RPC-M23-T-B（M22520/1-01）

Application Specification

一. **Application scope and characteristics**

This crimp tool was designed according to MIL-C-22520/1-01. Applicable for cold crimping of wires and barrel contacts for electrical connectors. Applicable contact series: CDM/DDM; CDF/DDF; CEM/DEM; CEF/DEF.DM; CDF; CEM; CEF.

Applicable wire size: 12AWG-26AWG (3.33mm^2 – 0.128mm^2)

Order No.: T3100000022-000

二. **Work principle**

1. **Crimp method**

   The tool works following curve propulsion mode. Force transmits to four clamp heads from four curve shape structures inside the cavity of head of the handle. Clamp heads move forward to center direction, during the motion progress, the tooth in the front of clamp heads press contact barrel, following completing the crimping connection of wire and contact. Well cooperation during the motion of the four clamp heads ensures consistent crimping depth and good crimping quality.

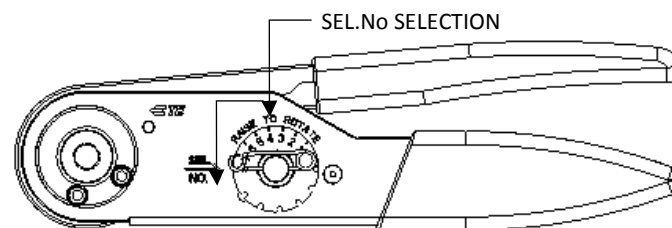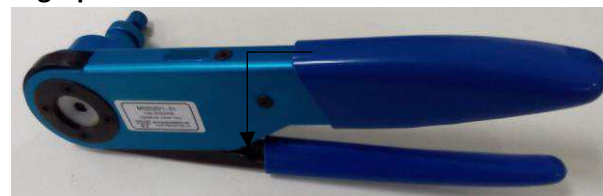2. **Crimping SEL.No(As right picture shows)**

   This tool has 8 SEL.No, and the corresponding wire size (mm^2 & AWG) are shown as below:

WIRE SIZE		Contact Series	SEL.No	Contact Series	SEL.No
mm^2	AWG				
0.14mm^2	26		5		6
0.25mm^2	24		6		6
0.37mm^2	22		6		6
0.5 mm^2	20		6		6
0.75 mm^2	18	CDM/CDF DDM/DDF	6	CEM/CEF DEM/DEF	6
1.0 mm^2	18		6		6
1.5 mm^2	16		7		6
2.5 mm^2	14		7		8
3.0 mm^2	12				8
4.0 mm^2	12				8

3. Poka-Yoke function

   This tool has Poka-yoke function. If the crimping is not fully complete, the Poka-yoke structure woks accordingly, the tool handle can not be open, and the crimping parts can not be took out. Only in the case of completely crimping action, the Poka-yoke structure will open automatically, then the tool handle can be open, the crimping parts can be took out. The crimping action is done.

三. **Application graphic instructions**

SEL.No SELECTION

Rotate this button to adjust "H" to make the tooth of clamp head matching with contact crimping area

CDM/DDM SERIES"H" =10.2mm （Ref）
CDF/DDF SERIES"H" =15.5mm （Ref）
CEM/DEM SERIES"H" =17.2mm （Ref）
CEF/DEF SERIES"H" =20.0mm （Ref）

When tool handle is in fully open position, pull out the spring, pull up the knob and rotate it to adjust the SEL.No

Hole for contact inserting