


11148000	Operating Instructions	
Valid from: 30.03.2023	EPIC® CIRCON CRIMPING TOOL	


EPIC® CIRCON CRIMPING TOOL 11148000

Operating Instructions for

EPIC® 1mm & 2 mm Contacts of the circular connectors M23 & LS1



Important information on the correct use of the EPIC® CIRCON Crimping Tool

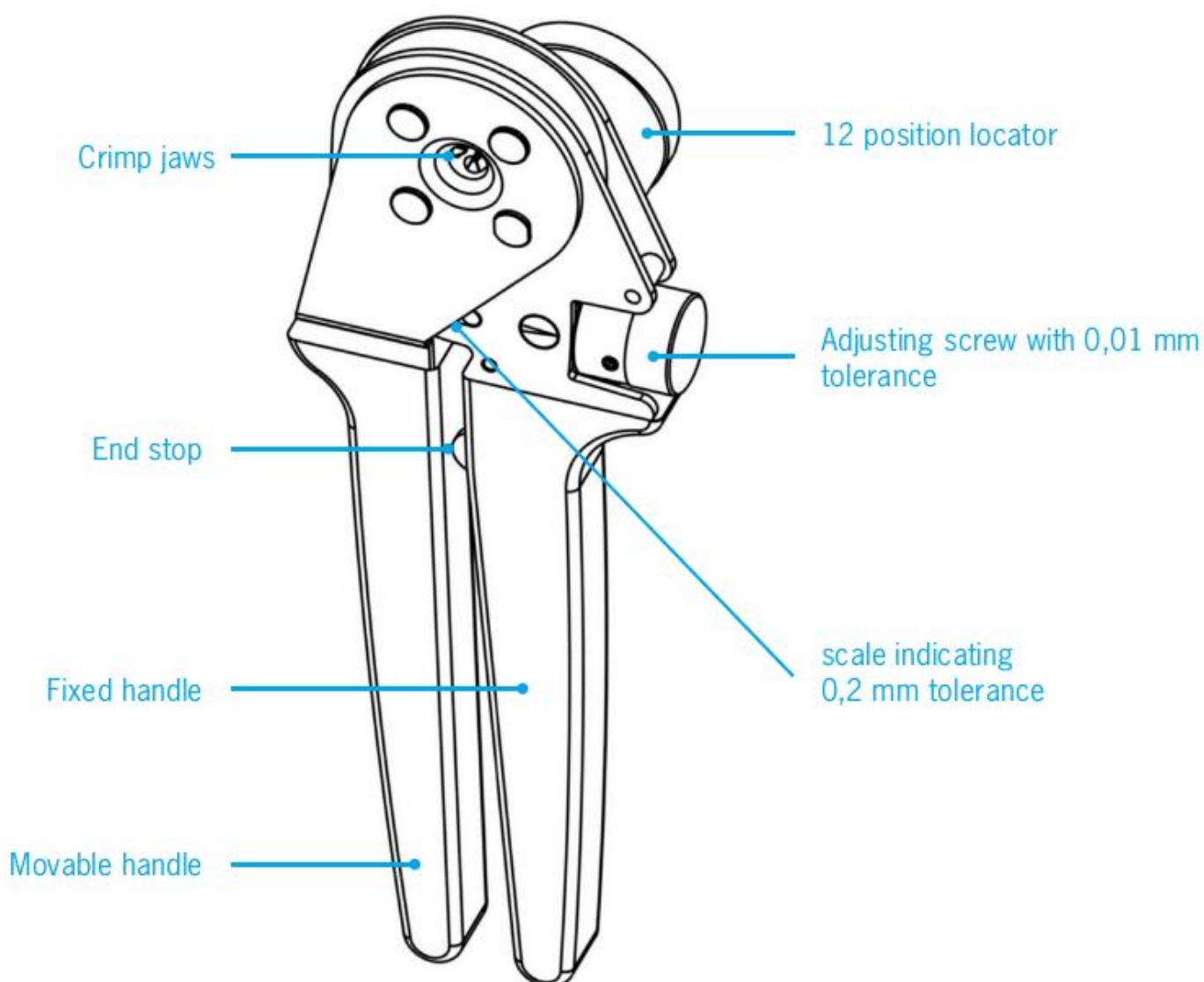
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1. General information

