

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.

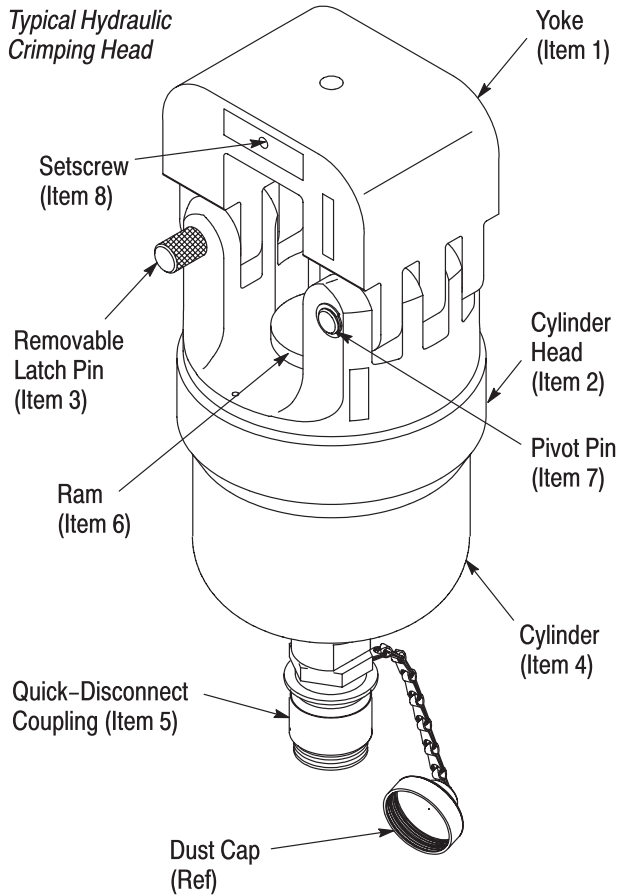


Figure 1

1. INTRODUCTION

This instruction sheet covers a series of inspections and servicing procedures for Tyco Electronics Hydraulic Crimping Heads 1673672-1 (408-8910), 1752787-1 (408-8914), 1752788-1 (408-8915), 1752877-1 (408-8956), and 1976230-1 (408-10145). See Figure 1.

These crimping heads are recommended for use only with Foot Hydraulic Pump 1583659-1, Hydraulic Hand Pump 1583661-1, and with Electric Hydraulic Pumps 1804700-1 (115 Vac), and 1804700-2 (230 Vac).

2. INSPECTION AND SERVICING

At intervals of once a year or every 7500 cycles, whichever comes first, the hydraulic head should be returned to Tyco Electronics for magnetic particle inspection. Additionally, inspect and service the head every month or every 1,000 cycles, whichever comes first, following the information in Figure 2.

Addresses for Tyco Electronics service and repair, or for replacement parts, are provided in Section 3, REPAIRS.

3. REPAIRS

A complete inventory of customer-replaceable parts listed on the appropriate instruction sheet for each crimp head should be stocked and controlled to prevent lost time when replacement of parts is necessary. Order replacement parts through your Tyco Electronics Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

Tools may also be returned for evaluation and repair. For tool repair service, contact a Tyco Electronics Representative at 1-800-526-5136.

4. REVISION SUMMARY

- Updated document to corporate requirements
- Added crimping head 1976230-1 and changed pump part numbers in Section 1

FIGURE 1 (ITEM NO.)	FIGURE 1 (ITEM NAME)	INSPECT ITEM FOR THESE PROBLEMS	IF PROBLEMS ARE FOUND DO THIS TO CORRECT THEM
1	Yoke	CRACKS, GOUGES, NICKS, or GALLING where yoke contacts dies (Visual Inspection)	CRACKS: Return to Tyco Electronics for repair (See Section 3, REPAIRS) GOUGES, NICKS, or GALLING: Remove any sharp edges using fine emery cloth

Figure 2 (cont'd)

FIGURE 1 (ITEM NO.)	FIGURE 1 (ITEM NAME)	INSPECT ITEM FOR THESE PROBLEMS	IF PROBLEMS ARE FOUND DO THIS TO CORRECT THEM
2	Cylinder Head	CRACKS, GOUGES, NICKS, or GALLING where cylinder head contacts dies (Visual Inspection)	CRACKS: Return to Tyco Electronics for repair (See Section 3, REPAIRS)
			GOUGES, NICKS, or GALLING: Remove any sharp edges using fine emery cloth
3	Removable Latch Pin	PIN STICKS or DOES NOT MOVE FREELY- Should normally rotate freely and be easily disassembled and re-assembled	Remove any BURRS, RUST, or SHARP EDGES using fine emery cloth
4	Cylinder	CRACKS, GOUGES, NICKS, or GALLING where yoke contacts dies (Visual Inspection)	CRACKS: Return to Tyco Electronics for repair (See Section 3, REPAIRS)
		LEAKS OIL between cylinder and coupling; coupling STICKS to cylinder - Should normally turn on and off freely when moderate pressure is applied using a wrench	GOUGES, NICKS, or GALLING: Remove any sharp edges using fine emery cloth LEAKS OIL or STICKS: Tighten or replace coupling
5	Quick Disconnect Coupling	COUPLING MATES HARD or WON'T MATE or UNMATE, LEAKS OIL, or STICKS at hose connection - Should normally turn on and off freely by hand	Replace coupling if not satisfactory
6	Ram	<i>Power "ON" (Ram "UP")</i> GALLING, CRACKS, or OIL LEAKS between ram and cylinder head or between cylinder and cylinder head (Visual Inspection)	CRACKS or OIL LEAKS: Return tool to Tyco Electronics for repair (See Section 3, REPAIRS)
		Ram DOWEL PIN SHORT, DAMAGED, or OUT-OF-POSITION - Should normally be flush to or below ram counterbore (See NOTE)	GALLING: Remove any sharp edges using fine emery cloth PINS: Return tool to Tyco Electronics for repair (See Section 3, REPAIRS)
		Ram SETSCREW STICKS - Should normally turn in and out easily when moderate pressure is applied using a hex wrench	SETSCREW: Replace if not satisfactory
		<i>Power "OFF"</i> RAM DOES NOT RETURN freely or fully to its original position	RAM: Return tool to Tyco Electronics for repair (See Section 3, REPAIRS)
7	Pivot Pin	YOKE STICKS when pivoting, or will not pivot freely	Remove any BURRS, RUST, or SHARP EDGES using fine emery cloth, lubricate with light oil and re-assemble - if not corrected, replace pin
8	Setscrew	SETSCREW DOES NOT HOLD stationary die in place, or SETSCREW STICKS - Should normally turn in and out easily when moderate pressure is applied using a hex wrench	Replace setscrew if unsatisfactory

NOTE: Pin Inspection applies only to hydraulic heads 1752787-1, 1752788-1, 1752877-1, and 1976230-1. Setscrew inspection does not apply to hydraulic head 1976230-1.

Figure 2 (end)