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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





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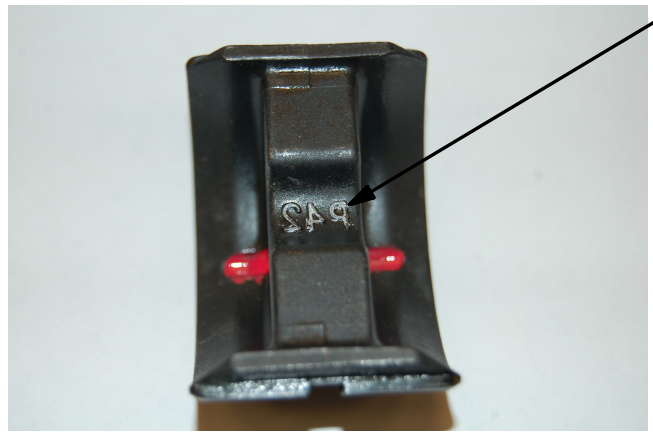
# INSTRUCTIONS FOR THE USE OF GO AND NO-GO PIN GAUGES FOR CD-920 AND CD-940 STYLE CRIMP DIES

Please follow the steps below for the use of pin gauges to check for wear of the Crimp Die set, also for an undersized Crimp Die set.

## STEP ONE

Please select the correct Crimp Die set and the correct gauge pins for the application that you will be checking.

Your die set outside surfaces should look like this.



Your RAISED LETTER die set inside surfaces should look like this. The raised letters in this picture have been painted to show up more clearly. The diameter will be gauged across the surfaces of these letters. In die sets with recessed letters, the pockets will be gauged.

For the purposes of this gauging, the upper pin tolerance (NO GO) is +/- .001" and the lower pin tolerance (GO) is +/- .001".

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
03	9/4/14	BJPU	BJPU	ASJ	REVISED AND REDRAWN ON TEAM CENTER, NO DIMS CHANGED	4763
02	8/6/14	BJPU	BJPU	ASJ	UPDATED WITH +/- .001" TOLERANCE ON PIN DIAMETER	4763
01	7/29/14	BJPU	BJPU	ASJ	UPDATED WITH CD-940-750 INFORMATION	4763
00	7/9/14	BJPU	BJPU	ASJ	RELEASE FOR KOREAN SALES	4763

