

GENERAL INFORMATION

Crimping tool model : YJQ-H2Q-1.5, applied to crimp jack socket and sheath. Dimension of jack socket : $\Phi 1.55$. Outer diameter of sheath: $\Phi 2.55$. Advice selector: SEL. 5.

Initial crimped item should be tested in tension and electric performance before batch production.

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 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. 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 crimp tool should be used with customized positioner that has a screw size with

5/16-24UNF and a 1.058mm positioning height change after rotation per circle. The locking screw should be tighten after adjustment according to the requirements of product and the crimped sample should be tested fully before batch crimping.

4. Hand switch and foot treadle are two optional working ways (can not use together). To swift working ways, 1.5MM hexagonal 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. The initial testing of NO and NO-GO gauge should be from the biggest selector (sel.8) and it can test the crimping range directly from the crimping diameter.

3. Working air pressure: 4.5-8MPA.

CRIMPING INSTRUCTIONS

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



2. The positioners (need to purchase separately) used in crimping tool M22520/7-01 can be applied to this crimping tool which has 8 selectors (normally use sel.5) to adjust the working diameter of four indenters. (instruction is on the left of this page)



3. Crimping instruction: firstly insert the contact and wire, 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.

