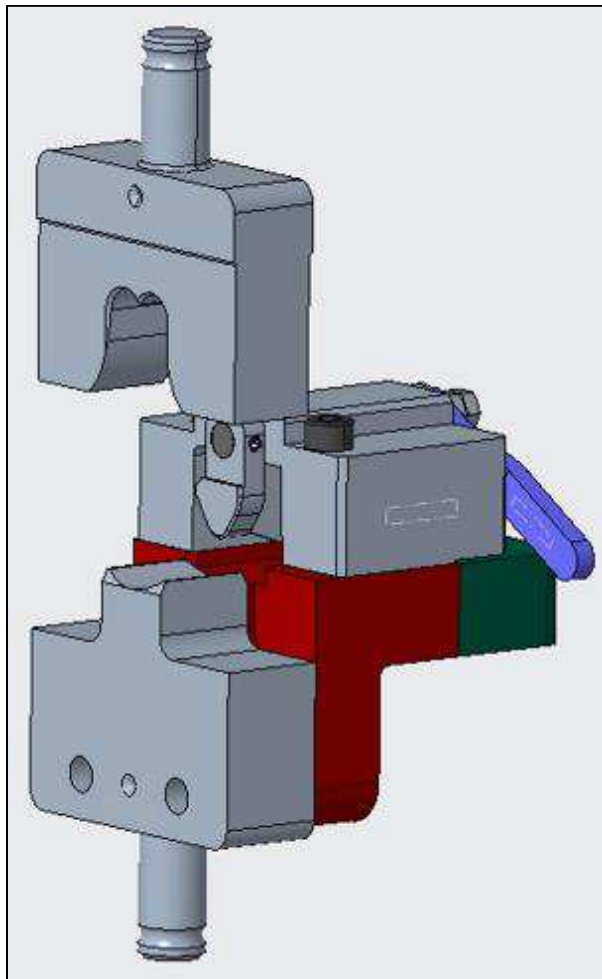


Figure 1: Crimping Die and Terminal Locator Assembly for HVP800-90 Terminals



1 Introduction

The crimping die assemblies listed in Table 1 are designed to be installed into the modular tool holders listed in Table 1. The crimping die assemblies are designed to crimp HVP800-90 Terminals. Refer to application specification [114-94083](#) for detailed information about these terminals.

Table 1: Crimping die assemblies

Crimping die assembly	Wire size	Terminal part number	Modular tool holders
2359761-1	16.0 mm ²	2355358-3	2305470-1 2326378-1
	25.0 mm ²		
2359762-1	35.0 mm ²	2-2141211-2	
	50.0 mm ²	3-2141211-2	



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

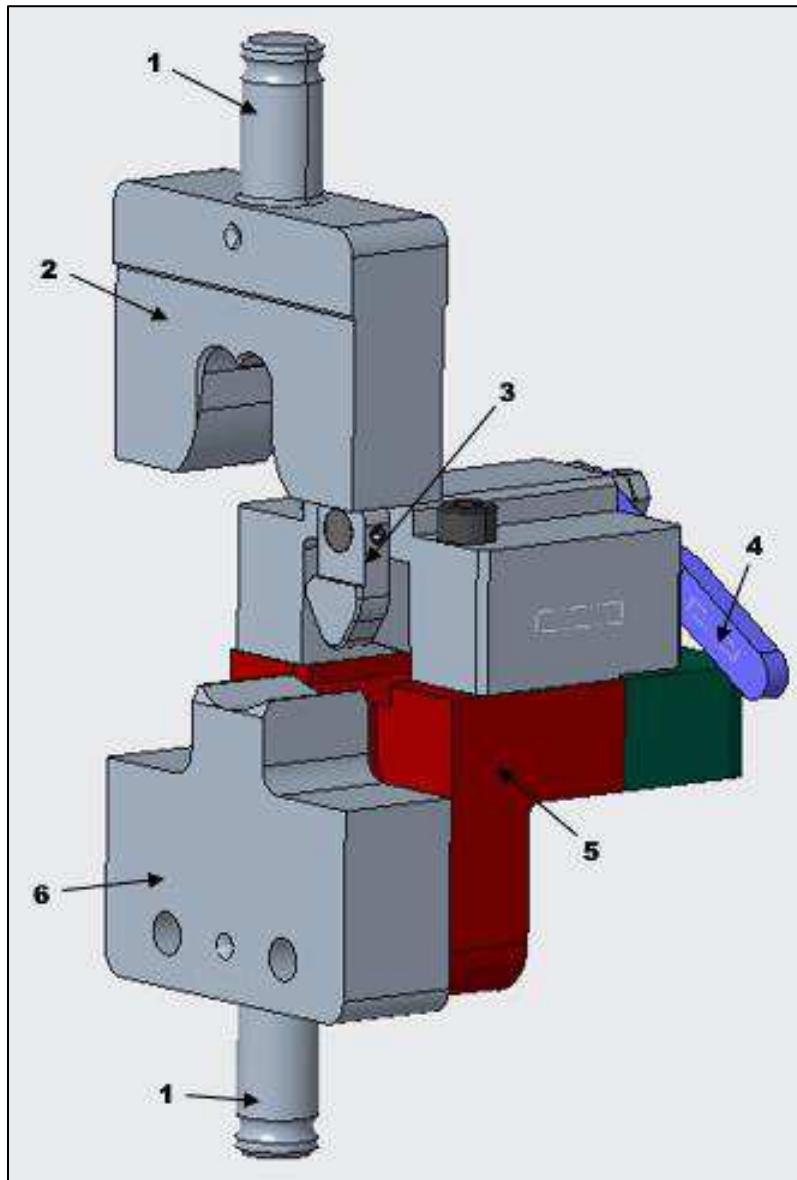
Each die assembly consists of a crimper, anvil, wire stopper, and terminal locator assembly (Figure 2).