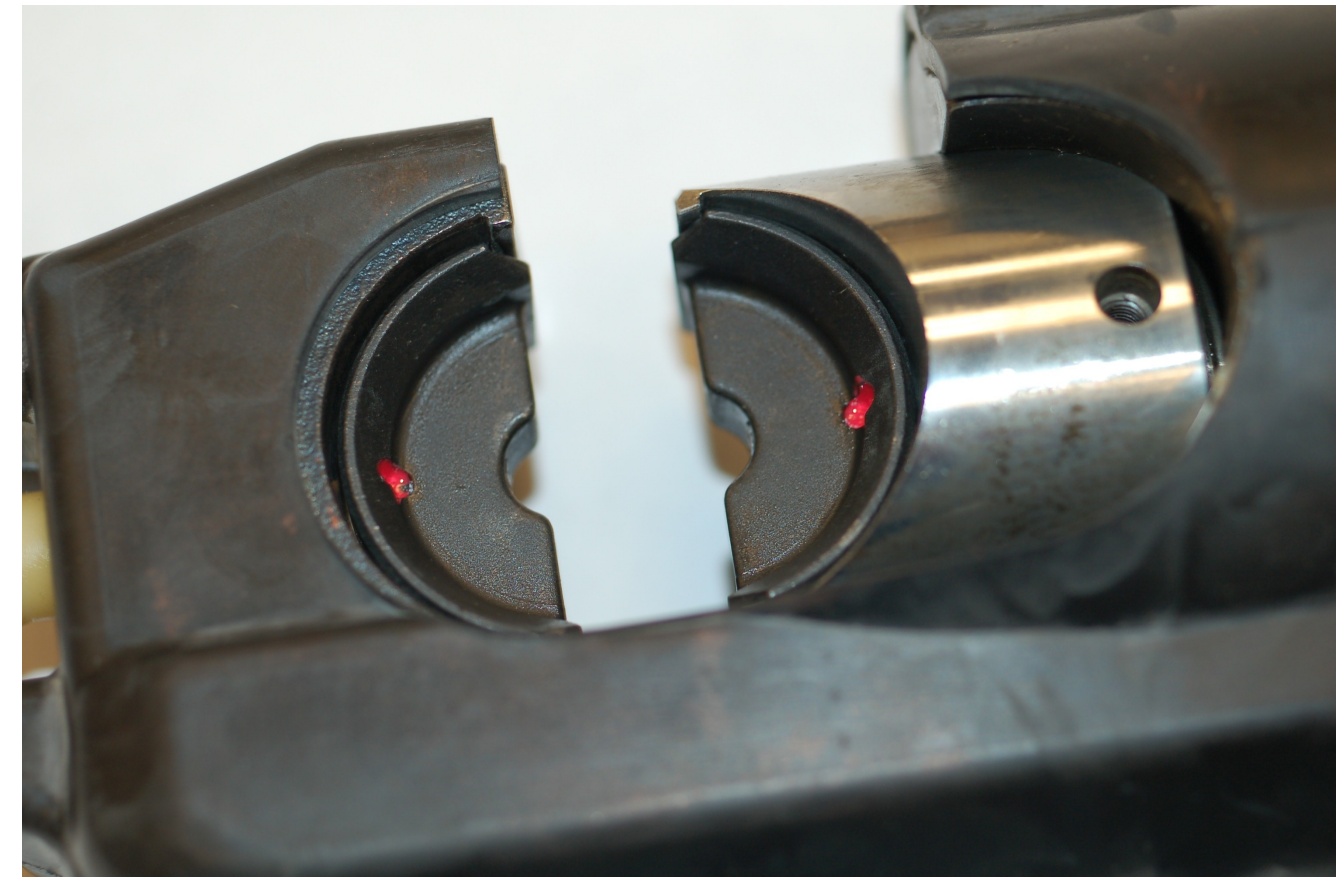
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ITEM REVISION NAME		R27416AB/03	
DATABASE FILE NAME		R27416AB_DS_TP27416B01/03A Page1	
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [mm]		MATERIAL:	
.X ± .1 [ 2.54 ] .XX ± .01 [ .25 ]		NONE	
.XXX ± .005 [ .127 ] ANGLES ± 5 °		DRAWING NUMBER:	
THIRD ANGLE PROJECTION		TP27416B01	
DRAWN BY	DATE	CHK	SCALE
BJPU	9-4-14	ABJ	NONE
SHT 1 OF 7			SIZE
			B





# STEP TWO

Insert the correct Crimp Die in the correct tool as shown in the picture below.



Pull the top release die button to insert the die into the non-movable (upper) portion of the tool. Push in the release button to insert the die into the moving (lower) portion of the tool. Make sure the Crimp Dies are fully engaged and aligned with each other.

