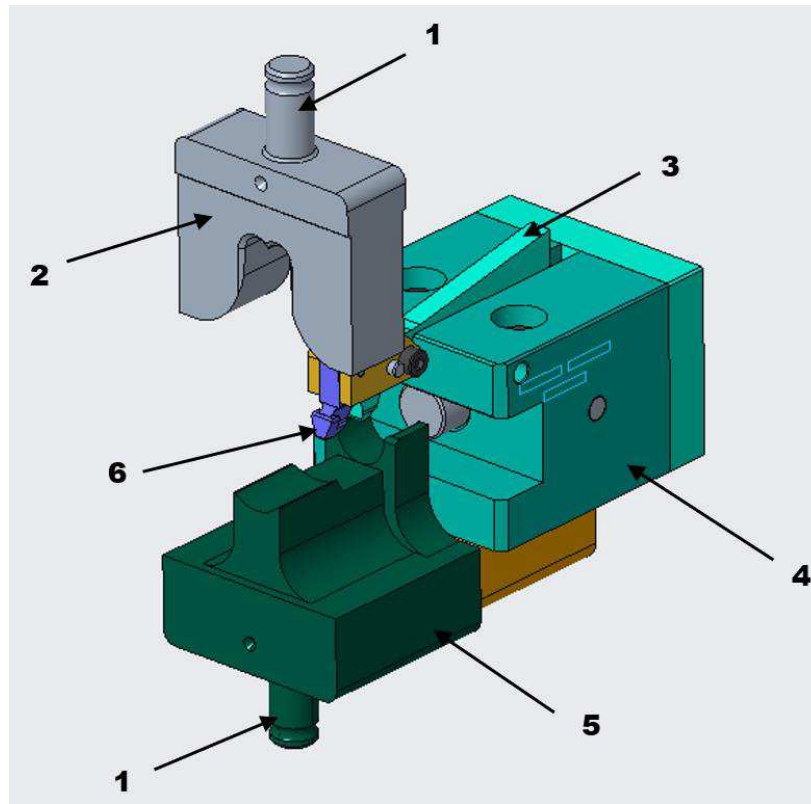


Figure 1: Crimping die and terminal locator assembly for HVP800-180 terminals



- 1 Shank
- 2 Crimper
- 3 Stop block
- 4 Terminal locator assembly
- 5 Anvil
- 6 Wire stopper

1. INTRODUCTION

The crimping die assemblies listed in Table 1 are designed to be installed into the modular tool holders listed in Table 2. The crimping die assembly is designed to crimp HVP800-90 terminals to wire in the range of 16-50 mm².

Table 1: Crimping die assemblies

Crimping die assembly	Wire range mm ²	Terminal part number	Application specification
2351791-1	16-25	2208669-3	114-94325
2351792-1	35-50	2208608-3	

Table 2: Modular tool holders

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

2. DESCRIPTION

Each crimping die assembly consists of a crimper, an anvil, and a terminal locator assembly (consisting of a stop block and a wire stopper), as shown in Figure 1.



NOTE

The terminal locator assembly is designed to maintain terminal position during the crimping process. It is supplied pre-assembled to the crimping die.

3. INSTALLING AND REMOVING THE DIE ASSEMBLY

For information concerning die installation or removal, or general performance of the Modular Tool Holder, refer to the applicable 408 series instruction sheet packaged with the tool holder (Table 1).



