



ASTRO TOOL CORP.

Your Connection for Aerospace and Medical Tooling

Connector Assembly Tooling for Aerospace and Telecommunication

Ultra Precision Medical Crimping Tools

Operation Instructions for Portable Hex Die Crimp Tool No. 621200 and Associated Types

BASIC DESCRIPTION

The Astro Tool Corp. Portable Pneumatic Hex Die Crimper has all the features of the M22520/5-01 "C" frame crimp tool. It accepts all standard M22520/5 die sets and meets all the basic requirements of M22520/5.

TOOL REQUIREMENTS

The 621200 requires a 80-120 P.S.I. regulated, filtered and lubricated air supply. Astro offers the 11413 air regulator for this purpose.

BASIC OPERATION

1. Observe all caution labels on the tool before assembling dies or connecting the air supply to the tool.
2. Select the appropriate die set for the connector or contact to be crimped.

DIE INSTALLATION

3. Raise the safety shield by depressing the safety shield lever on the side of the crimp tool.
4. Insert the stationary die in the front of the tool. The keyway of the die should line up with key in the tool. Press on the die until the retaining ring clicks into place. See figure #1.

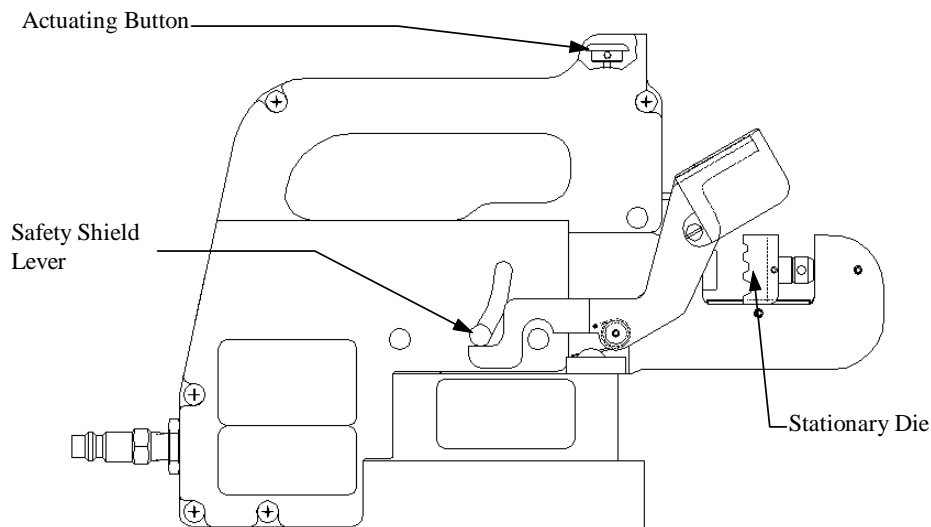


Figure # 1

5. With the safety shield raised, insert the movable die half into the back of the frame. The keyway of the die should align with the key in the tool. Press on the die until the retaining ring clicks into place. Release the safety shield after die installation.
6. Connect a regulated, filtered and lubricated air supply to the tool.

CRIMPING OPERATION

7. Pre-assemble the connector or contact to the prepared wire or cable following the manufacturer's specifications.
8. Raise the safety shield by depressing the safety lever.
9. Insert and position the connector in the stationary die.
10. Release the safety shield lever. The dies will hold the connector in place.
11. Depress the actuating button on top of the tool. The tool will complete one cycle.
12. Raise the safety shield and remove the crimped assembly.

DIE REMOVAL

13. Disconnect the air supply from the tool.
14. To remove the stationary die, use Astro part number DRT5 and position as shown on the front end of the frame. Tap the DRT5 as shown, see figure # 2. The stationary die will dislodge from the retaining ring and will be free for removal.

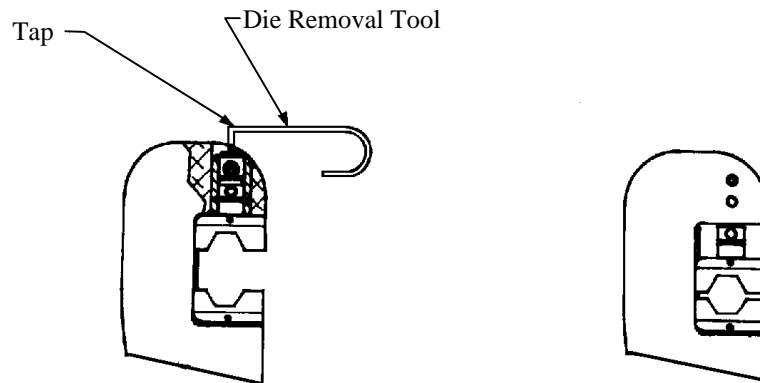


Figure # 2

15. To remove the movable die, hook the DRT5 tool around the die nest, as shown, see figure # 3. Push the safety shield lever down firmly using two hands. The movable die will dislodge from the retaining ring and will be free for removal.