Designed and manufactured pursuant to state-of-the-art technical requirements and latest safety standards, this four-indent crimp tool PEW 8.75 to be used only when in order and in strict compliance with existing safety rules. The tool has been developed for crimping of both male and female turned contacts. The tool is only to be used for the application described below. The manufacturer is not liable for damages caused by improper use or unauthorised technical modifications of the tool.

2. Application

The four-indent crimp tool PEW 8.75 has been developed for optimal crimping of turned contacts for wire ranges 0.14 to 6.0 mm² (26 through 10 AWG).



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3. Description of the tool

The tool consists of a movable handle with precision ratchet mechanism, a fixed handle with a metric scale, an adjustment system by micro setting of 0.01 mm tolerance, four indenter jaws and a 12-position locator, fully rotatable, for accurate positioning of contacts. A reference table marked onto the crimp tool's surface informs on the locator position and crimp depth to be selected to match a particular contact. The tool can be adjusted to any crimp depths that might be requested by the contact manufacturer.

4. Function

- Loosen the clamping screw on the opposite site of the adjusting screw before using the tool (don't remove the clamping screw!).
- 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 entry hole of the tool on the opposite side of the locator.
- The contact is fixed by closing the handles to the first lock-in position thus preventing the contact falling out of the tool and facilitating insertion of cable into the contact.


The precision ratchet assures consistently accurate crimps every time by forcing the tool to be closed to its fullest extent, completing the crimping cycle before the tool opens automatically.

Changing the Locators

Loosen the hexagon socket with the enclosed allen-key. Remove the locator by turning it counter clockwise.

CAUTION:

Do not crimp onto the gauge when inserted or any other items that are not meant for the intended application! Do not crimp on solid material exceeding 35 HRC (e.g. steel)!

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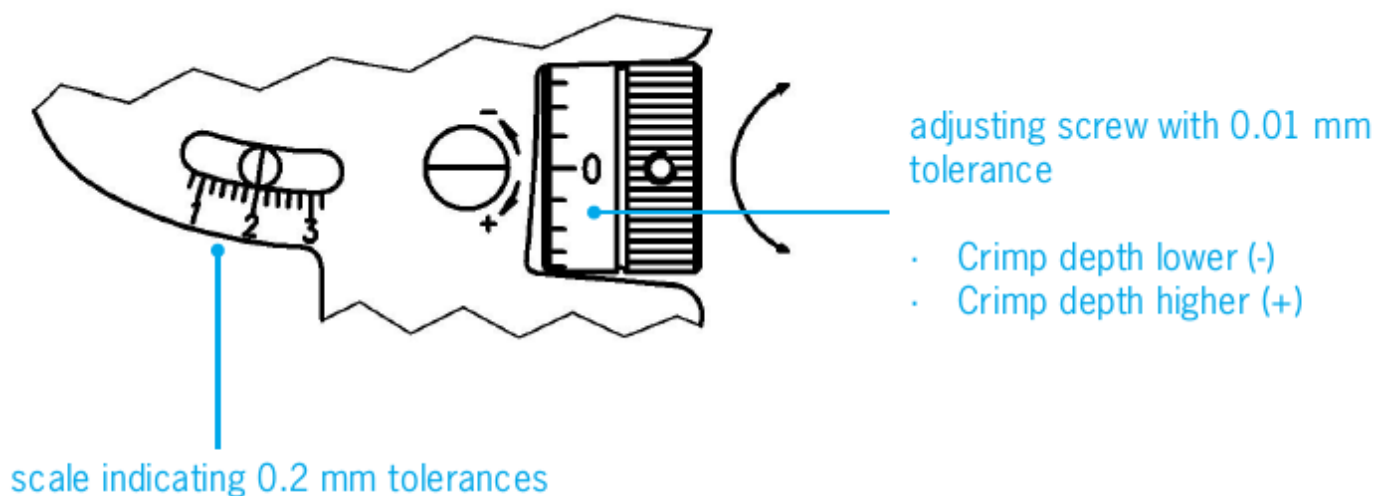
5. Adjustment of crimp depth