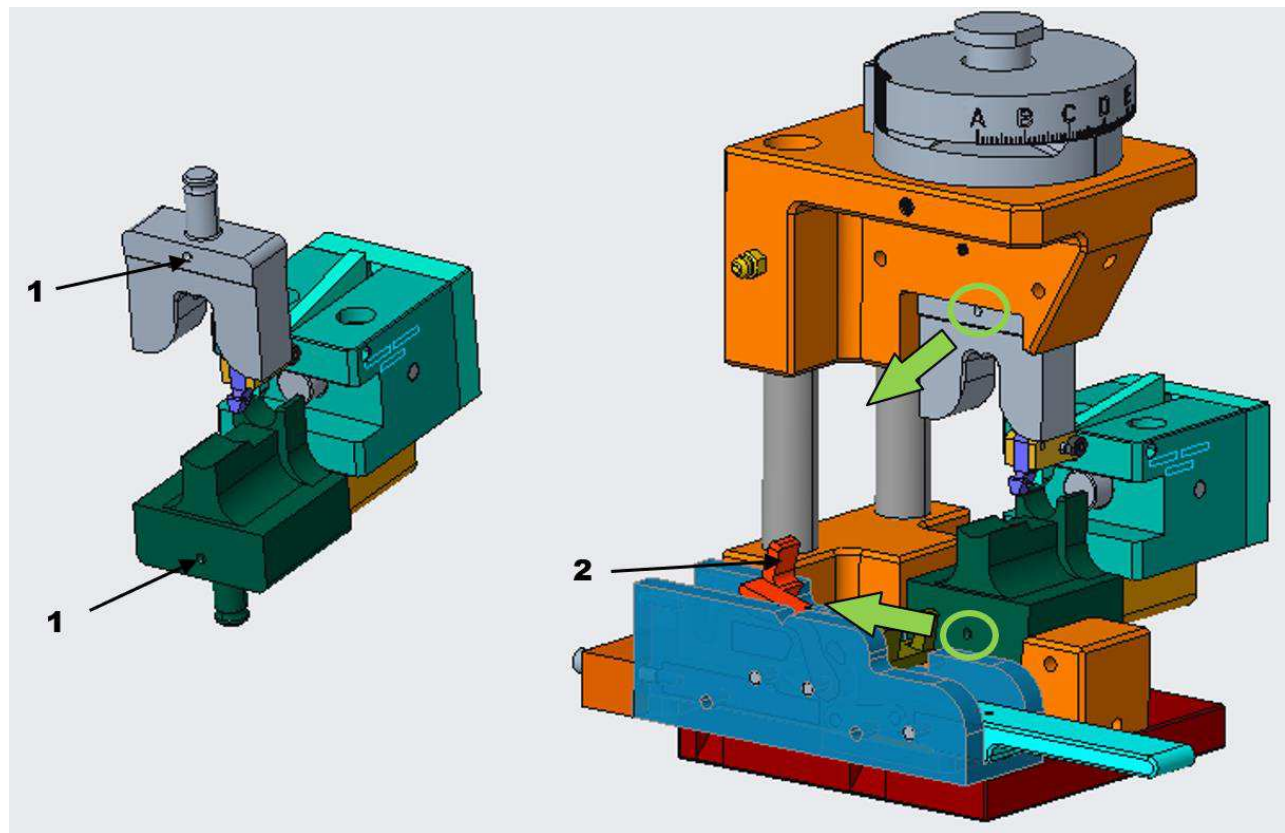
Disconnect electrical power before installing the die assembly into the tool holder.



Disconnect 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 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

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.

