

Figure 1

## 1. INTRODUCTION

The HV Modular Die Holder without Fine Adjust (PN 2326378-1) is a product line that provides the customer with a versatile platform where multiple, modular die sets can be used to crimp multiple, high voltage terminals. This Die Holder is designed to be used with AT-66 Machine; PN 1-528008-4 and 528008-4.

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



**DANGER**

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



**CAUTION**

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



**NOTE**

Highlights special or important information.

## 2. GENERAL SAFETY INSTRUCTIONS

As with any product incorporating moving parts, be aware of all pinch points. Observe all safety labels displayed on the Terminator, in addition to safety standards set by your organization and the industry.



**DANGER**

The HV Modular Die Holder without Fine Adjust functions by transferring a force of up to 15 tons from a power unit (terminator) to a crimp interface, which can cause dramatic damage and/or dismemberment. Be sure all protective safety devices (interlocks) and guarding are in place and working.

### 3. KEY FEATURES

The HV Modular Die Holder without Fine Adjust can accommodate various crimp dies and wire sizes/orientations.

#### 3.1. Interchangeable Dies

HV Modular Die Holder without Fine Adjust provides the option to exchange crimp dies to add versatility to the Die Holder.



**CAUTION**

*Before performing any work on the Die Holder, verify that the terminator is disconnected from its power source.*

1. Removing Dies

Unscrew the set screws identified in Figure 2 and remove the dies from the Die Holder. **MAKE SURE** the tools being used to remove the dies **DO NOT** contact the crimp surfaces.

2. Installing Dies

Refer to die Instruction Sheet for proper orientation, and place dies into the Die Holder accordingly. Secure the dies in the Die Holder by tightening the set screws shown in Figure 2.



**NOTE**

*The set screws are on the front face of the Die Holder.*

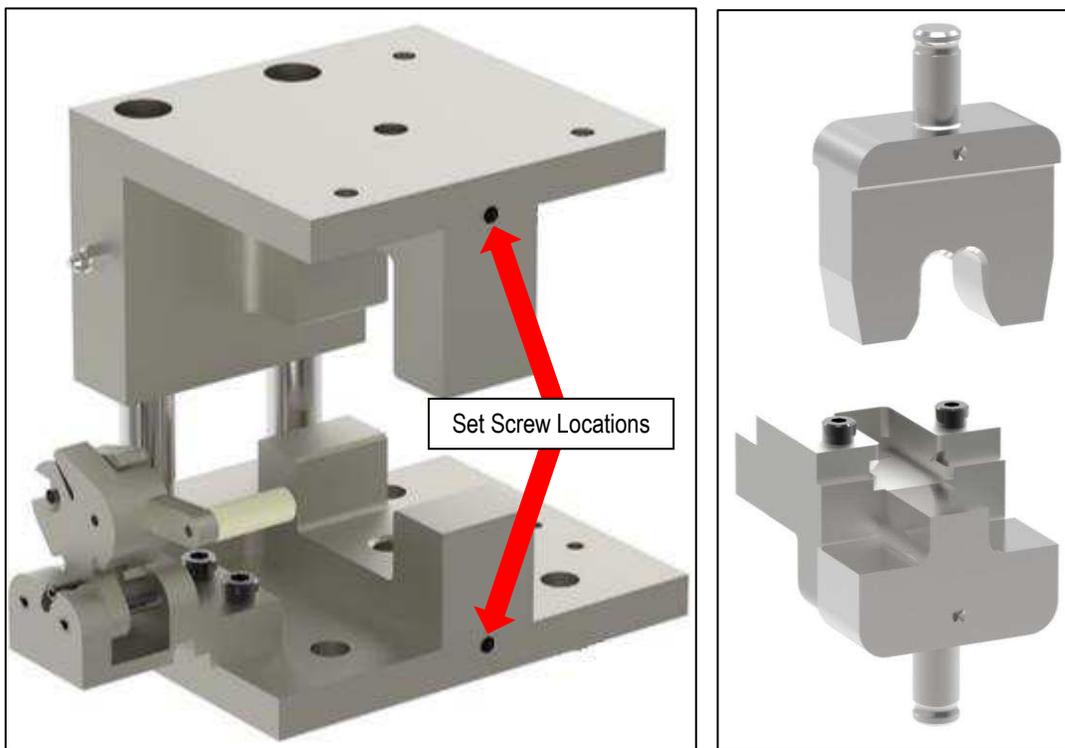


Figure 2

### 3.2. Wire Clamp

The HV Die Holder provides locations to mount a Wire Clamp on either side of the Die Holder (see Figure 3). This allows for versatility in crimping orientations and a wider range of crimping options. The Wire Clamp is likewise, designed to be used on either side of the Die Holder.



