

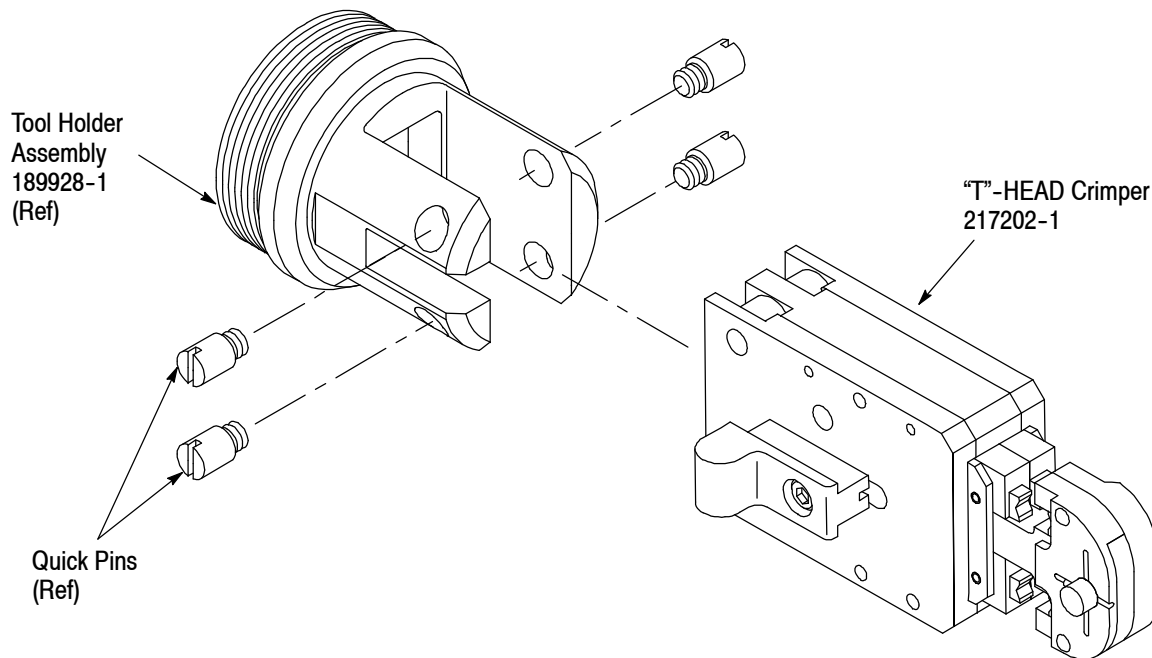


Figure 1

1. INTRODUCTION

“T”-HEAD Crimper 217202-1 is designed to crimp PIDG* and PLASTI-GRIP* terminals on wire sizes 22-14 AWG. The crimper is used with 626 Pneumatic Tooling Assemblies 189721-1, 189722-1, 189723-1, and 189724-1. For information concerning the setup and operation of the pneumatic tools, refer to Customer Manual 409-5862.

This instruction sheet provides:

- Installation and removal of the crimper from the tool holder assembly.
- Maintenance, inspection, and repair information for the crimper.

For information concerning wire preparation, crimping procedures, and crimp inspection, refer to the associated instructions supplied with the terminals.

Read these instructions thoroughly before proceeding.

NOTE



Measurements are in metric units [followed by U.S. customary units in brackets]. Figures and illustrations are not drawn to scale and are for reference only.

2. DESCRIPTION (Figure 1)

The “T”-HEAD Crimper attaches (via four quick pins) to the tool holder assembly of the pneumatic power unit. When actuated, a cam extends through the tool holder into the crimper, driving an internal, roller-guided envelope. The other end of this mechanism is connected to an anvil and, as the cam pushes against the roller-guided envelope, the anvil moves in a straight line and bottoms against a stationary indenter. When the cam of the pneumatic tool retracts, the force is removed from the envelope.

The envelope must then be manually retracted by use of a plastic slide switch. The plastic slide switch permits opening and closing of the anvil for insertion and removal of terminals or splices.

3. INSTALLATION AND REMOVAL OF CRIMPER (Figure 1)

Before installing the crimper, refer to Customer Manual 409-5862 for instructions on installing the appropriate tool holder assembly (including cam) on the pneumatic tool. After the appropriate tool holder assembly has been installed, proceed as follows:

NOTE



Removal is the reverse of installation.

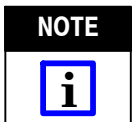


To prevent personal injury, ALWAYS disconnect the main air supply and electrical supply (if applicable) of the pneumatic tool before installing or removing the crimper.