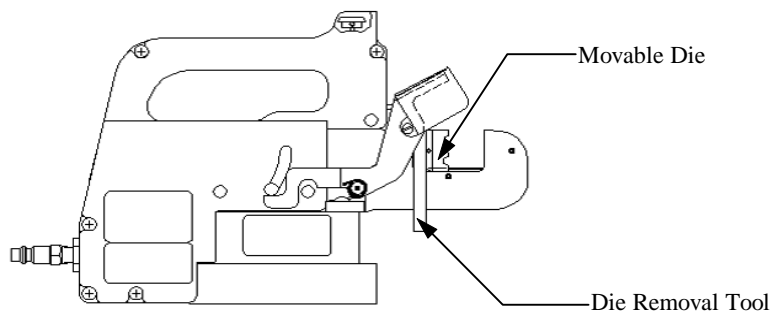


Figure # 3

EMERGENCY RELEASE

If the crimp tool should jam in the crimp position; release the tool by depressing the Emergency Release Lever. This releases air pressure from the air cylinder allowing the movable die to retract. See figure # 4.

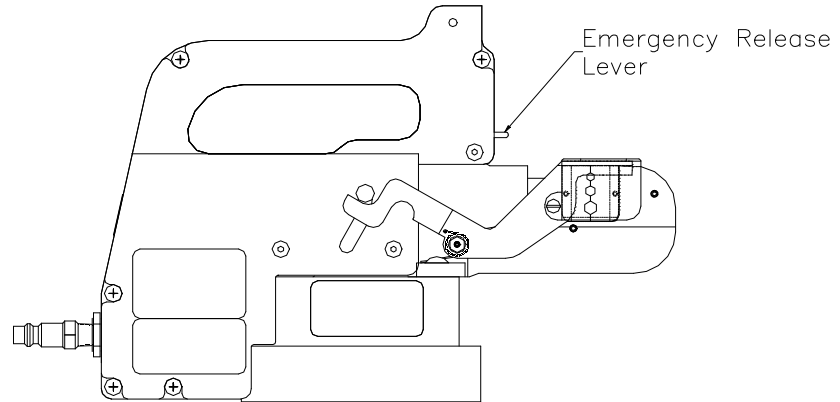


Figure # 4

INSTRUCTIONS FOR 621201 AND 621202 BENCH MOUNT

The Astro Tool Corp. 621200 portable pneumatic C-Frame crimping tool can be bench mounted for improved operating efficiency. The bench mount can be positioned at any angle to suit the operator. A foot pedal may be added to increase the versatility of the tool.

There are two versions of the bench mount assembly:

Part number 621201; A 360 degree swivel bench mount assembly.

Part number 621202; A 360 degree swivel bench mount assembly with a foot pedal actuator.

ASSEMBLY INSTRUCTIONS FOR 621201 BENCH MOUNT:

1. Firmly attach the base plate to the bench before attaching the tool; to prevent tipping.
2. Remove the stem from the base by loosening the hand screw.
3. Assemble the tool to the stem with the two screws and washers supplied. Before tightening the screws, center the tool on the stem plate.
4. Insert the stem into the base, select a desired angle and tighten the hand screw firmly.
See figure # 5.

