Operating instructions

ERGOCRIMP die set with positioner Locking TAB REC. 3.3

Customer Manual No.: *411-18227-1 Rev.B*
Customer Manual PN: *1-744017-7*
Language: *en (translation)*

TE connectivity APPLICATION TOOLING

Contents

1 Revision history

Rev.	Date	Description	Name
A	18.10.1999	First version	-
A1	06.10.2014	Revision	Christian Witt
B	20.05.2015	Revision	Levin Sandhu

Tab. 1 : Revision history

2 Introduction

2.1 About these operating instructions

These operating instructions describe the use and operation of the ERGOCRIMP die set with the manual crimping tool and the necessary maintenance measures. All persons using this tool must therefore be familiar with these operating instructions and follow these instructions. It should be stressed that the operating instructions for the ERGOCRIMP crimping tool are essential.

These operating instructions must be available with the tool at all times. The tool owner/user is obliged to supplement these operating instructions with instructions in line with existing national regulations for the prevention of accidents and environmental protection.

These operating instructions apply to the following crimping tool(s) of TE Connectivity:

- ERGOCRIMP die set with positioner: TE PN 539755-2

The following documents must be observed in addition to these operating instructions:

- ERGOCRIMP operating instructions: TE PN 5-744001-2 / 411-18087

2.2 Intended use

The ERGOCRIMP die set is used to crimp splice connectors and socket connector contacts according to the TE processing specification and drawing. The ERGOCIMP die set may only be used for repair purposes or for making samples, not for series production. The following contacts can be processed with the ERGOCRIMP die set:

Contact PN	Cross-section	Contact	TE processing specification
963759 / 963920	0.2 - 0.5 mm²	TAB REC. 3.3	114-18041-1
963760 / 963921	0.5 - 1.0 mm²	TAB REC. 3.3	114-18041-1
963761 / 963922	1.5 mm²	TAB REC. 3.3	114-18041-1
963761 / 963922	2.5 mm²	TAB REC. 3.3	114-18041-1

Tab. 2 : Processable contacts

3 Description

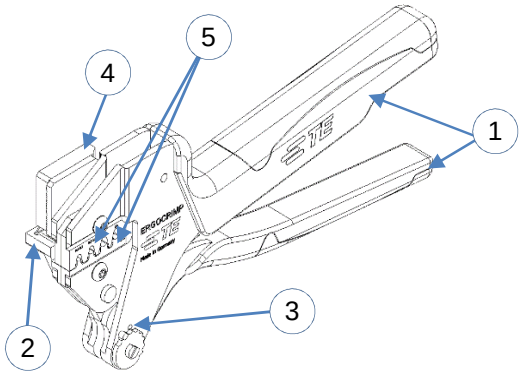

Abb. 1 : The hand tool

Item	Description	Item	Description
1	Tool handles	2	Socket contact positioner
3	Ratchet release	4	Positioning unit
5	Dies		

Tab. 3 : Hand tool components

4 Changing the die set

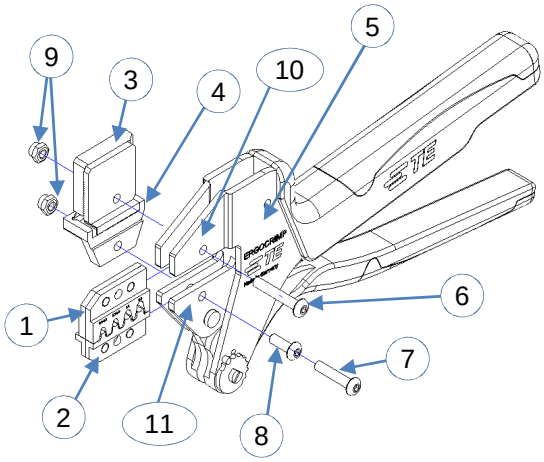

Abb. 2 : Exploded drawing

No.	Description	No.	Description
1	Upper die	2	Lower die
3	Positioning unit	4	Socket contact positioner
5	Basic hand tool	6	Upper die fixing screw
7	Lower die and contact positioner fixing screw	8	Lower die fixing screw
9	Hex nuts	10	Fixed crimping jaw
11	Movable crimping jaw		

