

HT270.02

Clincher Hand Tool

User's Manual



Revision : 01
Date : April 2013



www.foehrenbach.be

1. Purpose

Termination of dedicated flex-foils with FCI Clincher female or male connectors. HT270.02 is the successor of both the HT270 and HT274.



2. Tool description

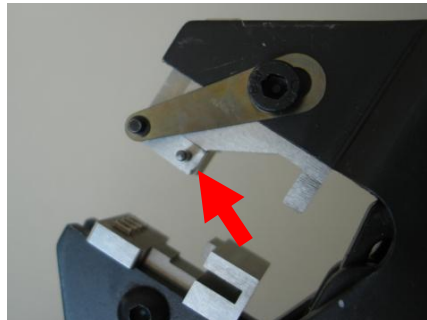
- Cat. No.: HT270.02
- Single head clinch tool. The tool terminates 2, 3 or 4 connector per cycle.
- The tool is equipped with an anvil that can support up to 4 Clinch contacts.
- Short set-up times.
- The tool kit consists of:
 - The manual clinch tool
 - This user's manual

3. The process

In order to accommodate the applied size of Clincher connector, the tool is featuring a press plate that can be adjusted for 2, 3 or 4 contacts. Before starting the termination process, please be sure that the mentioned devices are correctly installed and adjusted.



Press plate not active



Press plate active

With your finger, you can move the press plate between the active and not active position.





Left and right press plate not active



Left and right press plate active

3.1. Terminating a flex-foil

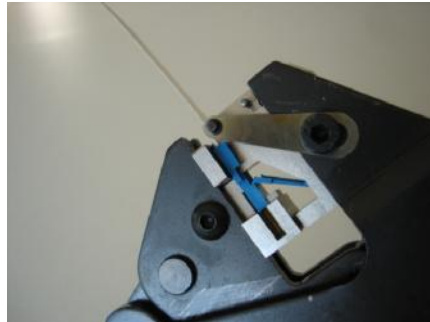
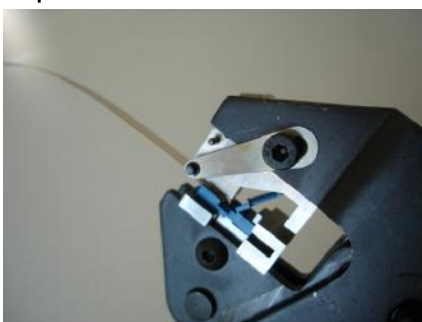
After a proper adjustment of the press plates, the tool is ready for terminating flex-foils.

1. Place the hand tool in your hand, so that the movable handle may be actuated.
2. Place Clincher connector on the anvil.

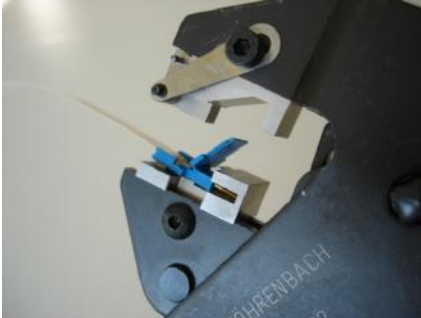


3. Place cable well positioned in the connector.

4. Close hand tool by moving the handle and hold Clincher connector with cable in place.



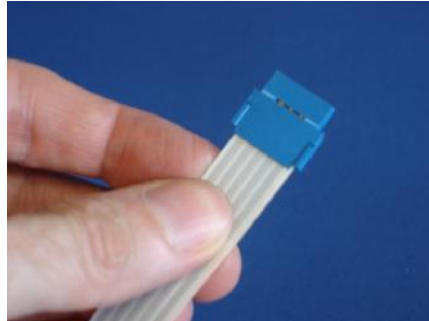
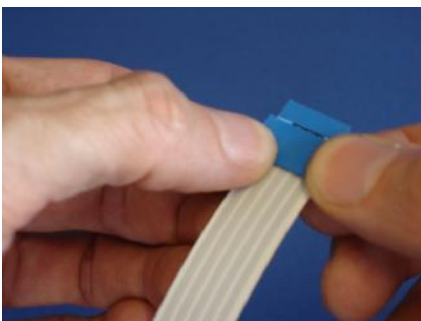
5. When the hand tool is completely closed, the movable handle may be returned to its standing position.