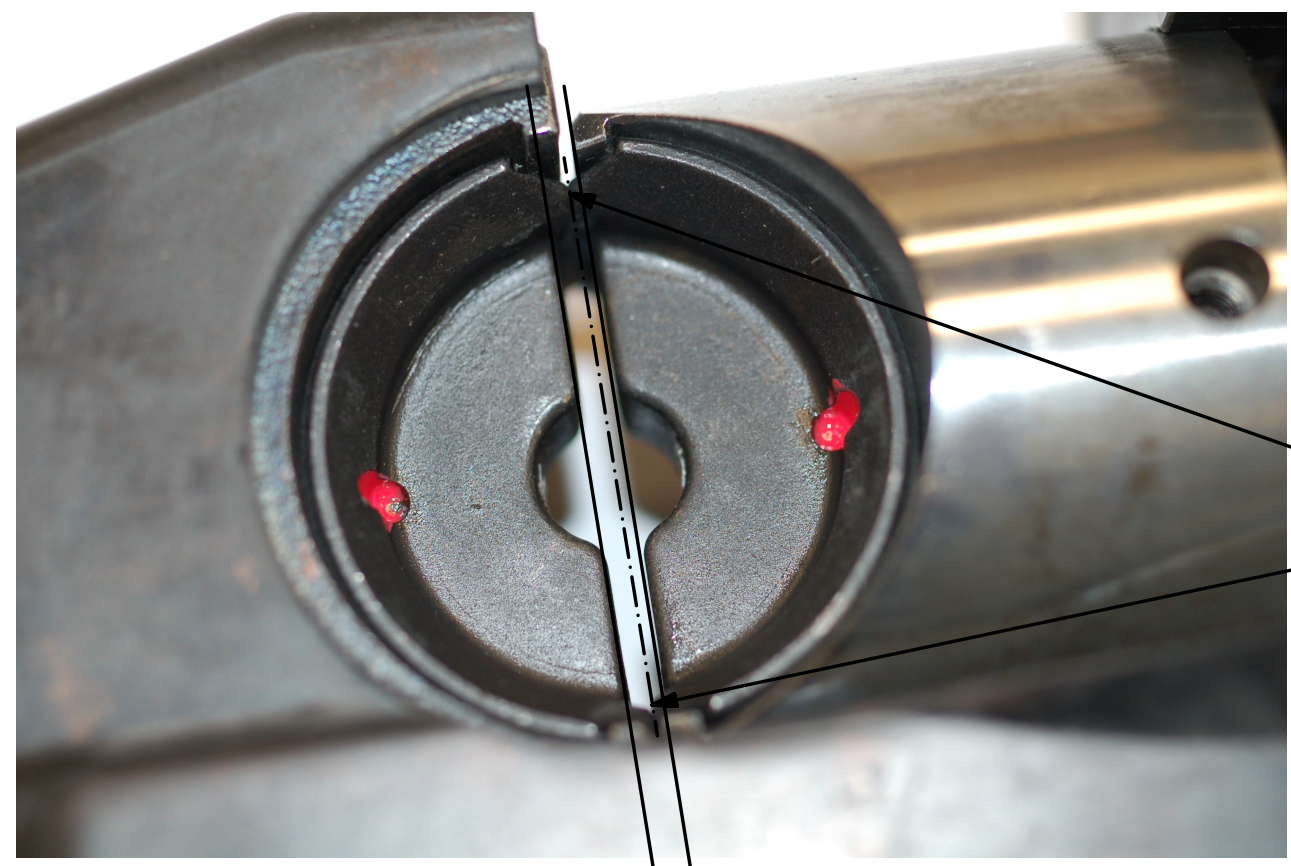
REV	DATE	BY	CHK	APR	DESCRIPTION	ECN	TITLE INSTRUCTIONS, GAGING CD-920 / CD-940 DIE FMY'S CONTROL DRAWING					
							ITEM REVISION NAME R27416AB/03					
							DATASET FILE NAME R27416AB_DS_TP27416B01/09A Page2					
03	9/4/14	BJPU	BJPU	ASJ	SEE PAGE 1 FOR DRAWING CHANGES	4763	UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]					
02	8/6/14	BJPU	BJPU	ASJ	SEE PAGE 1 FOR DRAWING CHANGES	4763	.X ± .1 [ 2.54 ]      .XXX ± .005 [ .127 ] .XX ± .01 [ .25 ]      ANGLES ± 5 °					
01	7/29/14	BJPU	BJPU	ASJ	SEE PAGE 1 FOR DRAWING CHANGES	4763	THIRD ANGLE PROJECTION					
00	7/9/14	BJPU	BJPU	ASJ	SEE PAGE 1 FOR DRAWING CHANGES	4763	DRAWING NUMBER: TP27416B01					
							DRAWN BY	DATE	CHK	SCALE	SHT 2 OF 7	SIZE
							BJPU	9-4-14	ABJ	NONE		B





# STEP THREE

Close the Crimp Dies in the tool so that they are completely against one another as shown below. The jaws should be brought together so they just meet and touch. The dies should NOT be able to be moved in this position. This will confirm that there is enough force to close them, but not enough force to compress them.



Die halves touch here

Parts are aligned and under slight pressure to meet and NOT move. NOT under full tool pressure!

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
03	9/4/14	BJPU	BJPU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
02	8/6/14	BJPU	BJPU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
01	7/29/14	BJPU	BJPU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
00	7/9/14	BJPU	BJPU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763

TITLE <b>INSTRUCTIONS, GAGING CD0920 / CD-940 DIE FMY'S</b> CONTROL DRAWING			
ITEM REVISION NAME R27416AB/03		<b>PANDUIT</b>	
DATASET FILE NAME R27416AB_DS_TP27416B01/09A Page3			
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]			
.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]	MATERIAL: NONE	
.xx ± .01 [ .25 ]	ANGLES ± 5 °	DRAWING NUMBER: TP27416B01	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
SHT 3 OF 7			SIZE B

