

Figure 1

## 1. INTRODUCTION

The CERTI-CRIMP II Tool Holder Assembly 1213860-1 is used to adapt the crimping head from a CERTI-CRIMP II Hand Tool to an SDE Electric Bench Terminator. Figure 1 shows a typical crimping head, mounted to CERTI-CRIMP II Tool Holder Assembly 1213860-1, installed onto an SDE Electric Bench Terminator.

**NOTE**



*Figures and illustrations are for reference only, and are not to scale.*

This instruction sheet provides:

- Instructions for installing and removing the tool holder assembly to the Electric Bench Machine
- Instructions for installing the crimping head onto the tool holder assembly
- Instructions for adjusting the crimp height
- Maintenance, inspection, and repair instructions for the tool holder assembly

For information concerning the setup and operation of the SDE Electric Bench Terminator, refer to customer manual 409-10052.

Read this instruction sheet, and the related customer manual, thoroughly before using the tool holder assembly.

## 2. DESCRIPTION

The tool holder assembly facilitates the connection of the crimping head to the SDE Electric Bench Machine and provides the necessary straight line motion of the movable die when the SDE Electric Bench Machine is actuated.

The tool holder assembly features a switch (handle) and three quick pins. See Figure 2. The switch (handle) can be used to manually open and close the dies of the crimping head for insertion and removal of the product.

The two outer quick-release pins secure the outer tabs of the crimping head to the tool holder assembly, and the center quick-release pin secures the the movable die of the crimping head to the internal spring-loaded switch of the tool holder assembly.

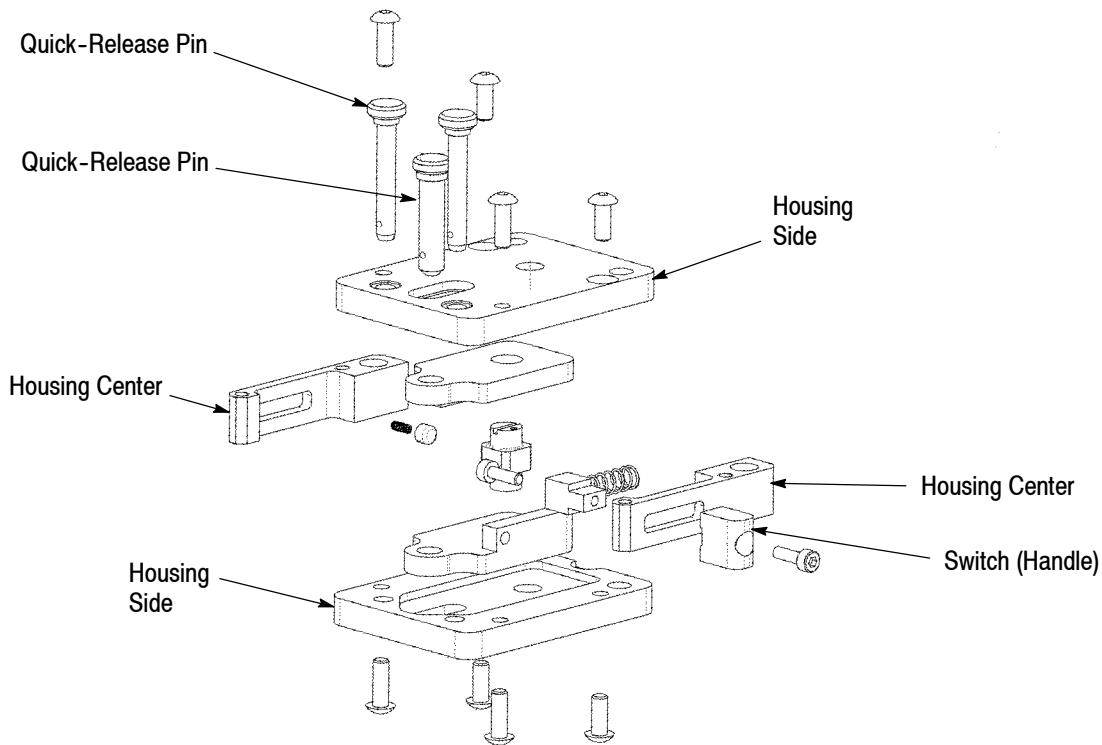



Figure 2

### 3. INSTALLATION AND REMOVAL

#### 3.1. Installation and Removal of the CERTI-CRIMP II Tool Holder Assembly 1213860-1


##### A. Installation

Before mounting the CERTI-CRIMP II Tool Holder Assembly, always make sure the guide ram of the terminator is in the lowest position. See Figure 3.

