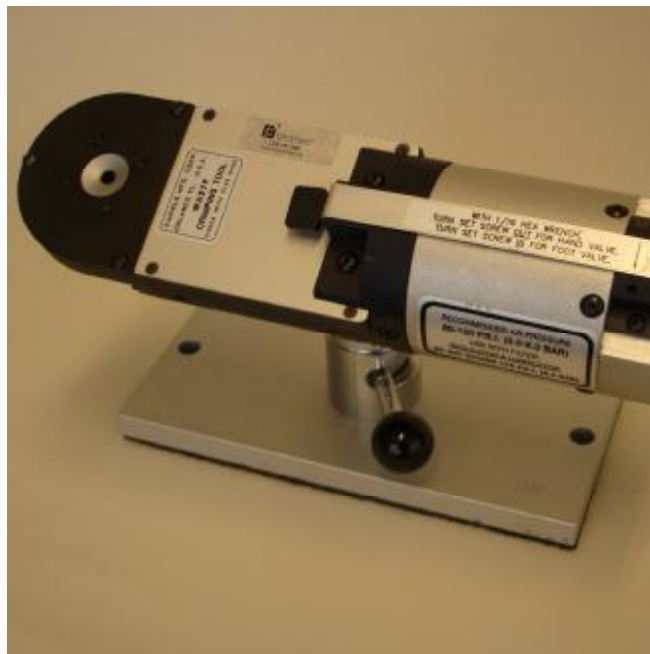


LTA 101 055

Pneumatic Crimp Tool

User's Manual



Revision : 02
Date : March 17, 2005



www.foehrenbach.be

1. Purpose

Crimping of FCI power contacts type 72715-701.



2. Tool description

- Cat. No.: LTA 101 055
- 8 indent pneumatic crimping tool.
- Short set-up times.
- The system consists of:
 - The pneumatic crimp tool
 - This user's manual
 - A bench mount
 - Foot valve
 - Locator

3. The process

Put the contact in the tool till it seats properly in the locator. Put the wire in the contact. Activate the foot pedal. Release the foot pedal and take the crimped wire assembly. The locator is spring loaded. As such, in order to repeat the crimping position, you have to decide if the operator should push the wire plus contact to the hard stop (over win the spring force) or not.

3.1. Cable prep and crimp specifications

Please refer to FCI product spec GS-12-308, FCI application spec GS-20-053.

4. Adjustments

- At the rear, the tool is equipped with a crimping depth adjustment. Position 1 provides the highest crimping depth, while position 8 provides the lowest crimping depth. Depended on your measured pull off force and the mentioned spec, you have to adjust the crimping depth.



Crimping depth adjustment

- The tool is equipped with an adjustable locator. By adjusting the locator, you can position the contact in the crimping die. For a correct adjustment, please refer to the mentioned spec.



Locking ring

Contact position adjustment

- For any support, please contact Föhrenbach Application Tooling:

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5. General specifications

- Colour : Black / metal.
- Weight : crimp tool= 3 kg, foot valve= 2 kg
- Size : l: 260 mm x w: 100 mm x h: 170 mm

6. Input material and functional requirements

6.1. Wire

- Stranded wire which is specified for the 72715-701 contacts.

6.2. Components

- FCI power contacts type 72715-701.



7. Process output

- Due to the manual process, the output capacity is 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 lighted environment (1000 Lux).
- Only skilful operators who are trained by Föhrenbach Application Tooling engineers are allowed to apply the tool.

9. Environmental conditions

9.1. Ambient temperature

The ambient temperature is measured at a height of 1.5 m above the floor.

- | | | |
|----|--|-----------------|
| a. | Normal range | : + 15 to +30°C |
| b. | Average value | : ± 23°C |
| c. | Maximum variation within a 5 min. period | : ± 5°C |

9.2. Humidity

- | | | |
|----|---|------------------|
| a. | Normal range (no condensation) | : 40 to 70% R.H. |
| b. | Range not resulting in constantly reduced operation | : 10 to 90% R.H. |

9.3. Atmospheric pressure

Normal range: 533 - 1060 m bar.

10. Power connections

10.1. Electrical

No electrical supply required.

10.2. Pneumatic

Industrial compressed air. 6 bar.

11. Warranty

Please refer to our Terms and Conditions of Sale.

Appendix

Connections

Connect the air supply to the foot pedal.



Connect the foot pedal to the crimping tool



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