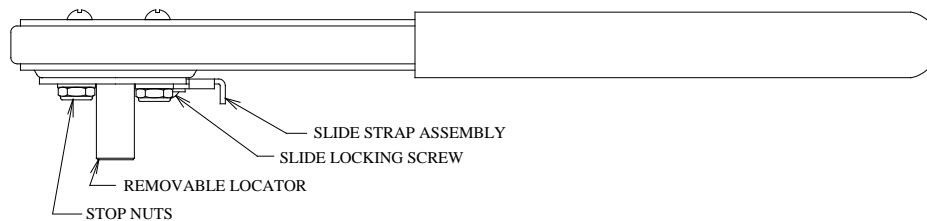
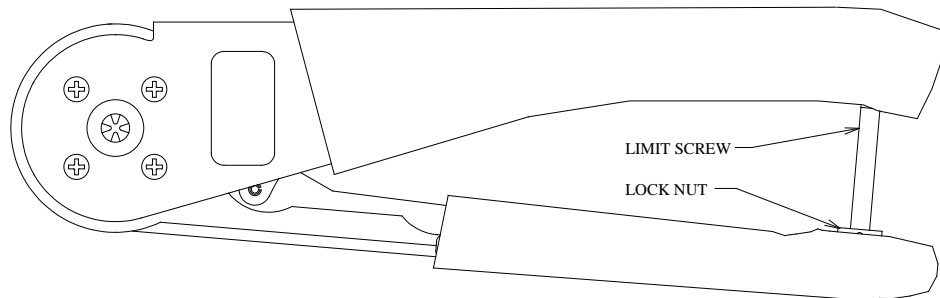


ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

HOW TO USE CYCLE-CONTROLLED HAND CRIMPING TOOL FOR ELECTRICAL CONNECTOR PINS AND SOCKETS Catalog Number 11067-11454-615466 and Associated Types



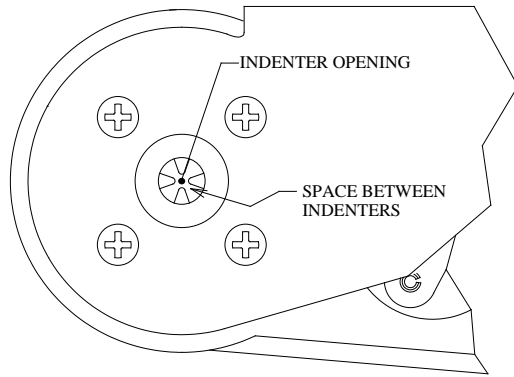
GENERAL INSTRUCTIONS

1. Observe precision ratchet action by opening and closing the tool fully several times. Note that the tool cannot be opened without fully completing the cycle. When held the tool fits your hand for less fatiguing one-hand operation.
2. Identify the following parts:
 - Limit screw
 - Lock Nut
 - Replaceable Contact Locator
 - Slide Strap Assembly
 - Slide Locking Screw

NOTE: THERE IS ONLY ONE ADJUSTMENT TO MAKE. NEVER ATTEMPT TO DISASSEMBLE THE TOOL. NEVER TIGHTEN OR LOOSEN STOP NUTS ON THE BACK OF THE TOOL

TO ADJUST RATCHET FOR CRIMP DEPTH

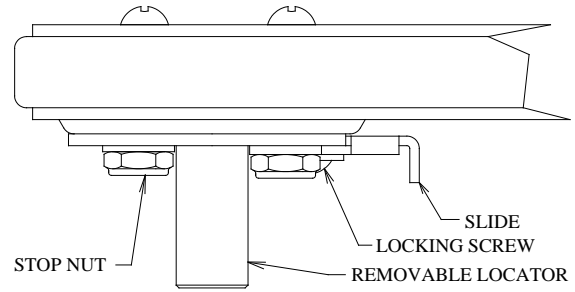
1. Loosen lock nut and limit screw.
2. Adjust the limit screw to approximate indenter opening desired.
3. Close tool fully to trip ratchet.
4. Select gage pin of desired diameter and insert into the indenter opening. Be sure the gage pin is in the indenter opening and not between the indenters. The gage pin should slide easily into the indenter opening, providing a slip-fit without any play or sloppiness. **DO NOT CRIMP GAGE PIN.**
5. Readjust the limit screw as necessary to obtain the required slip fit of the gage pin in the indenter opening.



6. Lock limit screw in position with the lock nut.
7. After adjustment has been completed, re-insert the gage pin into the indenter opening to verify fit.
8. Re-adjust if required.
9. Periodic gaging of the tool is recommended.

TO INSTALL REPLACEABLE CONTACT LOCATOR

1. Check to verify that the locator to be used is correct for your contact application.
2. Loosen the locking screw. Pull the slide into the open position.



3. Insert the locator into the well. Push the slide into the locking position, and tighten the locking screw.
4. Insert the contact and conductor into the indenter opening. Close tool fully to crimp.
5. Inspect the crimped contact. Re-check the fit of the gage pin in the indenter opening.

NOTE: FOR LONG LIFE AND OPTIMUM PERFORMANCE, THIS TOOL SHOULD BE KEPT CLEAN AND HANDLED WITH THE SAME CARE AS ANY OTHER PRECISION INSTRUMENT.

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