**DANGER**  To avoid personal injury, be sure the SDE Electric Bench Terminator is disconnected from the power source prior to the installation or removal of the tool holder assembly.


1. Be sure that the terminator has been switched off.
2. Be sure that the CERTI-CRIMP II tool holder assembly is mounted with the switch (handle) in the front, to facilitate die opening and closing.
3. Mount the tool holder assembly from the back and lock with the guide (safety) pins. Refer to Figure 3 and Figure 4.
4. Refer to Paragraph 3.2, to remove and install the crimping dies.

##### B. Removal

**DANGER**  To avoid personal injury, be sure the SDE Electric Bench Terminator is disconnected from the power source prior to the installation or removal of the tool holder assembly.

1. Be sure the terminator has been switched “off.”
2. Remove the locating pins from the tool holder assembly.
3. Remove and/or replace the tool holder assembly.
4. When removing the tool holder assembly, make sure that the guide ram of the terminator is in the lowest position.
5. If installing or removing crimping dies, refer to Paragraph 3.2.

#### 3.2. Installation and Removal of CERTI-CRIMP II Crimping Heads

**DANGER**  To avoid personal injury, be sure the SDE Electric Bench Terminator is disconnected from the power source prior to the installation or removal of the crimping heads.

As supplied, the tool holder assembly has three quick-release pins installed (Figure 2 and Figure 4 ). The two outer pins will be used to secure the two outer housing tabs of the crimp head (exposed portion of the crimp head) to the tool holder assembly.

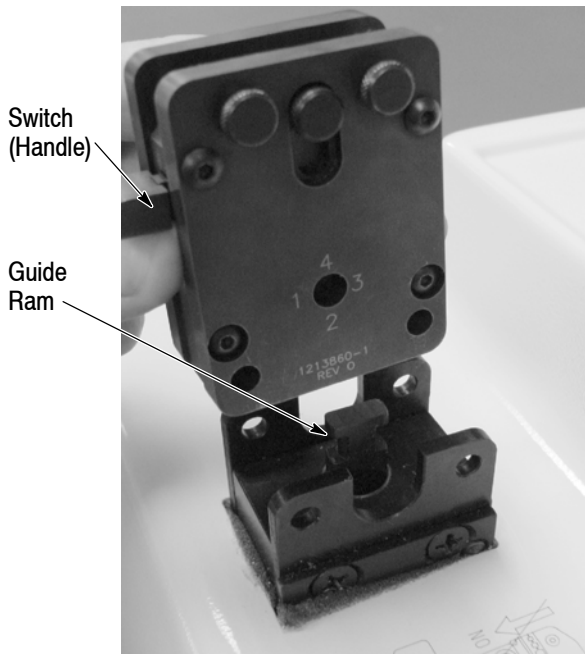


Figure 3

The center pin will be used to secure the movable die of the crimp head to the ram of the tool holder assembly.

1. Remove the quick-release pins shown in Figure 4.
2. Insert the exposed portion of the crimping head into the tool holder assembly cavity.
3. Insert the two outer quick-release pins through the holes in the tool holder assembly, and through the holes in the two outer tabs of the crimping head.

**NOTE** *The outer quick-release pins will “snap” into position when they are properly inserted.*

4. Insert the center quick-release pin into the tool holder assembly and through the holes in the ram and the moveable die of the crimp head.

**NOTE** *The center quick-release pin will “snap” into position when it is properly inserted.*

The finished assembly should appear as shown in Figure 5.

**B. Removal**

To remove the crimping head, it will be necessary to remove the three quick-release pins, and then remove the crimp head from the tool holder assembly.

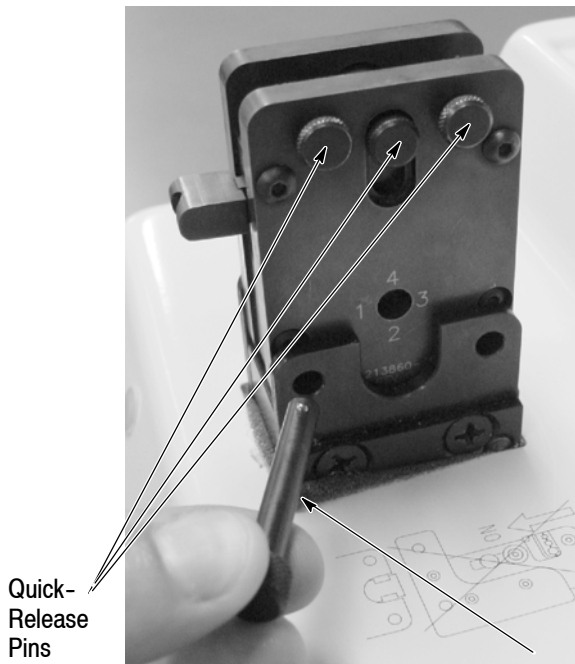


Figure 4

**A. Installation**

These pins must be removed prior to installing the crimping head.