6. Repeat procedure 1-4 when a Clincher connector is used with more than 4 positions.



7. Close the connector.



Note:

The hand tool has stops, which prevents opening the tool before the clinch action is complete. Should it be necessary, the stop can be released by turning the ratchet wheel in the direction indicated by the arrow. Keep the movable handle under light pressure during this operation.



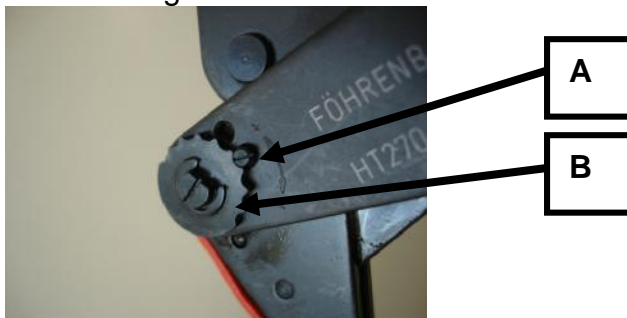
Attention!

In order to warrant the termination quality, verify constantly the clinch quality and clinch height in order to verify the quality and take the responsibility related to the produced terminations.

This manual is describing only a production means. For all termination and connector related issues, please follow the instructions as described in the FCI Technical Application TA-372.

4. Adjustments and maintenance

- The tool is adjusted by Föhrenbach Application Tooling engineers for the characteristics of a test flex-foil. In order to warrant a proper operation, the crimp height must be adjusted for the applied flex-foil. The crimp height and quality criteria in relation with the applied flex-foil are described in the application note TA-372 or any update issued by FCI.
- The crimp height can be adjusted as follows. Remove the screw "A" and turn the wheel "B" in the + or – direction. After completing the adjustment, install screw "A" again.



- Regular checks must be made on press plate and anvil.
 - If necessary, these parts may be cleaned.
 - Damaged parts must be replaced immediately.
 - Movable parts should be lightly oiled.
- For any support, please contact Föhrenbach Application Tooling:

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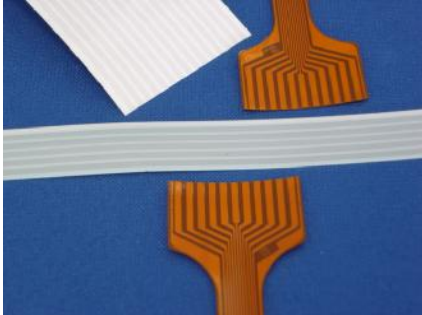
5. General specifications

- Colour : black metal with red plastic levers.
- Weight of tool : +/- 0,6 kg
- Size : l: 205 mm x w: 100 mm x h: 22 mm

6. Input material and functional requirements

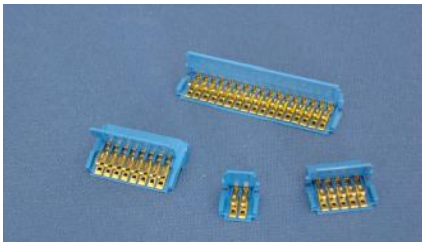
6.1. Cable

- Flex-foil cable that fits to the applied Clincher connectors.



6.2. Components

- Female and male Clincher connectors. Number of positions: 2 till 34.
- Product part number:
 - Male clincher 66226-series
 - Female clincher 65801-series
 - Latched clincher 67516-series



7. Process output

- Due to the manual process, the output capacity and quality are highly depended on the skills of the operator.

8. Safety and ergonomics

- Apply the tool only for the target as mentioned in chapter 1. Purpose.
- For operator safety, it's necessary to apply eye protection.
- Apply the tool only in a dry and clean environment.
- Apply the tool only in a well-lit area (1000 Lux).
- Only skilful operators who are trained by Föhrenbach Application Tooling engineers are allowed to apply the tool.

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