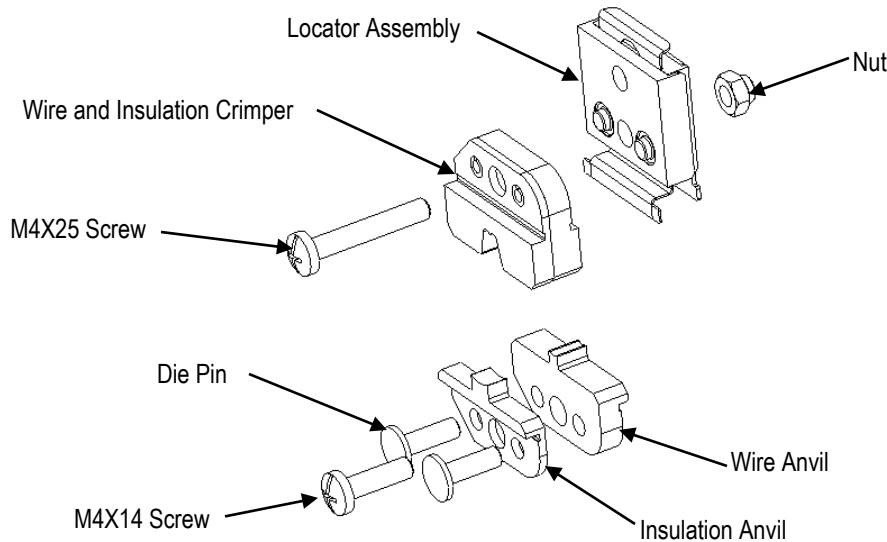


PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.



This die is a "commercial" grade die and is designed primarily for field installation, repair, maintenance work, or prototyping in industrial, commercial, or institutional applications. Product crimped with this tool will meet the crimp height requirement for hand tools in the appropriate 114 Series Application Specification, but may not comply with other feature parameters of the specification. TE Connectivity (TE) offers a variety of tools to satisfy your performance requirements. For additional information, call the number at the bottom of this page.

Die Assembly		Contact	Wire Dimensions		
Part Number	Locator Assembly ⁽¹⁾		Size [mm ²]	Insulation Diameter	Strip Length
2844392-2	2063771-2	41729	16-14 AWG [1.2-2.0]	.120-.170 [3.0-4.3]	.238 [6.05]

⁽¹⁾ Supplied with die assembly. Also available separately.

Figure 1

1. INTRODUCTION

This die assembly is used with SDE Closed Head Battery Tool 2217481-[] to crimp the contact onto the wire listed in Figure 1.

2. DESCRIPTION

Die components are shown in Figure 1.



NOTE

Dimensions in this instruction sheet are in inches [with millimeters in brackets]. Figures are not drawn to scale.

3. INSTALLATION AND REMOVAL OF DIE ASSEMBLY (FIGURE 2)



NOTE

Refer to Customer Manual 409-32032, Section 4.2, for die assembly and removal.



NOTE

The Wire and Insulation crimpers are held together by spring pins and are installed as one part.

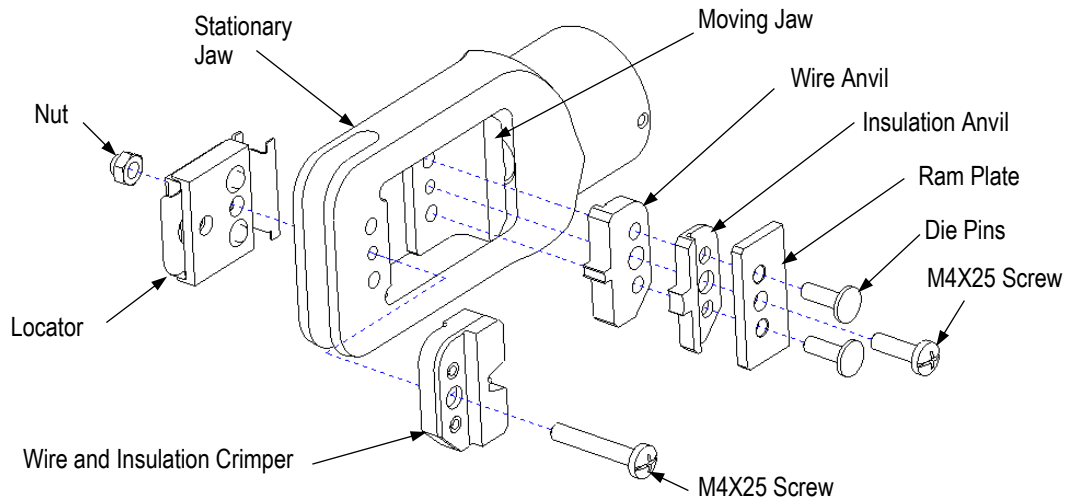


Figure 2

4. CONTACT SUPPORT ADJUSTMENT



NOTE

The contact support is preset prior to shipment, but minor adjustment may be necessary.