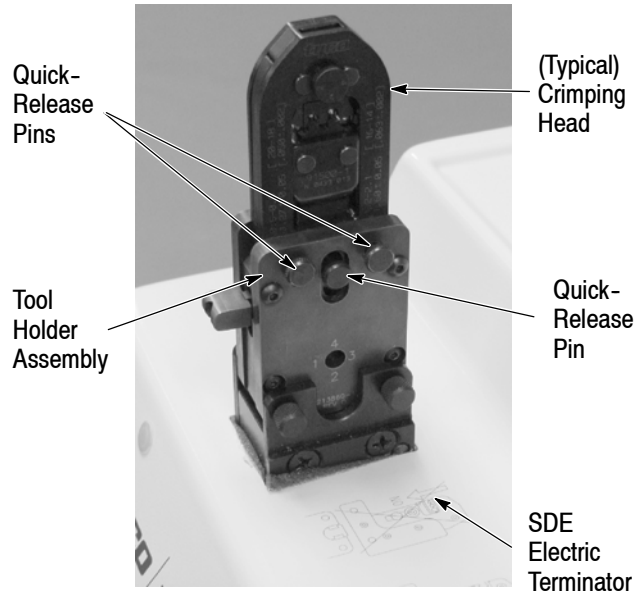


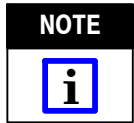
Figure 5

**4. CRIMP HEIGHT ADJUSTMENT**

Crimp height adjustment is required only if the crimp height listed in the Tyco Electronics die specification is not achieved.

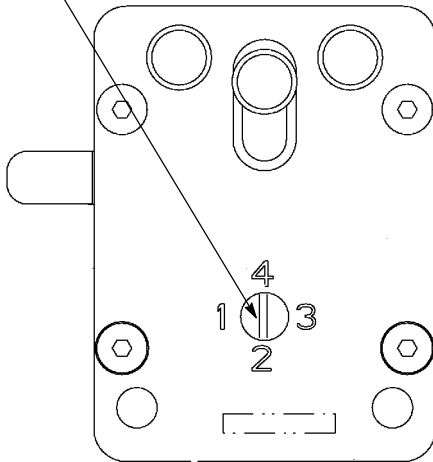
Adjust the crimp height with a flat-bladed screwdriver.

There are four different crimp heights. Refer to Figure 6.



Although Tyco Electronics normally recommends Position No. 2 (adjustment of the manufacturer), Positions No. 3 and No. 4 increase the travel of the tool head, which decreases the crimp height. Position No. 1 decreases the the travel of the head, which increases the crimp height.

Use a Flat-Bladed Screwdriver



Crimp Height Adjustment  
(One Step Equals 0.1mm [.004 In.])

Figure 6

**5. OPERATION**

The tool holder assembly is used with the SDE Electric Bench Terminator and a CERTI-CRIMP II Crimping Head. For operating instructions, refer to Customer Manual 409-10052.

**6. PREVENTIVE MAINTENANCE AND INSPECTION**

It is recommended that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations.



To avoid personal injury, ALWAYS DISCONNECT the SDE Electric Bench Terminator before performing maintenance or inspection.

**6.1. 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 adapter.
2. Make sure that all 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 tool holder assembly is not in use, store it in a clean, dry area.

**6.2. Lubrication**

Lubricate all pins, pivot points, and bearing surfaces with a high quality grease. It is recommended using Molykote paste which is a commercially available lubricant. Lubricate according to the following schedule:

- If the tool holder assembly is used daily—lubricate daily
- If the tool holder assembly is used occasionally—lubricate weekly
- If the tool holder assembly is used weekly—lubricate monthly

**6.3. Visual Inspection**

Regular inspections should be performed by quality-control personnel. A record of scheduled inspections should remain with the tool holder assembly or be supplied to personnel responsible for the tool holder assembly. 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 established company policies.

1. Remove all lubrication and accumulated film by immersing the tool holder assembly in a suitable commercial degreaser that will not affect paint or plastic.
2. Make certain all components are in place.
3. Check all bearing surfaces for wear. Replace any worn parts. If replacements are necessary, refer to Section 7, REPLACEMENT AND REPAIR.

**7. REPLACEMENT AND REPAIR**

Customer-replaceable parts are listed in Figure 7.

