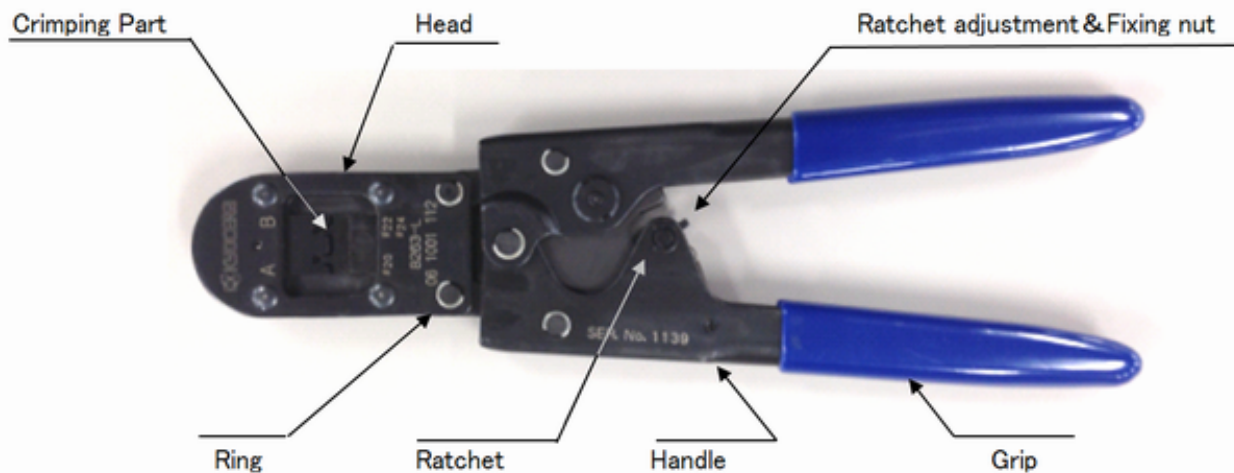
INSTRUCTION MANUAL

Series 1001

Crimping Tool: 06 1001 112

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No.	EDN/DCN	Date	Prepared by	Checked by	Approved by

■ Part names and functions



■ Basic specification

Part number	06 1001 112
Weight	Approx. 420g
Outer dimensions	220(W)x70(H)x25(D)mm

■ Crimping conditions

Make sure that the tensile strength of contacts crimped by using this tool satisfies the specified values in the following table.

Insertion position	Applicable wire, AWG No.	Crimping height for reference (mm)		Tensile strength (N)
		Core wire	Coated wire	
A	20	0.96 to 1.01	1.85 to 1.95	6.5
		0.77 to 0.91	1.65 to 1.85	
B	24			3.0
Length of the uncoated part			2.5 to 3.2mm	

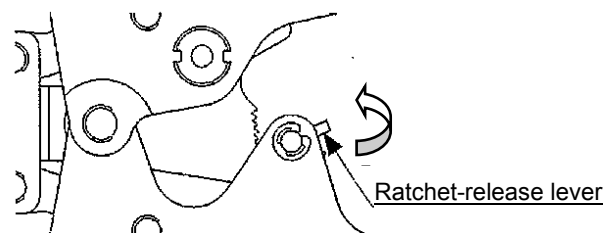
■ Applicable contacts and wires

If a special wire requires to be used, please consult us.

Applicable contact	Applicable wires			
	Style No.	AWG No.	Core-wire structure [No. of strands/dia. of the strand (mm)]	Outer dimension, coated wire (mm)
60 8263 2513 00 XXX	UL1007 twisted wire	20	21/0.18	φ1.8
		22	17/0.16	φ1.58
		24	11/0.16	φ1.42

<Precautions>

- When setting/removing contacts into/from the tool, be careful to avoid contacts from being hooked at the cable stopper or anvil, or the contact would be deformed.
- Do not tie wires tightly, so that no extra stress would not apply to contacts.
- Set a contact in the right orientation.
- The tool is equipped with ratcheting structure, so that the handle would not open until proper stress is apply to it.
- As an emergency measure against wrong crimping, the ratcheting could be released by the ratchet-release lever turned in the direction shown by the arrow in the following figure.



<Routine check>

- 1) After use, lubricate the teeth with machine oil.
- 2) Make sure that the handle opens/closes 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.