1. Crimp a sample according to Section 5 and determine if the contact is straight, bending upward, or bending downward. If adjustment is required (contact is bent), loosen the screw that holds the contact support onto the locator assembly (refer to Figure 3).
2. Place a contact with wire into the nest of the tool, and actuate the tool until the wire crimper bottoms against the wire anvil.

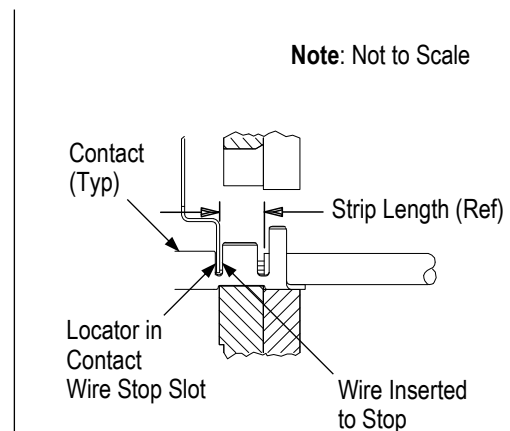
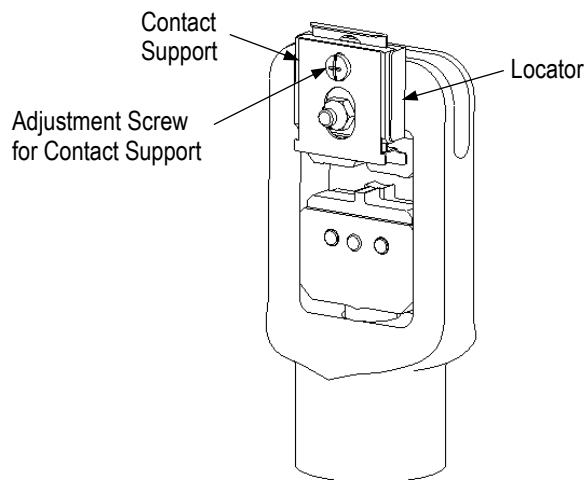


Figure 3

3. Slightly loosen the screw that holds the contact support to the locator assembly.
4. Move the contact support as required to eliminate bending of the contact.
5. Tighten the contact support screw.
6. Remove and inspect the contact.
7. Crimp another sample. If the contact is still being bent during crimping, repeat the adjustment procedure.

5. CRIMPING PROCEDURE



NOTE

Before using the tool, the contact crimp height should be verified as described in Section 6.

1. Strip the wire to the length indicated in Figure 1; taking care not to nick or cut wire strands.
2. Ensure the tool is fully opened.
3. Holding the contact by the mating end with the open “U” of the wire barrel facing the top of the tool, insert the contact (insulation barrel first) into the crimping chamber from the front of the tool. Position the contact up into the nest so the locator drops into the slot in the contact (see Figure 3). Move the front end of the wire barrel against the locator.



CAUTION

Make sure both sides of the insulation barrel are started evenly into the crimping chamber. Do not attempt to crimp an improperly positioned contact.

4. Hold the contact in position and actuate the ram until the die is closed sufficiently to hold the contact in position. **Do not deform the wire barrel or insulation barrel.**
5. Insert the stripped wire into the wire barrel until it butts against the wire stop as shown in .
6. Holding the wire in place, complete the crimp by actuating the ram until the crimp is complete and the tool opens. Remove the crimped contact.



NOTE

The crimped contact may stick in the crimping area, but the contact can be easily removed by pushing down on the top of the locator.

7. Check the contact crimp height as described in Section 6.

6. CRIMP HEIGHT INSPECTION

1. Refer to Figure 4, and select a maximum size wire.
2. Crimp the contact.
3. Using a crimp height micrometer, measure the crimp height as shown in Figure 4. If the crimp height conforms, the tool is considered dimensionally correct.



NOTE

Detailed information on obtaining and using crimp height comparators can be found in Instruction Sheet [408-7424](#).

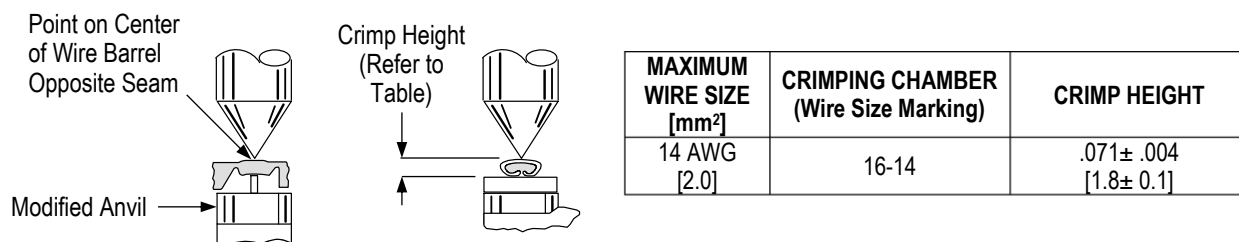


Figure 4

7. TOOL MAINTENANCE AND INSPECTION

7.1. Maintenance

1. Ensure that the tool and dies are clean by wiping them with a clean, soft cloth. Remove any debris with a clean, soft brush. **Do not use objects that could damage any components.**
2. Remove all lubrication and accumulated film from the dies by immersing the dies in a suitable commercial degreaser.

