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With the principle of “Quality Parts,Customers Priority,Honest Operation,and Considerate Service”,our business mainly focus on the distribution of electronic components. Line cards we deal with include Microchip,ALPS,ROHM,Xilinx,Pulse,ON,Everlight and Freescale. Main products comprise IC,Modules,Potentiometer,IC Socket,Relay,Connector.Our parts cover such applications as commercial,industrial, and automotives areas.

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## Contact us

Tel: +86-755-8981 8866 Fax: +86-755-8427 6832

Email & Skype: info@chipsmall.com Web: www.chipsmall.com

Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China



# customer manual

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ORIGINAL INSTRUCTIONS

## SAFETY PRECAUTIONS — IMPORTANT SAFETY INFORMATION



**NOTE**

Keep all decals clean and legible, and replace them when necessary.



**DANGER**

**ELECTRIC SHOCK HAZARD**

This tool is not insulated. When using this unit near energized electrical lines, use proper personal protective equipment.



Failure to observe this warning could result in severe injury or death.



**DANGER**

**SKIN INJECTION HAZARD**

Do not use hands to check for oil leaks. Highly pressurized oil will puncture the skin causing serious injury, gangrene, or death. If injured, seek medical help immediately to remove the oil.



**DANGER**

**FIRE HAZARD**

Do not use solvents or flammable liquids to clean the crimping tool. Solvents or flammable liquids could ignite and cause serious injury or property damage.



Failure to heed these warnings could result in severe injury from harmful fumes or burns from flying debris.



**DANGER**

**FIRE HAZARD**

Do not dispose of batteries in a fire. They will vent fumes and will explode. Instead, dispose of batteries in an environmentally responsible manner or send the battery back to TE.



**DANGER**

Inspect the tool and jaws/dies before each use. Replace any worn or damaged parts. A damaged or improperly assembled tool can break and strike nearby personnel.

Failure to observe this warning could result in severe injury or death.



**CAUTION**

— Do not place the tool in a vise. The crimping tool is designed for hand-held operation.

— Protect the crimping tool from rain and moisture. Water will damage the crimping tool and battery.

Failure to observe these precautions may result in injury or property damage.



**CAUTION**

— Do not allow anything to contact the battery terminals.

— Do not immerse the batteries in liquid. Liquid may create a short circuit and damage the battery. If the batteries are immersed, contact your service center for proper handling.

— Do not place the battery into a pocket, tool pouch, or tool box with conductive objects. Conductive objects may create a short circuit and damage the battery.

— Do not place a battery on moist ground or grass. Moisture may create a short circuit and damage the battery.

Failure to observe these precautions may result in injury or property damage.



**CAUTION**

— Do not store the battery at more than 60°C [140°F]. Damage to the battery can result.

— Do not use another manufacturer's charger.

— Do not attempt to open the battery. It contains no user-serviceable parts.

Failure to observe these precautions may result in injury or property damage.



**CAUTION**

— Do not perform any service or maintenance other than as described in this manual. Injury or damage to the tool may result.

Failure to observe these precautions may result in injury or property damage.



Always wear approved eye protection while operating equipment.



Always wear approved hearing protection while using equipment.



Do not operate equipment if the guards are removed.



Read and understand this entire document before using equipment.

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## ***SAFETY PRECAUTIONS — AVOID INJURY***

Safeguards are designed into this application equipment to protect operators and maintenance personnel from most hazards during equipment operation. However, certain safety precautions must be taken by the operator and repair personnel to avoid personal injury, as well as damage to the equipment. For best results, application equipment must be operated in a dry, dust-free environment. Do not operate equipment in a gaseous or hazardous environment.

Carefully observe the following safety precautions before and during operation of the equipment:

- ALWAYS wear appropriate ear protection.
- ALWAYS wear approved eye protection when operating powered equipment.
- ALWAYS keep guard(s) in place during normal operation.
- ALWAYS insert power plug into a properly grounded receptacle to avoid electrical shock.
- ALWAYS turn off the main power switch and disconnect electrical cord from the power source when performing maintenance on the equipment.
- NEVER wear loose clothing or jewelry that may catch in moving parts of the application equipment.
- NEVER insert hands into installed application equipment.
- NEVER alter, modify, or misuse the application equipment.

