



Crimping Heads	Specification
58422-1	408-9535
58445-1	408-9598
DYNA-CRIMP* 69051	408-2450
DYNA-CRIMP 69065	408-2452
DYNA-CRIMP 69066	408-2453
DYNA-CRIMP 69067	408-2454
DYNA-CRIMP 69069	408-1745
2161730-1	408-9535

Figure 1

1. INTRODUCTION

This instruction sheet covers a series of inspections and servicing procedures for Hydraulic Crimping Heads listed in the table in Figure 1.

These crimping heads are recommended for use only with Hydraulic Hand Pump 314979-1 (Customer Manual 409-5860); and with DYNA-CRIMP Hydraulic Power Units 69120-1, 115 VAC, and 69120-2, 230 VAC (Customer Manual 409-1950).

Warning: To avoid personal injury and potential damage to the crimp head, TE Connectivity (TE) requires the crimp head to operate at 8,000 to 8,400 PSI [552 to 579 bar]. TE recommends using 8,200 PSI [565 bar] TE Hydraulic Pumps as other manufacturers' pumps may apply insufficient pressure (resulting in an inadequate crimp) or excessive pressure (resulting in failure of the head). Additionally, the TE pump must be used to maintain CE certification; if using other manufacturers' pumps, the user is responsible for self-certification.



NOTE

Illustrations are for reference only and are not drawn to scale.

2. INSPECTION AND SERVICING

At intervals of once a year or every 7500 cycles, whichever comes first, the hydraulic head should be returned to TE 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 TE service and repair, and replacement parts are provided in Section 3; REPLACEMENT PARTS and REPAIRS.

Figure 1 Item No.	Figure 1 Item Name	Inspect for This Problem	Solution
1	Yoke	CRACKS, GOUGES, NICKS, or GALLING where yoke contacts dies (Visual Inspection)	CRACKS: Return to TE for repair (See Section 3)
			GOUGES, NICKS, OR GALLING: Remove any sharp edges using fine emery cloth
2	Cylinder Head	CRACKS, GOUGES, NICKS, or GALLING where cylinder head contacts dies (Visual Inspection)	CRACKS: Return to TE for repair (See Section 3)
			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 TE for repair (See Section 3)
		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)	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
6	Ram	Power "ON" (Ram "UP") - GALLING, CRACKS, or OIL LEAKS between ram and cylinder head or between cylinder and cylinder head (Visual Inspection)	GALLING: Remove any sharp edges using fine emery cloth CRACKS or OIL LEAKS: Return to TE for repair (See Section 3)
		Ram DOWEL PIN SHORT, DAMAGED, or OUT OF POSITION (should normally be flush with or below ram counter-bore (NOTE: Pin inspection applies only to hydraulic heads 58422-1, 58445-1, and 2161730-1))	Pin problem: Return to TE for repair (See Section 3)
		Ram SETSCREW STICKS (should normally turn in and out easily when moderate pressure is applied using a hex wrench)	Replace setscrew
		Power "OFF" - Ram does not return freely or fully to its original position	Ram problem: Return to TE for repair (See Section 3)
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

Figure 2

3. REPLACEMENT PARTS AND REPAIRS

A complete inventory of customer-replaceable parts listed on the appropriate customer drawing should be stocked to allow immediate replacement. Order parts through your TE Representative or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write, or return the entire tool for evaluation and repair, with a written description of the problem to:

CUSTOMER SERVICE (38-35)
TE CONNECTIVITY CORPORATION
P.O. BOX 3608
HARRISBURG, PA 17105-3608

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

4. REVISION SUMMARY

- ◆ Added Warning (paragraph 1)
- ◆ Added Hydraulic Head 2161730-1
- ◆ Revised interval for magnetic particle inspection (paragraph 2)
- ◆ Added tool evaluation and repair reference (paragraph 3)