NOTE

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

Figure 2: Components



- | | |
|-----------------------|------------------------------------|
| 1 Shank | 4 Handle |
| 2 Crimper | 5 Terminal locator assembly |
| 3 Wire stopper | 6 Anvil |

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 2).

Table 2: Instruction sheets

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



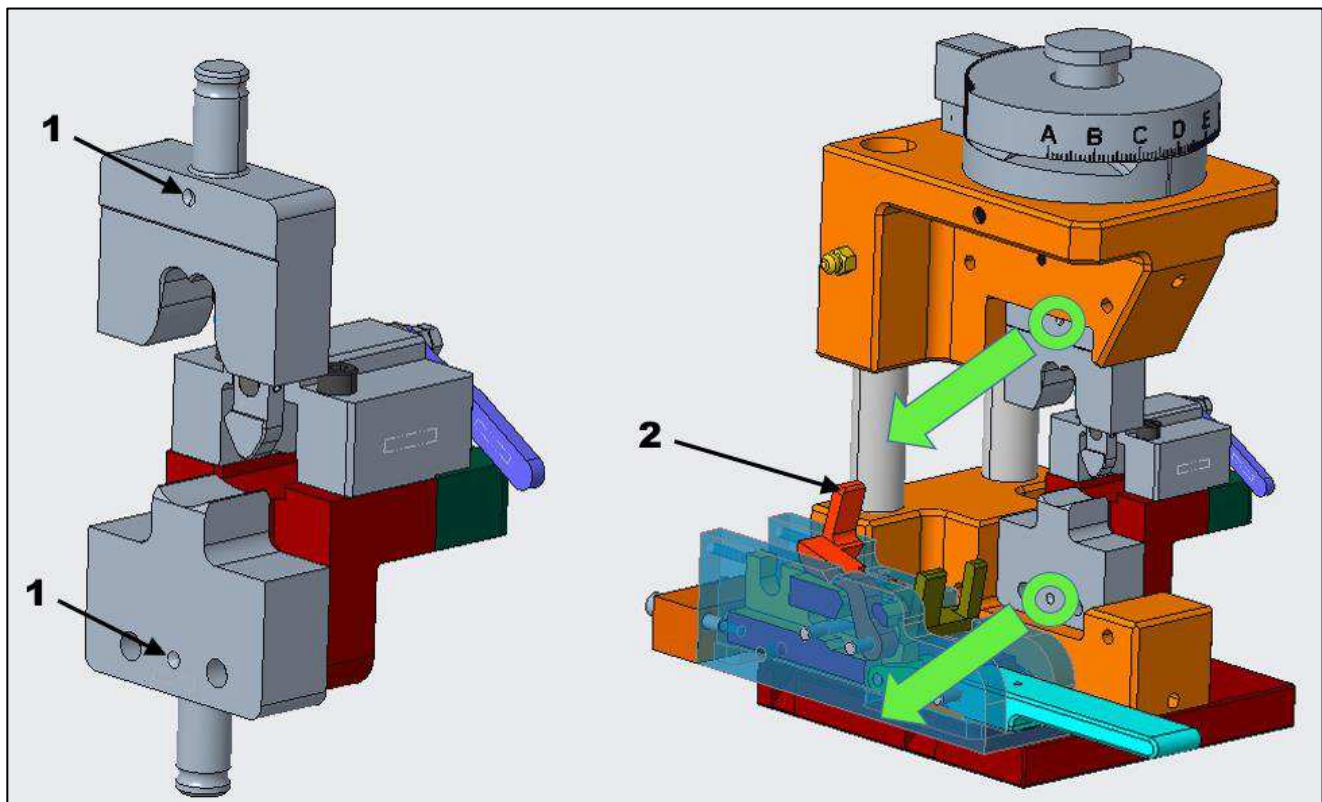
Disconnect electrical power before performing maintenance or repair on this equipment.



