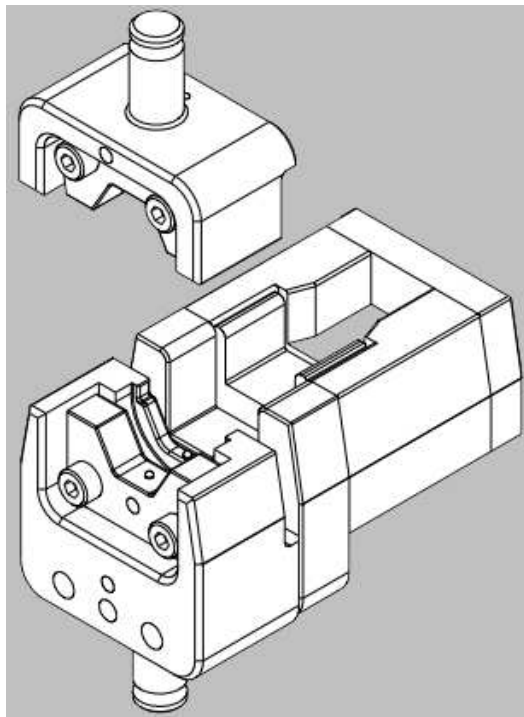


Figure 1: Crimping Die and Locator Assembly for HV800-90-Degree Shield and Ferrules



1 Introduction

Crimping die assemblies 2410073-1, 2326595-1, 2326596-1, and 2326578-1 are designed to be installed into the modular tool holders listed in Table 2. The crimping die assemblies crimp the shield and ferrules for the HV800 90-Degree terminals (refer to application specification [114-94052](#) for terminal assembly and crimp information).

Table 1: Part numbers

Crimping die assembly	Wire size	Terminal
2410073-1	16mm ²	9-2141157-4 9-2141158-2
2326595-1	25mm ²	9-2141157-3 9-2141158-2
2326596-1	35mm ²	9-2141157-2 9-2141158-2
2326578-1	50mm ²	9-2141157-1 9-2141158-2

Table 2: Modular tool holders

Modular tool holder	Instruction sheet
2305470-1	408-35048
2326378-1	408-35049



NOTE

Dimensions in this instruction sheet are in millimeters with [inches in brackets]. Figures are for reference only and are not drawn to scale.

Read these instructions thoroughly before crimping connectors.

2 Description

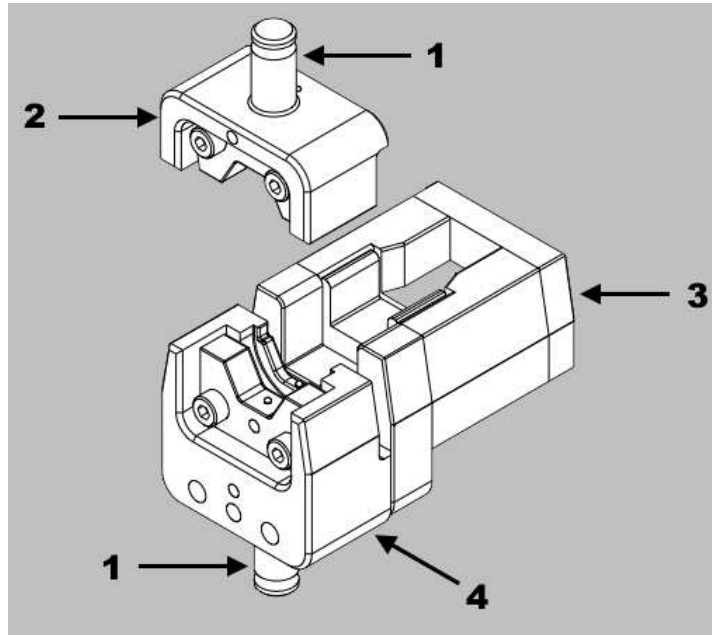
Each crimping die assembly includes a lower crimper, upper crimper, and terminal locator (Figure 2).



