

New XCXY-01 Crimp Tool Instruction

GENERAL INFORMATION

The new XCXY-01 four-indent hand crimp tool is a wide range of crimping tools that can be used with the products of GJB standard and MIL standard series. It is applied to the cold-press connection of the wire and the contact in the electrical connector.

CRIMPING RANGE

CONTACTS: 10-20

WIRE SIZE: 10 AWG-26 AWG (5 mm²-0.128 mm²)

WORKING PRINCIPLES

1. Crimping Method

The crimp tool adopts curve propulsion mechanism, its applied force transfers through four curves in the head cavity of the right plier handle to the four indenters. The four indenters do the centripetal linear motion, which makes its front-end teeth crimp the contact to complete the crimping process. The cycle controlled precision ratchet assures the consistency of impression and the crimping quality of wires and contacts.

2. Crimping Range Adjustment

The crimp tool has a 10-position selector knob that accurately divides the crimping range into 10 positions. The accurate data is listed as follows:

Selector NO.	Intender Working Diameter mm/INCH	
	A(GO)	B(NO GO)
1	0.71/0.028	0.84/0.033
2	0.81/0.032	0.94/0.037
3	0.91/0.036	1.04/0.041
4	0.99/0.039	1.12/0.044
5	1.14/0.045	1.27/0.050
6	1.32/0.052	1.45/0.057
7	1.50/0.059	1.63/0.064
8	1.73/0.068	1.86/0.073
9	1.85/0.073	1.98/0.078
10	1.98/0.078	2.1/0.083

3. Crimp lock mechanism

The crimp tool has a self-locking function. When the crimping is not completed correctly, the locking mechanism functions, the crimp handle cannot be opened, and the crimping items cannot be taken out. When the crimping is properly completed, the locking mechanism is opened, and the crimp handle can be opened. The crimped items can be taken out and the crimping is completed.

If a large-diameter contact strayed into the crimp hole for crimping by mistake or the crimp hole is stuck by a hard object, continuing the crimp operation would make the indenters or other mechanical parts damaged. Please contact us at 0573-82326018. 13736819909).

PRODUCT CONFIGURATION



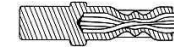
XCXY-01 crimp tool and matched turret positioner DWQ-01

RANGE OF APPLICATION

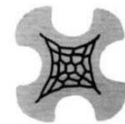
The internal through hole diameter of this tool is 6.5mm, and the maximum outer diameter of the applicable terminal should be less than 6.3mm.

This tool is suitable for crimping copper contacts. It cannot be used for other hard materials such as steel. If it is needed, it may cause damage or reduce the life.

CRIMP STYLE 4-indent 8-impression Crimping



Indentation section I



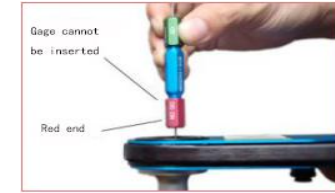
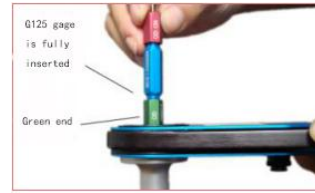
Indentation section II

GAGING INSTRUCTIONS

Set the XCXY-01 hand crimp tool to the 4th selector position and use the G125 (M22520/3-01)GO-NOGO Gage to test the tool.

"GO" Gaging: keep the tool in fully closed position, insert the green "GO" gage end of G125 into the indenters of XCXY-01 crimp tool, it should be easy to enter, otherwise, the selector gear is incorrect

"NO GO" Gaging: keep the tool in fully closed position, insert the red "NO GO" end of G125 into the indenters of XCXY-01 crimp tool, it can't pass through completely, otherwise, the selector gear is incorrect



Note: Operate the tool in fully closed position first, and then use the gage. DO NOT CRIMP THE GAGE!

POSITIONER SELECTION

1.Crimp connection of XC series contacts

Positioner model	DWQ-01											
	Ø1 (Red)				Ø1.5 (Blue)			Ø2、Ø3 (Yellow)				
Selector NO.	1	2	3	3	4	5	6	7	7	8	9	10
Pinhole specification	Ø1A	Ø1A	Ø1B	Ø1B	Ø1.5A	Ø1.5B	Ø1.5B	Ø2A	Ø2B	Ø3A	Ø3B	Ø3B
Crimping barrel outer diameter	Ø2.1				Ø2.8			Ø3.6		Ø4.6		
Crimping barrel inner diameter	Ø1.0		Ø1.3		Ø1.4	Ø1.8		Ø2.1	Ø2.5	Ø3.0	Ø3.4	
MIL wire AWG	22	20	20	18	18	16	14	14	12	12		10
GJB wire MM ²	0.35	0.5	0.5	0.75	0.75	1.5		2	3	4	5	

1.Crimp connection of XCA series contacts

Positioner model	DWQ-01											
	Ø1 (Red)				Ø1.5 (Blue)			Ø2、Ø3 (Yellow)				
Selector NO.	1	2	3	3	4	5	6	7	7	8	9	10
Pinhole specification	Ø1A	Ø1A	Ø1B	Ø1B	Ø1.5A	Ø1.5B	Ø1.5B	Ø2A	Ø2B	Ø3A	Ø3B	Ø3B
Crimping barrel outer diameter	Ø1.8		Ø2.1		Ø2.4	Ø2.8		Ø3.2	Ø3.6	Ø4.2	Ø4.6	
Crimping barrel inner diameter	Ø1.0		Ø1.3		Ø1.4	Ø1.8		Ø2.1	Ø2.5	Ø3.0	Ø3.4	
MIL wire AWG	22	20	20	18	18	16	14	14	12	12		10
GJB wire MM ²	0.35	0.5	0.5	0.75	0.75	1.5		2	3	4	5	

3. Application of MIL standard connector (One)

Selection Table of MIL wires and connector and contact models that suitable for M22520/1-02 (turret head TH1A) in 12, 16, 20# contact in M26482, M26518, M26500, M38300, M81659, M83733, M83723, M83527, M81703, AS5015, AS81714 series connectors :

CONTACT SIZE	POSITIONER AND MATING END COLOR	2 6	2 4	2 2	2 0	1 8	1 6	1 4	1 2	WIRE SIZE
20-20	RED	1	2	3	4					SELECTOR NO.
16-22	BLUE	1	2	3						
16-20*		1	2	3	4					
16-16					4	5	6			
12-16	YELLOW				4	5	6			
12-12								7	8	
MS3162&63 MS3192&93 MS18134&36 MS24254&55 MS90453&54 M39029/1, /2, /3, /4, /5, /9, /10, /11, /12 M83723/29, /30, /33, /34 *M39029/1-101 USE RED POS										

4. Application of MIL standard connector (Two)

Selection Table of MIL wires and connector and contact models that suitable for M22520/1-04 (turret head TH163) in 12, 16, 20# contact in M1760, M38999 series connectors :

MS27655 MS27490, 91,92,93,94	POSITIONER COLOR	24	22	20	18	16	14	12	WIRE SIZE
-20	RED	1	2	3					SELECTOR NO.
-16	BLUE			4	5	6			
-12	YELLOW						7	8	

5. Application of MIL standard connector (Three)

Selection Table of MIL wires and connector and contact models that suitable for TP positioner 1716P in 10# contact in M1760, M38999 series connectors :

Contact		10#(M39029/56-527,M39029/58-528)		
Wire size	mm2	3	4	
	AWG		12	10
SEL. No.		8	9	10