**NOTE**

A Wire Clamp is a manually operated mechanism that holds a wire in a fixed position while the crimping operation is taking place. Operation of the Wire Clamp requires the user to press down on the lever which will open the clamp jaws. Releasing the lever will close the jaws (reference Figure 4).

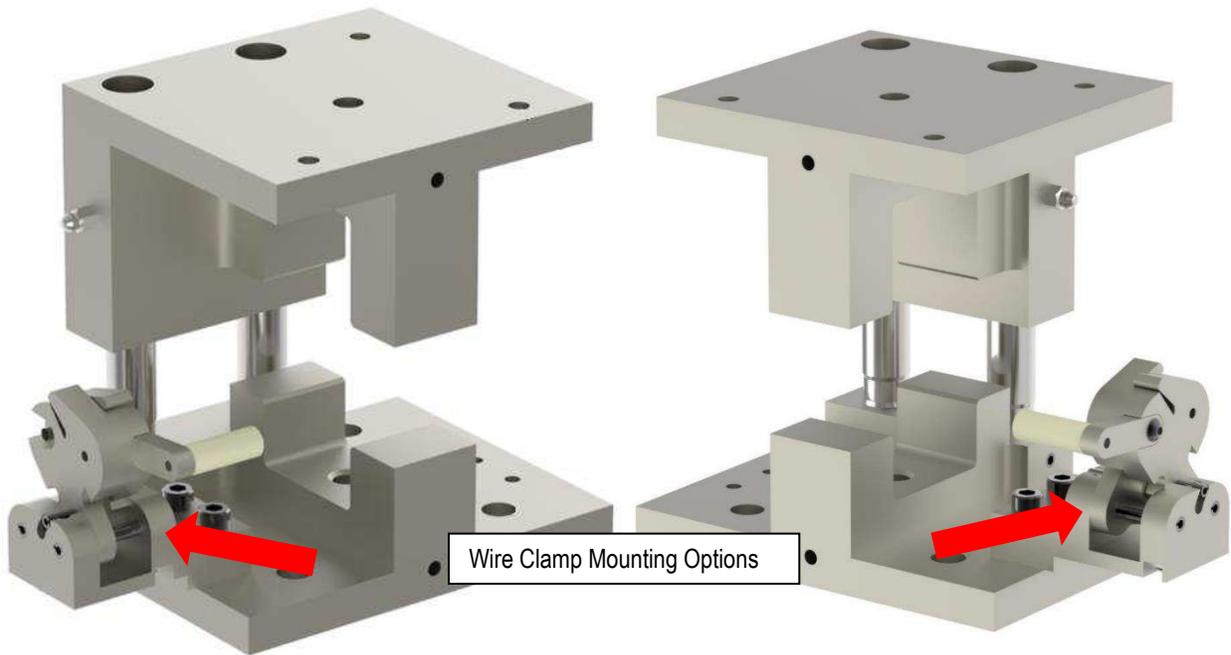


Figure 3

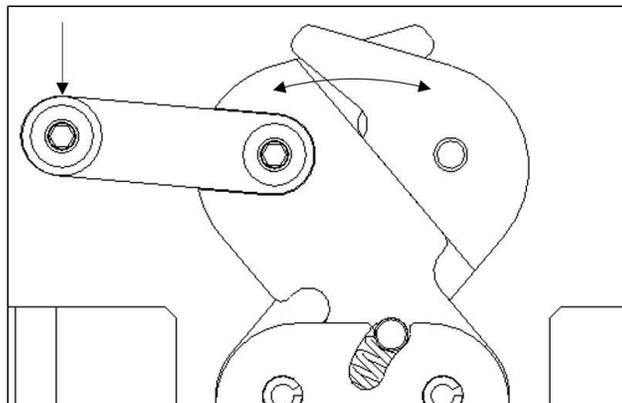


Figure 4

To change the location of the Wire Clamp, unfasten the bolts show in Figure 5.

