

## 1. GENERAL INFORMATION

YJQ-W2JQ pneumatic crimp tool is compatible with the M22520/1-01 which is widely used for the crimping of wires and contacts in electronic connectors. Thru-hole Diameter:  $\Phi 6.80\text{mm}$

### CRIMP RANGE

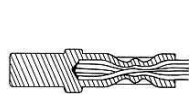
CONTACTS : 12-20

Wire crimp range: 12 AWG -26AWG (  $3.33\text{mm}^2\text{-}0.128\text{mm}^2$  )

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



**Crimping Sample**



Crimp Section View 1



Crimp Section View 2

## 2. 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 has eight working selections. 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. 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.

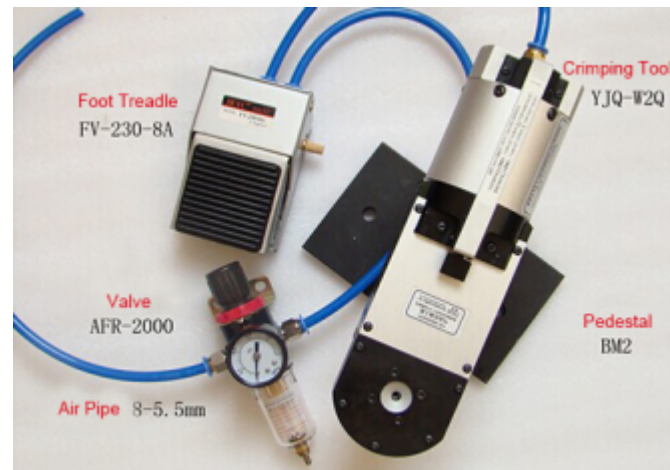
## 3. CAUTIONS

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. Working air pressure: 80-120 P.S.I. Max air pressure: 120P.S.I. ( 5.5-8.3BAR )

## 4. CRIMPING INSTRUCTIONS

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



2. Adjustable positioner is not removable; It contains a dial which has 8 selections to adjust the working diameters of the 4 indenters. ( check the left table )



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.

