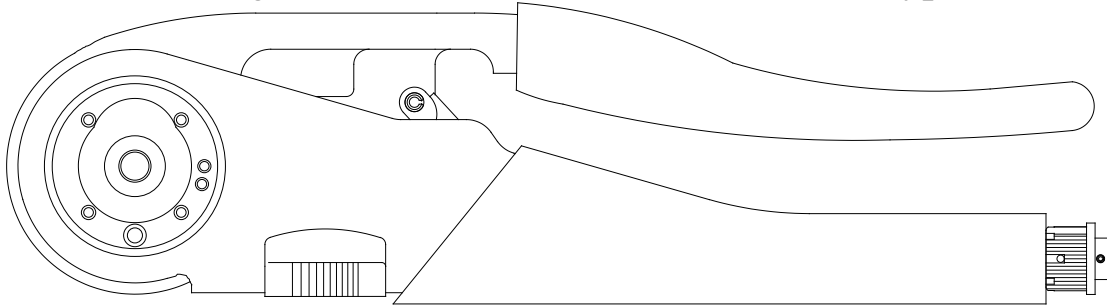




# ASTRO TOOL CORP.

## CONNECTOR ASSEMBLY TOOLING HOW TO USE THE LARGE MICROCRIMP TOOL Catalog Number 612548-2 and Associated Types



### GENERAL

The 612548-2 Microcrimp Tool is a micro adjustable, cycle controlled hand crimping tool. It is a fast, versatile, manually operated, octadent tool for crimping circular pin and socket contacts.

The tool is adjustable in a range of .025 to .075-inch. Settings to within .0005-inch increments are possible for precision crimping.

Turret and Positioner assemblies are available for most applications, consult the factory for your specific needs.

Open and close the tool several times and observe the precision cycle controlled ratchet mechanism. Note that the tool may not be opened or closed without completing the cycle.

For long life and optimum performance, this tool should be kept clean and handled carefully, as any other precision instrument.

### OPERATION

**NOTE:** For proper crimping, the Basic Tool must be used with an appropriate Positioner or Turret Assembly.

1. Select the proper Positioner or Three Position Turret Assembly for the contact to be crimped.
2. Attach the head to the turret ring on the tool using the captive socket head cap screws. A 9/64 hex wrench is required. Verify that the guide pin is properly located prior to tightening the cap screws. The turret will need to be in the "un-locked" position before attaching to the tool.

3. Select the appropriate insert from the color coded data plate on the side of the Turret. Turn the knurled knob until the color coded position is aligned with the index mark. Depress the turret until it locks into position.
4. Consult the Data Plate for correct selector setting.
5. Locate the adjustment window on the tool and observe where the red indicator is located. Consult Data Plates on either side of the tool for gaging data. Pull and rotate the red adjustment knob, located at the end of the tool, until the indicator lines up with the desired size opening. Rotate clockwise to increase, counter-clockwise to decrease opening. See figure #1.

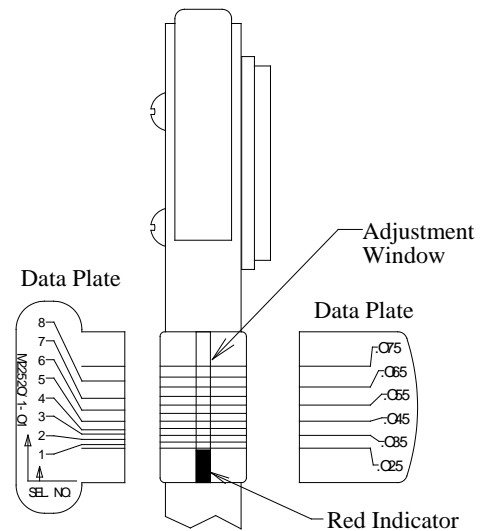


Figure #1

6. It will be necessary to verify the opening by using gage pins. Select the proper GO gage pin for the opening required (refer to gaging information table). Close the tool completely and insert the GO pin between the indenters, as shown in figure #2. The gage pin should be a slip-fit between the indenter tips with no sloppiness or free play.

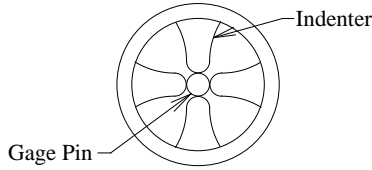


Figure #2

**CAUTION:  
DO NOT CRIMP GAGE  
TOOL DAMAGE WILL RESULT**

7. Insert the wire and contact through the Indenter Opening and into the Positioner Assembly. Squeeze the handles until the Tool comes to a positive stop. Release the handles and the tool will return to the full open position.

8. Remove the completed crimped assembly.

**CAUTION:**

Do not press down on the wire during the crimp cycle.

**GAGING INFORMATION**

( Dimensions in Inches )

| SELECTOR SETTING NUMBER | GO SIZE ± .0001 | NO GO SIZE ±.0001 |
|-------------------------|-----------------|-------------------|
| 1                       | .0280           | .0330             |
| 2                       | .0320           | .0370             |
| 3                       | .0360           | .0410             |
| 4                       | .0390           | .0440             |
| 5                       | .0450           | .0500             |
| 6                       | .0520           | .0570             |
| 7                       | .0590           | .0640             |
| 8                       | .0680           | .0730             |

**TOOL SERVICE**

Astro Tool's 612548-2 Crimp Tool is designed for long, reliable service. If the tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the tool to our factory.

Upon receipt of the tool, Astro will inspect and overhaul each tool to put the tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired. Please note that Astro's Quality Control system is traceable to The National Institute of Standards and Technology (N.I.S.T.).

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charge for such parts.

**ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL, CRIMP TOOLS AND CONNECTOR SERVICE KITS**

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