## ***TOOLING ASSISTANCE CENTER***

***CALL TOLL FREE 1-800-722-1111 (CONTINENTAL UNITED STATES AND PUERTO RICO ONLY)***

The **Tooling Assistance Center** offers a means of providing technical assistance when required.

In addition, Field Service Specialists are available to provide assistance in the adjustment or repair of the application equipment when problems arise which your maintenance personnel are unable to correct.

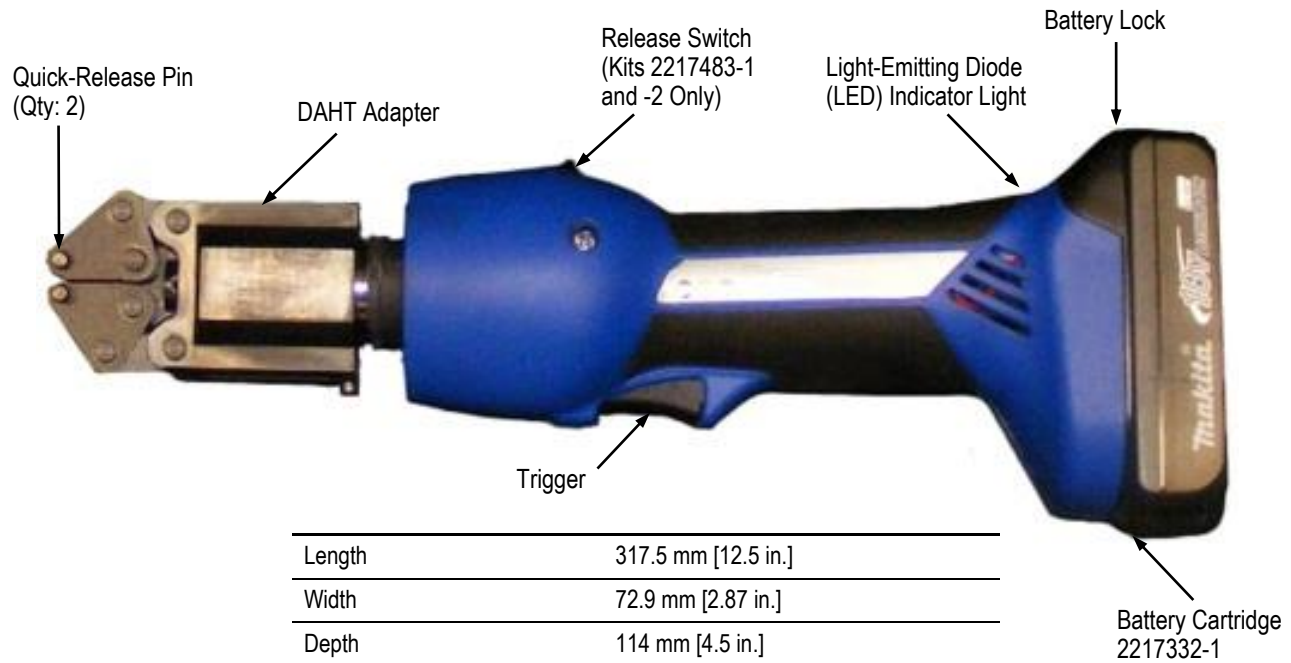
### **INFORMATION REQUIRED WHEN CONTACTING THE TOOLING ASSISTANCE CENTER**

When calling the Tooling Assistance Center regarding service to equipment, it is suggested that a person familiar with the device be present with a copy of the manual (and drawings) to receive instructions. Many difficulties can be avoided in this manner.