Disconnect air supply before performing maintenance or repair on this equipment.

During installation, orient the dies so 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

For wire strip length and specific crimp information for each terminal being crimped, refer to the 114 series application specification listed in section 1.

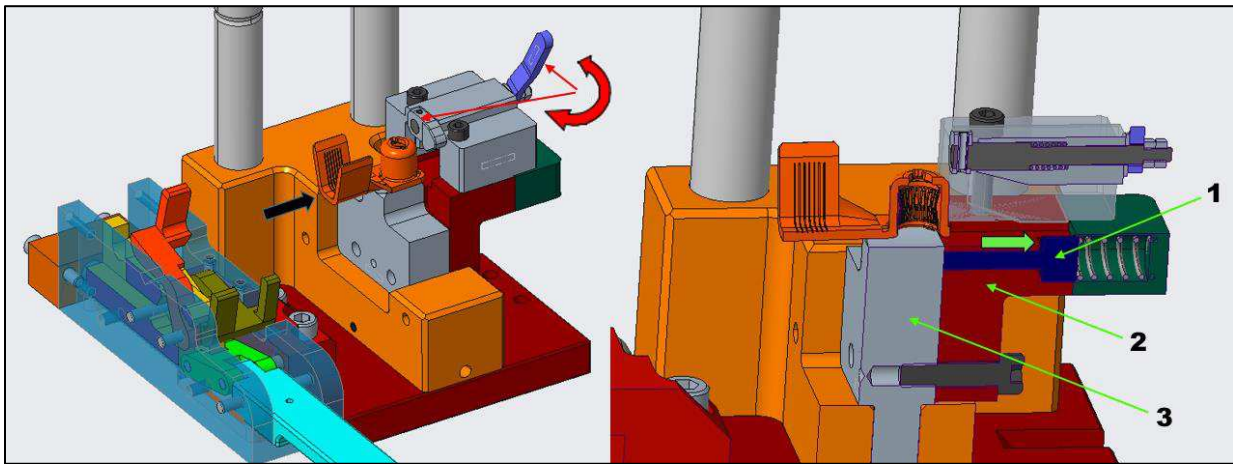


CAUTION

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. Rotate the handle to lift the wire stopper
2. Insert the terminal into the die assembly and place it on the anvil with the socket end facing the locator.
3. Slide the terminal into the locator until it touches the extrusion pin (Figure 4).
4. Turn the handle back to lower the wire stopper.