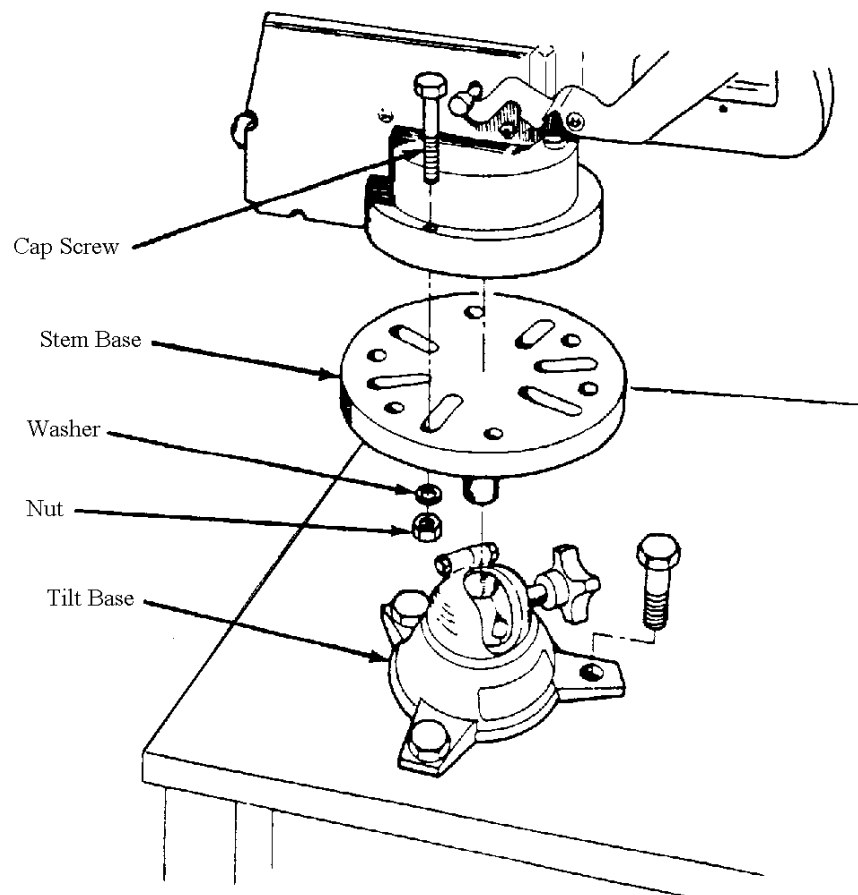


Figure #5

5. The tool is now ready for hand actuated operation as described in the BASIC OPERATION section of this manual.

621202 BENCH MOUNT AND FOOT SWITCH INSTALLATION:

1. Mount tool as described in instructions for 621201 Bench Mount Assembly Instructions section of this manual.

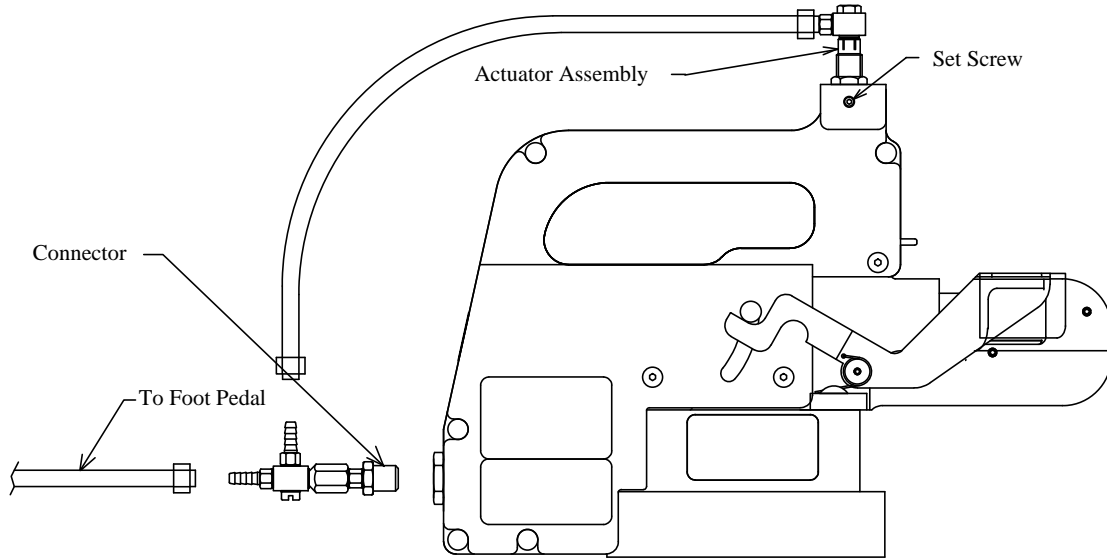
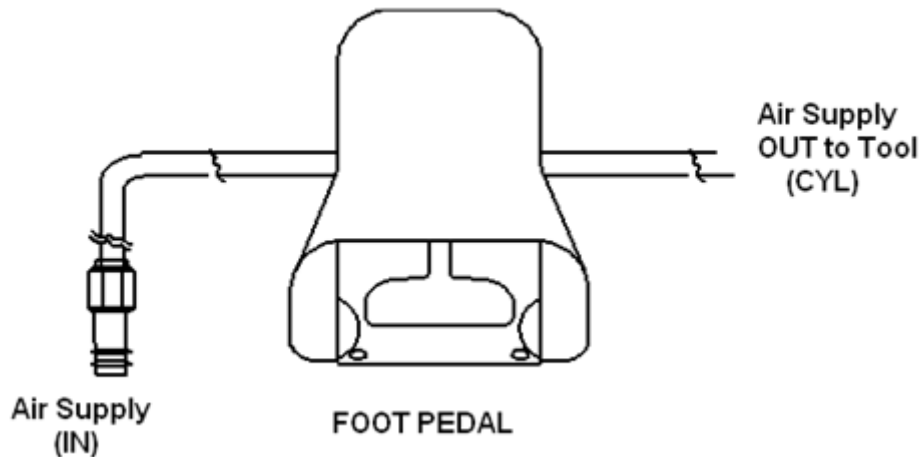


Figure # 6

2. Connect Foot Switch and Actuator Assembly to tool using supplied connectors. See Figure # 6.
3. Install the appropriate die set for the connector or contact to be crimped. Refer to DIE INSTALLATION section of this manual.
4. Connect filtered and lubricated air supply to the foot pedal assembly.
5. The tool is now ready for use. Follow the crimping instructions as described in the CRIMPING OPERATION section of this manual.



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