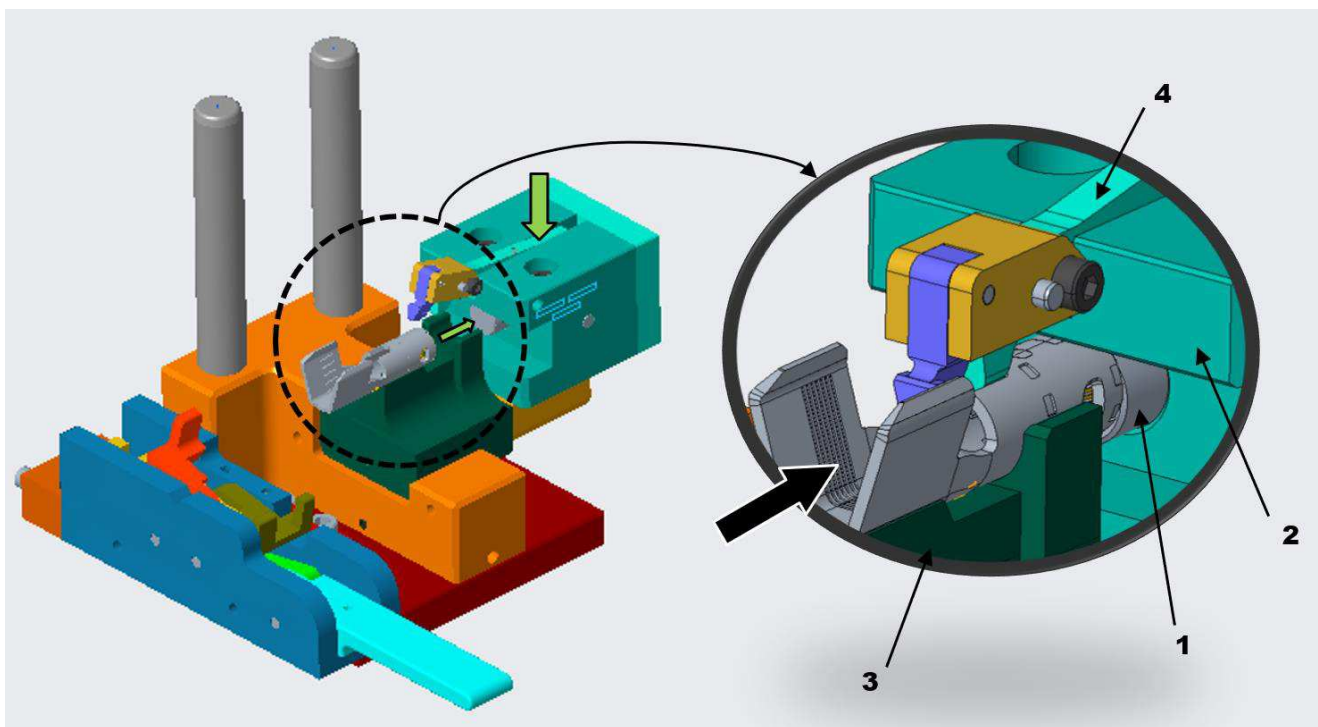


CAUTION

If the tool holder is equipped with a crimp height (fine adjust) adjustment, you can prevent 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. Push down the lever and insert the terminal into the die assembly. Place it on the anvil with the socket end facing the locator.
2. Slide the terminal into the locator until it touches the extrusion pin (Figure 3).
3. Loosen the stop block to allow the front end to enter the opening of the terminal.

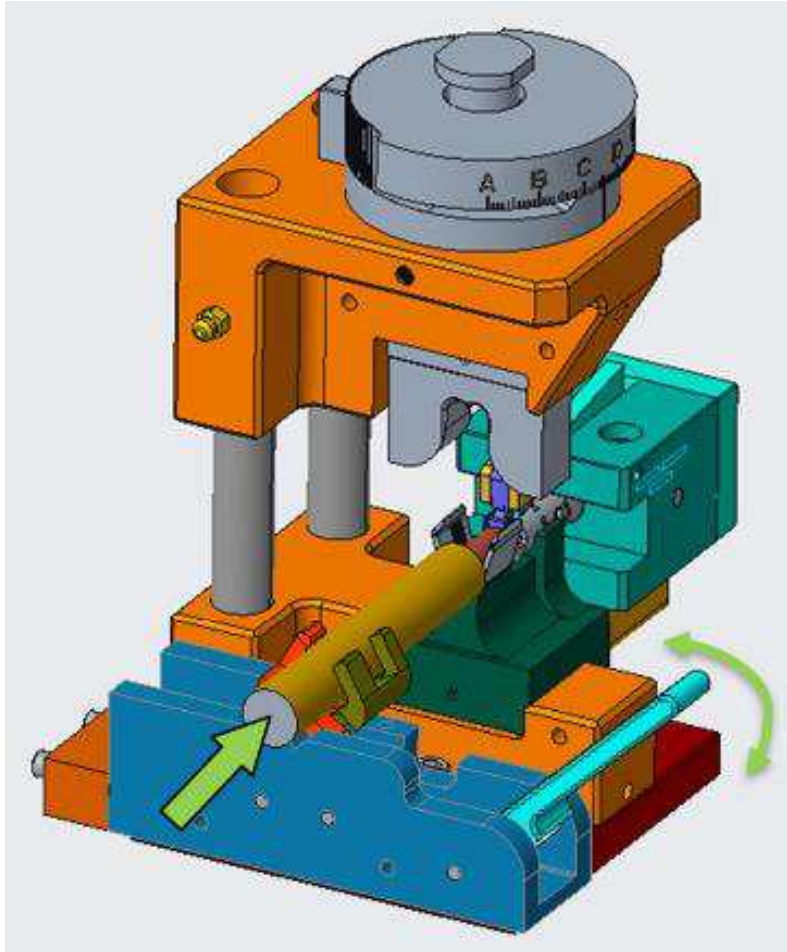
Figure 3: Pushing terminal against extrusion pin



- 1 Extrusion pin
- 2 Locator
- 3 Anvil
- 4 Lever

4. Open the wire clamp by pressing down on the wire clamp lever (Figure 4).

Figure 4: Wire clamp lever



5. Place the properly stripped wire into the wire barrel of the terminal so that the front end rests against the wire stopper.
6. Release the lever to clamp the wire in place.
7. Cycle the terminator to perform the crimp.
8. Remove the crimped product from the terminator.

5. INSPECTING THE CRIMP

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

6. MAINTENANCE AND INSPECTION

6.1. Daily maintenance

Make each operator of the power unit 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. Recommendations call for 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:

- 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 or abnormal wear is evident, replace the 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. 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

Initial release