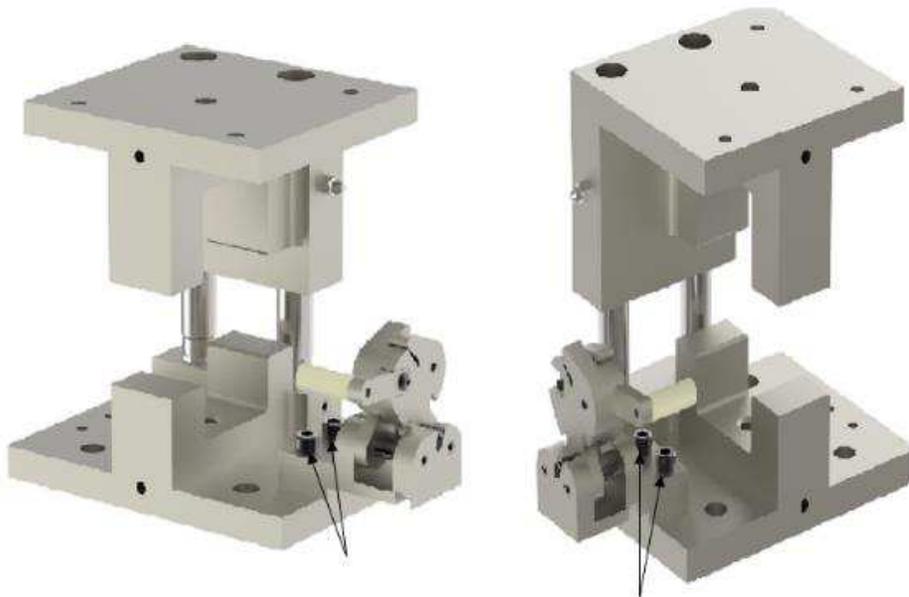


Figure 5

### 3.3. Grease Port

The moving parts of the machine require regular lubrication to ensure reliable service and long life.

1. Preferred greases are:

Chevron Ultra-Duty EP NLGI 2, Chevron Ulti-Plex EP NLGI 2, and Caltex Ultra-Duty EP NLGI 2.



**NOTE**

Contact TE Engineering for 2<sup>nd</sup> choice alternatives.



**NOTE**

For operation in temperatures below 10 °C (50 °F), it will be necessary to use a No. 1 grease.

2. Recommended Greasing Schedule:

Every 50,000 cycles, one pump of grease should be applied (via a grease gun) to each location indicated in Figure 6.

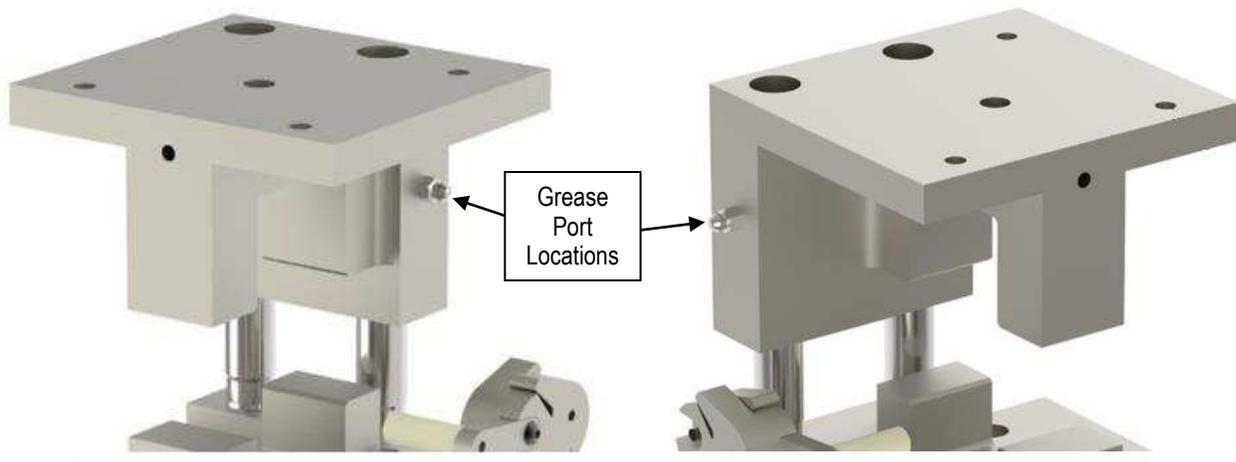


Figure 6

## 4. DIE HOLDER INSTALLATION AND REMOVAL

**DANGER**

To avoid personal injury, make sure the power air source to the machine is turned off and power cord/air supply are disconnected before installing or removing the Die Holder.

