



Operating Instructions

HT40 Die Set, MPT 6.0 - 10.0 sq.mm

Customer Manual No.: 411-18588-1 Rev.A
Customer Manual PN: 2-744017-0
Language: EN (translation of the German original version)

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1 Revision history

Rev.	Date	Description	Name
A	20.11.2015	First version	Levin Sandhu

Tab. 1 : Revision history

2 Introduction

2.1 About these operating instructions

These operating instructions describe the use and operation of the HT40 crimping die with the hand crimping tool and the necessary maintenance measures. All persons using the crimping die must therefore be familiar with and follow these operating instructions. It should be stressed that the operating instructions for the crimping die are essential.

These operating instructions must be available with the crimping die at all times. The tool owner and/or user is obliged to supplement these operating instructions with instructions in line with existing national regulations for the prevention of accidents and environmental protection.

These operating instructions apply to the following crimping die from TE Connectivity:

- HT40 DIE SET, MPT 6.0-10.0 SQ.MM: TE PN 7-1579016-3

The following document must be observed in addition to these operating instructions:

- HT40 BASIC HAND TOOL: TE PN 4-1579000-0 / 411-18589

2.2 Intended use

The HT40 crimping die is used to crimp terminals according to the TE processing specification and drawing. The crimping die may only be used for repair purposes or for making samples, not for series production. The following terminals can be processed with the crimping die:

Terminal PN	Cross-section	Terminal	TE processing specification
962933 / 962921 LP* 962932 / 962918-1 LP*	6 sq.mm	Maxi Power Timer	114-18075 TE PN 7-1579016-3
962933 / 962921 LP* 962932 / 962918-1 LP*	10 sq.mm	Maxi Power Timer	114-18075 TE PN 7-1579016-3

Tab. 2 : Processable terminals

LP* = Loose Piece

3 Description

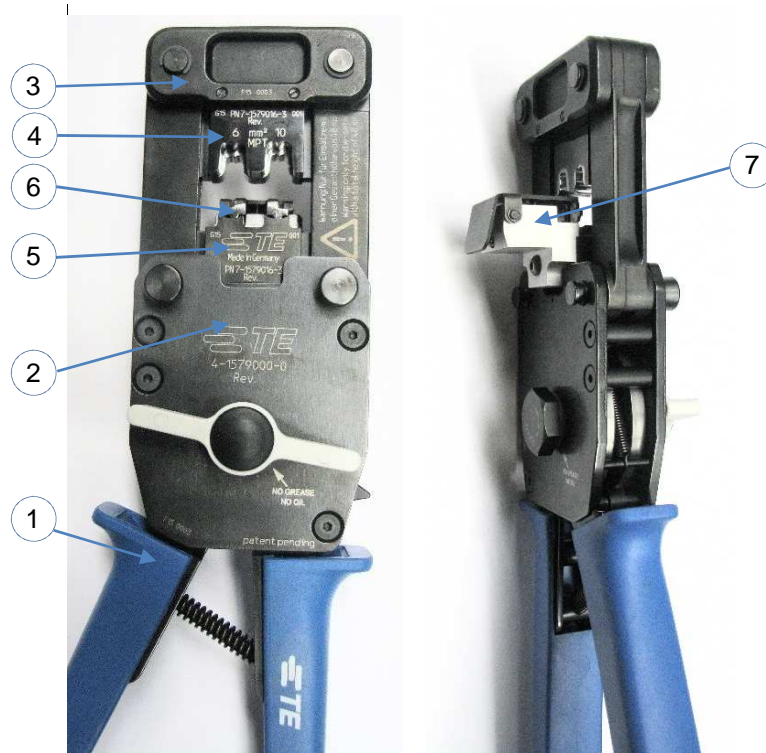


Abb. 1 : The hand tool, front (left), rear (right)

Item	Designation	Item	Designation
1	Tool handles	2	Hand tool basic body
3	Hand tool head	4	Crimping die top
5	Crimping die bottom	6	Wire stop plate
7	Locator		

Tab. 3: Hand tool components

4 Changing the dies

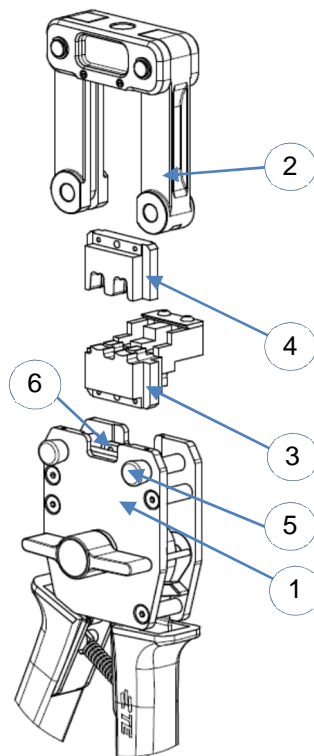


Abb. 2 : Exploded drawing (representation may differ)

No.	Designation	No.	Designation
1	Hand tool basic body	2	Crimping head/Upper die holder
3	Lower die	4	Upper die
5	Locking pin	6	Lower, movable die holder

Tab. 4 : Components of the hand tool

4.1 Installing dies

- Select the crimping die that you require.
- Open the tool handles and make sure that the movable die holder is completely retracted.
- Pull both locking pins out until the stop.
- Remove the crimping head.
- Position the lower die in the lower die holder until it has engaged.