When calling the Tooling Assistance Center, be ready with the following information:

1. Customer name
2. Customer address
3. Person to contact (name, title, telephone number, and extension)
4. Person calling
5. Equipment number (and serial number if applicable)
6. Product part number (and serial number if applicable)
7. Urgency of request
8. Nature of problem
9. Description of inoperative component(s)
10. Additional information/comments that may be helpful

**Crimping Tool Kit with Battery Cartridge Installed**



Length	317.5 mm [12.5 in.]
Width	72.9 mm [2.87 in.]
Depth	114 mm [4.5 in.]
Mass/Weight (with Battery)	1.86 kg [4.1 lbs]
Sound Level	70 dBA at 1 Meter
Vibration	< 2.5 m/s <sup>2</sup>
Hydraulic Oil	Shell Tellus T15 or RIVOLTA S.B.H. 11
Maximum Crimping Force	15.6 kN [1.75 tons]
Average Crimping Time	2-4 seconds
Average Crimps per Charge	85-170 (Approx.)
Charging Voltage	18 V
Charging Time	15 Min. - 1.3 AH/22 Min. - 3.0 AH

Figure 1

**1. INTRODUCTION**

DAHT lithium-ion battery-powered crimping tool kits 2217483-[ ] each consist of a battery crimping tool (with a DAHT adapter installed), as well as two rechargeable battery cartridges used to power the tool. See Figure 1.

Each kit has a battery charger. The battery charger part number, its voltage, and the kit region of use are listed in Figure 2. The battery-powered crimping tool may or may not have a release switch to retract the ram.

When reading this manual, pay particular attention to DANGER, CAUTION, and NOTE statements.



**DANGER**

Denotes an imminent hazard that may result in moderate or severe injury.



**CAUTION**

Denotes a condition that may result in product or equipment damage.



**NOTE**

Highlights special or important information.

Shell and RIVOLTA are trademarks of their respective owners.

CRIMPING TOOL KIT	REGION OF USE	BATTERY CHARGER	BATTERY CHARGER VOLTAGE	RAM RETRACT SWITCH
2217483-1	North America	2217331-1	110 V	Yes
2217483-2	Europe	2217331-2	220 V	
2217483-3	North America	2217331-1	110 V	No

Figure 2

Each kit is designed to accept the crimping head from any TE DAHT to adapt the crimping head for use with the battery-powered crimping tool. For crimping head information (including wire preparation, crimping procedure, maintenance and inspection, and replacement procedure), refer to the appropriate instruction sheet for the associated DAHT and crimping head.



**NOTE**

*Dimensions in this customer manual are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

**2. RECEIVING AND INSPECTION**

Each kit is thoroughly inspected during and after assembly. Prior to packaging and shipping a final series of tests and inspections is made to ensure proper function of the tool. The following inspection should be performed as a safeguard against potential problems generated in transit.

1. In a well-lighted area, carefully uncrate the tool kit and inspect each component as it is removed from the crate.
2. Thoroughly inspect each component for evidence of damage that may have occurred in transit. If any of the components are damaged, file a claim against the carrier and notify TE Connectivity immediately.
3. Keep this manual and all drawings and product samples with the tool for the benefit of operation and maintenance personnel.

The crimping tool should be inspected at regularly scheduled intervals, depending on care, degree of operator skill, the type and size of the product to be crimped, and environmental conditions. At a minimum, the tool should be inspected after every 40 hours of use.

**3. USER INTERFACE INFORMATION (PRE-OPERATION TESTING)**

**3.1. LED Indicators**

**A. White LED Work Light**

This LED automatically turns on when the trigger is pulled. The indicator remains lit for ten seconds after the trigger is released.

**B. Red LED Indicator**

The tool is equipped with a special circuit board incorporating several important features. These features inform the user of the current status of the tool. The red LED will signal in the cases given in Figure 3.

