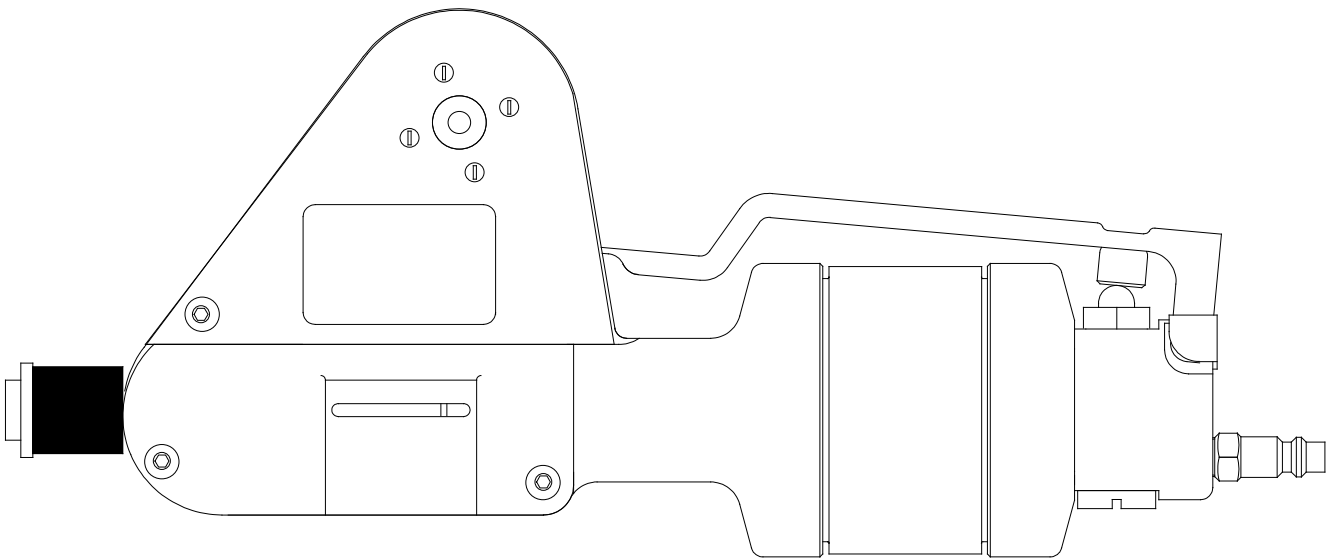




ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

EXTERNAL ADJUST MANUAL FEED PNEUMATIC CRIMPING TOOL
Catalog Number 612141 and Associated Types



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

ASTRO TOOL CORPORATION • 21615 S.W. T-V HWY. • BEAVERTON OREGON 97003
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EXTERNAL ADJUST CYCLE CONTROLLED PNEUMATIC MANUAL FEED CRIMPING TOOL

GENERAL:

The Astro Tool Corporation Externally Adjustable Manual Feed Pneumatic Crimping Tool is a fast, versatile, pneumatically actuated four indenter tool for crimping MS style or proprietary circular contacts. This tool accommodates all the turret head assemblies used with the MS 3191-4 or the M22520/1-01 crimping tools. The tool is capable of accommodating contact sizes 12 to 26 and wire sizes 12 to 30 AWG. Using the micrometer adjustment, the tool is adjustable over a wide range of settings.

This tool may be adapted to a wide variety of applications. For further details contact the factory.

SCOPE:

This manual gives the proper procedures for basic operation, inspection and calibration of the External Adjust Manual Feed Tool.

OPERATION:

a. GENERAL INSTRUCTIONS

Air pressure of 80 P.S.I minimum is required to operate the External Adjust Manual Feed Crimping Tool. The recommended operating range is 80-120 P.S.I. An air regulator, filter and lubricator should be used for long life and proper operation of the tool. Clean, non-detergent, non-additive oil (SAE 10 or lighter) is recommended with oil flow of 1 to 3 drops per minute. The tool is portable but can be used bench mounted or suspended. This is a FULL CYCLE TOOL; once the cycle has been started the trigger will not release until the cycle is completed.

b. CRIMP DEPTH GAGING

To check the indenter opening, connect the tool to the air supply and depress the trigger and hold. Select a round gage pin that will slide smoothly into the indenter opening. Assure that the gage pin is in the indenter opening and not between the indenters. There should be no sloppiness in the fit.

