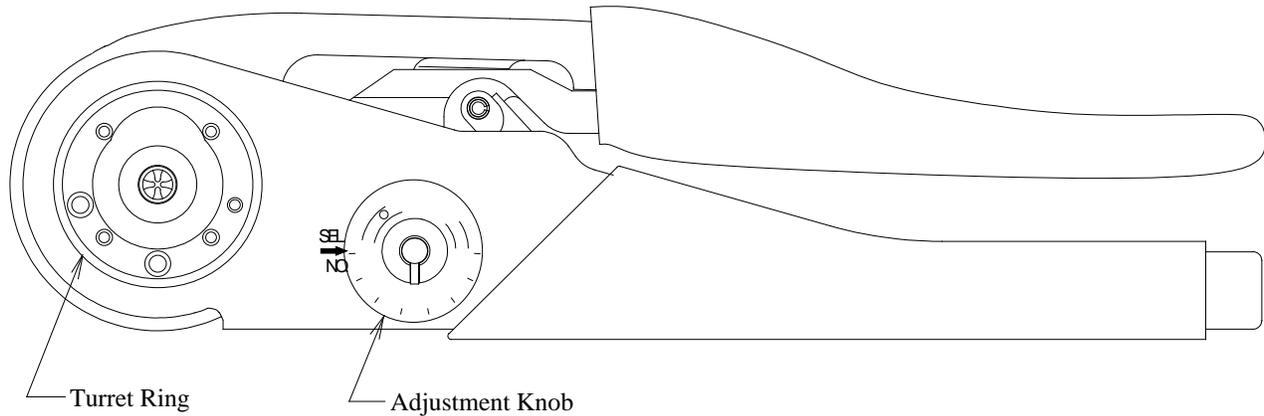


ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING



615708 8-STEP ADJUSTABLE CRIMP TOOL M22520/1-01(NSN 5120-00-165-3912)

GENERAL

The Astro Tool 615708 8-step crimp tool is a cycle controlled, precision crimp tool capable of crimping wire barrel sizes 12 to 20.

Observe the precision ratchet action by opening and closing the tool several times. Note that the tool cannot be opened without fully completing the crimp cycle. When held the tool fits your hand for less fatiguing one hand operation.

BASIC TOOL OPERATION

NOTE: For proper crimping, the Basic Tool must be used with an appropriate Positioner or Turret Assembly.

1. Select the proper Positioner or Three Position Turret Assembly for the contact to be crimped.

2. Attach the head to the turret ring on the tool using the captive socket head cap screws. A 9/64 hex wrench is required. Verify that the guide pin is properly located prior to tightening the cap screws. The turret will need to be in the "un-locked" position before attaching to the tool.

3. Select the appropriate insert from the color coded data plate on the side of the Turret. Turn the knurled knob until the color coded position is aligned with the index mark. Depress the turret until it locks into position.

4. Consult the Data Plate for correct selector setting. Raise and rotate Adjustment Knob until the proper selector setting is lined up with the arrow on the Top Handle. Release the Adjustment Knob. The tool is now ready to crimp.

5. Insert the wire and contact through the Indenter Opening and into the Positioner Assembly. Squeeze the handles until the Tool comes to a positive stop. Release the handles and the tool will return to the full open position.

6. Remove the completed crimped assembly.

CAUTION:

Do not press down on the wire during the crimp cycle.

GAGING INSTRUCTIONS

Gaging the tool requires the M22520/3-01 Gage Pin Assembly, Astro part # 615716.

1. Set the tool to selector setting # 4.
2. Close the handles to the fully closed position.
3. Holding the tool closed, insert the GO pin into the indenter opening as shown, see figure # 1 The gage must pass freely between the indenter tips.
4. Holding the tool closed, insert the NO GO pin into the indenter opening. The gage pin must NOT go between the indenter tips.

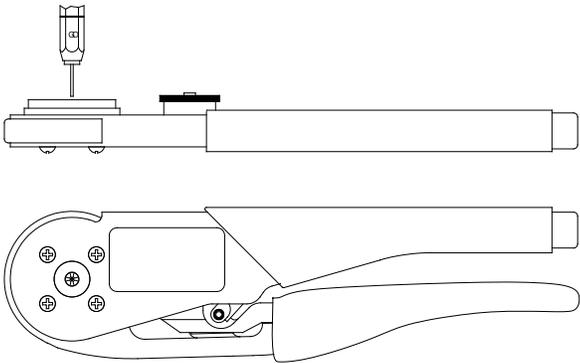


Figure # 1

CAUTION:
DO NOT CRIMP GAGE.
TOOL DAMAGE WILL RESULT.

Astro manufactures the ATK6002 gaging kit with gage pin assemblies for each selector setting. Contact the factory for price and availability.

GAGING INFORMATION

(Dimensions in Inches)

SELECTOR SETTING NUMBER	GO SIZE ± .0001	NO GO SIZE ±.0001
1	.0280	.0330
2	.0320	.0370
3	.0360	.0410
4	.0390	.0440
5	.0450	.0500
6	.0520	.0570
7	.0590	.0640
8	.0680	.0730

TOOL SERVICE

Astro Tool's 615708 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. Please note that Astro's Quality Control system is traceable to The National Institute of Standards and Technology (N.I.S.T.).

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 charge for such parts.

ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL, CRIMP TOOLS AND CONNECTOR SERVICE KITS

ASTRO TOOL CORPORATION • 21615 S.W. T-V HWY. • BEAVERTON OREGON 97003
 503-642-9853 • FAX 503-591-7766