WHAT HAPPENS	WHAT IT MEANS
Red LED flashes for two seconds.	The battery has been inserted in the tool.
Red LED is lit constantly for 20 seconds at the end of the cycle.	Battery charge is below 17 volts at the beginning of the cycle.
Tool will not start. Red LED light remains lit for 20 seconds after trigger is released	Battery charge is below 16 volts at the beginning of the cycle.
Tool will stop. Red LED light remains lit for 20 seconds after the trigger is released.	Battery voltage drops below 13 volts during the cycle.
Tool will stop. The LED will flash for 20 seconds after the trigger is released.	Motor current exceeds 20 A during the cycle.
	Circuit has become hot.

Figure 3

### 3.2. Pressure Sensor

The tool is equipped with a pressure sensor that alerts the user of an incomplete crimp.

— If the tool is manually retracted before completion of a crimp, the red LED will flash for two seconds and an audible alarm will sound for two seconds.

— If the tool is unable to reach the required crimp force, the red LED will flash for two seconds and an audible alarm will sound until after the trigger is released.



**NOTE**

The tool has an on-board memory of previous crimp cycles and the cycle count. This information can be accessed and downloaded onto a computer using USB Adapter Module 2217896-1.

## 4. OPERATION

### 4.1. Battery Installation and Removal



**NOTE**

Batteries Directive 2006/66/EC introduces new requirements from September 2008 on removability of batteries from waste equipment in EU Member States. To comply with this Directive, this device is designed to allow the rechargeable battery pack to be easily removed by the end-user when it needs to be replaced.

To install the battery, slide the battery into the bottom of the crimping tool until it can go no further. There will be an audible “click” of the battery lock to indicate that the battery has been properly installed.

To remove the battery, disengage the battery lock by applying pressure on the lock toward the bottom of the crimping tool, and slide the battery away from the tool.



**DANGER**

Always dispose of the old battery pack in an environmentally-responsible way; in accordance with local waste regulations. Where possible, recycle the battery cartridge. Contact local authority for details of battery recycling locations.

## 4.2. Crimping Head Installation and Removal

**CAUTION**

Do not operate the crimping tool without the adapter installed. Damage to the ram or seals can result.

**CAUTION**

Do not operate the crimping tool without a crimping head installed. Damage to the adapter can result.

Each kit is supplied with the DAHT adapter installed on the battery-powered hand tool. The only installation required is the crimping head.

### A. Installation

As supplied, the adapter has two quick-release pins installed as shown in Figure 1. These pins will be used to secure the links of the crimping head (exposed portion of the crimping head) to the adapter. These pins must be removed prior to installing the crimping head.

**DANGER**

To avoid personal injury, be sure to exercise extreme caution when handling the crimping tool. Remove the battery before installing the crimping head.

1. Remove the battery from the crimping tool.
2. Remove the quick-release pins.
3. Align the crimping head mounting holes with the quick-release pin holes as shown in Figure 4.
4. Insert the exposed portion of the crimping head into the adapter cavity.
5. Insert the two quick-release pins through the holes in the adapter and through the holes in the links of the crimping head.

**NOTE**

The quick-release pins will “snap” into position when they are properly inserted.

**DANGER**

After the crimping head is installed, make sure the quick-release pins are fully inserted to avoid personal injury and damage to the tool.

