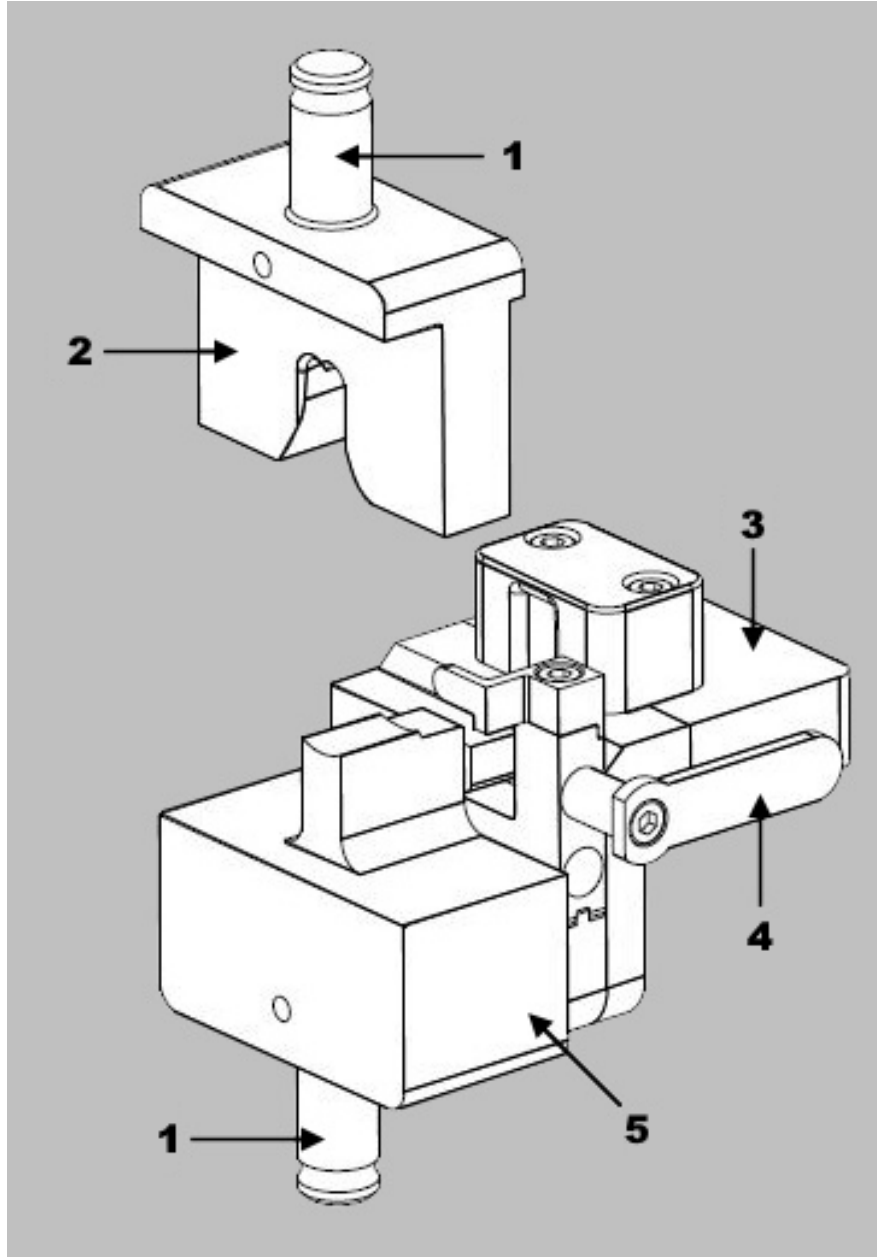


Figure 1: Crimping die (PN 2305855-1) and terminal locator assembly for PCON 12 terminals



- 1** Shank
- 2** Crimper
- 3** Terminal locator assembly
- 4** Wire stop assembly
- 5** Anvil

Table 1: Specifications

Crimping die assembly	Wire range	Terminal part number	Application spec	Modular tool holder	Instruction sheet
2305855-1	10-16mm ²	1-2840573-2	114-162014	2305470-1	408-35048
		1-2840575-2		2326378-1	408-35049

1. INTRODUCTION

Crimping die assembly PN 2305855-1 is designed to be installed into the modular tool holders listed in Table 1. The crimping die assembly is designed to crimp PCON 12 receptacle terminals.

When reading this instruction sheet, pay attention to **DANGER**, **CAUTION**, and **NOTE** statements:

**DANGER**

Denotes an imminent hazard that can result in moderate or severe injury.

**CAUTION**

Denotes a condition that can result in product or equipment damage.

**NOTE**

Highlights special or important information.