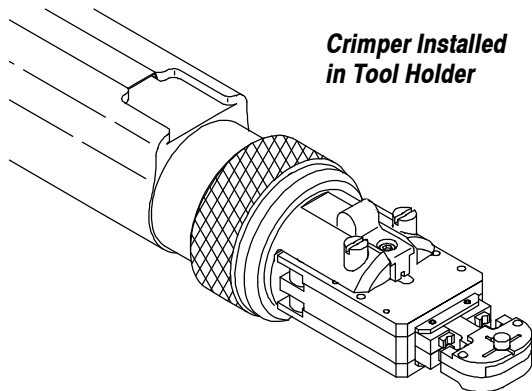


DO NOT operate pneumatic tool without the crimper assembly installed. After crimper is installed, verify that the quick pins are FULLY tightened to avoid personal injury and damage to the tool.

1. Remove quick pins from tool holder assembly. Refer to Figure 1.
2. Slide the crimper into tool holder assembly, aligning the threaded holes on the crimper with the quick pin holes on the tool holder.
3. After crimper is properly aligned in the tool holder assembly, insert and tighten the quick pins. Refer to Figure 2.



Tyco Electronics recommends using Loctite† No. 242 removable threadlock, or equivalent, to prevent the quick pins from loosening.



**Crimper Installed
in Tool Holder**

Figure 2

4. MAINTENANCE AND INSPECTION

Tyco Electronics recommends that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations.



To avoid personal injury, ALWAYS disconnect the main air supply and electrical supply (if applicable) of the pneumatic tool system before performing maintenance or inspection.

4.1. Daily Maintenance

Tyco Electronics recommends that each operator be responsible for the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a lint-free cloth. DO NOT use objects that could damage the crimper.
2. Make sure that all pins, rings, and other components are in place and secure.
3. Make certain all surfaces are protected with a thin coat of any good SAE 20 motor oil. DO NOT oil excessively.
4. When the crimper is not in use, store it in a clean, dry area.

4.2. Periodic Inspection

Regular inspections should be performed by quality-control personnel. A record of scheduled inspections should remain with the crimper or be supplied to supervisory personnel responsible for the crimper. Though recommendations call for at least one inspection a month, the frequency should be based on amount of use, working conditions, operator training and skill, and your established company policies. These inspections should include a visual inspection as described in Paragraph 4.3.

4.3. Visual Inspection

1. Remove all lubrication and accumulated film by immersing the crimper in a suitable commercial degreaser that will not affect paint or plastic.
2. Make certain all components are in place. If replacements are necessary, refer to Paragraph 6, REPLACEMENT AND REPAIR.
3. Check all bearing surfaces for wear. Replace worn parts.

4.4. Lubrication

Lubricate all pins, pivot points, and bearing surfaces with a high quality grease. Tyco Electronics recommends the use of Molykote● grease, which is a commercially available lubricant. Lubricate according to the following schedule:

- Crimper used in daily production – lubricate daily
- Crimper used daily (occasional) – lubricate weekly
- Crimper used weekly – lubricate monthly

†Trademark of Loctite Corporation

●Trademark of Dow Corning Corporation

5. CRIMPER DISASSEMBLY AND ASSEMBLY

These instructions provide disassembly and assembly procedures which are to be used whenever internal parts of the crimper are to be replaced.

5.1. Disassembly (Refer to Figure 3)

1. Obtain a 12.7 mm [.50 in.] thick wooden block with a surface area large enough to accommodate the crimper. Lay the flat side of the crimper (side opposite the plastic slide switch) on the work surface of the block. Mark the block at the approximate locations of the two slotted spring pins on each side of the crimper. At the marks, drill two 1/4-inch holes through the wooden block. The holes will facilitate driving the slotted spring pins out the bottom of the crimper.
2. Reposition the crimper on the block so the slotted spring pins line up with the holes in the block. Using a 1/8-inch punch, drive the slotted pins approximately 6.35 mm [.250 in.] through the crimper housing.
3. Remove the shoulder screw which secures the plastic slide switch to the internal envelope and remove the plastic slide switch.
4. Remove the four shoulder cap screws and the four spring washers which secure the two outer housings to the center housing, then remove the outer housing.

5.2. Assembly (Refer to Figure 3)

1. Properly assemble internal parts, using Figure 3 as a guide, and position the roller-guided envelope assembly in the center housing.

2. Replace outer housing and secure with the four shoulder cap screws (with spring washers). DO NOT tighten screws.
3. Position the plastic slide switch so that the protruding slotted spring pin fits into the slide groove on the bottom of the switch. Then slide the switch to align its mounting hole with the hole in the envelope.
4. Insert the shoulder screw through the plastic switch into the hole in the envelope and tighten the screw.
5. Tighten the four shoulder cap screws.
6. Using a bench vice, press the two slotted spring pins back into the housing.