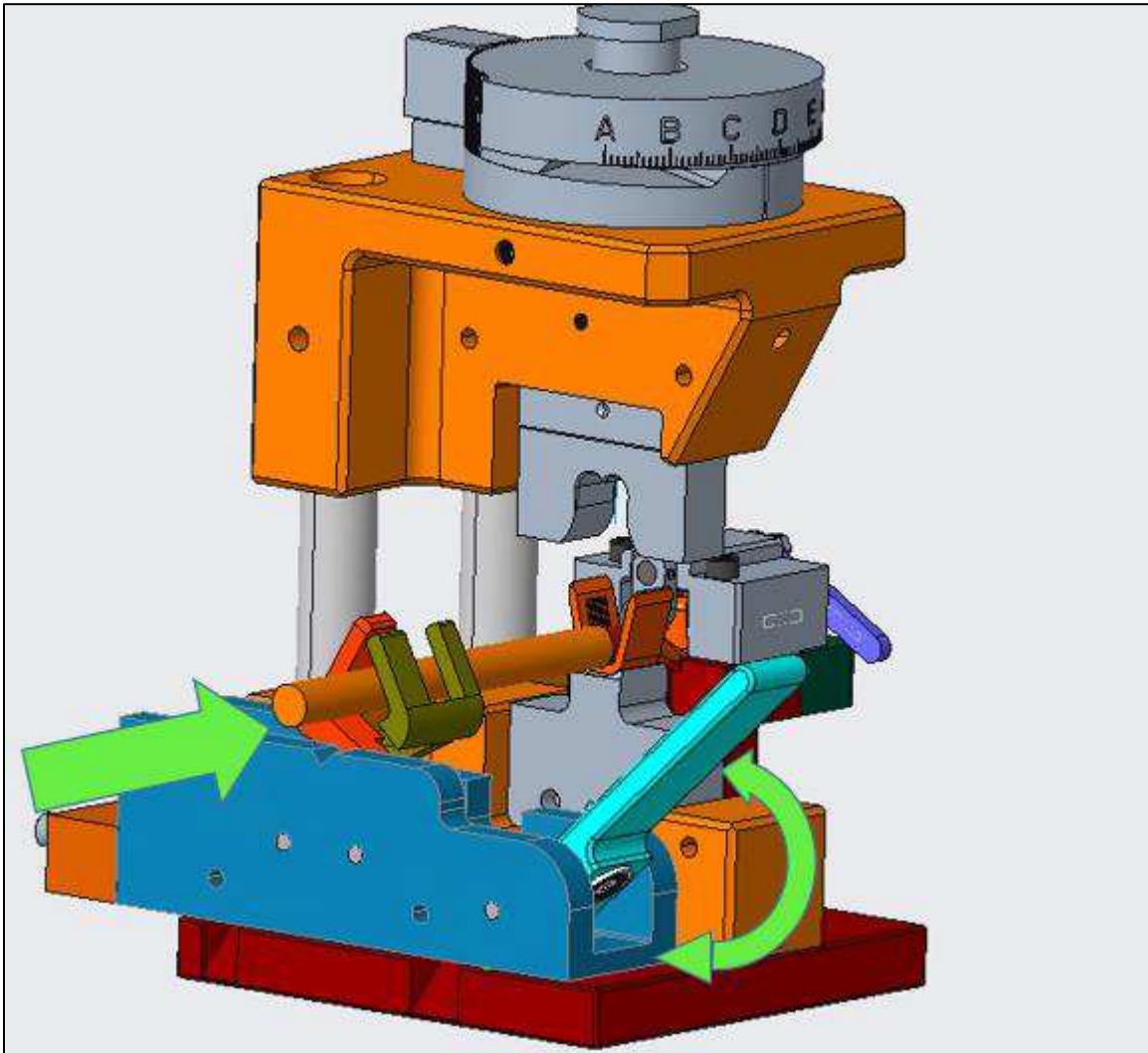
Figure 4: Pushing terminal against extrusion pin



- 1 Extrusion pin
- 2 Locator
- 3 Anvil

5. Open the wire clamp by pressing down on the wire clamp lever (Figure 5).

Figure 5: Wire clamp lever



6. Insert the properly stripped wire into the wire barrel of the terminal.
7. Release the lever to clamp the wire in place.
8. Cycle the terminator to perform the crimp.
9. Remove the crimped product from the terminator.

5 Inspecting the crimp

For crimp inspection information, refer to the 114 series application specification listed 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 or tool.
- 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:

- Remove all contaminants with a clean, soft brush or soft, lint-free cloth. Do not use objects that could damage the dies.
- Inspect the crimp area for flattened, chipped, cracked, worn, or broken areas.
- 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. You can also order parts by any of the following methods:

- Go to TE.com and click the **Shop TE Store** link at the top of the page.
- Call +1 800 522 6752.
- Write to:

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

For customer repair services, call +1 800 522 6752.

8 Revision summary

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

- Initial release