2. DESCRIPTION

Each die assembly consists of the following:

- Crimper
- Anvil
- Wire stop assembly
- Terminal locator assembly

**NOTE**

During the crimping process, the terminal locator assembly is designed to maintain terminal position. The wire stop assembly is designed to control wire position. Both assemblies are supplied pre-assembled to the crimping die.

3. DIE ASSEMBLY INSTALLATION

For information concerning die installation and/or removal, and general performance of the modular tool holders, refer to the applicable 408 series instruction sheet packaged with the tool holders.

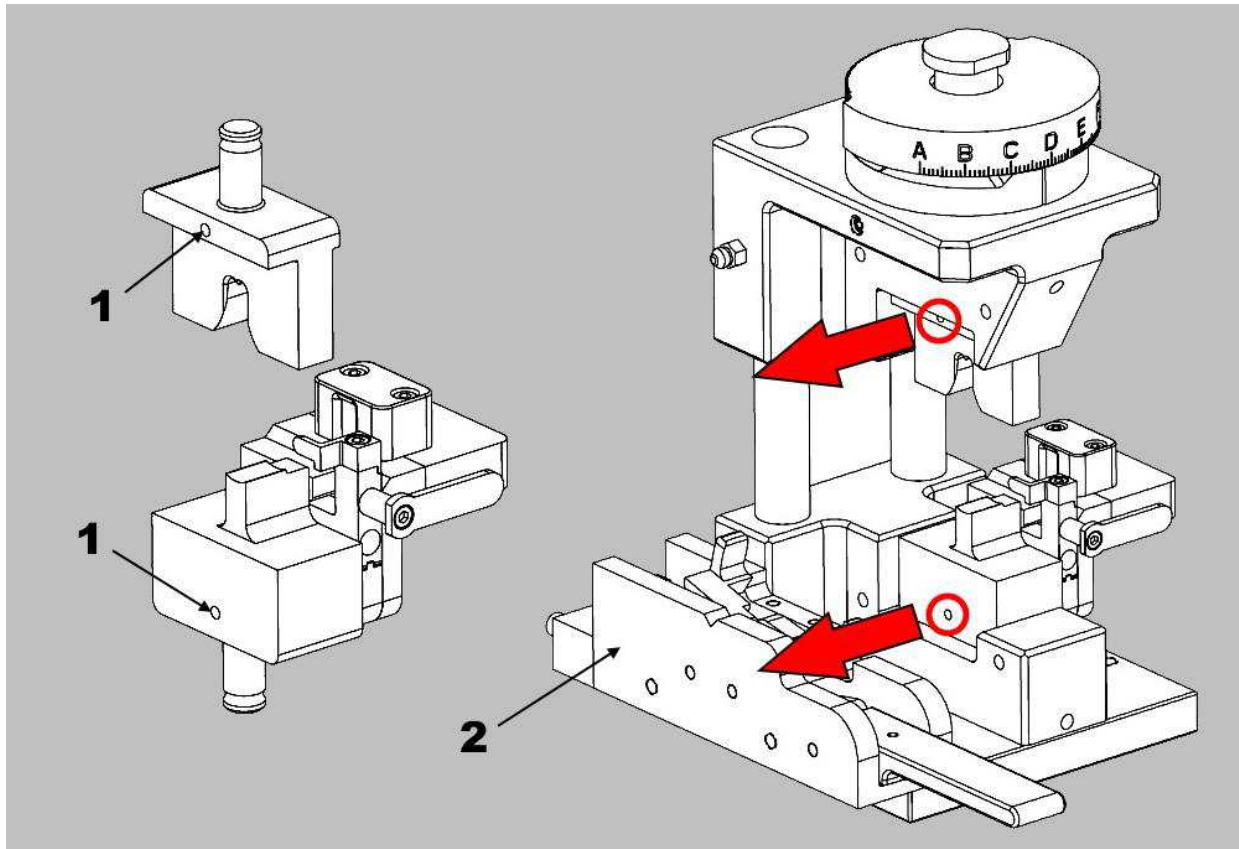


DANGER

To avoid personal injury, **always disconnect** electrical and air supply to power unit before installing the die assembly into the tool holder.

To achieve proper orientation of the dies during installation, ensure that the alignment dots are facing toward the wire clamp on the modular tool holder (Figure 2).

Figure 2: Alignment dots



- 1 Alignment dots
- 2 Wire clamp

4. CRIMPING PROCEDURE

Wire strip length and specific crimp information for each terminal being crimped can be found in the applicable 114 series application specification referenced in Table 1.

