

Figure 1

## 1. INTRODUCTION

SDE Hand Tool Pneumatic Adapter 1583527-1 is used to adapt the crimping head from an SDE hand tool for use with 626 pneumatic tooling assembly or micro pneumatic tooling assembly. Figure 1 shows a typical crimping head used with the adapter. The adapter must be installed onto the appropriate tool holder assembly using the quick pins.

This instruction sheet provides:

- installing the crimping head onto the adapter,
- installing and removing the adapter from the tool holder assembly, and
- maintenance and inspection and replacement and repair information for the adapter

For information concerning the setup and operation of the pneumatic tooling assembly, refer to Customer Manual 409-5862 for the 626 and 409-10039 for the micro.

Read these instructions and the related customer manual thoroughly before using the adapter.

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

## 2. DESCRIPTION

The adapter facilitates the connection of the crimping head to the pneumatic tooling assembly and provides the necessary straight line motion of the movable die when the pneumatic tooling assembly is actuated.

The adapter features a switch, two quick pins, and a threaded SDE pin. The switch can be used to manually open and close the dies of the crimping head for insertion and removal of the product. The quick pins secure the outer housing tabs of the crimping head to the adapter, and the threaded SDE pin secures the movable die of the crimping head to the internal spring-loaded die holder and switch of the adapter.

## 3. INSTALLATION (Refer to Figure 2)

### 3.1. Installing the Crimping Head

1. If applicable, remove the crimping head from the hand tool.
2. Remove the two quick pins and threaded SDE pin from the adapter.
3. Orient the adapter so that the front (side with the protruding slotted spring pin) is facing upward, and orient the crimping head so that the back (side with the wire size markings) is facing upward.

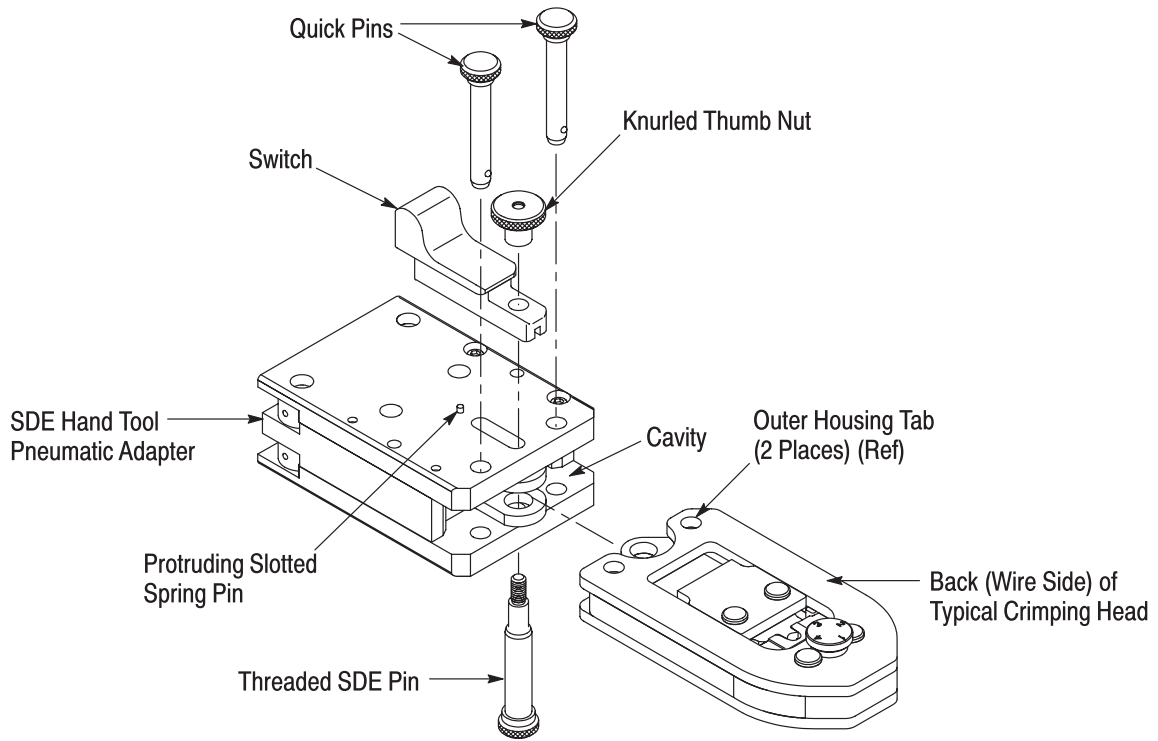


Figure 2

4. Insert the crimping head, outer housing tabs first, into the cavity of the adapter until it stops.

5. Insert the two quick pins through the two holes in the top plate of the adapter, through the holes in the two outer housing tabs of the crimping head, and through the two holes in the bottom plate of the adapter.

**NOTE** *The quick pins will snap into position when properly installed.*

6. Insert the threaded SDE pin through the center slot in the bottom plate and the holes in the spring-loaded die holder of the adapter, through the hole in the movable die of the crimping head, and through the slot in the top plate of the adapter.

**NOTE** *The shoulder just below the knurl of the threaded SDE pin will bottom on the bottom plate of the adapter when properly installed.*

7. Slide the hole in the switch over the threaded SDE pin and position the switch so that the protruding slotted spring pin fits into the groove in the bottom side of the switch.

