

M23 crimping tools

SAI M23 crimping tool 1

n

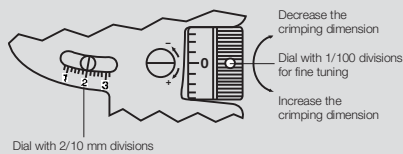
**Adjusting the crimping dimensions**

The adjustment mechanism is used to set the crimping depth of the crimping mandrel as described below.

The adjusting dial is used to prepare the feed; the dial can be turned clockwise (for decreasing the dimension) or counter-clockwise (for increasing the dimension).

Adjustment precision

- 1 division mark on the dial \cong 1/100 mm adjustment
- 1 complete revolution of the dial \cong 0,2 mm adjustment read from scale
- 5 revolutions of the dial \cong 1 mm adjustment read from scale

Verifying the crimping dimension

The four-mandrel crimping tool is pre-set at the factory. The actual crimping size should still be checked periodically. It should be checked using the plug gauge (\varnothing 2.0 mm) that is included with the crimping tool as described below. Use the dial on the stationary tool shank to set the size to 2.0 mm on the scale. Set to the zero-point tick mark on the dial and close the tool. (Refer to the diagram showing the crimping size adjustment.) At this setting, it should be possible to move the 2.00-mm- \varnothing plug gauge without any play or extra room. If this is not possible, then the size deviation (+/-) can be determined using the dial's fine-adjustment mechanism. If this size check reveals that the tool is not within the tolerance range specified by the manufacturer of the contacts, then you should contact the manufacture of the tool for further inspection.

Servicing and maintenance

Before you start to use the hand crimping tool, it must be clean and in proper working condition. Crimp residue or fragments must be removed from the crimping jaws and locator. The joints should be regularly lubricated using machine oil to protect them from dirt. Make sure that all bolts are secured with locking rings.

Technical data

Crimp contact	Wire cross-section (mm ²)	Crimping mandrel adjustment	Locator position	Order No.
Crimp male, signal 1 mm	0.14	0.75	11	1170150000
	0.25	0.82		
	0.34	0.90		
	0.50	1.00		
	0.75	1.08		
	1.00	1.20		
Crimp female, signal 1 mm (0.08 - 0.56 mm ²)	0.14	0.75	12	1995860000
	0.25	0.80		
	0.35	0.87		
	0.50	0.97		
Crimp female, signal 1 mm (0.34 - 1.00 mm ²)	0.50	0.95	12	1170180000
	0.75	4.00		
	1.00	1.05		
Crimp male, signal 1.5 mm	0.14	0.75	3	1170220000
	0.25	0.82		
	0.35	0.90		
	0.50	0.96		
	0.75	1.03		
	1.00	1.00		
Crimp female, signal 1.5 mm	0.14	0.75	4	1170230000
	0.25	0.80		
	0.35	0.87		
	0.50	0.97		
Crimp female, signal 1.5 mm (0.34 - 1.00 mm ²)	0.50	0.95	4	1170240000
	0.75	1.00		
	1.00	1.05		
Crimp male, signal 2 mm	0.75	1.30	5	1170250000
	1.00	1.40		
	1.50	1.55		
	2.50	1.75		
	2.50	1.75		
Crimp female, signal 2 mm	0.75	1.30	6	1170260000
	1.00	1.40		
	1.50	1.55		
	2.50	1.75		
	2.50	1.75		
Crimp male, power 1 mm	0.14	0.75	1	1170390000
	0.25	0.80		
	0.35	0.85		
	0.50	1.03		
	0.75	1.08		
	1.00	1.13		
Crimp female, power 1 mm	0.14	0.75	2	1995830000
	0.25	0.80		
	0.35	0.85		
	0.50	0.89		
	0.75	0.95		
	1.00	1.02		
Crimp male, power 2 mm	0.75	1.20	7	1170400000
	1.00	1.40		
	1.50	1.55		
	2.50	1.70		
	2.50	1.70		
Crimp male, power 2 mm	2.50	1.47	7	1170410000
	4.00	1.60		
	4.00	1.60		
Crimp female, power 2 mm	0.75	1.20	8	1995820000
	1.00	1.40		
	1.50	1.55		
	2.50	1.70		
Crimp female, power 2 mm	2.50	1.47	8	1170420000
	4.00	1.60		
	4.00	1.60		