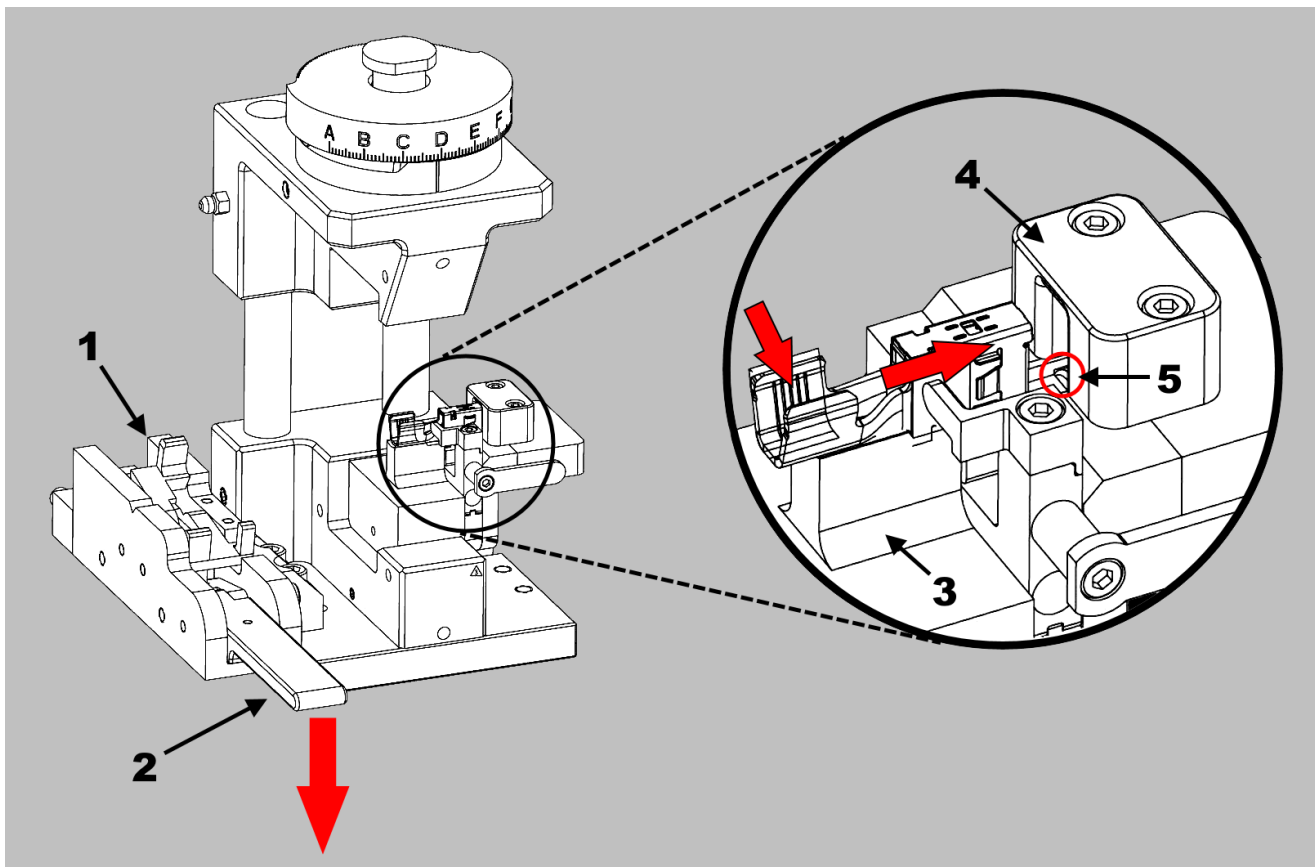


CAUTION

If the tool holder is equipped with a crimp height (fine adjust) adjustment, damage to the terminator, modular tool holder or die assembly can be avoided 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. Insert PCON 12 receptacle contacts into the terminal locator of the die assembly and place it on the anvil (Figure 3).
 - Push the terminal against the extrusion pin.
 - Push the contacts into the locator and seat the crimp barrels on the anvils.
2. Push down fully on the handle to open the grip jaws (Figure 3).