The crimp depth has to be adjusted as follows:

Adjusting screw turned clockwise for reducing of crimp depth and anticlockwise for increasing of crimp depth.

Adjustment tolerances

- 1 scale spacing on the screw = adjustment by 1/100 mm
- 1 full rotation of screw = adjustment by 0.2 mm (indication on the screw as well as on the rough scale)
- 5 rotations of the screw = adjustment by 1 mm (indication on the scale)



6. Gauging the crimp depth

Crimp tool adjustment is carried out in the factory. Gauging every working day is recommended to ensure accurate calibration. This is easily accomplished with a GO–NOGO gauge (Ilme art. CCPNP RN) at \varnothing 2.0 mm position. The crimp depth of 2.00 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 is to close. In case the GO-side doesn't go or the NOGO-side goes, i.e. the tolerances required by the manufacturer are overstepped, please contact your distributor for action.


CAUTION:

Do not crimp onto the gauge when inserted or any other items that are not meant for the intended application! Do not crimp on solid material exceeding 35 HRC (e.g. steel)!

7. Maintenance and repair

Keep the tool clean and properly stored when not in use. The joints need to be oiled regularly and the circlips securing the bolts should always be in place. For any repair, please return the tool to your distributor.

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8. Adjustment: LS1 & M23 Contacts

Contact		Adjustment			
Type	Art.Nr.	mm ²	AWG	Adjusting wheel	Locator
LS 1 A6 2 mm Female hyperboloid contact	44420104 44420105	4,00	12	1,55	4
LS 1 A6 2 mm Female contact with contact spring	44429370 44429371	0,50	22	1,15	
		0,75	20	1,20	
		1,00	18	1,30	
		1,50	16	1,50	
		2,50	14	1,65	
LS 1 A6 1 mm female contact with slit	74020600 74020601	0,14	26	0,80	3*
		0,34	24	0,90	
		0,50	22	1,10	
		0,75	20	1,15	
		1,00	18	1,20	
LS 1 1 mm Female hyperboloid contact	74034500 74034501	0,14	26	0,80	
		0,34	24	0,90	
		0,50	22	1,10	
		0,75	20	1,15	
		1,00	18	1,15	
LS 1 2 mm male contact	74034100 74034101	0,14	26	1,25	6
		0,34	24	1,30	
		0,50	22	1,30	
		0,75	20	1,50	
		1,00	18	1,65	
	44420103	4,00	12	1,55	
LS 1 / M 23 1 mm female contact with slit	74200600 74020601	0,14	26	0,80	3 *
		0,34	24	0,90	
		0,50	22	1,10	
		0,75	20	1,15	
		1,00	18	1,20	
LS 1 / M 23 1 mm Female hyperboloid contact	74034500 74034501	0,14	26	0,80	
		0,34	24	0,90	
		0,50	22	1,10	
		0,75	20	1,15	
		1,00	18	1,20	
M 23 2 mm female contact with slit	72401600 72401601	1,00	18	1,45	8
		1,50	16	1,50	
		2,50	14	1,65	
M 23 2 mm male contact	72401000 72401001	1,00	18	1,45	7
		1,50	16	1,50	
		2,50	14	1,65	
M 23 1 mm male contact	72400000 72400001	0,14	26	0,80	9
		0,34	24	0,90	
		0,50	22	1,15	
		0,75	20	1,15	
		1,00	18	1,20	

* Use additional locator