NOTE

The terminal locator maintains the terminal's position during the crimping process. It is supplied pre-assembled to the crimping die.

Figure 2: Components



- 1 Shank
- 2 Upper crimper
- 3 Terminal locator
- 4 Lower crimper

3 Installing the die set and locator assembly

For information concerning die installation and removal, as well as the general performance of the modular tool holder, refer to the instruction sheet packaged with the tool holder (Table 2).



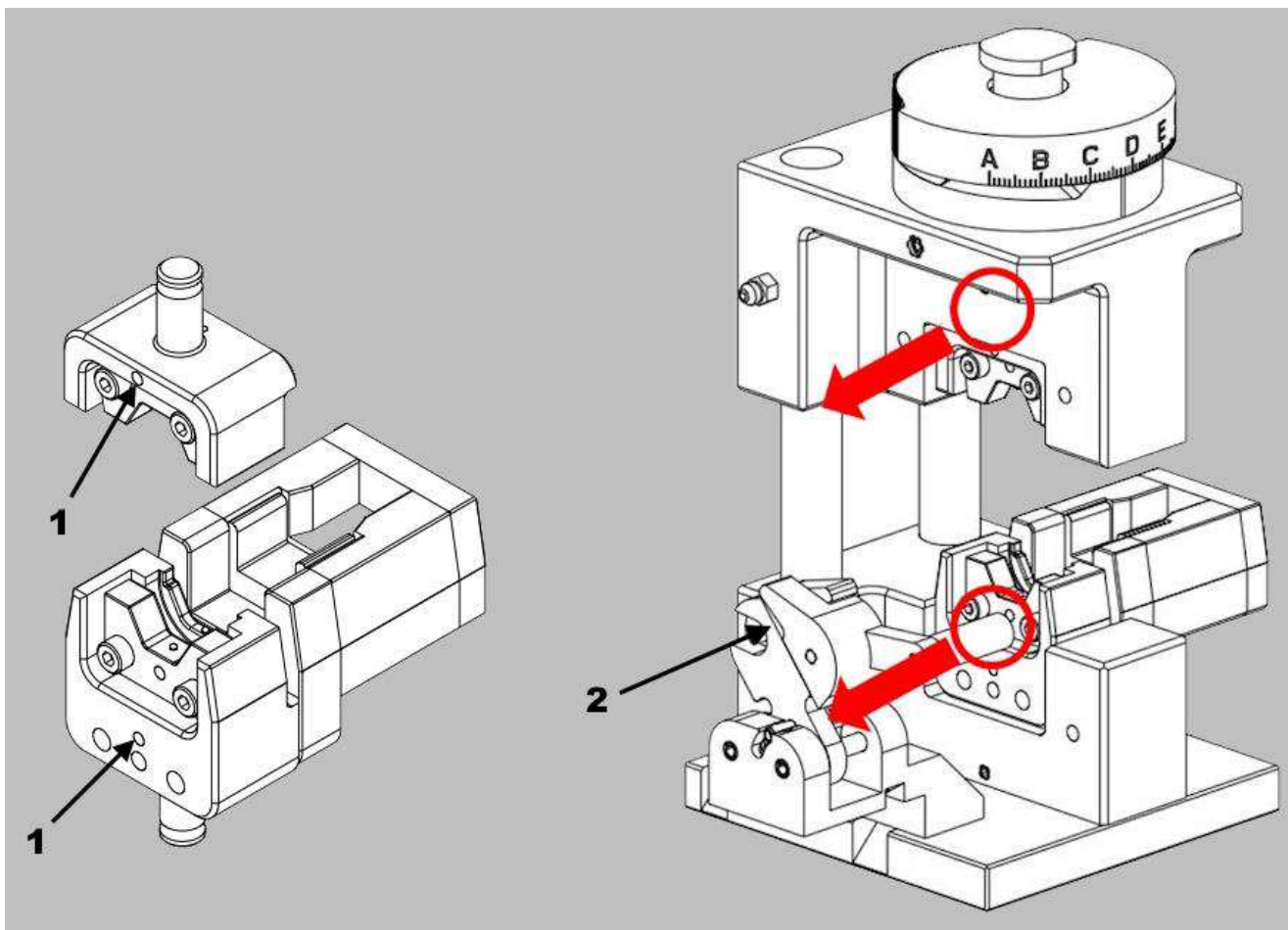
To avoid injury, disconnect the electrical power before installing the die assembly into the tool holder.



