

Crimping Die Assembly	Wire Range	Terminal Part Number (Application Spec)	Modular Tool Holder (Instruction Sheet)
2326506-1	5mm ²	2103942-1 (Inner Ferrule) 2103943-1 (Outer Ferrule) (114-162012)	2305470-1 (408-35048) 2326378-1 (408-35049)
2326507-1	12mm ²	2103942-2 (Inner Ferrule) 2103943-2 (Outer Ferrule) (114-162012)	

Figure 1

1. INTRODUCTION

Crimping Die Assemblies (PN 2326506-1, PN 2326507-1) are designed to be installed into the Modular Tool Holders listed in Figure 1. They are designed to crimp PCON 12 ferrules.

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 crimping die assembly consist of a Ferrule Upper Die (Crimper), Ferrule Lower Die (Anvil) and a Locator Housing Assembly (which consists of a Locator Housing and a Terminal Block).

The Locator Housing Assembly is designed to maintain terminal position during the crimping process. The Locator Housing Assembly 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).

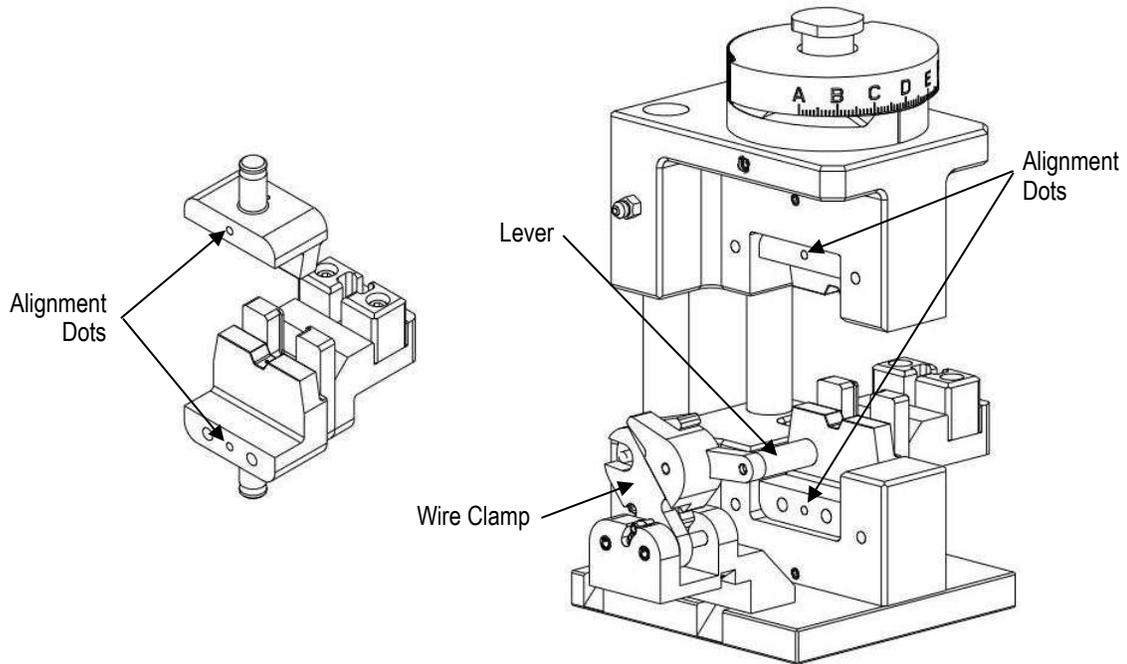


Figure 2

4. CRIMPING PROCEDURE



NOTE

Strip length and specific crimp information for each terminal can be derived from the applicable 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 working to the specified crimp height.