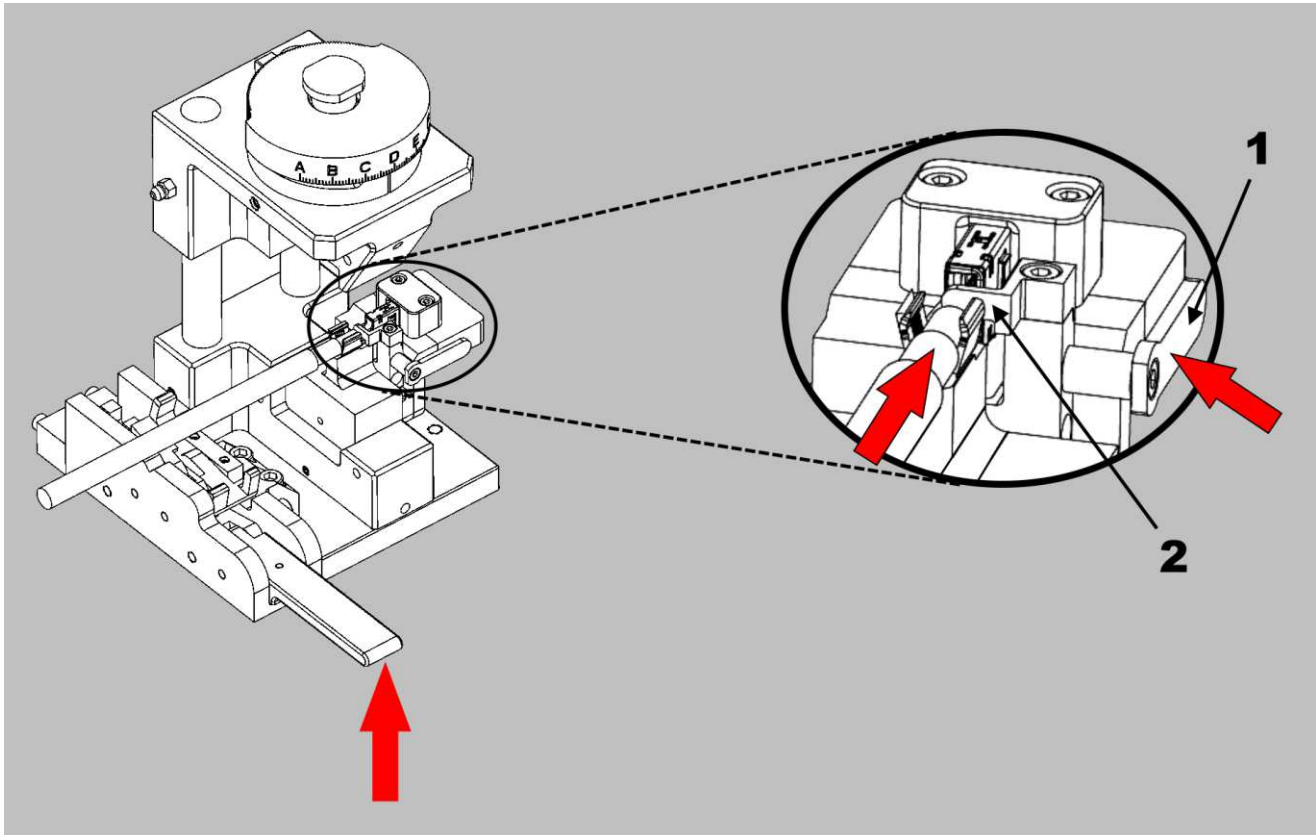
Figure 3: Inserting the receptacle



- 1 Grip jaws
- 2 Handle
- 3 Anvil
- 4 Locator
- 5 Extrusion pin

3. Insert prepared wire ends located correctly in the crimp barrel of the PCON 12 receptacle contacts while pushing the wire stop handle (Figure 4). Push the wire strands against the wire stop.
4. Release the wire stop handle. Lift the handle to close the grip jaws around the cable (Figure 4).

Figure 4: Inserting the wire



- 1 Handle
- 2 Wire stop

5. Cycle the terminator to perform the crimp.
6. Remove the crimped product from the terminator.

5. CRIMP INSPECTION

For crimp inspection information, refer to the 114 series application specification referenced in Table 1 for the terminal being crimped.

6. MAINTENANCE AND INSPECTION

Each die assembly is inspected before shipment. Inspect the die assembly immediately upon arrival at the facility of use to ensure that it has not been damaged during shipping.

6.1. Daily maintenance

Each operator of the power unit must be made aware of, and responsible for, the following daily maintenance requirements:

- Remove dust, dirt and other contaminants with a clean 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 must be performed by quality control personnel. A record of scheduled inspections must remain with the dies or be supplied to personnel responsible for the dies. Recommendations call for at least one inspection per month, but the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards. Perform the inspection as follows:

- Remove all contaminants with a clean brush or soft lint-free cloth.
- Inspect the crimp area for flattened, chipped, cracked, worn, or broken areas. If damage is evident, replace the die assembly.

7. REPLACEMENT AND REPAIR

If the dies are damaged or worn excessively, they must be replaced. To obtain replacement dies, refer to the appropriate instruction sheet or customer manual and order parts through your TE representative. You can also order parts by any of the following methods:

- Go to TE.com and click the **Shop TE** link at the top of the page.
- Call 800-522-6752.
- Write to:

CUSTOMER SERVICE (038-035)
TE CONNECTIVITY CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

For customer repair services, call 800-522-6752.

8. REVISION SUMMARY

Revisions to this instruction sheet include:

Initial release