

## GENERAL INFORMATION

YJQ-X2Q is a pneumatic crimp tool applied to crimp the sheath of springwire socket and contact. The NO.4/4.5/5 stand for the outer diameter of the sheath to recognize the tool.

This tool is applied to crimp the sheath with outer diameter 4mm, 4.5mm, 5mm, and its corresponding selectors are sel.2, sel.5 and sel.8. Details are shown as the following:

Sel. NO.	GO	NO-GO	Explanation
Sel.1	<3.6mm		0.03-0.05mm smaller than sel. 2 for fine adjustment
Sel.2	3.60mm	3.70mm	applied to sheath with outer diameter 4mm
Sel.3	<b>not available</b>		
Sel.4	<4.1mm		0.03-0.05mm smaller than sel. 5 for fine adjustment
Sel.5	4.10mm	4.20mm	applied to sheath with outer diameter 4.5mm
Sel.6	<b>not available</b>		
Sel.7	<4.6mm		0.03-0.05mm smaller than sel. 8 for fine adjustment
Sel.8	4.60mm	4.70mm	applied to sheath with outer diameter 5mm

Indentation width: 0.6mm, length: 1.2mm. Indenter working diameter: 8mm.

## WORKING PRINCIPLES

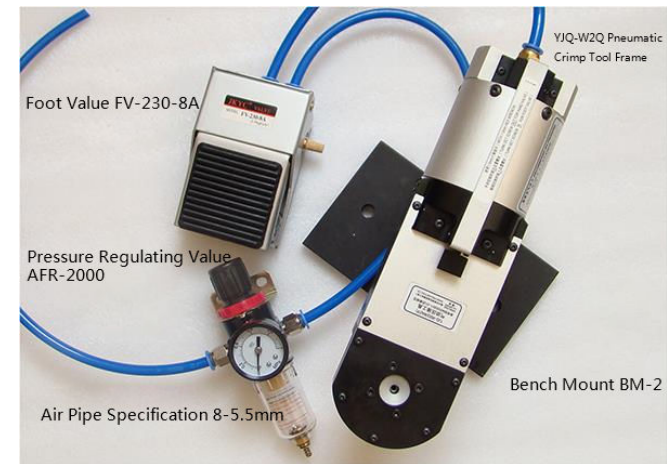
- The crimp tool adopts curve propulsion mechanism, its applied force transfers through four curves in the head cavity of the right plier handle to the four indenters. The four indenters do the centripetal linear motion, which makes its front-end teeth crimp the contact to complete the crimping process. The cycle controlled precision ratchet assures the consistency of impression and the crimping quality of wires and contacts.
- 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.
- This crimp tool should be used with universal positioner that contain a raised positioning core to facilitate positioning and has a screw size with M10\*1 and a 1mm positioning height change after rotation per circle. The locking screw should be tightened after adjustment according to the requirements of product and the crimped sample should be tested fully before batch crimping.
- 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

- Do not crimp any hard steel material or not matched size contacts, please contact us if the tool get stuck by improper use.
- This tool is suitable for crimping three kinds of sheaths, which is equipped with fine adjustment selectors. The sel. 3 & 6 can't use due to the large span of the selectors.
- Working air pressure: 4.5-7MPA.

## CRIMPING INSTRUCTIONS

Connect all the parts according to the below picture.



Note: the model of foot treadle has been updated