

FIELD ENGINEERING SERVICES

CUSTOMER SATISFACTION IS OUR BUSINESS

2354-1 (04/09)

TECHNICAL BULLETIN

NO.

TB- 2023-01

SUBJECT

**Maintenance Reminder –
Hydraulic Crimping Heads –
69069 and 1673672-1**

FIELD ENGINEERING
RELEASE DATE

7/3/2023

REFERENCE DOCUMENTATION

- 408-1745
- 408-8910
- 408-9684
- 409-35004

Hydraulic tools experience very high operating pressures and forces and, as such, are subject to wear and tear in normal operation. This is a reminder to our customers of the importance of regular inspection, maintenance, and establishment of safe operating procedures for hydraulic tooling.

Visual Inspection shall be conducted monthly or every 1,000 tool cycles, whichever comes first. (Refer to Figure 1. below)

1. Remove all pressure on tool and disconnect tooling from hydraulic power source.
2. Visually inspect die closure surfaces for chipped, pitted, or flattened areas.
3. With hydraulic pressure released, inspect the assembled head for nicks, scratches, and cracks. Inspect for cracks especially at the corners of the yoke and around the top of the cylinder.
4. Inspect pivot pin holes and latch pin holes for wear. Do Not Operate the tool if damage or defects are found. Replace parts, as needed.
5. Connect tooling to a hydraulic power source. DO NOT EXCEED PRESSURE RATINGS OF TOOLING. Follow all safety precautions.
6. Activate power unit. Raise ram to “UP” position. Inspect flat and round surfaces of ram for galling (fretting or wear by friction), cracks, or oil leakage. Release pressure and make sure that ram retracts smoothly.
7. If head shows evidence of galling, cracks, oil leakage, or rough cycling, return the crimping head to TE for repairs.
8. If there are any questions, please contact a TE Tooling Representative at 1-800-526-5136. Detailed Operating Instructions should be reviewed per TE reference documents:
 - 408-1745
 - 408-8910
 - 408-9684
 - 409-35004

IMPORTANT

Once per year, or every 7,500 cycles (whichever comes first), the hydraulic head should be returned to TE for magnetic particle inspection.

Tools may also be returned for evaluation and repair. For tool repair service contact:

Americas : NAToolRepairs@te.com

Europe/Middle East/Africa : TEFE2@te.com

Asia Pacific : tfe1ap@te.com

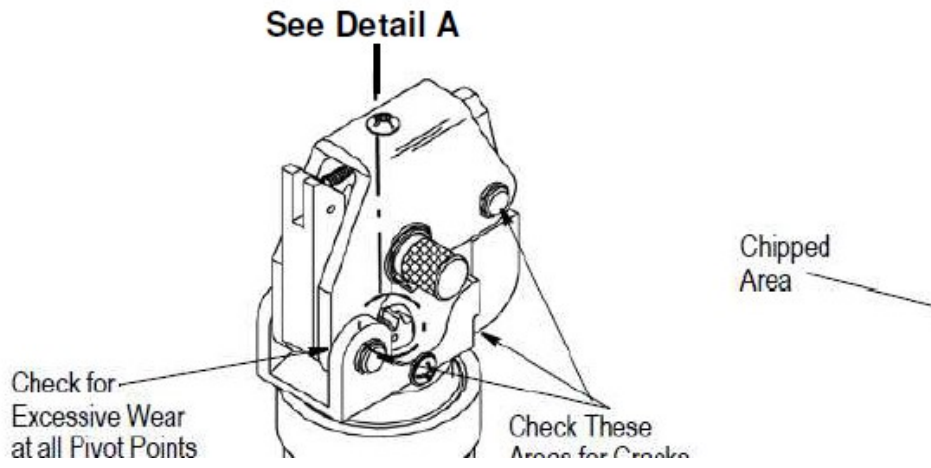


FIGURE 1. Inspection points for 69069 and 1673672 Hydraulic Tooling

Customer-replaceable parts are available. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary.

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