8. Thread the knurled thumb nut onto the threaded SDE pin. Tighten the thumb nut.

**3.2. Installing and Removing the Adapter**

After the crimping head has been installed onto the adapter, the adapter is ready for installation onto the tool holder assembly of the pneumatic tooling assembly. Proceed as follows:

**DANGER** *To avoid personal injury, ALWAYS DISCONNECT the main air supply to the pneumatic tooling assembly before installing or removing the adapter.*

1. Install the appropriate tool holder assembly (including the cam) onto the pneumatic tooling assembly.

**DANGER** *DO NOT operate pneumatic tooling assembly without the proper adapter and crimping head installed. After the adapter is installed, make sure that the quick pins are FULLY tightened to avoid personal injury and damage to the assembly.*

2. Remove the quick pins from the tool holder assembly, and insert the adapter into tool holder assembly as shown in Figure 1.

3. Insert and tighten the quick pins of the tool holder assembly. Refer to Figure 1.

**NOTE** *It is recommended using a medium-strength liquid removable threadlocker to prevent the quick pins from loosening.*

4. Connect the pneumatic tooling assembly to an adequate air supply according to the customer manual supplied with the pneumatic tooling assembly.

Removing the adapter is the reverse of installing the adapter.

#### 4. 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 main air supply of the pneumatic tooling assembly before performing maintenance or inspection.*

##### 4.1. 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 adapter is not in use, store it in a clean, dry area.

##### 4.2. 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:

- Adapter used in daily—lubricate daily
- Adapter used occasionally—lubricate weekly
- Adapter used weekly—lubricate monthly

##### 4.3. Visual Inspection

Regular inspections should be performed by quality-control personnel. A record of scheduled inspections should remain with the adapter or be supplied to personnel responsible for the adapter. 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 adapter 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 5, REPLACEMENT AND REPAIR.

#### 5. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 3. 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 representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

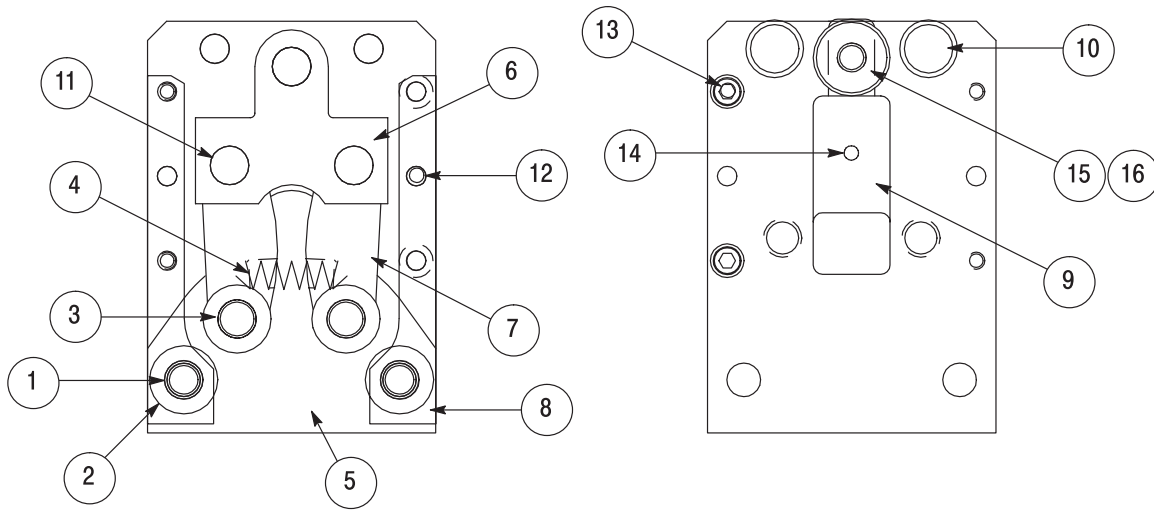
CUSTOMER SERVICE (038-035)  
 TYCO ELECTRONICS CORPORATION  
 PO BOX 3608  
 HARRISBURG PA 17105-3608

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

#### 6. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements



**CUSTOMER-REPLACEABLE PARTS**

| ITEM | PART NUMBER | DESCRIPTION                            | QTY PER ADAPTER |
|------|-------------|--|-----------------|
| 1    | 217347-1 ■  | PIN, Fixed                             | 2               |
| 2    | 314479-4 ■  | ROLLER                                 | 8               |
| 3    | 217348-1 ■  | PIN                                    | 2               |
| 4    | 3-22279-8 ■ | SPRING, Compression                    | 1               |
| 5    | 217349-2    | HOUSING                                | 2               |
| 6    | 1673373-1   | HOLDER, SDE Die                        | 1               |
| 7    | 217343-1    | LINK                                   | 2               |
| 8    | 217342-1    | HOUSING, Center                        | 2               |
| 9    | 217340-1    | SWITCH, Plastic                        | 1               |
| 10   | 217873-1    | PIN, Quick                             | 2               |
| 11   | 679495-1    | PIN                                    | 2               |
| 12   | 4-21028-4   | PIN, Slotted Spring                    | 2               |
| 13   | 6-21000-8   | SCREW, Socket Head Cap, 4-40 x .88 in. | 4               |
| 14   | 21028-1     | PIN, Slotted Spring                    | 1               |
| 15   | 1673374-1   | PIN, SDE                               | 1               |
| 16   | 22347-5     | NUT, Knurled Thumb                     | 1               |

■ Recommended Spare Parts

Figure 3