

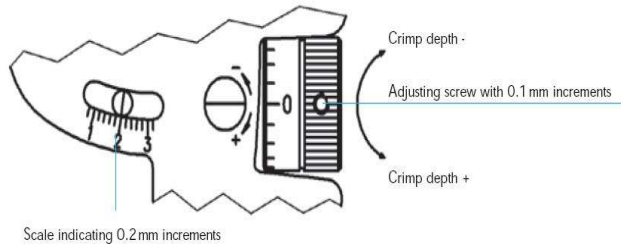
### Adjustment of Crimp Depth

Crimp depth can be adjusted as follows:

Turn the adjusting screw clockwise for reducing the crimp depth and counter-clockwise for increasing the crimp depth.

### Adjustment Increments:

- 1 space on the adjusting screw = adjustment by 0.01 mm
- 1 full rotation of adjusting screw = adjustment by 0.2 mm (indication on the screw as well as on the rough scale)
- 5 rotations of the adjusting screw = adjustment by 1 mm (indication on the scale)



Crimp tool .....KP-TOOL-01 / 1201550017

### Application

The four indent crimp tool KP-TOOL-01 / 1201550017 has been developed for optimal crimping of machined contacts with diameters from 0.14 to 6.0 mm<sup>2</sup> (26 through 10 AWG).

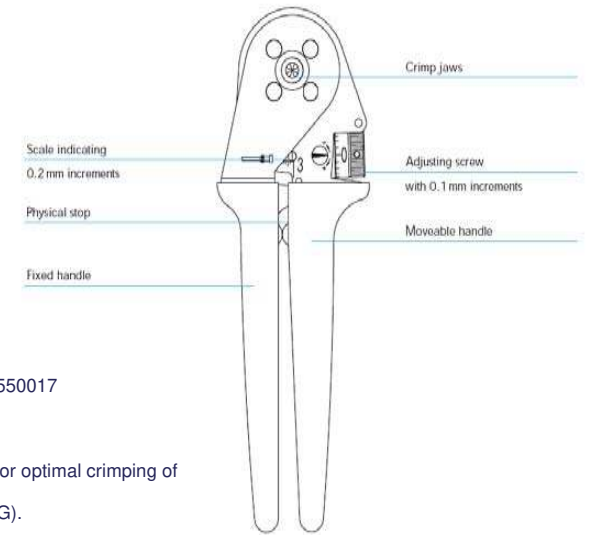
### How to Crimp

The reference table indicates the correct locator position to be selected and the crimp depth to be adjusted for the contact to be crimped. The contact is then inserted through the access hole of the tool on the opposite side of the locator. The contact is held in place by closing the handles to the first lock-in position thus preventing the contact from falling out of the tool and facilitating insertion of the wire into the contact.

The precision ratchet assures consistently accurate crimping every time by forcing the tool to be closed all the way completing the crimping cycle before the tool can be opened again.

### Exchange of the Locator

The locator can be exchanged by removing the socket head cap screw with a socket wrench. It can then be disassembled from the hex head screw by turning it counter-clockwise.



### Control of Crimp Depth

Crimp tool adjustment is done at the factory, but with frequent use, periodic calibration is recommended to insure accuracy. This is easily accomplished with a 2.0 mm Ø wire gauge as follows.

A crimp depth of 2.0 mm is set by means of the adjusting screw (scale mark at „2“, screw mark at „0“ as shown in the fig. above) and the tool in the closed position.

After insertion of the gauge, there must be just enough space for moving the gauge inside the entry hole. If the opening is too small or too large to exactly match the gauge, the deviation (+/-) can be checked by the precision setting of the screw.

Please contact the factory in case the deviation exceeds the tolerances specified by the contract manufacturer.

### Maintenance and Repair

Keep the tool clean and properly stored when not in service. All pivot points need to be oiled regularly and the spring clips securing the bolts have to always be in place.

For repair please send the tool back to the factory.

EC NO: WELU2010-0448 DRWN: FP 3/18/2010 CHKD: RE 3/18/2010 APPR: NS 3/19/2010	QUALITY SYMBOLS 	GENERAL TOLERANCES (UNLESS SPECIFIED)		DIMENSION STYLE	SCALE	DESIGN UNITS	FIRST ANGLE PROJECTION
		mm	INCH	MM ONLY	NTS	METRIC	
		4 PLACES ±---	±----	DRAWN BY	M23-PWR-CRIMP TOOL		
		3 PLACES ±---	±----	DATE	-		
		2 PLACES ±0,05	±----	FP 3/18/2010	-		
1 PLACE ±0,10	±----	CHECKED BY	-				
ANGULAR ± 1/2 °	±----	RE 3/18/2010	-				
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	DESCRIPTION REV	APPROVED BY		MATERIAL NO.	DOCUMENT NO.	SHEET NO.	
		NS 3/19/2010		1201550017	SD-120155-017	1 OF 1	
		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION		SIZE	MOLEX MOLEX INCORPORATED		
01	REV			A3			