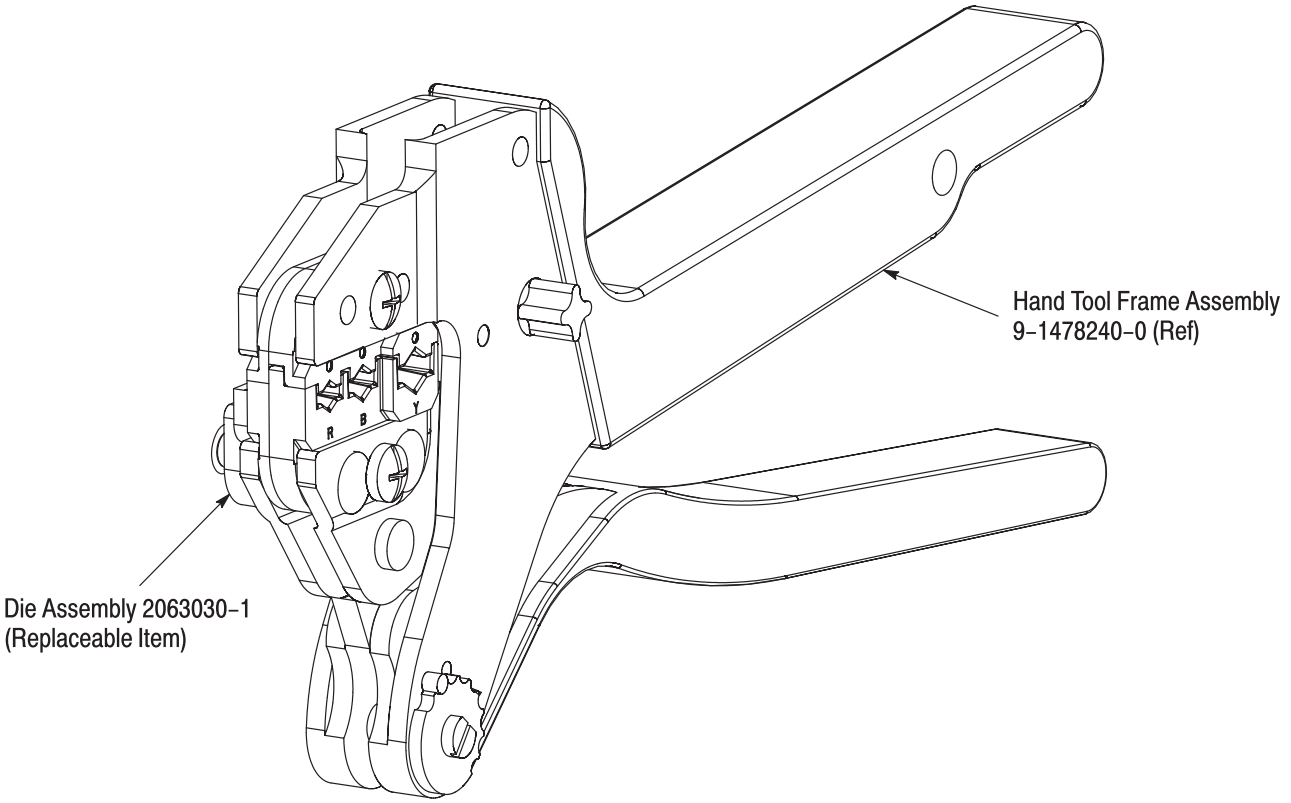
PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.



TERMINAL/STRIP LENGTH INFORMATION

PRODUCT LINE	WIRE SIZE RANGE, AWG	INSULATION DIAMETER (MAX.)	INSULATION COLOR	STRIP LENGTH	
				MINIMUM	MAXIMUM
PIDG or PLASTI-GRIP Terminals	22-16	3.56 [.140]	Red	5.15 [.203]	5.95 [.234]
	16-14	4.32 [.170]	Blue	5.15 [.203]	5.95 [.234]
	12-10	6.35 [.250]	Yellow	7.94 [.312]	8.73 [.344]
PIDG FASTON* Terminals	22-18 Flag	3.56 [.140]	Red	8.33 [.328]	9.14 [.360]
	16-14 Flag	4.32 [.170]	Blue	8.33 [.328]	9.14 [.360]

Figure 1

1. INTRODUCTION

This instruction sheet provides application and maintenance procedures for the Premium RBY Die Set and Locator Assembly 2063030–1 for PIDG and PLASTI–GRIP Red / Blue / Yellow Terminals. See Figure 1.

The die set is designed to crimp PIDG and PLASTI–GRIP terminals onto pre–stripped wire.

Read these instructions thoroughly before crimping any terminals.

NOTE

All dimensions are in millimeters [with inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.

