

ORIGINAL INSTRUCTIONS

Figure 1

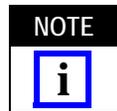
## 1. INTRODUCTION

The TE Connectivity CERTI-CRIMP II Tool Head / Modular T-Head Adapter Assembly 2031480-1 is designed to couple any TE CERTI-CRIMP II head assembly (example: 91500-3) or Modular T-Head Assembly (2161000-1) to the Electro-Hydraulic Hand Tool (2031400-[ ]). Refer to Figure 1 to see the hand tool, adapter, and tool head.

The Electro-Hydraulic Hand Tool and specific CERTI-CRIMP II head assemblies or modular T-Head assembly must be ordered separately.

For specific CERTI-CRIMP II/Modular T-Head crimp head information (including wire preparation, crimping procedures, maintenance and inspection procedures, as well as repair and replacement procedures) refer to the appropriate instruction sheet for the associated hand tool and crimping head.

Refer to Customer Manual 409-10095 for information concerning Electro-Hydraulic Hand Tool 2031400-[ ].



*All dimensions on this instruction sheet are in metric units [with inches in brackets]. Figures and illustrations are for identification only, and are not drawn to scale.*

## 2. RECEIVING/INSPECTION

Adapter Assembly 2031480-1 is thoroughly inspected during and after assembly. Prior to packaging and shipping a final series of tests and inspections is made to ensure proper function of the adapter. The following inspections should be performed as a safeguard against potential problems generated in transit.

1. In a well-lighted area, carefully unpack the adapter and inspect each component as it is unpacked.

2. Thoroughly inspect each component for evidence of damage that may have occurred in transit. If any of the components are damaged, file a claim against the carrier and notify TE immediately.



*It is IMPORTANT that these instructions, and other documents shipped with the tooling (e.g., drawings, parts lists, tooling manual, etc.), remain with the adapter, head, and hand tool for the benefit of personnel responsible for installation, operation, and maintenance.*

The adapter should be inspected at regularly scheduled intervals, depending on care, degree of operator skill, the type and size of product being crimped, and environmental conditions.

### 3. INSTALLATION/REMOVAL OF ADAPTER ASSEMBLY AND CERTI-CRIMP II HEADS OR MODULAR T-HEAD



*Do not operate the Electro-Hydraulic Hand Tool without the CERTI-CRIMP II head and adapter installed. Repeated operation in this manner may result in damage to the Electro-Hydraulic Hand Tool.*



*To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release hydraulic pressure, if applicable -- see Customer Manual 409-10095) before installing or removing the CERTI-CRIMP II tool head or adapter assembly.*

#### 3.1. Adapter Installation/Removal

Refer to the Electro-Hydraulic hand tool Customer Manual (409-10095) for instructions on installing and removing the adapter assembly and the crimping heads.

#### 3.2. CERTI-CRIMP II Head Installation Removal

##### A. Installation

As supplied, the adapter assembly has three quick-release pins installed. Refer to Figure 2. The two outer pins will be used to secure the two outer housing tabs of the CERTI-CRIMP II crimp head or Modular T-Head to the adapter assembly.

The center pin will be used to secure the movable die of the CERTI-CRIMP II crimp head or Modular T-Head to the ram of the adapter assembly.

These pins must be removed prior to installing the CERTI-CRIMP II crimp head or Modular T-Head.

1. Remove the quick-release pins (see Figure 2).
2. Insert the CERTI-CRIMP II tool head or Modular T-Head into the adapter cavity.
3. Insert the two outer quick-release pins through the holes in the adapter housing and the holes in the two outer tabs of the CERTI-CRIMP II crimp head or Modular T-Head. See Figure 2.

