



# Operating instructions

## SDE Crimping Die Set 1.5, 2.5 diameter Contacts

Customer Manual No.: 411-18592-1 Rev.A  
Customer Manual PN: 2-744017-5  
Language: EN (translation of the German original version)

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## 1 Revision history

| Rev. | Date       | Description   | Name         |
|------|------------|---------------|--------------|
| A    | 12.08.2015 | First version | Levin Sandhu |
|      |            |               |              |
|      |            |               |              |

Tab. 1 : Revision process

## 2 Introduction

### 2.1 About these operating instructions

These operating instructions describe the use and operation of the SDE crimping die with the hand crimping tool and the necessary maintenance measures. All persons using the machine must therefore be familiar with and follow these operating instructions. It should be stressed that the operating instructions for the SDE crimping die set are essential.

These operating instructions must be available with the crimping die set at all times. The tool owner and/or user is obliged to supplement these operating instructions with instructions in line with existing national regulations for the prevention of accidents and environmental protection.

These operating instructions apply to the following crimping machine from TE Connectivity:

- SDE Crimping Die Set 1.5, 2.5 diameter Contacts: TE PN 3-1579017-3

The following operating instructions must also be observed:

- HT33-SDE Basic Hand Tool, Operating Instructions: TE PN 1-744017-0 / 411-18581

### 2.2 Intended use

The SDE crimping die set serves to crimp pin and socket contacts according to TE processing specifications and diagrams. The SDE crimping die set may only be used for repair purposes or for making samples, not for series production. The following terminals can be processed with the crimping die set:

| Terminal PN                    | Cross-section       | Terminal       | TE processing specification   |
|--------------------------------|---------------------|----------------|---|
| 962972, 962982, 962993, 962999 | 1.5 mm <sup>2</sup> | 2.5 System SWS | Appl. Spec. 114-18020<br>Appl. Spec. 114-18040<br>TE PN 3-1579017-3 |
| 962972, 962982, 962993, 962999 | 2.5 mm <sup>2</sup> | 2.5 System SWS | Appl. Spec. 114-18020<br>Appl. Spec. 114-18040<br>TE PN 3-1579017-3 |

Tab. 2 : Processable terminals

### 3 Description

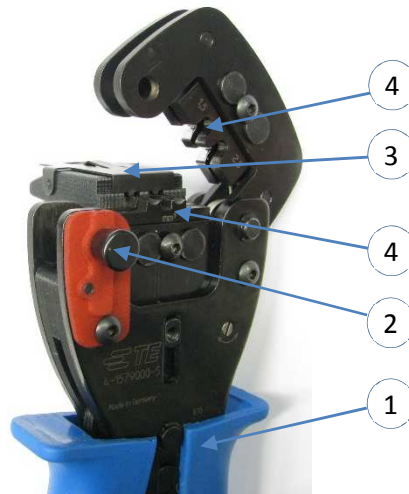


Abb. 1 : The hand tool including crimping die set

| Item | Designation         | Item | Designation                      |
|------|---------------------|------|----------------------------------|
| 1    | Tool handles        | 2    | Releasable locking device, bolts |
| 3    | Terminal positioner | 4    | Crimping die set                 |

Tab. 3 : Hand tool components including crimping die set

### 4 Reconfiguring the crimping dies

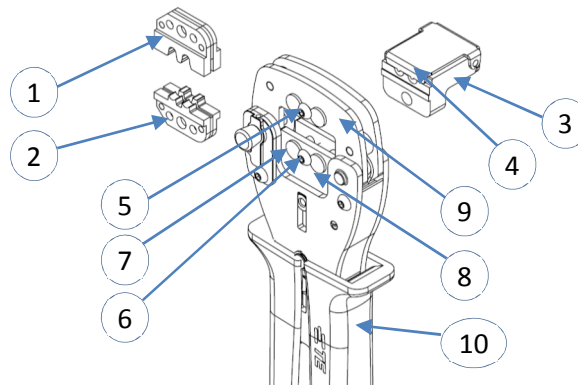


Abb. 2 : Exploded diagram of the hand tool including crimping die set

| No. | Designation            | No. | Designation            |
|-----|------------------------|-----|------------------------|
| 1   | Upper crimping die     | 2   | Lower crimping die     |
| 3   | Terminal positioner    | 4   | Positioning plate      |
| 5   | Upper die-fixing screw | 6   | Lower die-fixing screw |
| 7   | Centring pins          | 8   | Movable crimping jaw   |
| 9   | Fixed crimping jaw     | 10  | Basic hand tool        |

Tab. 4 : Components of the crimping die set

## 4.1 Assembling the crimping dies

- Close the handles until the ratchet releases and allows you to fully open the handles.

### NOTE

The ratchet mechanism of the hand tool has resting points which click when closing the handles. The ratchet mechanism is opened by the last click.

- Open the crimping head via the releasable locking device. To do this, remove the bolt.
- Position the upper crimping die against the stationary crimping jaw so that the writing on the crimping die points towards the front of the crimping tool.