A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Parts other than those listed should be replaced by Tyco Electronics to ensure quality and reliability. Order replacement parts through your Tyco Electronics Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

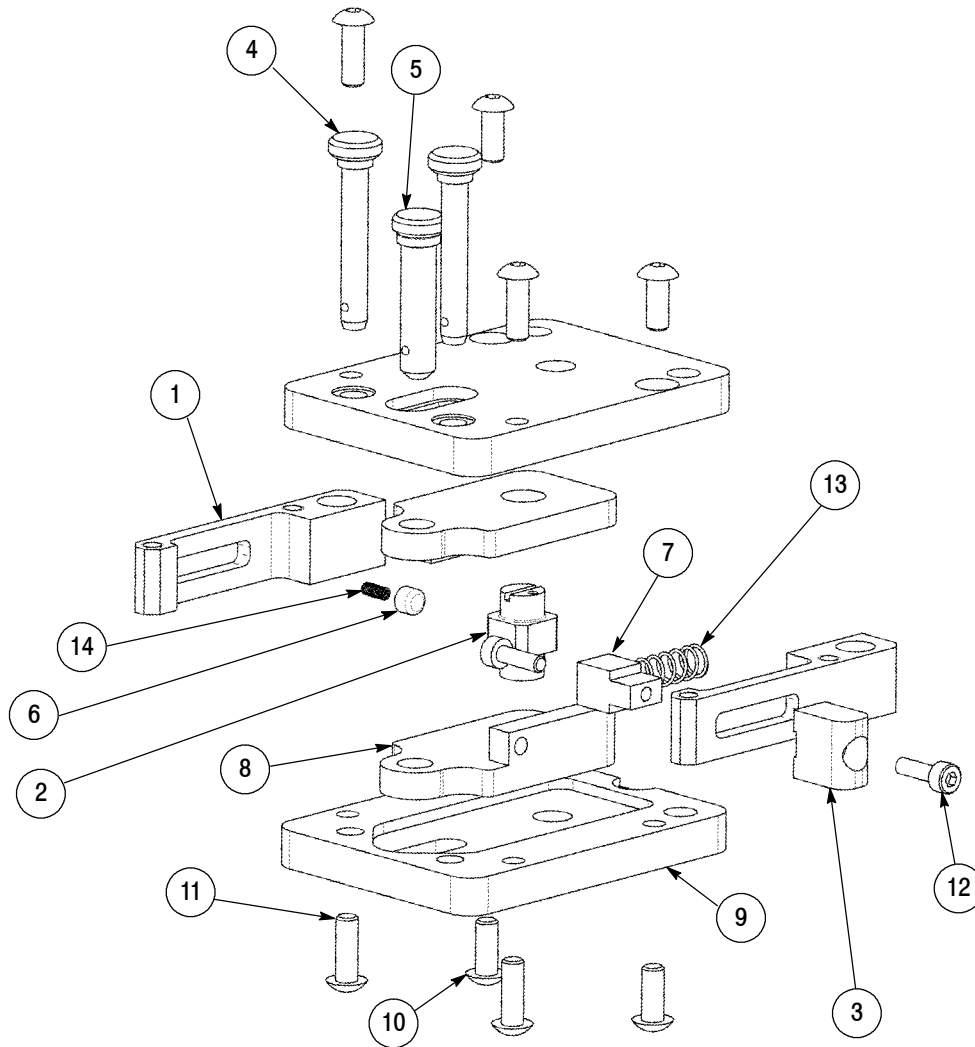
CUSTOMER SERVICE (038-035)  
TYCO ELECTRONICS CORPORATION  
PO BOX 3608  
HARRISBURG PA 17105-3608

For customer repair service, call 1-800-526-5136.

**8. REVISION SUMMARY**

- Added "Original Instructions"

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**CUSTOMER-REPLACEABLE PARTS**

ITEM	PART NUMBER	DESCRIPTION	QTY PER ADAPTER
1	1213854-1	HOUSING CENTER	2
2	1213859-1	ECCENTRIC	1
3	1213856-1	HANDLE, (Switch)	1
4	217873-1	PIN, Quick Release	2
5	217873-2	PIN, Quick Release	1
6	1213858-1	PLUNGER	1
7	1213861-1	POST, Spring Stop	1
8	1213857-1	RAM	2
9	1213853-1	HOUSING SIDE	2
10	18024-7	SCREW, Btn Skt Hd Cap (M4 X 10.0)	4
11	18024-8	SCREW, Btn Skt Hd Cap (M4 X 12.0)	4
12	18023-4	SCREW, Skt Hd Cap, M3 X 10.0	2
13	22280-9	SPRING, Compression	1
14	6-22278-0	SPRING, Compression	1

Figure 7