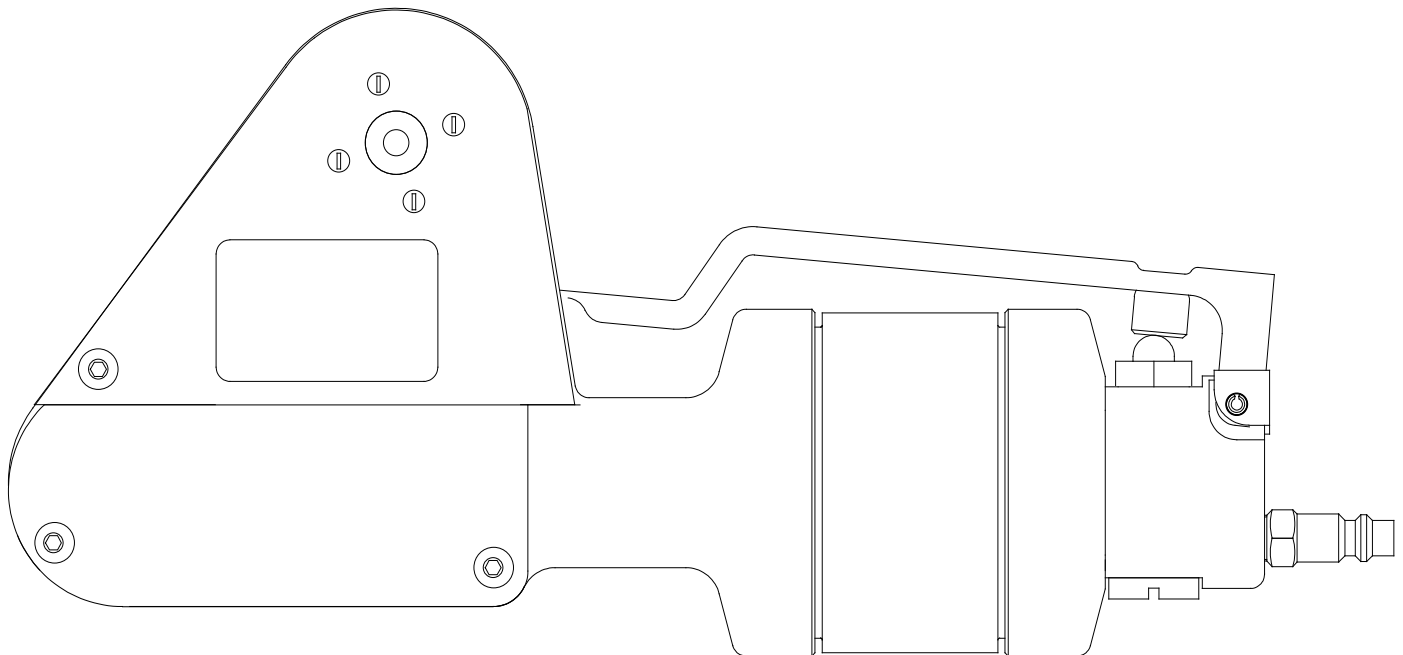




ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

CYCLE CONTROLLED MANUAL FEED PNEUMATIC CRIMPING TOOL
Catalog Number 10967 and Associated Types



ASTRO TOOL CORP. MANUFACTURERS OF INSTALLING, REMOVAL AND CRIMP TOOLS
21615 SW. T-V HWY. ■ BEAVERTON ■ OREGON 97003 ■ 503-642-9853 ■ FAX 503-591-7766
CONNECTOR ASSEMBLY TOOLING

CYCLE CONTROLLED PNEUMATIC MANUAL FEED CRIMPING TOOL

1. GENERAL

The ASTRO TOOL CORP. MANUAL FEED PNEUMATIC CRIMPING TOOL is a fast, versatile, pneumatically operated, four indenter tool for crimping MS style or proprietary contacts. The tool is equipped with an adjustable stop plate that permits guide adjustment for the proper crimping depth for the contact size and wire range.