6. REPLACEMENT AND REPAIR

Replacement parts and recommended spares are listed in Figure 4. The recommended spares should be stocked for immediate replacement. Replacement parts can be ordered from:

CUSTOMER SERVICE (38-35)
 TYCO ELECTRONICS CORPORATION
 P.O. BOX 3608
 HARRISBURG, PA 17105-3608

For further repair and replacement information, call the Tooling Assistance Center at 1-800-722-1111.

7. REVISION SUMMARY

- Updated document to corporate requirements
- Added ORIGINAL INSTRUCTIONS

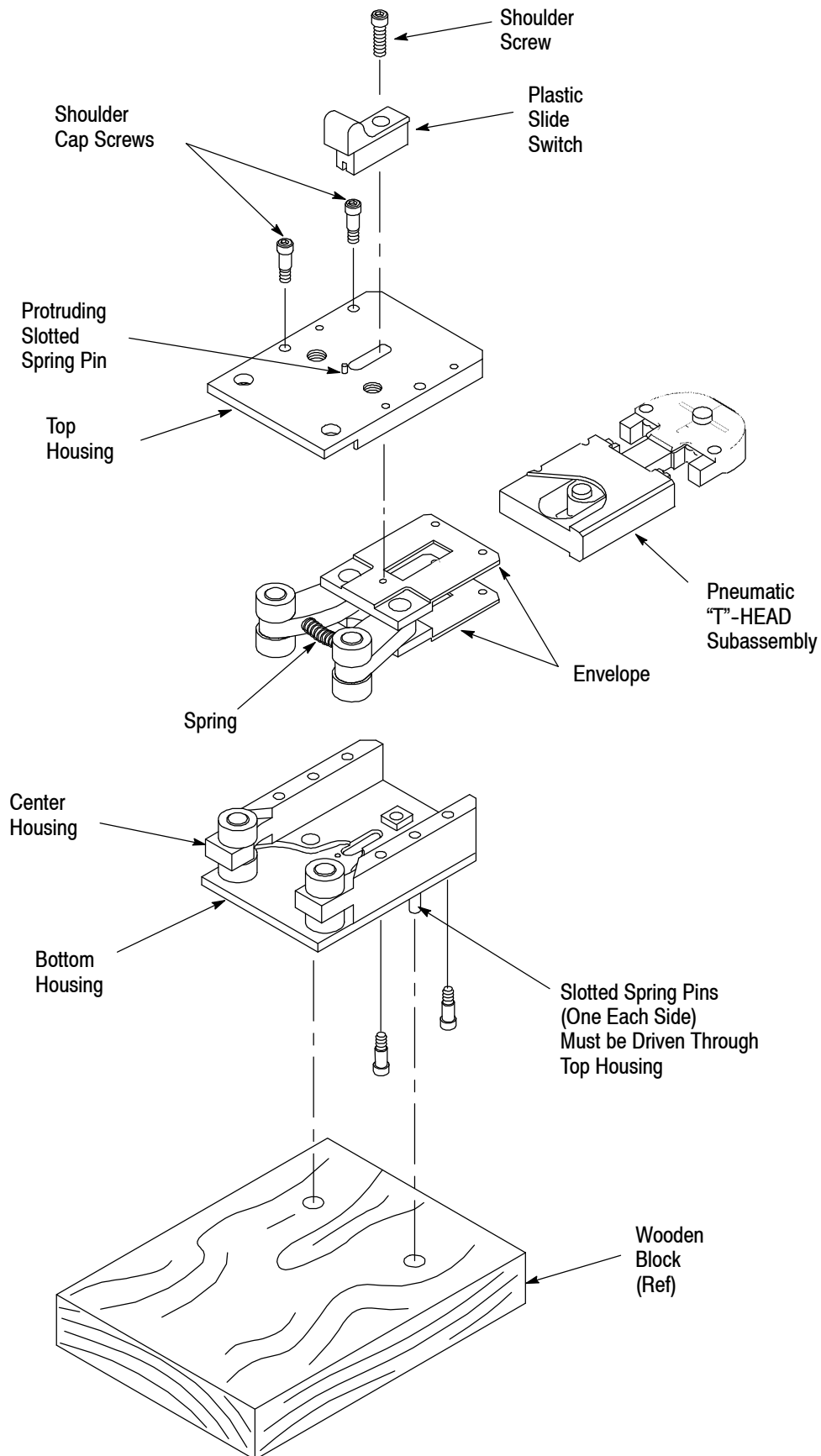
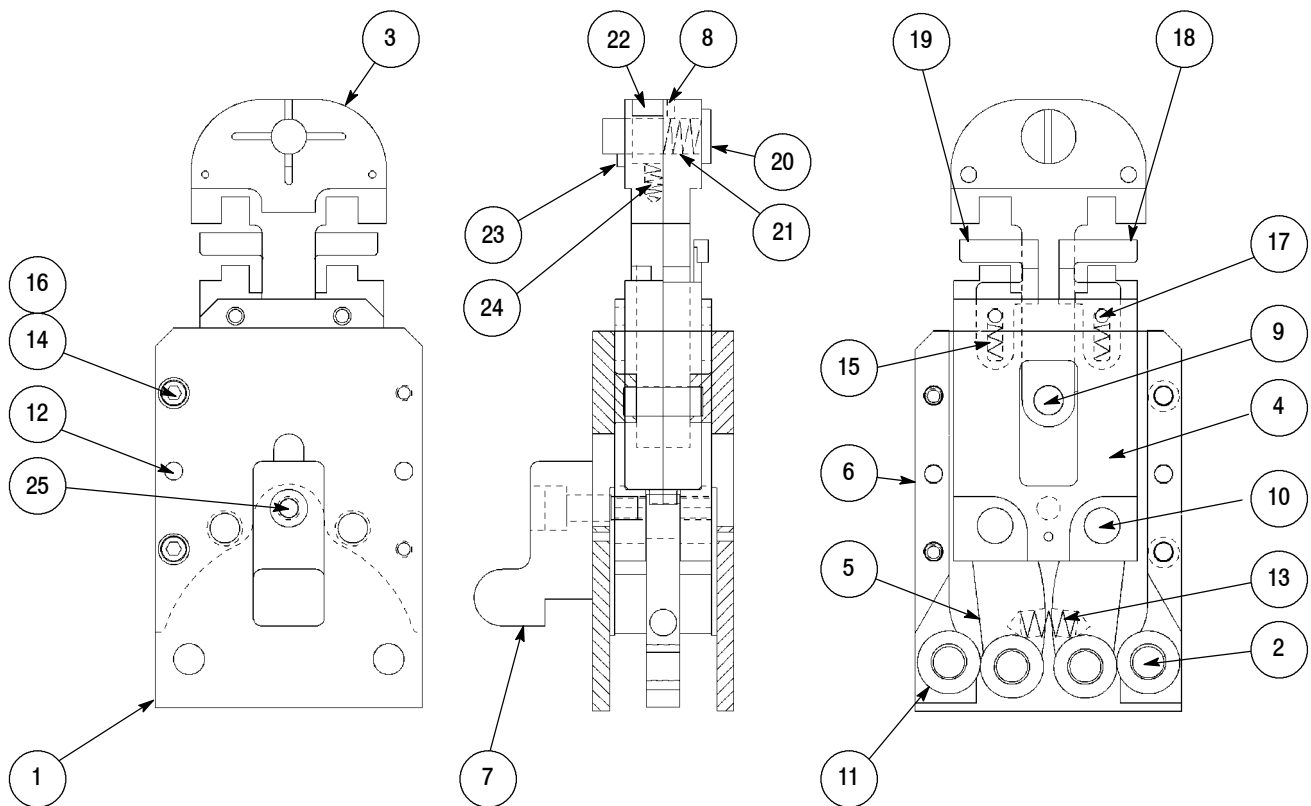