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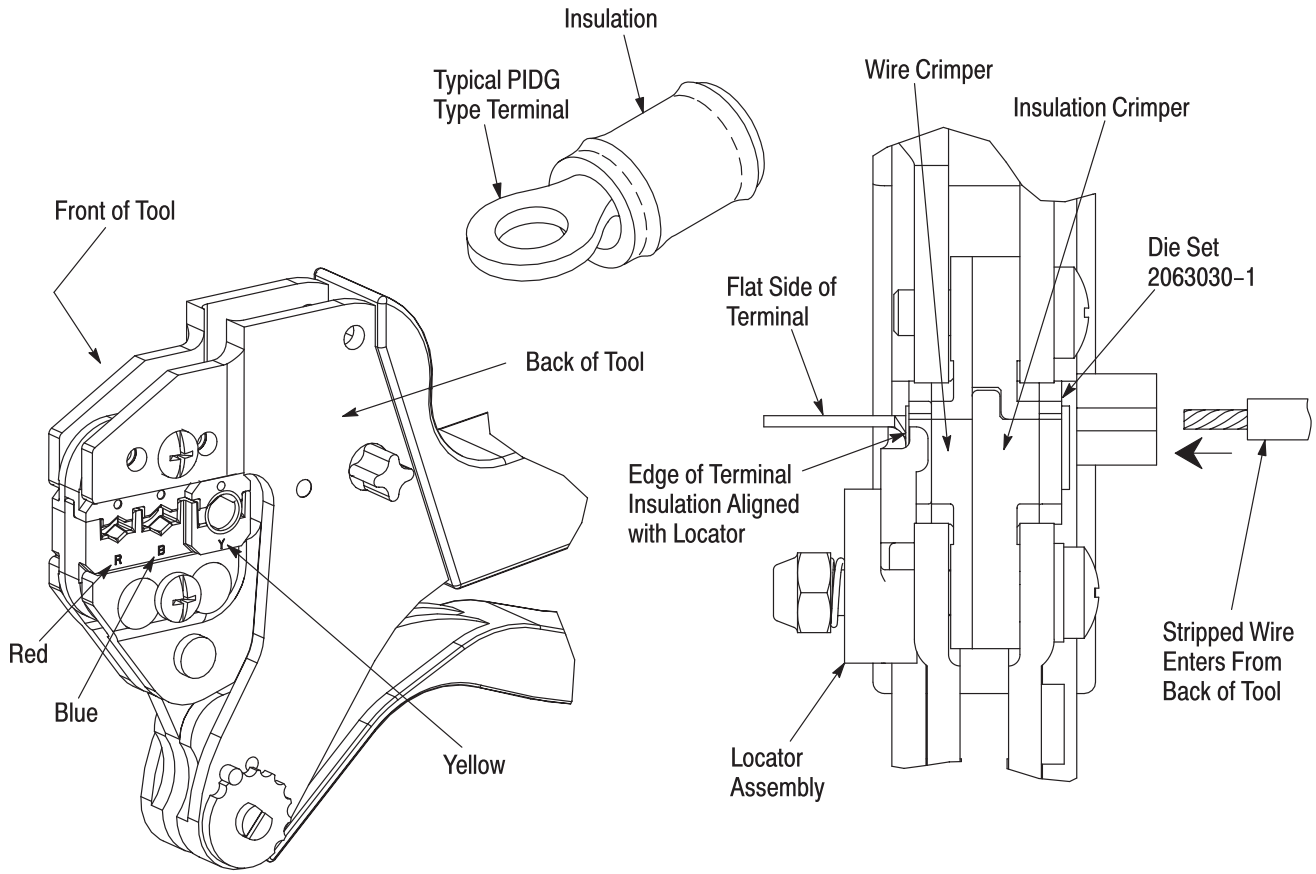


Figure 2

2. DESCRIPTION (Figure 1)

The die set is a replaceable die assembly with three crimping areas which are marked with the letters R,B, and Y. The letter corresponds to the insulation color of the terminal (Red, Blue, or Yellow) to be crimped in the crimping area. This die set can be used in the tools listed in Figure 4. Refer to the instructions packaged with the tools for die installation/removal and tool operation procedures.

3. CRIMPING PROCEDURE (Figure 2)

1. Strip wire to proper length. See Figure 1.
2. Choose desired terminal and match insulation color to crimping area letter.
3. Place terminal in the appropriate crimping chamber between the locator assembly and the upper die. Make sure that the flat side of the terminal faces up. See Figure 2.
4. Terminal should be positioned in tool so that wire enters from the BACK of the tool.
5. Close tool handles until terminal is held in dies without deforming wire barrel.
6. Place stripped wire in terminal wire barrel and squeeze handles until ratchet releases.