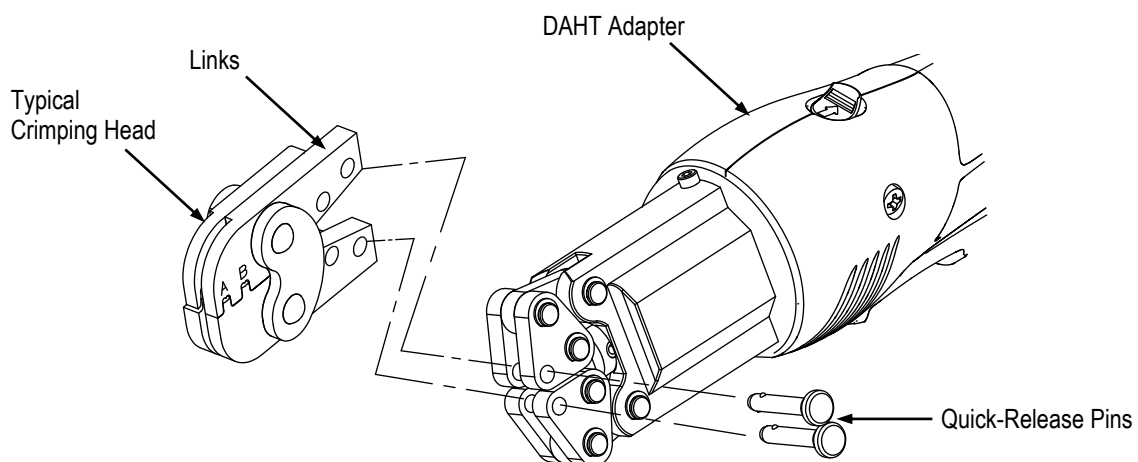


Figure 4



## B. Removal



### **DANGER**

To avoid personal injury, make sure to exercise extreme caution when handling the crimping tool. Remove the battery before removing the crimping head.

1. Remove the battery from the crimping tool.
2. Remove the two retaining rings from one side of the tool body, and push the retaining pins, along with the two remaining retaining rings, through the opposite side of the tool handle assembly, and then remove the crimping head. See Figure 5.

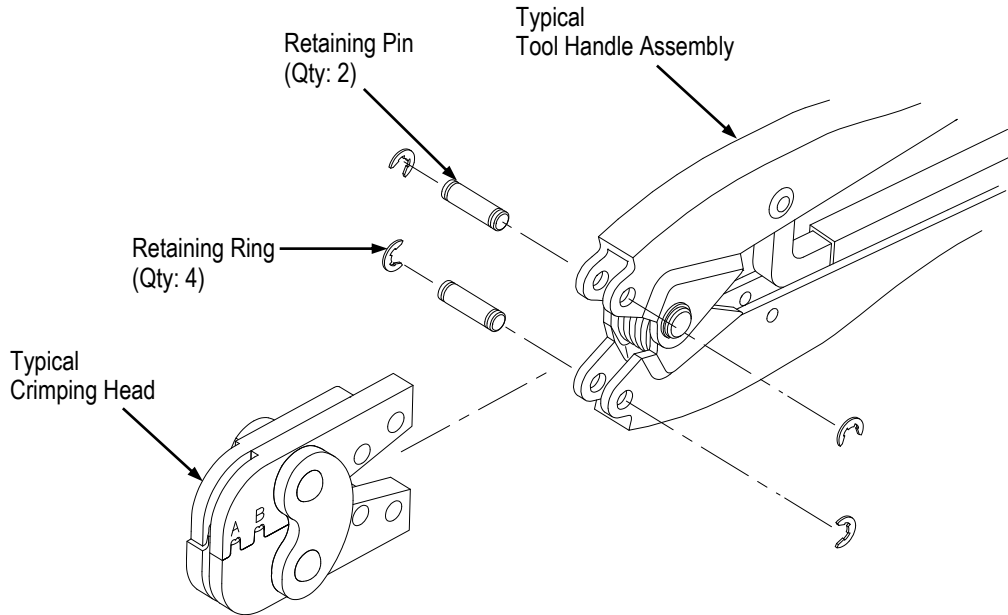


Figure 5

## 4.3. Crimping

The following procedure provides only general information concerning crimping. Refer to the instructions packaged with the crimping head for detailed information, including wire stripping dimensions and instructions for positioning the product to be crimped in the crimping area.



### **DANGER**

To avoid personal injury, keep fingers clear of the crimping area.

1. Center the wire barrel of the product to be crimped in the appropriate crimping chamber of the crimping head.
2. Depress the trigger to advance the moving ram. This closes the crimping head jaws or dies in order to hold the product to be crimped in place. Do not deform the wire barrel.
3. Place a pre-stripped wire in the wire barrel of the product to be crimped; making sure that the wire insulation does not enter the wire barrel.
4. Depress and hold the trigger to complete the crimp. The crimping tool will return automatically to the first position of its cycle when the crimp is complete.