Tab. 4 : Hand tool components

4.1 Installing dies

- Open the handles and remove the two fixing screws from the crimping jaws. The Allen key is in the fixed handle.
- Position the upper die set in the fixed crimping jaw with the bevels facing out (to the front).
- Thread the die set fixing screw through the upper jaw and the die set. Do not tighten the screw yet.
- Position the lower die set in the movable crimping jaw.
- Thread one of the die set fixing screws through the lower jaw and the die set. Do not tighten the screw yet.

> NOTE
> **If the socket contact positioner is not needed, use only the screw in location 8 to fix the lower die set.**

- Slowly press the tool handles together to mate and align the dies.
- Hold the handles closed and firmly tighten both die set fixing screws.
- Using the hex nuts, fix the positioning unit and the socket contact positioner (if used) on the outer face of the crimping jaw in the illustrated location.

4.2 Dismounting the die set

- Close the handles until the ratchet releases and allows you to fully open the handles.

> NOTE
> **The ratchet mechanism makes eight (8) audible clicks when you close the handles. On the ninth (9) click the ratchet mechanism releases and the handles can be opened.**

- Loosen and remove both hex nuts.
- Remove the positioning unit and the socket contact positioner (if used).
- Loosen and remove both die set fixing screws.
- Slide the dies out of the crimping jaws.

5 Operation

5.1 Contact crimping – socket contact

- Fully open the tool.
- Place a contact in the contact positioner and on the left side of the lower die.

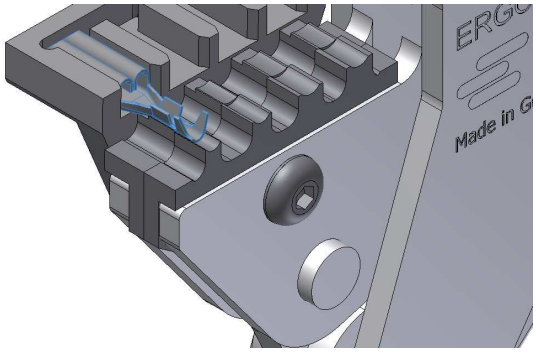

Abb. 3 : Socket contact placed on the lower die

- Close the tool handles until the first click so the contact is lightly clamped. Take care to avoid deforming the contact edges.
- Push the wire into the contact until it reaches the wire stop.

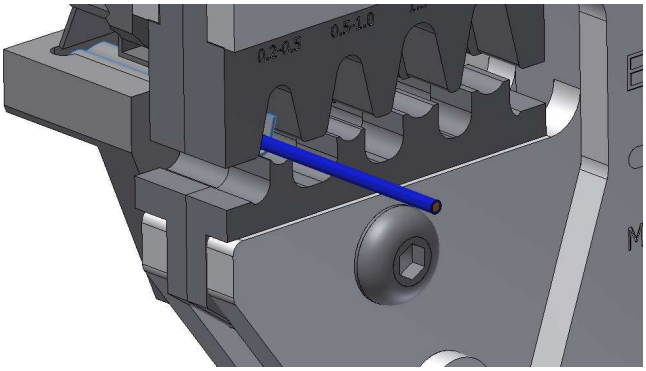

Abb. 4 : Insert wire up to wire stop

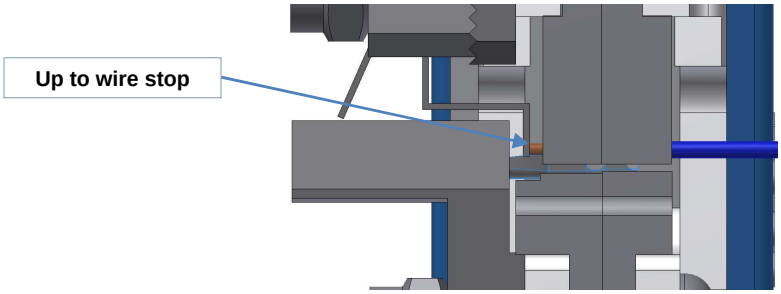

Abb. 5 : Wire inserted up to wire stop

- Close the tool handles until the ratchet mechanism releases and the handles open.