CAUTION

Damaged terminals may not be used. If a terminal has been damaged during termination, it must be cut from the wire and replaced with a new one.

4. MAINTENANCE AND INSPECTION

4.1. Daily Maintenance

It is recommended that operators of the die set be made aware of, and responsible for, the following steps of daily maintenance:

1. Remove dust, moisture, and any other contaminants from the die with a clean, soft brush, or a clean, soft, lint–free cloth. Do NOT use hard or abrasive objects that could damage the die.
2. Make certain that the retaining pins are in place and that they are secured with retaining rings.
3. All pins, pivot points, and bearing surfaces should be protected with a thin coat of any good SAE 20 motor oil. Do not oil excessively.
4. When the tool is not in use, keep handles closed to prevent objects from becoming lodged in the crimping jaws. Store the tool in a clean, dry area.

4.2. Periodic Inspection

Regular inspections of the die should be performed by quality control personnel. A record of scheduled inspections should remain with the die or be supplied to supervisory personnel responsible for the die. Inspection frequency should be based upon amount of use, working conditions, operator training and skill, and established company standards.

4.3. Visual Inspection

1. Remove all lubrication and accumulated film by immersing the tool (handles partially closed) in a suitable commercial degreaser that will not affect paint or plastic material.

2. Make certain that all retaining pins are in place and secured with retaining rings.

3. Close tool handles until ratchet releases and then allow them to open freely. If they do not open quickly and fully, the spring is defective and must be replaced. Refer to the instructions packaged with the tool.

4. Inspect the tool frame for wear or damage, paying particular attention to the tool jaws and pivot points. If damage is evident, refer to the instructions packaged with the tool for replacement of parts. If tool is acceptable, lubricate and return to service.

5. Check the crimping dies occasionally to make sure dies are not broken or chipped. If damage is evident, refer to Paragraph 6, PARTS REPLACEMENT.

5. MEASURING DIE OPENING

The die assembly will perform correctly as long as:

- The product specified is correct for the application.
- The specific die assembly is used.
- The die assembly has been measured to ensure that the openings are correct.
- The tool has been adjusted correctly.

Figure 3 provides information on die opening sizes.

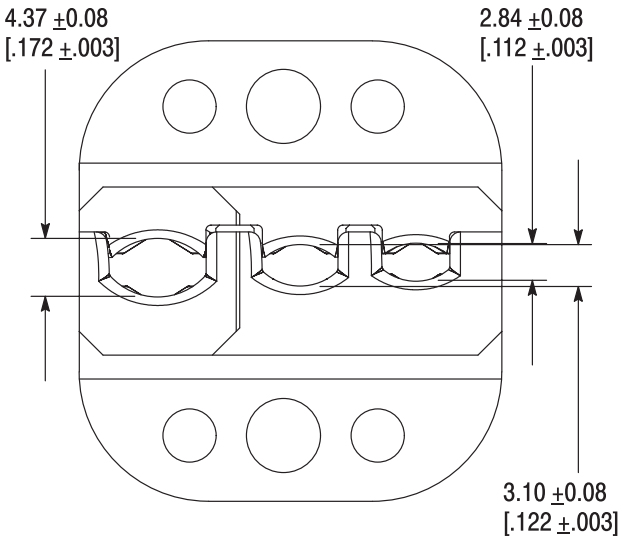


Figure 3

6. PARTS REPLACEMENT

Customer–replaceable parts are shown in Figure 1. If the dies are damaged or worn excessively, they must be replaced. Order the replaceable parts through your Tyco Electronics Representative, or call 1–800–526–5142, or send a facsimile of your purchase order to 1–717–986–7605, or write to:

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

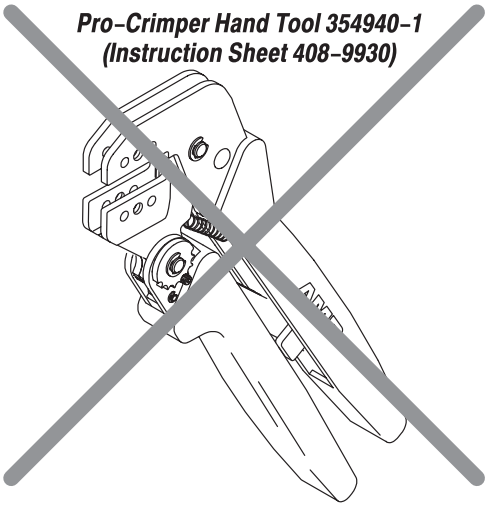
For tool repair service, please contact a representative at 1–800–526–5136.

