

Die Assembly Part Number	Wire Range	Terminal Part Number (Application Specification)	Modular Tool Holder (Instruction Sheet)
2351903-1	70mm ²	1670815-1 (114-18769)	2305470-1 (408-35048) 2326378-1 (408-35049)

Figure 1

1. INTRODUCTION

Crimping Die Assembly (PN 2351903-1) is designed to be installed into the Modular Tool Holders listed in Figure 1. The die assembly is designed to crimp the 1 position 70 mm² IPT Ring Tongue Terminal.

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 consists of a Crimper, Anvil, and Terminal Locator Assembly.



NOTE

The Terminal Locator Assembly is designed to maintain terminal position during the crimping process and 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(s), refer to the applicable 408 Series Instruction Sheet packaged with the tool holder(s).



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 in the direction of the Wire Clamp on the Modular Tool Holder (see Figure 2).

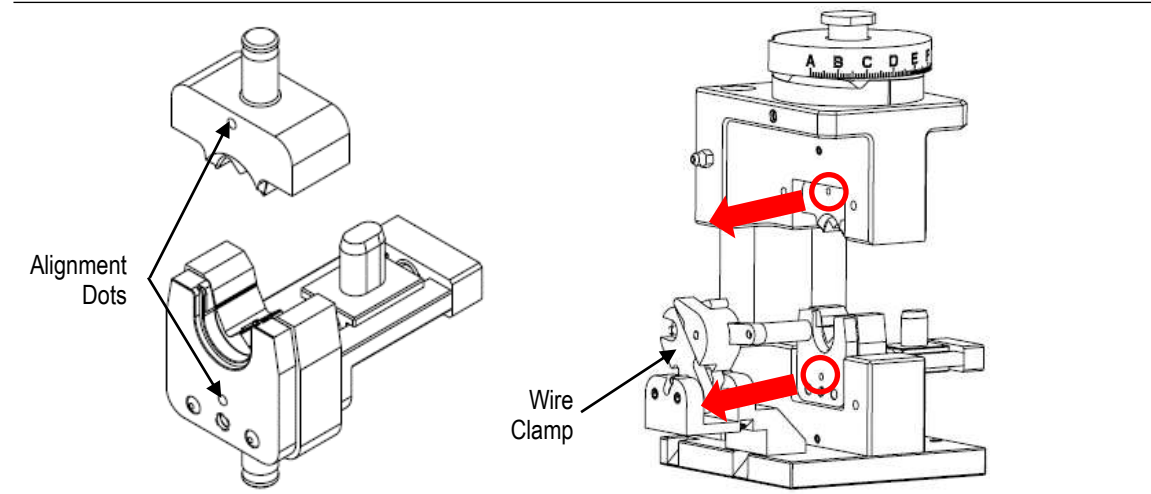


Figure 2

4. CRIMPING PROCEDURE [FIGURE 3]

Strip length and specific crimp information for each terminal being crimped using this die assembly can be found in 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 assembly can be avoided by starting at setting A on the crimp 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. Assemble the connector in accordance with Application Specification [114-18769](#) for the Protection Cap, IPT 70-120mm² (1670821), Single Wire Seal, IPT 70-120mm² (PN 1670820), 1pos. Ring Tongue Housing, IPT 70-120mm², Assy (PN 1670816), and EMC, Crimp Sleeve, IPT 70-120mm² (PN 1670813).
2. Insert the properly stripped wire into the wire barrel of the terminal per the 114 Series Application Specification referenced in Figure 1.
Verify there are no exposed strands.
3. Open the wire clamp by pressing down on the lever and insert the cable lug into the die assembly with the mounting hole placed on the terminal locator.
4. Release the lever to clamp the wire in place.
5. Cycle the terminator to perform the crimp.
6. Remove crimped assembly from the tooling.

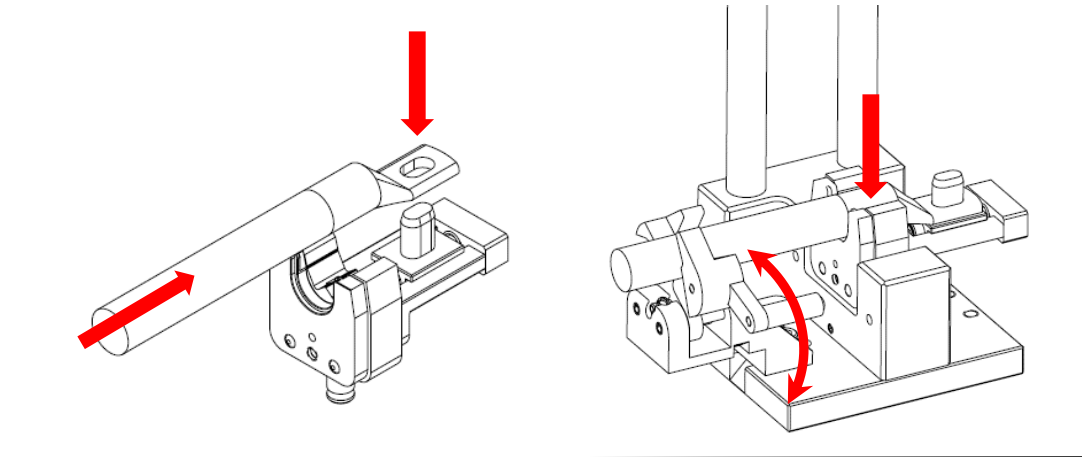


Figure 3

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 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:

- Remove dust, dirt and other contaminants with a clean brush or soft lint free cloth. DO NOT use objects that could damage the dies.
- 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:

- Remove all contaminants with a clean brush or soft lint free cloth.
- 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