**NOTE**

Always REMOVE the Ram Transportation Collar (if present) after installing the Die Holder in a machine, AND, be sure to INSTALL the Ram Transportation Collar onto the Die Holder ram just prior to removing the Die Holder from the machine.

**NOTE**

With the Die Holder in the machine, NEVER attempt to cycle the machine under power without terminals properly loaded; as described in this Section; otherwise, the tooling may be damaged.

**DANGER**

To avoid personal injury, the Die Holder should be used ONLY in an appropriate terminating machine.

### 4.1. Installation

1. Center the Die Holder on the machine Base Plate.
2. Start the (3) M6 cap screws into the machine Base Plate – DO NOT tighten fully.
3. Raise the upper section of the Die Holder and start (3) M6 cap screws into the ram of the terminator and tighten.
4. Tighten (3) M6 cap screws in the machine Base Plate.

### 4.2. Removal

1. Remove (3) M6 cap screws from the machine Base Plate.
2. Remove (3) M6 cap screws from the ram of the terminator:

**DANGER**

DO NOT allow upper section of the Die Holder to fall and pinch fingers.

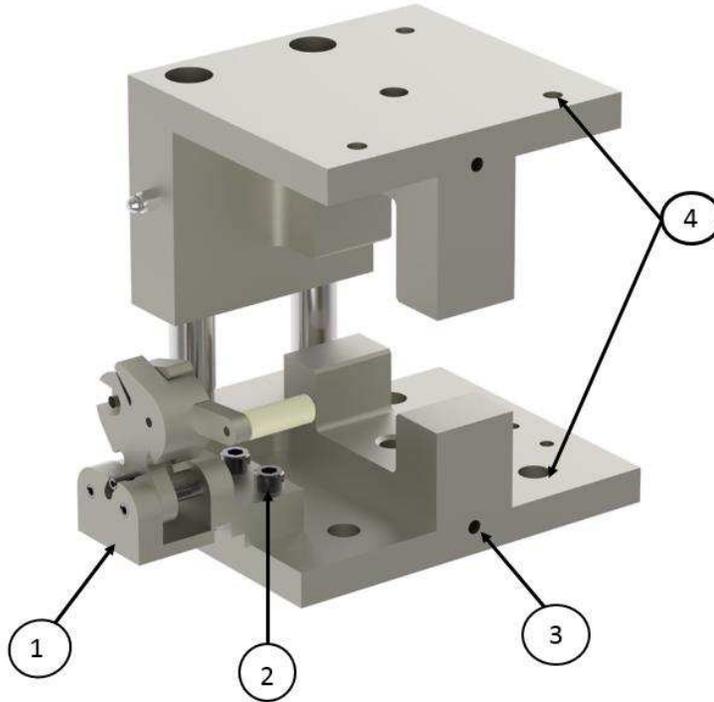
3. Remove Die Holder from machine.

## 5. REPLACEMENT AND REPAIR

Replacement parts and recommended spares (reference Figure 7) are identified in the drawings and documentation package. To order replacement parts, call 1-800-522-6752, send a facsimile of your purchase order to 717-986-7605, or write to:

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

Call 1-800-522-6752 for customer repair services.



Item	Item Name	TE P/N	Qty
1	ASM, Wire Clamp	2305445-3	1
2	SCR, Socket Head Cap M6 x 20	2-18023-9	2
3	SCR, Set, Cone Pnt M4 x 6.0	992763-6	2
4	SCR, Socket Head Cap M6 x 16	2-18023-8	6

Figure 7

**6. DISPOSAL**

Contact TE for disposal.

**7. REVISION SUMMARY**

- Revised Section 1
- Revised Figure 7
- Added Revision Summary [Section 7]