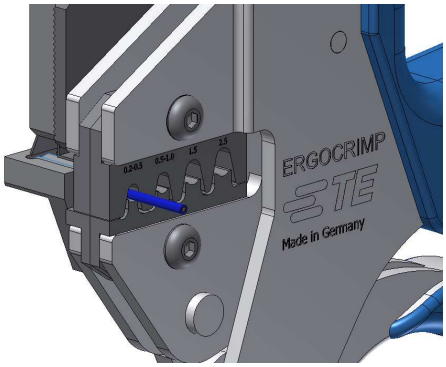

Abb. 6 : Handles completely closed

- Remove the crimped contact from the crimping die. If the contact is stuck, wiggle it slightly to remove it.
- Check the crimp height of the crimped contact, based on the information in the TE Connectivity processing specification and the drawing.

5.2 Contact crimping – splice connector

> NOTE
> **For this purpose, do not fit the socket contact positioner (item 4) as described in Section 4.**

- Fully open the tool.
- Place a contact on the lower die as shown in Fig. 7.

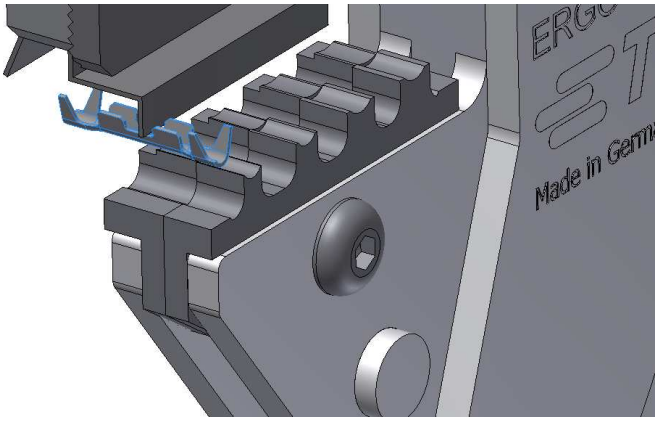

Abb. 7 : Positioning the contact

- Close the tool handles until the first click so the contact is lightly clamped. Take care to avoid deforming the contact edges.
- Push the wire into the contact until it reaches the wire stop (see Fig. 5).
- Close the tool handles until the ratchet mechanism releases and the handles open.
- Remove the crimped contact from the crimping die. If the contact is stuck, wiggle it slightly to remove it.
- Check the crimp height of the crimped contact, based on the information in the TE Connectivity processing specification and the drawing.

6 Customer Service / EMEA Service Hotline

Please contact us for all service enquiries or technical support:

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Additional information and contacts can also been found on the Web.
Visit us at: http://tooling.te.com/

7 Maintenance and servicing

7.1 Daily maintenance

The following daily maintenance tasks should be performed by the responsible operator:

- Using a soft, clean brush or a lint-free cloth, remove dirt, dust, moisture and other residue from the die set. Do not use any hard or abrasive tools or materials that could damage the tool.
- Apply sewing-machine oil to all pivot points and bearing surfaces. Do not lubricate excessively.
- If the die set is not needed, store it in a clean and dry location.

7.2 Periodic inspection

- The die set should be inspected periodically by suitably qualified staff according to the level of use, and the inspections should be documented.
- Check the die set for wear and damage, particularly in the crimping nest areas.