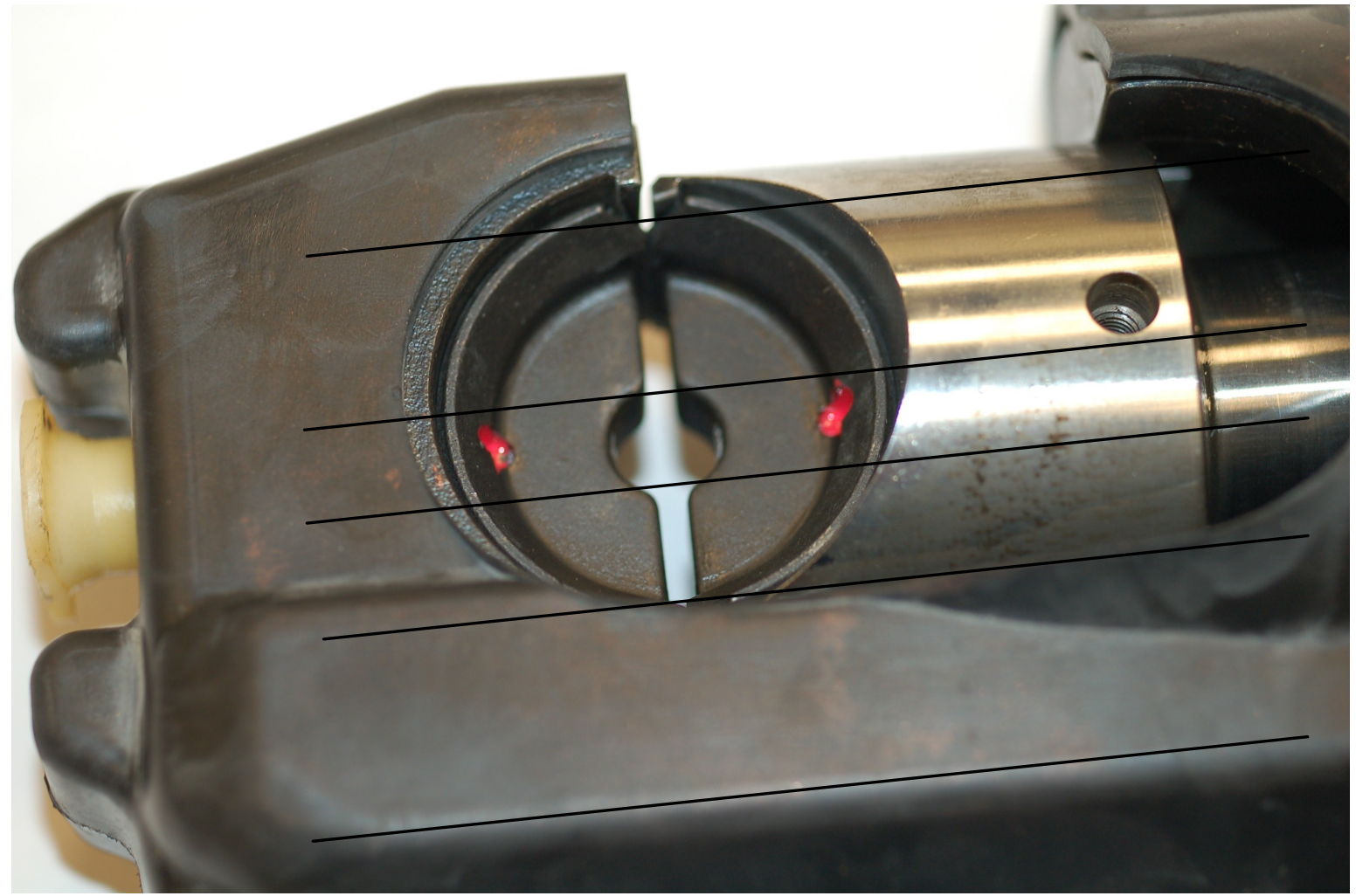




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# STEP FOUR

Check to see if both Crimp Dies are in-line with one another and centered in the tool.



The Crimp Dies should be aligned so that the maximum diameter pin can be inserted between the dies in the tool. If they are not aligned, a false GO or NO-GO could be seen.

