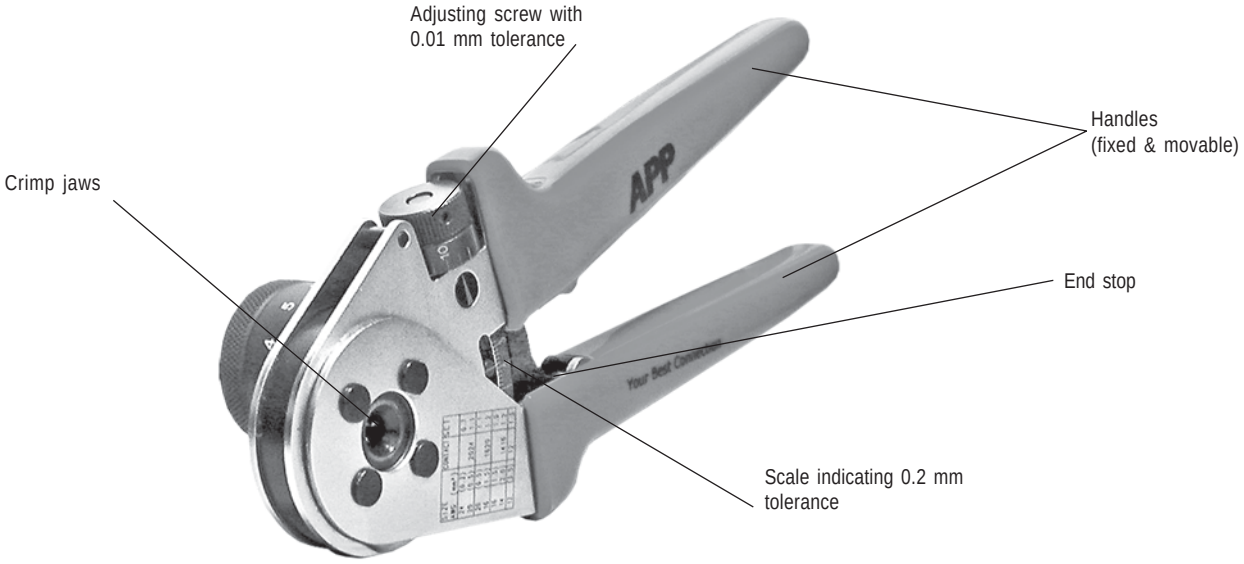
Operating Instructions
4 Indent Crimp Tool
PM1000G1

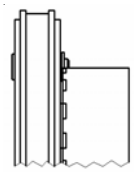
Designed and manufactured pursuant to state-of-the-art technical requirements and latest safety standards, this four indent crimp tool PM1000G1 is to be used only when in good working order and in strict compliance with existing safety rules.

The PM1000G1has 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 unauthorized technical modifications 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.



Manner of operation

The four indent crimp tool PM1000G1 has been developed for optimal crimping of turned contacts for wire ranges 0.14 to 6.0 mm² (26 through 10 AWG). 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.



12 Position

Locator Contact Positions

Position	Contact Designation	Position	Contact Designation
1	PM16SxxxxS32	7	PC20SGN
2	PM16PxxxxS30	8	PC20FGN
3	PM16PxxxxA30	9	SC20-GN
4	PM16PxxxxB30	10	PC12LSN
5	PM16PxxxxC30 PC16SSN	11	PC12FSN PC12SSN SC16-SN
6	SC20LGN	12	SC12-SN

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Changing the locator

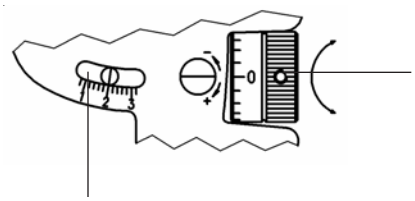
Loosen the hexagon socket with the enclosed allen key. Remove the locator by turning it counterclockwise.

Adjustment of crimp depth

Crimp depth to be adjusted as follows:
Adjusting screw turned **clockwise for reducing of crimp depth** and **counterclockwise for increasing of crimp depth**

Adjustment:

- 1 scale spacing on the screw = adjustment by 0.01 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)



scale indicating 0.2 mm divisions

crimp depth -

adjusting screw with 0.01 mm step

crimp depth +

Crimp Depth Chart

Size AWG	Size (mm^2)	Contact	Set
24	(0.2)	—	0.7
20	(0.5)	1620	1.1
20	(0.5)	—	1.1
16	(1.5)	1616	1.2
16	(1.5)	—	1.0
14	(2.0)	1614	1.2
12	(3.5)	1612	1.3

Control of crimp depth

Crimp tool adjustment is done in the factory, but under production use, periodic gauging is recommended to insure accurate calibration. This is easily accomplished with a gauge Ø 2.0 mm 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 is closed. Do not close the tool onto the gage pin. After insertion of gauge, it must be just enough space for moving the gauge inside the entry hole. If the indenter closure is too small or too large to exactly match the gauge, the deviation (+/-) can be checked by the precision setting of the screw. In case the deviation exceeds the tolerances requested by the contact manufacturer, please contact the factory.

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.

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