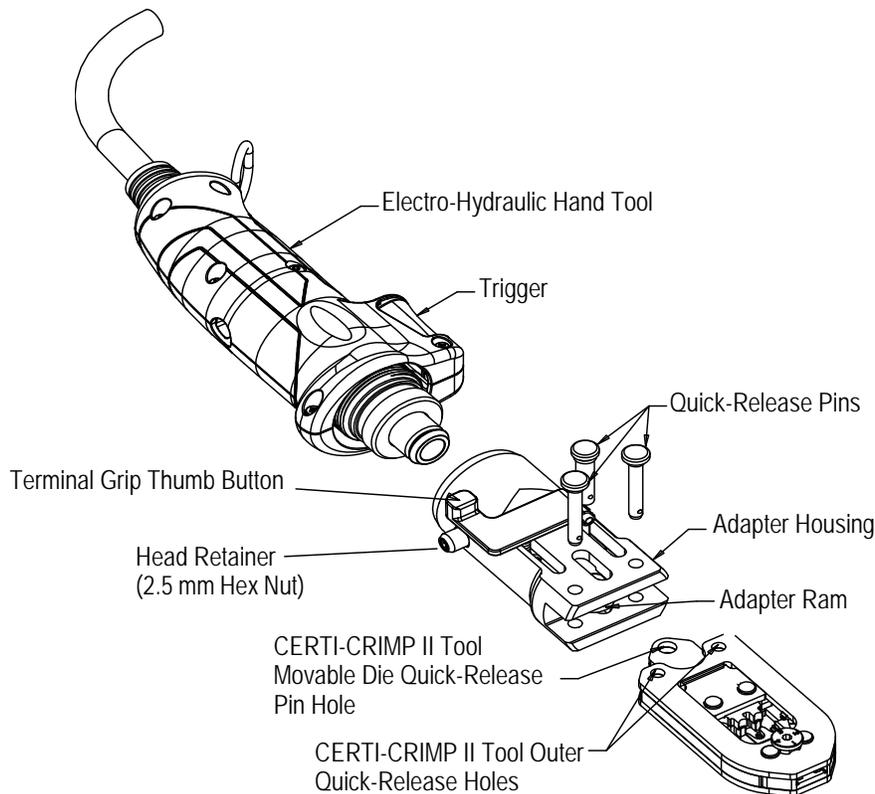


Figure 2



*The quick-release pins will “snap” into position when they are properly inserted.*

4. Press the terminal grip thumb button to release the adapter ram and allow it to move freely.
5. Insert the center quick-release pin into the adapter ram and through the movable die of the CERTI-CRIMP II crimp head or Modular T-Head.

**B. Removal**

1. Press the terminal grip thumb button to release the adapter ram and allow it to move freely.
2. Remove the quick-release pins.
3. Remove the CERTI-CRIMP II tool head or Modular T-Head from the adapter cavity.

**4. OPERATION**

The following procedure provides only general information concerning crimping. Refer to the instructions packaged with the CERTI-CRIMP II crimp head or Modular T-Head for detailed information, including wire stripping dimensions and instructions for positioning terminals and splices in the crimpers.



*To avoid personal injury, keep fingers clear of the crimping area.*

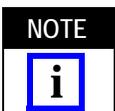
To operate the CERTI-CRIMP II crimp head or Modular T-Head in the Electro-Hydraulic Hand Tool using the Adapter assembly, proceed as follows:

1. Insert the contact into the appropriate die cavity.
2. Press the terminal grip thumb button (Figure 2) to advance the lower tooling and hold the contact in place. Do not deform the terminal insulation or wire barrel.
3. Place a pre-stripped wire in the barrel of the contact.
4. Squeeze the tool trigger until the jaws release. When the jaws release, the crimp is complete.



*It is not necessary to continue to hold the trigger to retract the tooling. The tooling will retract automatically.*

5. Remove the terminated wire.



*To abort a crimp, press the pressure release device on the power tool. Information on the pressure release device is contained in Customer Manual 409-10095, Section 6, PRESSURE RELEASE/ RESET TOOL.*

**5. PREVENTIVE MAINTENANCE**

**5.1. Daily Maintenance**

Perform the following maintenance on a daily basis:

1. Inspect the dies for wear or damage such as cracks, gouges or chips. If damage is found, return the CERTI-CRIMP II tool head or Modular T-Head to TE for inspection.
2. Clean the tooling, removing accumulations of dirt and grease on the adapter - particularly:
  - a. in areas where contacts are crimped, and
  - b. in the area where the CERTI-CRIMP II head or Modular T-Head connects to the adapter assembly.
3. Wipe the tooling with a soft, lint-free cloth.

**5.2. Yearly Maintenance**

Once a year or every 10,000 cycles (whichever comes first) return the CERTI-CRIMP II tool crimp head or Modular T-Head to TE for inspection.

**6. REPLACEMENT AND REPAIR**



*To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release hydraulic pressure, if applicable -- see Customer Manual 409-10095) before replacing or repairing components.*

Replacement parts are identified in Figure 2 and the table in Figure 3. The recommended spares should be stocked for immediate replacement. Order replacement parts (or return parts) through your

TE Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605. Or write to:

CUSTOMER SERVICE (038-035)  
 TYCO ELECTRONICS CORPORATION  
 PO BOX 3608  
 HARRISBURG PA 17105-3608

For repair services, call the Tooling Assistance Center at 1-800-722-1111.

For spare parts, refer to the table in Figure 3:

SPARE PARTS		
PART NO.	DESCRIPTION	QTY
217873-2	PIN, Quick-release	1
217873-1	PIN, Quick-release	2
2031486-1	RETAINER, Head	1
2063861-1	RING, Friction	1
986963-1	E-RING	1

*Figure 3*

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## 7. RoHS INFORMATION

Information on the presence and location of any substances subject to RoHS (Restriction on Hazardous Substances) can be found at the following website:

<http://www.te.com/customersupport/rohssupportcenter/>

Click on “Find Compliance Status” and enter equipment part number.

## 8. REVISION SUMMARY

- Updated document to corporate requirements
- Added new artwork to Figure 1
- Added text “Modular T-Head” to title, and appropriate text areas throughout document