

Crimping Die Assembly	Wire Range	Terminal Part Number (Application Spec)	Modular Tool Holder (Instruction Sheet)
2305854-1	25mm ²	2177473-1 (114-94125)	2305470-1 (408-35048) 2326378-1 (408-35049)
2326571-1	35mm ²	2177590-1 (114-94125)	
2305856-1	50mm ²	2177592-1 (114-94125)	

Figure 1

1. INTRODUCTION

Crimping Die Assemblies (PN 2305854-1, 2326571-1, and 2305856-1) are designed to be installed into the Modular Tool Holders listed in Figure 1. They are designed to crimp HV800-180 terminals.

When reading this instruction sheet, pay attention to DANGER, CAUTION, and NOTE statements:



DANGER

Denotes an imminent hazard that may result in moderate or severe injury.



CAUTION

Denotes a condition that may result in product or equipment damage.



NOTE

Highlights special or important information.

2. DESCRIPTION

Each die assembly consists of a crimper, anvil, and terminal locator.

The terminal locator is designed to maintain terminal position during the crimping process. The terminal locator is supplied pre-assembled to the crimping die.

3. DIE ASSEMBLY INSTALLATION

For information concerning die installation and/or removal, and general performance of the Modular Tool Holder, refer to the 408 Series Instruction Sheet packaged with the tool holder.



DANGER

To avoid personal injury, ALWAYS DISCONNECT electrical and air supply to power unit before installing the die assembly into the tool holder.

To achieve proper orientation of the dies during installation, ensure that:

- The alignment dots are facing the wire clamp on the Modular Tool Holder (see Figure 2).

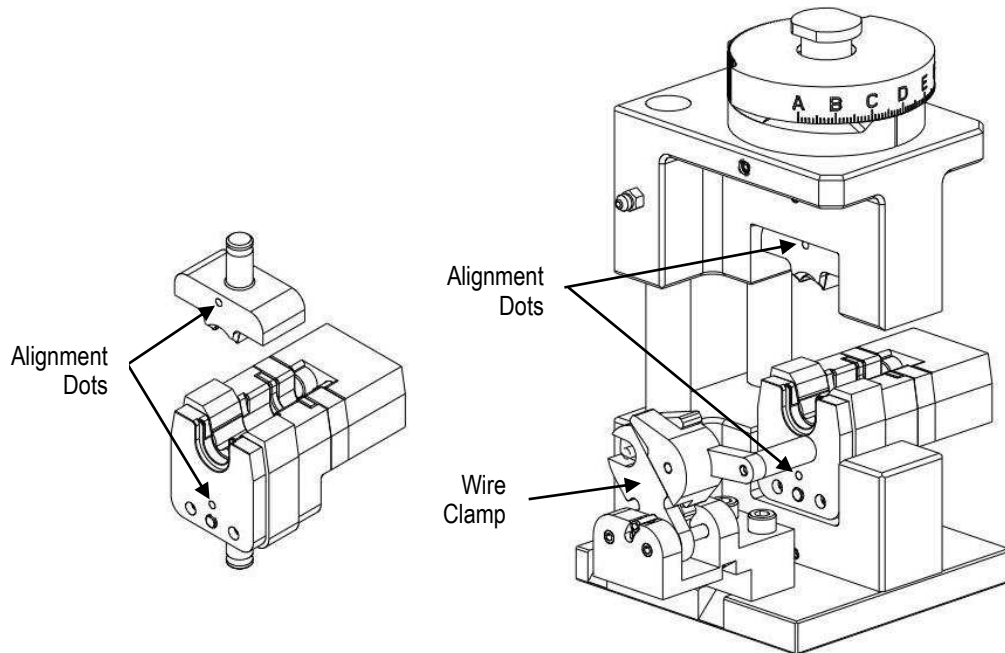


Figure 2

4. CRIMPING PROCEDURE



NOTE

Strip length and specific crimp information for each terminal can be found in the 114 Series Application Specification referenced in Figure 1.



CAUTION

If the tool holder is equipped with a Crimp Height (Fine Adjust) Adjustment, damage to the terminator, Modular Tool Holder or die assemblies can be avoided by starting at setting “A” on the crimp height disc, and incrementally adjusting to the specified crimp height. If the machine has crimp height/shut height adjustment, refer to the applicable 412 Series Customer Manual for guidance.

1. Insert terminal into die assembly with the contact end against the extrusion pins (see Figure 3a).
2. Open the wire clamp by pressing down on the lever. Insert the properly stripped wire into the wire barrel of the terminal (see Figure 3b). Ensure that there are no exposed strands. Release lever to clamp wire in place.
3. Cycle terminator to complete the crimp.
4. Remove crimped product.