7.2. Visual Inspection

1. Inspection of the tool and dies should be made on a regular basis to ensure they have not become worn or damaged.
2. Make sure the proper die retaining screws are properly secured.
3. Inspect the crimping chamber of the die assembly for flattened, chipped, worn, or broken areas. If damage or abnormal wear is evident, the dies must be replaced. Refer to Section 8.

8. REPLACEMENT

If the dies are damaged or worn excessively, they must be replaced. Order dies through your representative, call 1-800-522-6752, send a facsimile of your purchase order to 717-986-7605, or write to:

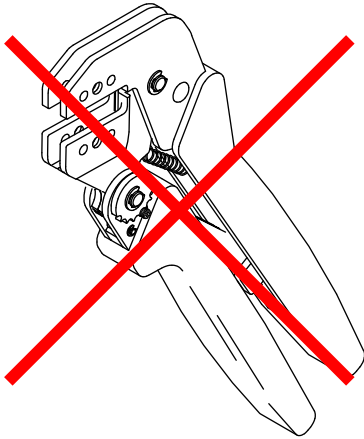
CUSTOMER SERVICE (038-035)
TE CONNECTIVITY CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

9. REVISION SUMMARY

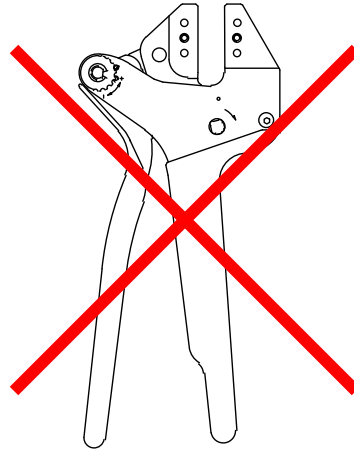
- Revised to latest enterprise name
- Revised NOTE in Section 2 to read "Dimensions are in inches [with millimeters in brackets]."
- Revised Figure 1 and Figure 4 to reflect NOTE change above

Tooling Compatible with Die Assembly PN 2844392-2

*PRO-CRIMPER III Hand Tool Frame 354940-1
(Instruction Sheet [408-9930](#))*



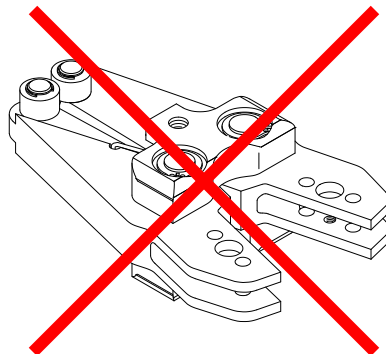
*SDE-SA Hand Tool 9-1478240-0
(Instruction Sheet [408-8851](#))*



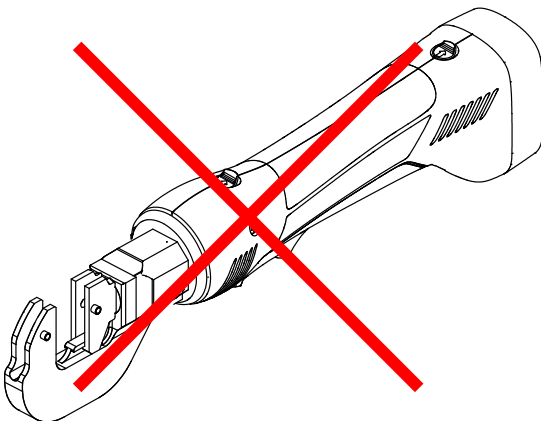
*SDE Bench Terminator 1490076-2
(Customer Manual [409-10052](#))*



*626 Adapter 679304-1
(Instruction Sheet [408-4070](#))*



*Battery Tool (Shouldered Die) 1725837-1 and -2
(Customer Manual [409-10053](#))*



*Battery Tool 2217481-1 and -2
(Customer Manual [409-32032](#))*

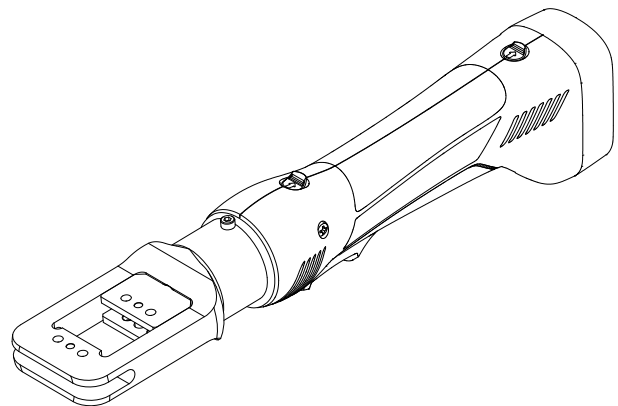


Figure 5

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