To avoid injury, disconnect the air supply before installing the die assembly into the tool holder.

To achieve proper orientation of the dies during installation, ensure that the alignment dots face toward the wire clamp on the modular tool holder (Figure 3).

Figure 3: Alignment dots



- 1 Alignment dots
- 2 Wire clamp

4 Crimping

Strip length and specific crimp information for each terminal being crimped can be found in the application specification mentioned in section 1.

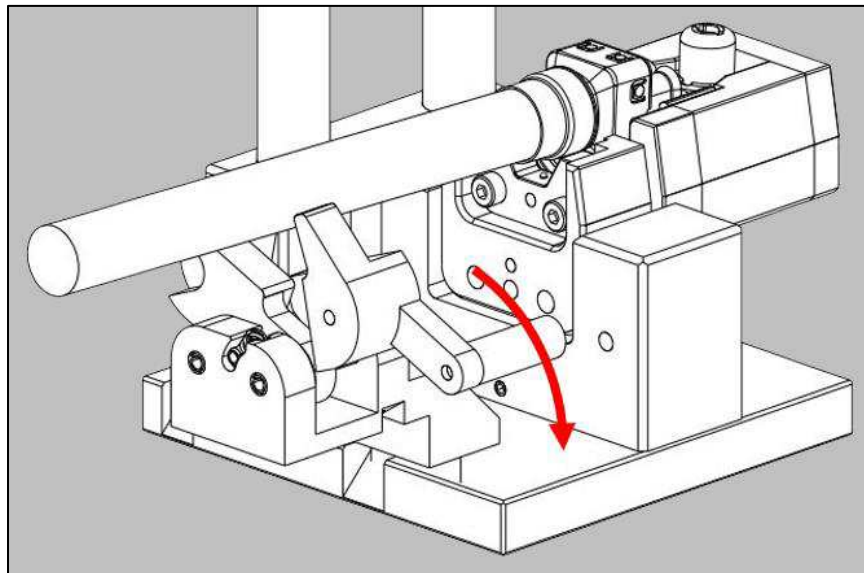


CAUTION

If the tool holder is equipped with a crimp height (fine adjust) adjustment, you can avoid damage to the terminator, modular tool holder, or die assembly by starting at setting A on the crimp disc and incrementally adjusting to the specified crimp height. If the machine has crimp height/shut height adjustment, refer to the applicable 412 series customer manual for guidance.

1. Assemble the connector as described in the application specification mentioned in section 1 for the shield and ferrules.
2. Open the wire clamp by pressing down on the lever (Figure 4).

Figure 4: Opening the wire clamp



3. Insert the prepared assembly into the locator (Figure 5) until the shield butts against the spring-biased shield stop (Figure 6).



NOTE

For clarity, upper tooling is not shown in Figure 5 and Figure 6.