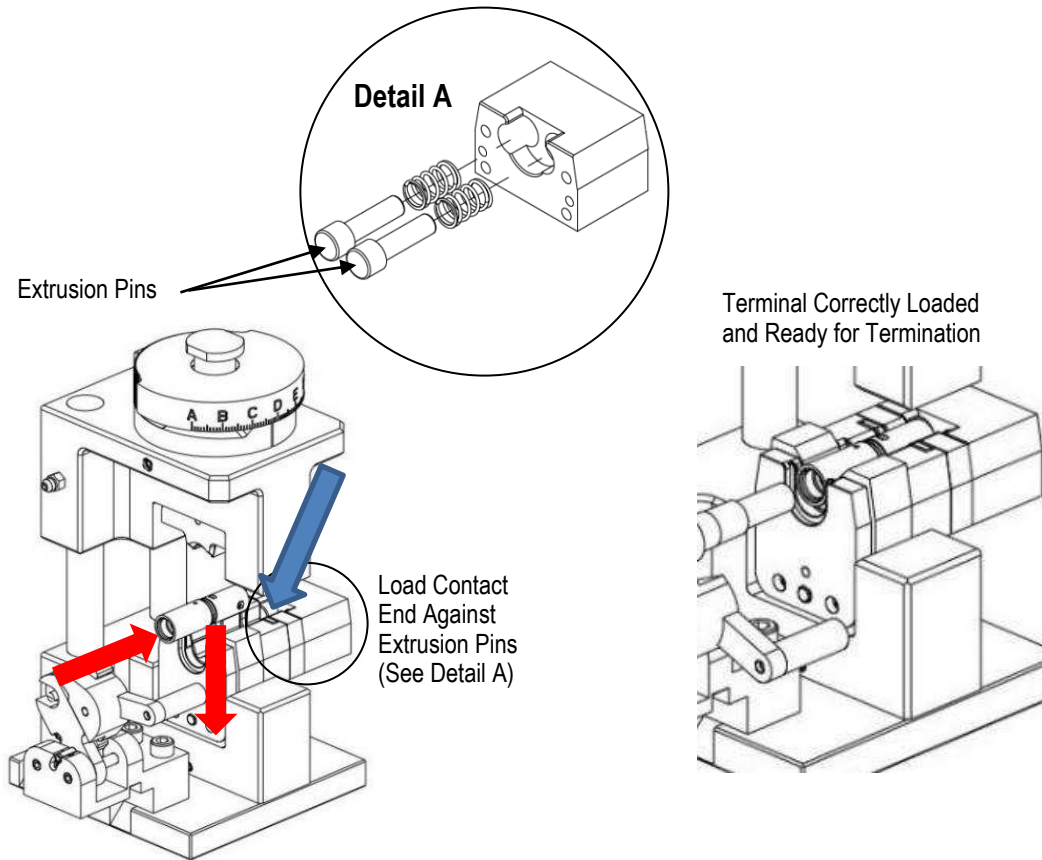


Figure 3a

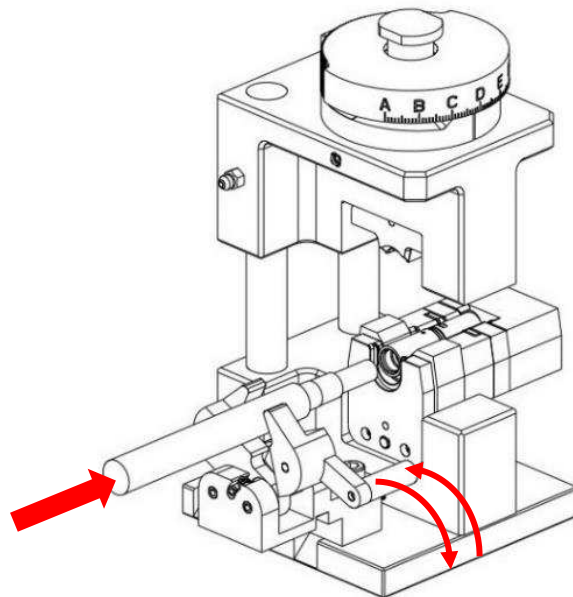


Figure 3b

5. CRIMP INSPECTION

For crimp inspection information, refer to the 114 Series Application Specification referenced in Figure 1 for the terminal being crimped.

6. MAINTENANCE AND INSPECTION

Each die assembly is inspected before shipment. TE Connectivity (TE) recommends that the die assembly be inspected immediately upon arrival at the facility of use to ensure that it has not been damaged during shipping.

6.1. Daily Maintenance

Each operator of the power unit must be made aware of, and responsible for, the following steps of daily maintenance:

1. Remove dust, dirt and other contaminants with a clean brush or soft lint free cloth. DO NOT use objects that could damage the dies.
2. When dies are not in use, store them in a clean dry area.

6.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the dies and/or be supplied to personnel responsible for the dies. Although recommendations call for at least one inspection per month, the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards. This inspection should be performed as follows:

1. Remove all contaminants with a clean brush or soft lint free cloth.
2. Inspect the crimp area for flattened, chipped, cracked, worn or broken areas. If damage is evident, the die assembly must be replaced.

7. REPLACEMENT AND REPAIR

To order replacement dies, call 1-800-522-6752, send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
TE CONNECTIVITY CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

Call 1-800-522-6752 for customer repair services.

8. REVISION SUMMARY

Initial Release