### **NOTE**

If it is necessary to retract the ram before a crimping cycle is completed, push the release switch. Pushing the release switch will result in the complete retraction of the ram. Only kits -1 and -2 have a release switch.



**CAUTION**

*This tool is not designed for continuous operation. After 100 cycles, allow the crimping tool to cool for 15 minutes.*

**5. PREVENTIVE MAINTENANCE**

**5.1. Daily Maintenance**

Perform the following maintenance on a daily basis:

1. Inspect the crimping head jaws or dies for wear or damage such as cracks, gouges, or chips.
2. Inspect the crimping tool for damage or leaks. If damage is detected, return the tool to TE for repair.
3. Clean the crimping tool, removing accumulations of dirt and grease from the adapter, particularly in areas where the crimping head is installed and the product is crimped. Wipe the entire tool frequently with a clean, lint-free cloth.
4. Make sure that the retaining pins are in place and that they are secured with retaining rings.

**5.2. Yearly Maintenance**

Once a year or every 10,000 cycles (whichever comes first), the crimping tool should be returned to TE for inspection.

**5.3. Lubrication**

Lubricate all pins, pivot points, and bearing surfaces with a high-quality grease. We recommend the use of Molykote paste, which is a commercially available lubricant.

Lubricate the adapter according to the following schedule:

- Adapter used in daily production should be lubricated daily
- Adapter used occasionally in daily production should be lubricated weekly
- Adapter used weekly should be lubricated monthly

**6. TROUBLESHOOTING**

Prior to beginning troubleshooting procedures, be sure the battery is operational.

1. Be sure that the battery is charged. Re-check the battery after several minutes to ensure that the battery is holding its charge.
2. Use a nonflammable contact cleaner or pencil eraser to clean the electrical contacts on the battery and crimping tool.
3. Re-install the battery, and check the crimping tool again.

Refer to Figure 6 for problems, probable causes, and remedy.

PROBLEM	PROBABLE CAUSE	REMEDY
Tool is inoperative.	Dirt, contaminants, etc, in ram area of tool.	Return tool to TE for evaluation.
	Crimping tool battery contacts damaged.	Reform the contacts.
	Tool components are worn or damaged.	Return tool to TE for evaluation.
Jaws stop during operation.	Oil level is low.	Return tool to TE for evaluation.
	Air in the hydraulic system.	Pull trigger and hold retract button simultaneously. Hold for approximately 10 seconds.
Crimping tool loses oil.	Damaged internal seal.	Return tool to TE for evaluation.

*Figure 6*

Molykote is a trademark.

## 7. REPLACEMENT AND REPAIR



**DANGER**

To avoid personal injury, ALWAYS remove the battery cartridge from the tool BEFORE performing any maintenance on the crimping tool.

Kit replacement parts are identified in Figure 7. Order replacement parts through or return parts to your TE Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605. Or write to:

CUSTOMER SERVICE (038-035)  
 TYCO ELECTRONICS CORPORATION  
 PO BOX 3608  
 HARRISBURG PA 17105-3608

PART NUMBER	DESCRIPTION
217873-3	Quick Release Pin
2217332-1	Battery
2217331-1	Charger, 120 V, North America
2217331-2	Charger, 220 V, Europe

Figure 7

For replacement parts for the crimping head, refer to the instruction sheets packaged with the specific crimping head.

## 8. DECOMMISSIONING

In compliance with the regulations in force in the country where the tool is used, the user must make sure that waste produced during operation is correctly disposed. Disposal of lubricants and parts removed must be carried out in compliance with the standards in force in the country where the tool is used.

## 9. RESTRICTION ON HAZARDOUS SUBSTANCES (RoHS) INFORMATION

Information on the presence and location of any substances subject to RoHS can be found at <http://www.te.com/customer-support/rohssupportcenter/>

- (1) Click “Check Product Compliance and Get Statements of Compliance (SoC)”
- (2) Then click “Check Product Compliance Search Tool”

## 10. REVISION SUMMARY

- Updated document to corporate requirements
- Changed information in table in Figure 1