Figure 5: Inserting assembly into locator

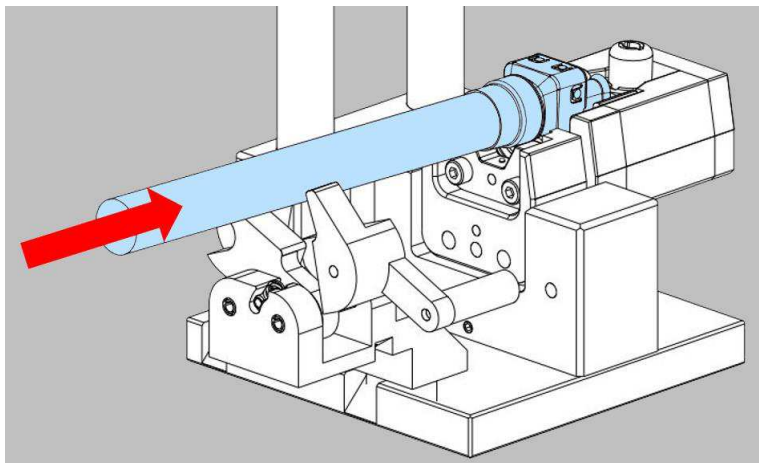
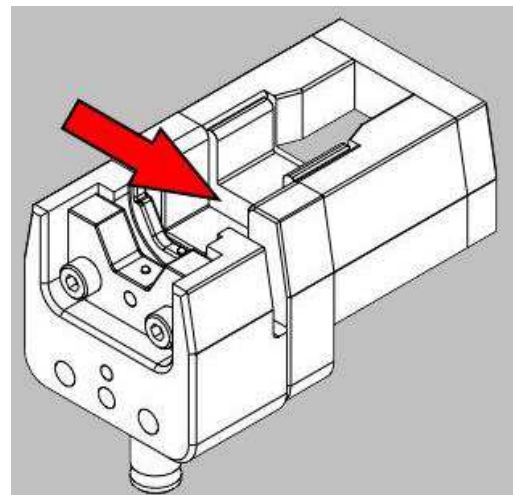
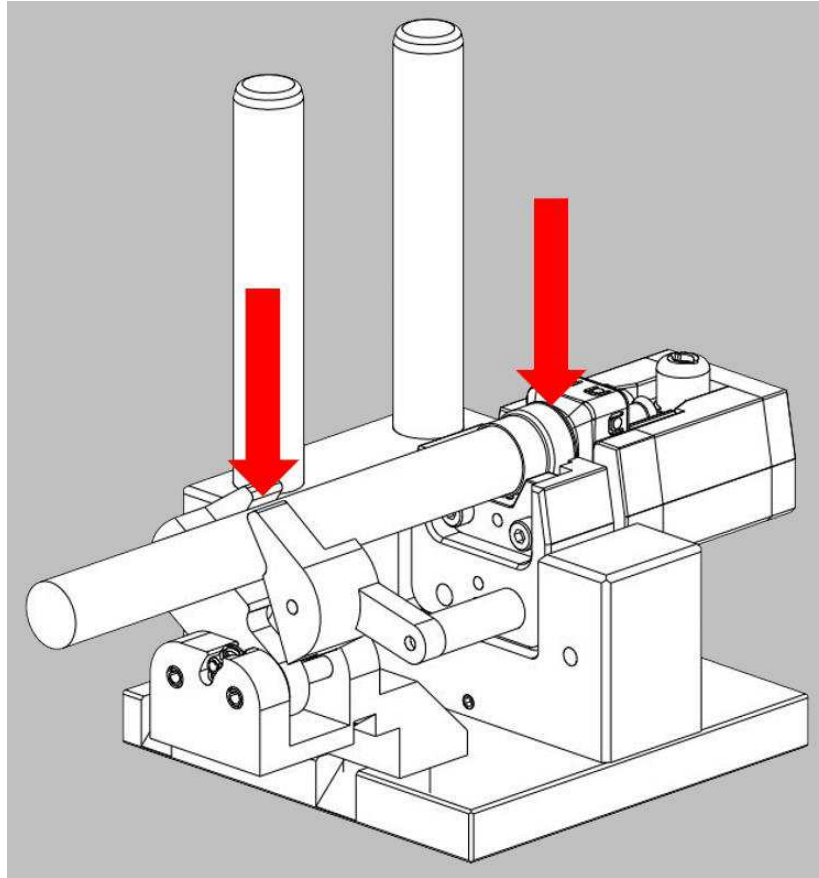