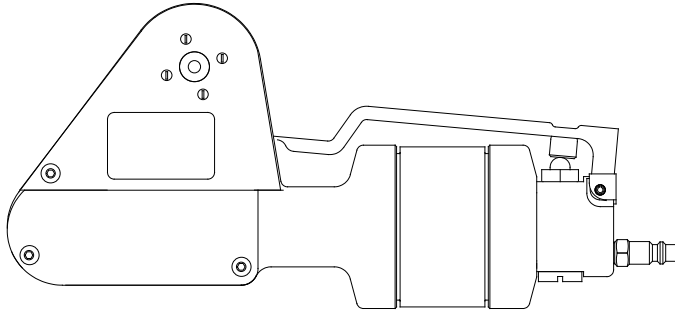


Figure #1
MANUAL FEED CRIMP TOOL

The tool is supplied with three standard replaceable contact locators and standard indenters. This tool meets the performance requirements for MIL-C-22520 and may be adapted for special or proprietary applications. For further details contact the factory.

2. SCOPE

The instructions in the operations section give the proper procedures for operation, inspection and calibration of the 10967 MANUAL FEED TOOL, unless noted.

3. OPERATION

a. GENERAL INSTRUCTIONS.

A minimum of 80 P.S.I. is required to operate the PNEUMATIC 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 ADJUSTMENT.

1. Remove left-half cover and loosen jam nut and stop plate. See figure # 2

WARNING

CAUTION IS TO BE EXERCISED WHEN OPERATING THIS TOOL WITH THE COVER REMOVED.

2. Connect air supply inlet of tool to 80-120 P.S.I. filtered, regulated, lubricated air source.
3. Depress and hold down air valve trigger.
4. Select a gage pin of the proper diameter and insert in the indenter opening. Pin diameter is determined by wire size and contact combination used. Refer to table 1 for recommended gaging for MS style contacts.

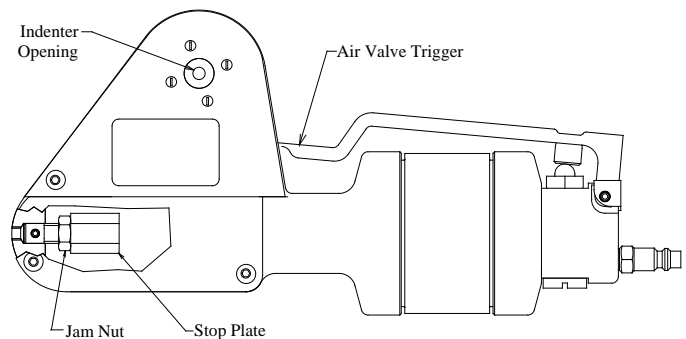


Figure #2
Jam Nut and Stop Plate
Shown on Typical Tool

CAUTION
ASSURE THAT THE GAGE PIN IS IN THE INDENTER OPENING AND NOT BETWEEN THE INDENTERS.

5. Gage pin must slide smoothly into indenter opening. There should be no play or sloppiness in the fit.

CAUTION
DO NOT CRIMP GAGE PIN

6. Release air valve trigger and readjust stop plate as necessary to obtain required indenter opening.
7. After desired indenter opening is achieved, lock the stop plate in position with the jam nut.
8. After locking down the stop plate, verify the gage setting by cycling the tool and checking the gaging with the gage pin. Readjust if required.

9. Replace left hand cover to original position when calibration is completed.

Manual Feed Tool Shown
With Contact Locator Installed

c. SETTING UP TOOL FOR OPERATION.

1. Loosen slide locking screw and move slide to the open position.
2. Insert contact locator into recess and push slide to the closed position. Tighten locking screw.

3. Insert material to be crimped, contact and conductor, through the indenter opening into the locator. Depress the air valve trigger fully to crimp.

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

NOTE

The depth of the crimp should be checked periodically and the tool adjusted as necessary.

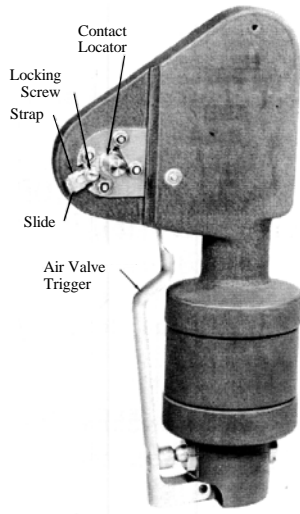


Figure # 3

TABLE I
RECOMMENDED CRIMP DEPTH SETTINGS
BASED ON CONTACT SIZE (REF.: MIL-C-22520)

Contact Size	Setting
20 and 20A	.035
16	.046
12	.067

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