YJQ-H1Q Pneumatic Crimp Tool Instruction

GENERAL INFORMATION

YJQ-H1Q crimp tool is used to the crimping of the pin end and the pin body of twist pin, crimping of wires and pins as well as crimping of wires and sockets. The indenter impression length is 1.2mm, and the terminal crimped outer diameter is 0.90mm. This crimp tool can be fitted with different custom-made lifting positioners. The first piece of crimped sample should be subjected to the corresponding tensile test and electrical performance test. After the test is passed, mass production can be carried out.

CRIMPING RANGE

Selector No.	Intender Working Diameter mm
1	**0.35±0.05**
2	**0.40±0.05**
3	**0.45±0.05**
4	**0.50±0.05**
5	**0.55±0.05**
6	**0.60±0.05**
7	**0.65±0.05**
8	**0.70±0.05**

WORKING PRINCIPLES

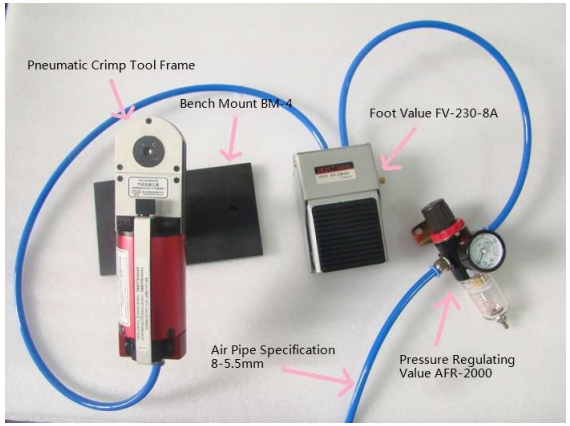
1. The crimp tool adopts curve propulsion mechanism, its applied force transfers through four curves in the head cavity of the right plier handle to the four indenters. The four intenders do the centripetal linear motion, which makes its front-end teeth crimp the contact to complete the crimping process. The cycle controlled precision ratchet assures the consistency of impression and the crimping quality of wires and contacts.
2.Ratchet and rack match up the self-locking mechanism ensure the accordance of each crimping. Lack of air pressure or short of air supporting time will cause the tool not be able to crimp properly, the press mould can not return to the correct place because of the self-locking mechanism. By adjusting air pressure or increase the air supporting time, the press mould will arrive to the correct place, the problem can be solved.
3. This crimping tool has eight working selections,the 1-8 selections is spaced 0.05mm apart for fine-tuning system errors and wear and tear.Firstly, take out the locking pin, lift up the select knob and rotate,make sure the pointer align with the desired selection, then put down the select knob, start crimping the contacts.
4. The crimp tool is equipped with a lifting positioner. The positioning core can be adjusted by the copper screw nut on the positioner. The thread pitch is 1mm, and the positioning height changes by 1mm per rotation for one week. Adjustment method: first screw the thread to the lower position, after placing the positioning core, the measuring core is far lower than the pressure block. At this time, the air source is turned on (the foot valve is recommended), so that the pressure block is closed, and the air is not released. In the case of the source, adjust the copper screw so that the positioning pin is raised to contact the clamp, and then adjust the screw in reverse. According to the thread pitch of 1mm, the depth can be calculated downward, and the adjustment screw will be tightened according to the product requirements. Locking, after the pressure test, the workpiece is measured to the size and the crimping is started.
5.Hand switch and foot treadle are two optional working ways (can not use together). To swift working ways, 1.5MMhexagonal wrench should be used. Adjust the M3 hexagon socket screw on the back of the crimper, which the arrow point to. Back out the screw until feel elastic force when press the hand switch, it is under hand switch working ;Screw in until feel no elastic force when press the hand switch, it is under foot treadle working. Please note: adjust the screw with slight strength.

CAUTIONS

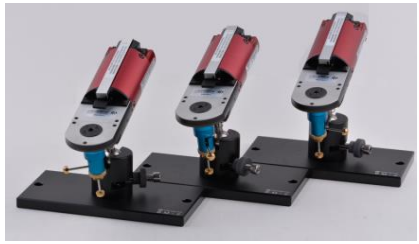
1. Do not crimp any hard steel material or not matched size contacts, please contact us if the tool get stuck by improper use.
2.When crimping , remember to retract positioning rod back to positioning hole, than crimp it ,otherwise the positioning rod will be damaged.
3.The working pressure can be applied at 3-4 atmospheres after actual testing.

CRIMPING INSTRUCTIONS

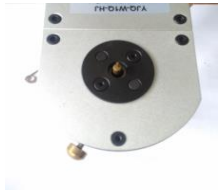
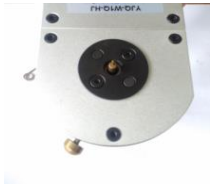
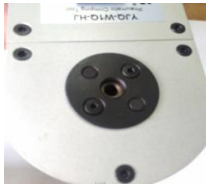
1. Connect all the parts according to the below pictures.



2.The crimping tool adapts HD series lifting positioners.Different contacts,different positioners.It contain a dials which has 8 selections to adjust the working diameters of the 4 indenters.(checkthe left table)



3. Crimping Instruction: firstly,stretch out the positioning rod above the crimping plane.Secondly,put the contact or twist pin into the positioning hole,retract positioning rod back to positioning hole.Thirdly, put wire. Finally,supply the air by foot treadle or manual button, release the foot treadle or manual button after the crimping complete. Take out the contact when the indenter back to the original position.

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