7. REVISION SUMMARY

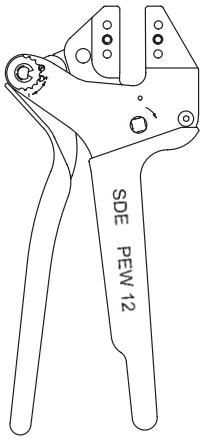
- Initial release of document

Die Set and Locator Assembly 2063030–1 Can be Used in Tools Show Below

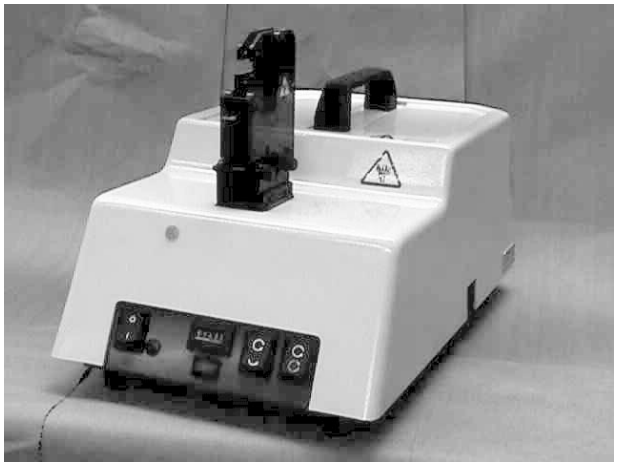
Pro–Crimper Hand Tool 354940–1
(Instruction Sheet 408–9930)



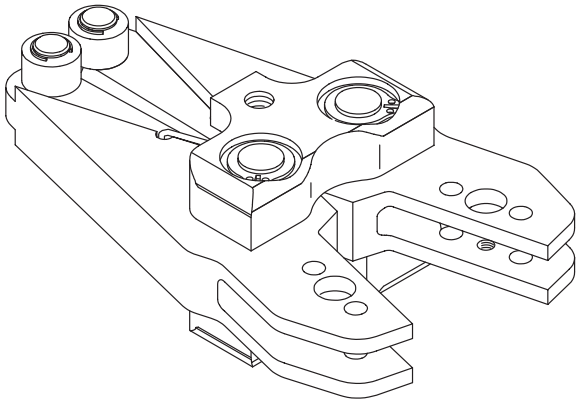
SDE PEW–12 Hand Tool 9–1478240–0
(Instruction Sheet 408–8851)



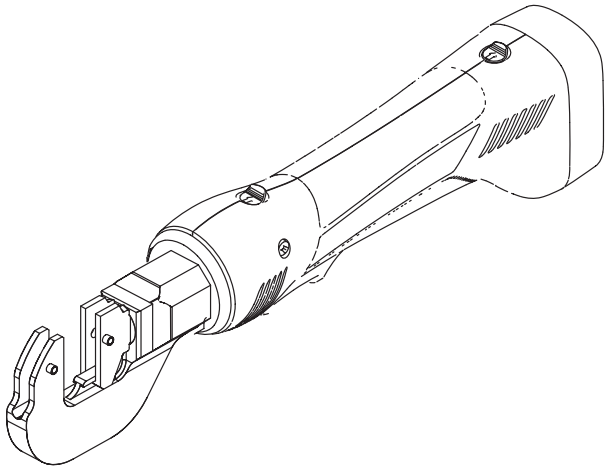
SDE Bench Terminator 1490076–2
(Customer Manual 409–10052)



626 Adapter 679304–1
(Instruction Sheet 408–4070)



Battery Tool (Shouldered Die) 1725837–1, –2
(Customer Manual 409–10053)



Battery Tool (Pin Die) 1213890–1, –2
(Customer Manual 409–10065)

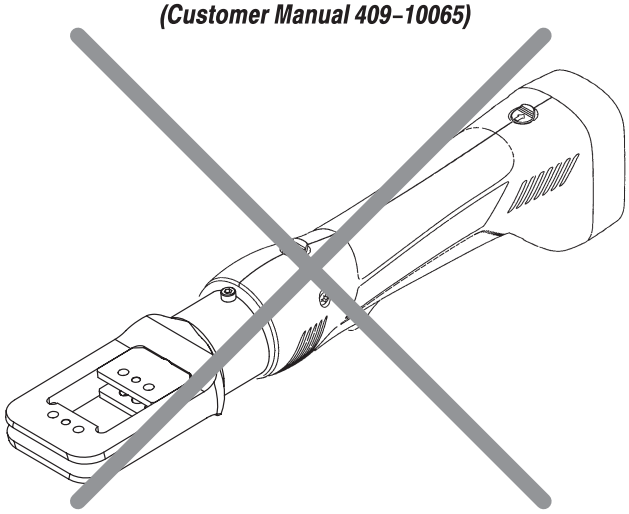


Figure 4