Figure 3



REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER ASSY
1	224472-1	HOUSING	2
2■	217347-1	PIN, Fixed	2
3	224471-1	PNEUMATIC T-HEAD SUBASSEMBLY	1
4	224474-1	ENVELOPE	2
5	217343-1	LINK	2
6	224473-1	CENTER, Housing	2
7	224475-1	SWITCH	1
8■	1-21010-9	SCREW, Set 4-40 x .125	1
9	303679	PIN	1
10■	318570-1	PIN, Stepped	2
11■	314479-4	ROLLER	8
12	5-21028-9	PIN, Slotted Spring .125 x 1.00	2
13■	3-22279-8	SPRING	1
14	6-21000-8	SCREW, Shoulder 4-40 x .88	4
15	302389	SPRING	2
16	21024-2	WASHER, Spring Lock #4	4
17	3-21028-3	PIN, Slotted Spring .094 x .312	2
18	1-304052-9	LOCATOR, Stop	1
19	2-304052-0	LOCATOR, Stop	1
20	301973	PIN, Adjustment	1
21	301977	SPRING	1
22	47664-3	INSERT, Indenter, Insulation	1
23	21028-3	PIN, Slotted Spring .062 x .312	1
24	301974	SPRING	1
25	1-21000-3	SCREW, Shoulder 4-40 x .250	1

■Recommended Customer Spares

Figure 4