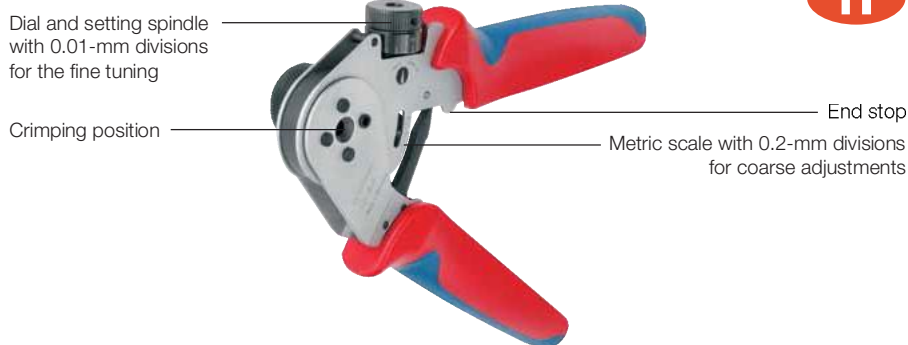
Ordering data

Type	Order No.
SAI M23 CRIMPING TOOL 1	1203840000

Operation mode

The following table specifies the locator positions and the crimping dimensions for various crimping contacts. The contact is inserted through the tool into the locator; this ensures the proper crimping position. The inserted contact is secured by closing gently (approximately to first snap-close level). Now the cable can be easily inserted and it is not possible for the contact to fall out. The tool must be pressed together until it reaches the end stop position in order to function properly. They are then able to open automatically which brings the crimping process to a close in the intended manner.

SAI M23 crimping tool 2



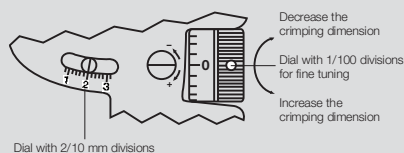
Adjusting the crimping dimensions

The adjustment mechanism is used to set the crimping depth of the crimping mandrel as described below. The adjusting dial is used to prepare the infeed; the dial can be turned clockwise (for decreasing the dimension) or counter-clockwise (for increasing the dimension).

Adjustment precision

- 1 division mark on the dial \cong 1/100 mm adjustment
- 1 complete revolution of the dial \cong 0,2 mm adjustment read from scale
- 5 revolutions of the dial \cong 1 mm adjustment read from scale

Verifying the crimping dimension



The four-mandrel crimping tool is pre-set at the factory. The actual crimping size should still be checked periodically. It should be checked using the plug gauge (\varnothing 1.0 mm) that is included with the crimping tool as described below. Use the dial on the stationary tool shank to set the size to 1.0 mm on the scale. Set to the zero-point tick mark on the dial and close the tool. (Refer to the diagram showing the crimping size adjustment.) At this setting, it should be possible to move the 1.00-mm- \varnothing plug gauge without any play or extra room. If this is not possible, then the size deviation (+/-) can be determined using the dial's fine-adjustment mechanism. If this size check reveals that the tool is not within the tolerance range specified by the manufacturer of the contacts, then you should contact the manufacture of the tool for further inspection.

Servicing and maintenance

Before you start to use the hand crimping tool, it must be clean and in proper working condition. Crimp residue or fragments must be removed from the crimping jaws and locator. The joints should be regularly lubricated using machine oil to protect them from dirt. Make sure that all bolts are secured with locking rings.

Technical data

Crimp contact	Wire cross-section (mm ²)	Crimping mandrel adjustment	Locator position	Order No.			
Crimp male 1 mm	0.14	0.86	1	1170150000			
	0.25	0.90					
	0.34	0.95					
	0.56	0.98					
	0.75	1.03					
	1.00	1.08					
Crimp female 1 mm (0.08-0.56 mm ²)	0.08	0.75	2	1995860000			
	0.14	0.78					
	0.25	0.82					
	0.34	0.86					
	0.56	0.90					
	0.34	0.77			2	1170180000	
0.56	0.82						
0.75	0.88						
1.00	0.95						
Crimp male 1.5 mm	0.14	0.65	3	1170220000			
	0.25	0.68					
	0.34	0.72					
	0.56	0.81					
	0.75	0.95					
	1.00	1.07					
Crimp female 1.5 mm (0.14-0.75 mm ²)	0.14	0.70		1170230000			
	0.25	0.73					
	0.34	0.77					
	0.56	0.85					
	0.75	1.05					
	0.34	0.88			1170240000		
0.56	0.95						
0.75	1.05						
1.00	1.13						
Crimp male 2.0 mm	0.75	1.20		1170250000			
	1.00	1.35					
	1.50	1.45					
	2.50	1.60					
	Crimp female 2.0 mm	0.75			1.25		1170260000
		1.00			1.35		
1.50		1.45					
2.50		1.60					

Ordering data

Type	Order No.
SAI M23 CRIMPING TOOL 2	1203960000