1. Assemble ferrules to prepared wire assembly per applicable 114 Series Application Specification referenced in Figure 1.
2. Open the Wire Clamp by pressing down on the Lever (see Figure 2.)
3. Insert the prepared assembly into the Crimping Die so that:
 - The outer ferrule is inserted into the Ferrule Locator, and
 - The crimped contact is inserted into the Terminal Block (Locator). **Note:** The crimped contact should fit within the surfaces identified to ensure proper spacing and orientation (see Figure 3).

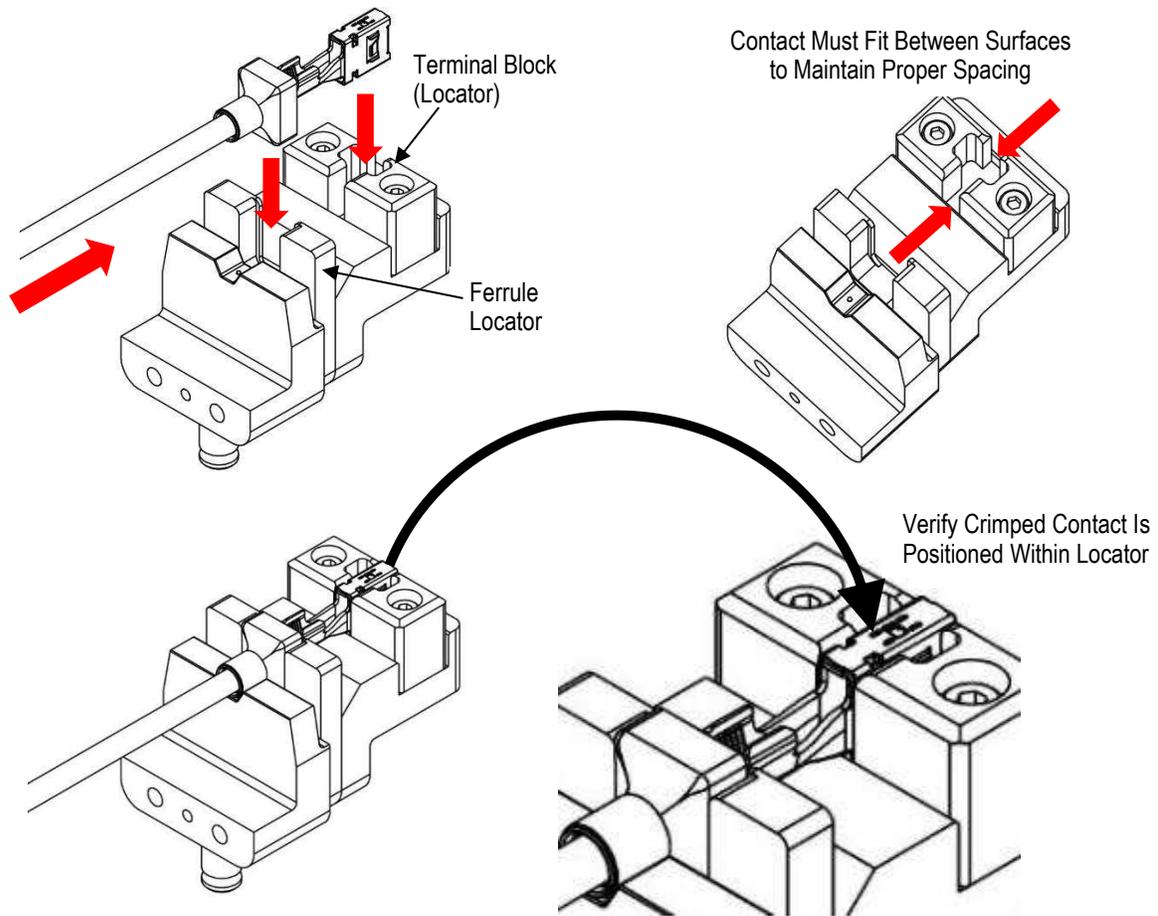


Figure 3

4. Release the lever to clamp wire in place.
5. Cycle terminator or power unit to complete the crimp.

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