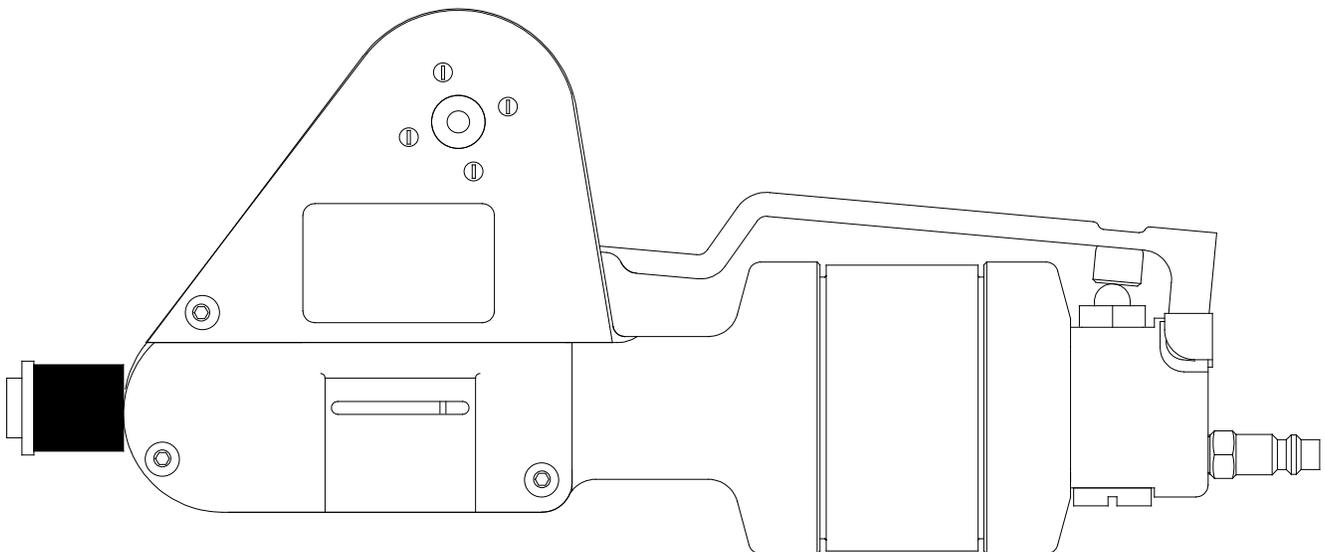




ASTRO TOOL CORP.

Your Connection for Aerospace, Medical and Telecommunication Tooling

EXTERNAL ADJUST • CYCLE CONTROLLED • PNEUMATIC
MANUAL FEED CRIMPING TOOL
Catalog Number 611483



MANUFACTURER OF • CRIMP TOOLS

- INSERTION/REMOVAL TOOLS
- CONNECTOR SERVICE KITS

ASTRO TOOL CORPORATION • 21615 S.W. T-V HWY. • BEAVERTON, OREGON 97003
503-642-9853 • FAX 503-591-7766
www.astrotool.com

GENERAL:

Astro Tool's 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 AN style locators. 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. 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. BASIC OPERATION

Select the proper locator for the application.

Loosen slide locking screw and move slide to the open position.

Insert contact locator into recess and push slide to the closed position. Tighten locking screw.

Adjust the External Adjust Manual Feed Tool to the proper indenter opening.

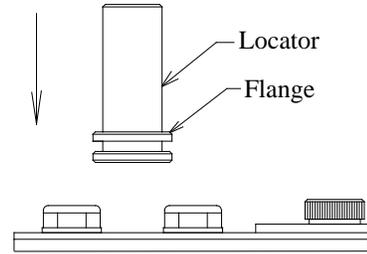


Figure # 1

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

Insert the wire into the contact. Depress the air valve trigger fully to crimp.

Release the air valve trigger, remove and inspect the crimped contact.

NOTE:

The indenter opening should be checked periodically.

TOOL SERVICE

Astro Tool's 611483 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.

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