### NOTE

The front side is the position shown in the cover sheet of the operating instructions.

- Insert the upper crimping die including the two centring pins up to the stop point. Insert it via the front of the crimping tool.
- Turn a die-fixing screw using the upper jaw and crimping die. Do not tighten the screw yet.
- Position the lower crimping die in the movable crimping jaw. The writing must face forwards.
- Insert the lower crimping die including the two centring pins up to the stop point. Insert it via the front of the crimping tool.
- Turn a die-fixing screw using the lower jaw and crimping die. Do not tighten the screw yet.
- Slowly press the handles together so that the crimping dies are placed together and aligned.
- Hold the handles closed and then tighten both of the die-fixing screws.
- Finally, with the help of a slotted screwdriver, fasten the contact positioner on the protruding fillister head screw onto the reverse side of the movable crimping jaw.

## 4.2 Disassembling the crimping dies

- Close the pliers until the ratchet releases and the handles open completely.
- Open the crimping head via the releasable locking device.
- Release and remove the contact positioner with the help of a slotted screwdriver.
- Release and remove the die-fixing screws from the crimping jaws.
- Remove all four centring pins.
- Remove the crimping dies from the crimping jaws.

## 5 Operation

### 5.1 Crimping terminals

- Fully open the tool.
- Open the insert area of the contact positioner via the positioning plate and press it downwards.
- Place the terminal in the terminal positioner and onto the contact area of the lower crimping die, chosen according to the wire cross-section.



Abb. 3 : Terminal placed in the lower crimping die (left)  
Placing the sealing ring and wire together (wire)

- ➔ Join together the wire and the sealing ring according to processing specification 114-18018.
- ➔ Insert the wire into the terminal until it reaches the wire stop.

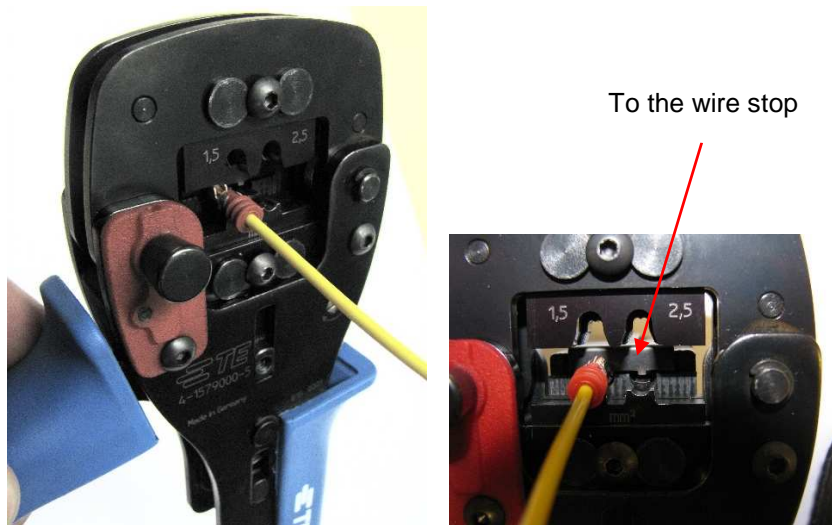


Abb. 4 : Inserting wire including sealing ring up to the wire stop point (left), wire stop point (right)

- ➔ Close the tool handles until the ratchet mechanism releases and the handles open.



Abb. 5 : Tool handles completely closed (left), check the crimped terminals (right)

- ➡ Open the contact positioner via the positioning plate and remove the crimped terminal from the crimping die. If the terminal is stuck, wiggle it slightly to remove it.
- ➡ Check the crimp height of the crimped terminal. based on the information in the TE Connectivity processing specification and the drawing.

## 6 Customer Service, EMEA Service Hotline

Please contact us for service enquiries or technical support:

|                       |  |
|-----------------------|--|
| Monday - Thursday     | 8:00 - 16:00                                   |
| Friday                | 8:00 - 14:00                                   |
| Tel.                  | +49 (0) 6151 607 -1518                         |
| EMEA Customer Service | <a href="mailto:TEFE1@TE.COM">TEFE1@TE.COM</a> |
| EMEA hand tool repair | <a href="mailto:TEFE2@TE.COM">TEFE2@TE.COM</a> |

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**Additional information and contact details can also be found online.**

Visit us at: <http://tooling.te.com/>

## 7 Maintenance and servicing

### 7.1 Daily maintenance

The following daily maintenance tasks should be performed by the responsible operator:

- Using a soft, clean brush or a lint-free cloth, remove dirt, dust, moisture and other residue from die set. Do not use any hard or abrasive tools or materials that could damage the die set.
- Apply sewing-machine oil to all pivot points and bearing surfaces. Do not lubricate excessively.
- When the die set is not needed, store it in a clean and dry location.

### 7.2 Periodic inspection

- The die set should be inspected periodically by suitably qualified staff according to the level of use, and the inspections should be documented.
- Check the die set for wear and damage, particularly in the crimping nest areas.