Figure 6: Shield stop



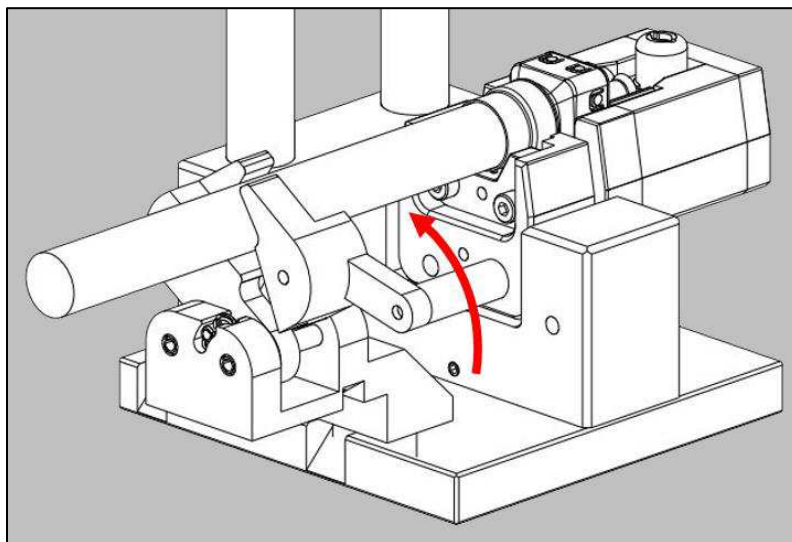
4. Push the assembly down into the tooling to seat the ferrule (Figure 7).

Figure 7: Seating the ferrule



5. Release the lever to clamp the wire in place (Figure 8).

Figure 8: Closing the wire clamp



6. Cycle the terminator to complete the crimp.
7. Remove crimped assembly from the tooling.

5 Inspecting the crimp

For crimp inspection information, refer to the application specification mentioned in section 1.

6 Maintenance and inspection

Each die assembly is inspected before shipment. When it arrives at your facility, inspect it immediately to ensure that it was not damaged during shipping.

6.1 Daily maintenance

Make each operator aware of (and responsible for) the following daily maintenance requirements:

- Remove dust, moisture, and other contaminants with a clean, soft brush or soft, lint-free cloth. **Do not** use objects that could damage the dies.
- When the dies are not in use, store them in a clean, dry area.

6.2 Periodic inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the dies or be supplied to personnel responsible for the dies. Perform at least one inspection per month. Base your inspection frequency on the amount of use, ambient working conditions, operator training and skill, and established company standards. Perform the inspection as follows:

1. Remove all contaminants with a clean, soft brush or soft, lint-free cloth. Do **not** use objects that could damage the dies.
2. Inspect the crimp area for flattened, chipped, cracked, worn, or broken areas.
3. If damage or abnormal wear is evident, replace the tool or dies. Refer to section 7, **Replacement and repair**.

7 Replacement and repair

If the dies are damaged or worn excessively, they must be replaced. Order replacement dies through your TE representative, or go to TE.com and click the **Shop TE Store** link at the top of the page.

For field service, go to the [Service and Repair](#) page on the TE website, or send an e-mail to the address for your region in Table 3.

Figure 9: Service and repair



Table 3: Field service e-mail addresses

Region	Address
Asia	Tefe1ap@te.com
EMEA (including India)	Tefe1@te.com
North America	Fieldservicesnorthamerica@te.com
South America	FSE@te.com

8 Revision summary

Since the last revision of this document, the following changes were made:

- Added crimping die assembly 2326578-1 to Table 1.
- Reformatted and edited.