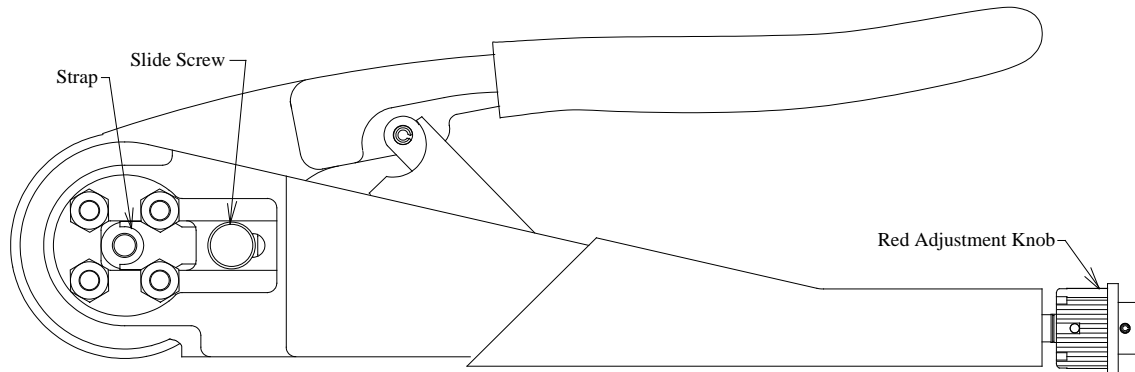




# ASTRO TOOL CORP.

## CONNECTOR ASSEMBLY TOOLING

### HOW TO USE THE MINIATURE MICROCRIMP TOOL Catalog Number 612118 and Associated Types



#### GENERAL INSTRUCTIONS

The 612118 Miniature Microcrimp Tool is a micro adjustable, cycle-controlled hand crimping tool. It is a fast, versatile, manually operated, octadent tool for crimping size #20 and smaller removable pin and socket contacts used in electrical connectors.

The tool is adjustable in a range of .015 to .043-inch. Settings to within .0005-inch increments are possible for precision crimping.

Locators are available for most applications, consult the factory for your specific needs.

For long life and optimum performance, this tool should be kept clean and handled as any other precision instrument.

#### OPERATION

Open and close the tool several times and observe the precision cycle control ratchet mechanism. Note that the tool may not be opened or closed without completing the cycle.

#### LOCATOR INSTALLATION

With the tool in the fully open position, loosen the slide screw and move the strap in the direction indicated, see figure # 1.

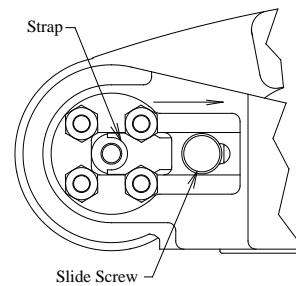


FIGURE #1

Select the proper locator for your application. Install the locator as shown, see figure #2. Note that the locator will only fit in the tool in one direction. Slide the strap over the locator and tighten the slide screw.

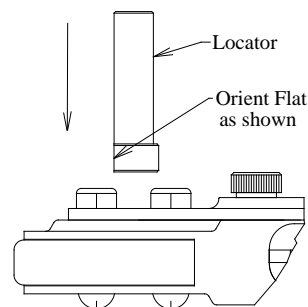


FIGURE #2

#### TOOL ADJUSTMENT

To adjust the indenter opening, locate the adjustment window on the tool and observe where the red indicator is located. Pull and rotate the red adjustment knob until the indicator lines up with the desired size opening. Rotate clockwise to increase, counter-clockwise to decrease opening. See figure #3.

**NOTE:**

**THE DATA PLATE INDICATOR LINES ARE FOR REFERENCE ONLY. PLEASE USE ONLY AS A GUIDE. YOU MUST PIN GAGE YOUR TOOL TO DETERMINE THE ACTUAL SETTING.**

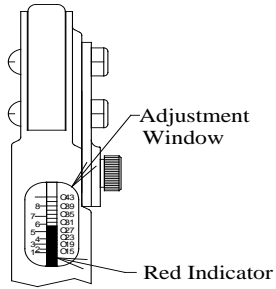


FIGURE #3

**TOOL GAGING**

It will be necessary to verify the opening by using gage pins. Select the proper GO gage pin for the opening required. Close the tool completely and insert the GO pin between the indenters, as shown in figure #4.

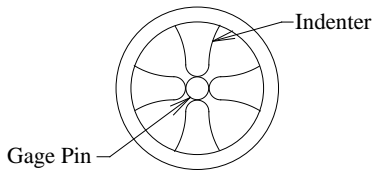


FIGURE #4

The gage pin should be a slip-fit between the indenter tips with no sloppiness or free play.

**CAUTION:  
DO NOT CRIMP GAGE**

**CRIMPING THE CONTACT**

With the tool in the fully open position, insert the contact and the prepared wire through the indenter opening and into the locator. Close the tool until a positive stop is achieved. Release the handles and the tool will return to the fully open position. Remove the crimped assembly.

**TOOL SERVICE**

Astro Tool's 612118 Crimp Tool is designed for long, reliable service. If the tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the tool to our factory.

Upon receipt of the tool, Astro will inspect and overhaul each tool to put the tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired.

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charges for such parts.