

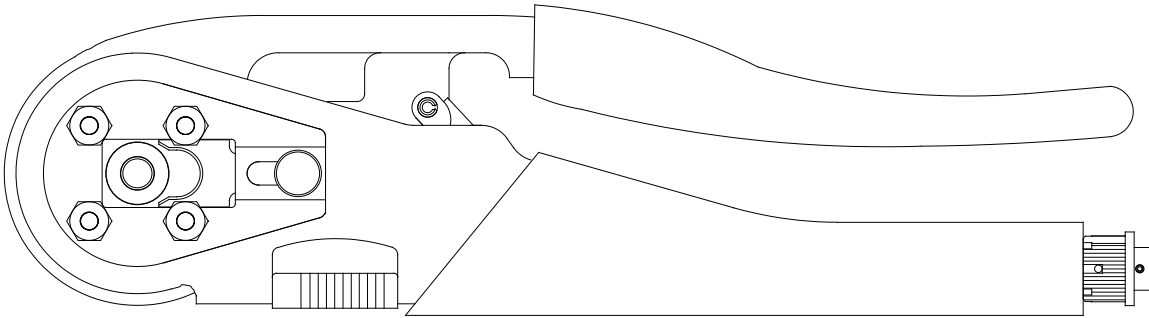


ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

HOW TO USE THE LARGE MICROCRIMP TOOL

Catalog Number 615702



GENERAL

The 615702 Microcrimp Tool is a micro adjustable, cycle controlled hand crimping tool. It is a fast, versatile, manually operated, octadent tool for crimping circular pin and socket contacts.

The tool is adjustable in a range of .075 to .125-inch. Settings to within .0005-inch increments are possible for precision crimping.

Locators are available for most applications, consult the factory for your specific needs.

For long life and optimum performance, this tool should be kept clean and handled carefully, as any other precision instrument.

OPERATION

Open and close the tool several times and observe the precision cycle control ratchet mechanism. Note that the tool may not be opened or closed without completing the cycle.

LOCATOR INSTALLATION. With the tool in the full open position, loosen the slide locking screw and move the slide in the direction indicated, see figure #1.

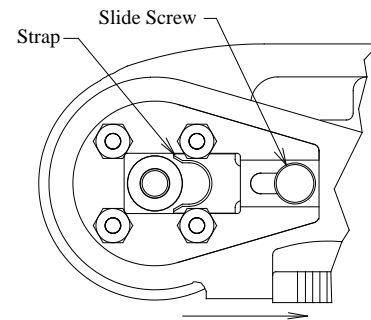


Figure #1

Select the proper locator for your application. Install the locator in the tool as shown in figure #2. The flange indicated on the locator should be flush with handle. Move the slide back into position and tighten slide screw.

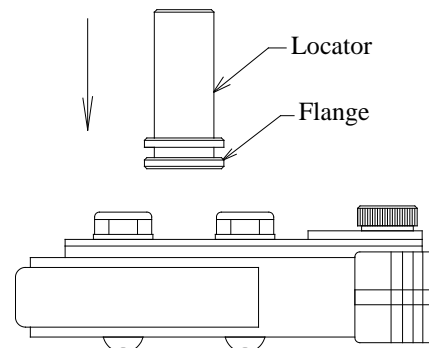


Figure #2

TOOL ADJUSTMENT. To adjust the indenter opening, locate the adjustment window on the tool and observe where the red indicator is located. Consult Data Plates on either side of the tool for gaging data. Pull and rotate the red adjustment knob, located at the end of the tool, until the indicator lines up with the desired size opening. Rotate clockwise to increase, counter-clockwise to decrease opening. See figure #3.

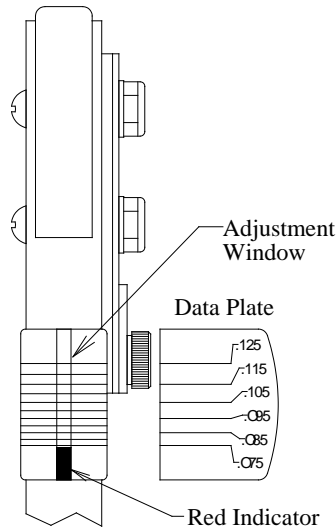


Figure #3

TOOL GAGING. It will be necessary to verify the opening by using gage pins. Select the proper GO gage pin for the opening required. Close the tool completely and insert the GO pin between the indenters, as shown in figure #4.

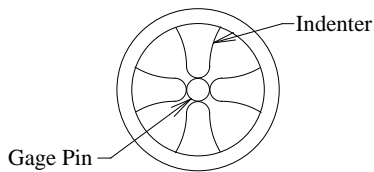


Figure #4

The gage pin should be a slip-fit between the indenter tips with no sloppiness or free play.

**CAUTION:
DO NOT CRIMP GAGE
TOOL DAMAGE WILL RESULT.**

Re-adjust adjustment knob as necessary.

TOOL SERVICE

Astro Tool's 615702 Crimp Tool is designed for long, reliable service. If the tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the tool to our factory.

Upon receipt of the tool, Astro will inspect and overhaul each tool to put the tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired.

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charge for such parts.

**ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL,
CRIMP TOOLS AND CONNECTOR SERVICE KITS**

ASTRO TOOL CORPORATION • 21615 S.W. T-V HWY. • BEAVERTON OREGON 97003
503-642-9853 • FAX 503-591-7766