CAUTION DO NOT CRIMP GAGE PIN

The diameter of the gage pin is the crimp depth setting.

To change the indenter opening pull out the red adjustment knob and rotate clockwise to increase indenter opening, or counter-clockwise to decrease indenter opening. The guide pin must be re-engaged when the tool is set.

c. ADJUSTMENT AND CALIBRATION

To adjust the RED INDICATOR, turn the adjustment knob until the RED INDICATOR is lined up with the #4 setting for M22520/1. Use ASTRO gage part number 615716 (M22520/3-01) to check indenter opening. DO NOT CRIMP GAGE. Using the GO pin verify the indenter opening. Verify that the NO-GO pin will not go. DO NOT CRIMP GAGE. See figure # 1.

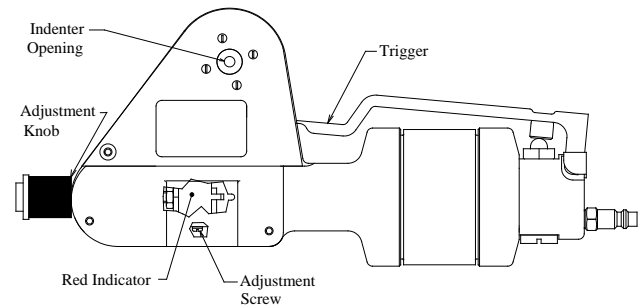


Figure #1

If the tool is out of adjustment, rotate the adjustment knob until the GO and NO-GO requirements are met. Verify that the guide pin has been re-engaged. Then loosen the adjustment screw and move the RED INDICATOR until it lines up with setting # 4 for M22520/1. Tighten the adjustment screw. The tool is now adjusted and calibrated. See figure # 1.

d. BASIC OPERATION

Select the proper three position turret or single position head for the application. Attach the head to the turret ring on the tool using the captive socket head cap screws. See figure # 2. A 9/64 hex wrench is required. Verify that the guide pin is properly located prior to tightening the cap screws.

If a three position turret is used, depress trigger on the side of the turret body and the spring loaded turret will snap out to the indexing position. Select the appropriate insert from the color coded data plate on the side of the turret. Turn the knurled knob on the turret until the color coded position is aligned with the index mark. Then depress the turret until it locks into position.

Adjust the External Adjust Manual Feed Tool to the proper indenter opening based on the color coded data plate on the three position turret head or single position head.

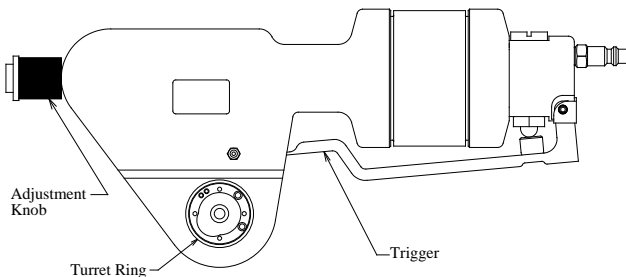


Figure # 2

Insert the contact through the indenter opening and into the positioner.

Insert the wire into the contact.

Depress the trigger fully to crimp.

CAUTION DURING CRIMPING:
DO NOT PRESS DOWN ON THE WIRE DURING THE CRIMP CYCLE. THE TURRET INSERTS ARE SPRING LOADED TO ALLOW THE CONTACT TO LENGTHEN IN BOTH DIRECTIONS DURING CRIMPING CYCLE.

Release the trigger and remove the crimped wire and contact assembly and inspect.

NOTE:

The indenter opening should be checked periodically .

TOOL SERVICE

Astro Tool's 612141 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.

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.

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