NOTE

Ensure that the die label points in the direction of the fast feed lever.

- Position the upper die in the crimping head until it has engaged.

NOTE

Ensure that the die label points in the direction of the fast feed lever.

- Insert the crimping head into the hand tool basic body again.
- Press the locking pins until the stop.

4.2 Removing dies

- Open the tool handles and make sure that the movable die holder is completely retracted.
- Pull both locking pins out until the stop.
- Remove the crimping head.
- Remove both crimping dies.
- Insert the crimping head into the hand tool basic body again.
- Press the locking pins until the stop.

5 Operation

5.1 Crimping terminals

- Fully open the tool.
- First, press the wire stop plate down so that the terminal holder opens and the terminal can be inserted into it.
- Insert the terminal to be processed into the right terminal holder for the wire cross-section. Make sure the terminal is pushed into the wire stop in the terminal holder.
- Release the terminal positioner, so that the terminal is fixed in place.



Abb. 3: Terminal holder opened (left), terminal positioned (right)

- Close the hand tool so that the edges of the terminal reach the top crimping shape.
- Strip the wire according to the processing specification.
- Insert the wire into the terminal until it reaches the wire stop.



Abb. 4 : Terminal positioned (left), insert wire to wire stop (right)

- ➔ Close the hand tool handles until the ratchet mechanism releases and the handles open.

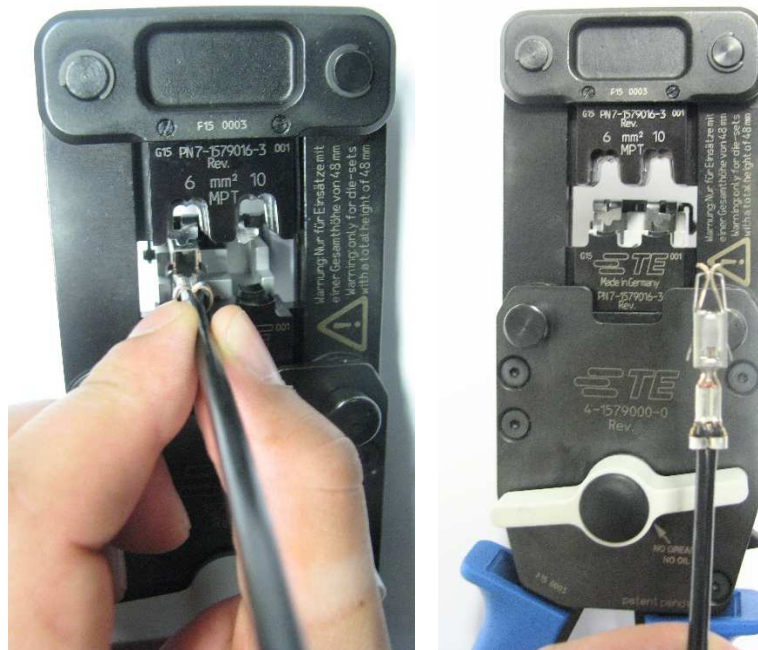


Abb. 5 : Remove terminal (left), crimped terminal (right)

- ➔ Remove the crimped terminal from the crimping die. If the terminal is stuck, wiggle it slightly to remove it.
- ➔ Check the crimp height of the crimped terminal. Refer to the information in the TE Connectivity processing specification and the drawing.

6 Customer Service, EMEA Service Hotline

Please contact us for service enquiries or technical support:

Monday - Thursday 8 am - 4 pm
Friday 8 am - 2 pm
Tel. +49 (0) 6151 607 -1518
www TEFE1@TE.COM (EMEA Customer Support)
www TEFE2@TE.COM (EMEA Hand Tool Repair)

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c/o Schenck Technologie- und Industriepark GmbH
Landwehrstr. 55/Gebäude 83
64293 Darmstadt
Germany

Additional information and contact details can also be found online.
Visit us at: <http://tooling.te.com/>

7 Maintenance and servicing

7.1 Daily Maintenance

The following daily maintenance tasks should be performed by the responsible operator:

- Using a soft, clean brush or a lint-free cloth, remove dirt, dust, moisture and other residue from the crimping die set. Do not use any hard or abrasive tools or materials that could damage the crimping die set.
- Apply sewing-machine oil to all pivot points and bearing surfaces. Do not lubricate excessively.
- If the crimping die set is not needed, store it in a clean and dry location.

7.2 Periodic inspection

- The crimping die set should be inspected periodically by suitably qualified staff according to the level of use, and the inspections should be documented.
- Check the crimping die set for wear and damage, particularly in the crimping nest areas.