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN	TITLE		ITEM REVISION NAME		DATASET FILE NAME		MATERIAL		DRAWING NUMBER	
							INSTRUCTIONS, GAGING CD-920 / CD-940 DIE FMY'S CONTROL DRAWING		R27416AB/03		R27416AB_DS_TP27416B01/03A Page4		PANDUIT		TP27416B01	
03	9/4/14	BJPU	JSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763	UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]		.X ± .1 [ 2.54 ]      .XXX ± .005 [ .127 ]		.XX ± .01 [ .25 ]      ANGLES ± 5 °		THIRD ANGLE PROJECTION		SHT 4 OF 7	
02	8/6/14	BJPU	JSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763	DRAWN BY		DATE		CHK		SCALE		SIZE	
01	7/29/14	BJPU	JSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763	JSFU		9-4-14		JSF		NONE		B	
00	7/9/14	BJPU	JSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763										

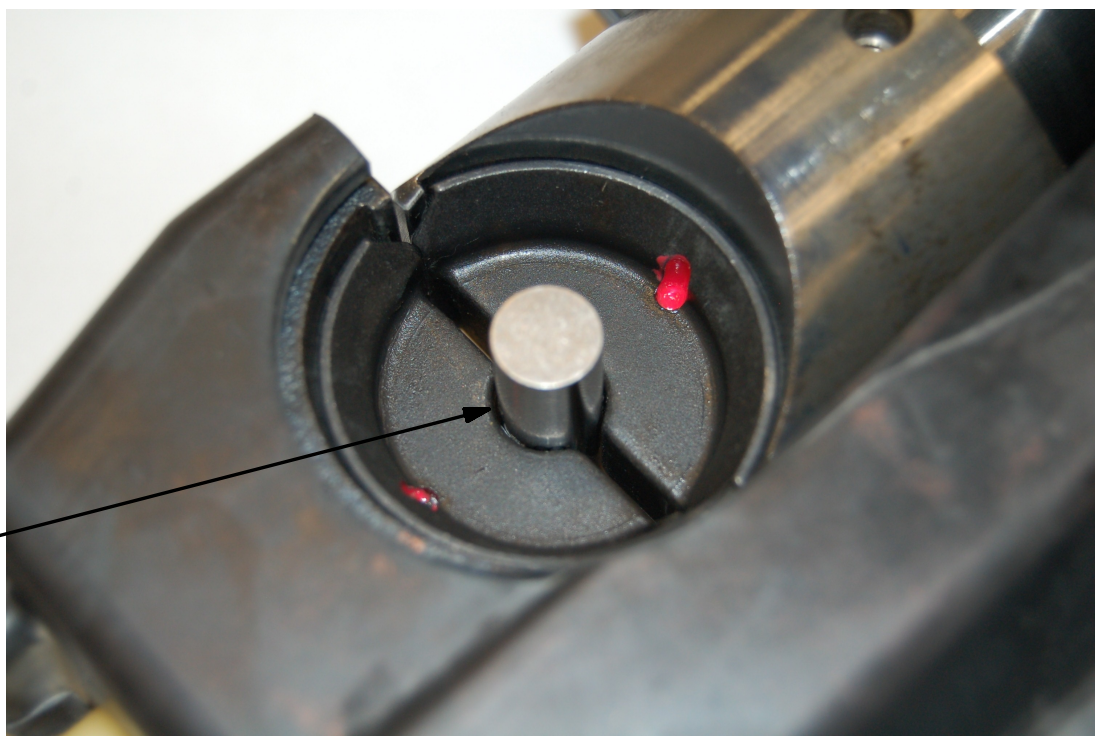




# STEP FIVE

Using the correct GO & NOGO Pin Gauges:

- a. Insert the pin gauge in the center of the Crimp Die. If checking for wear, and the correct GO pin gauge is able to pass through the center of the two Crimp Dies, then the dies are within specification.
- b. If checking to see if the Crimp Dies are over size (worn), then use the correct NO-GO pin gauge and insert it in the center of the two Crimp Dies. If the pin gauge is able to completely pass through the center of the two Crimp Dies, the Crimp Dies are out of specification and should not be used.



PIN MUST PASS THROUGH DIE SET

GO Pin gauge must pass through the center of the two dies for a PASS.  
 NO-GO pin gauge must NOT pass through the center of the two dies for a PASS.

GO PIN GAUGES ARE SHOWN IN BOTH PICTURES

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
03	9/4/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
02	8/6/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
01	7/29/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
00	7/9/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763

TITLE		INSTRUCTIONS, GAGING CD-920 / CD-940 DIE FMY'S CONTROL DRAWING	
ITEM REVISION NAME		R27416AB/03	
DATASET FILE NAME		R27416AB_DS_TP27416B01/03A Page5	
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE IN [mm]		MATERIAL: NONE	
.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]	DRAWING NUMBER: TP27416B01	
.xx ± .01 [ .25 ]	ANGLES ± 5 °	THIRD ANGLE PROJECTION	
DRAWN BY	DATE	CHK	SCALE
JSF	9-4-14	JSF	NONE
SHT 5 OF 7			SIZE B



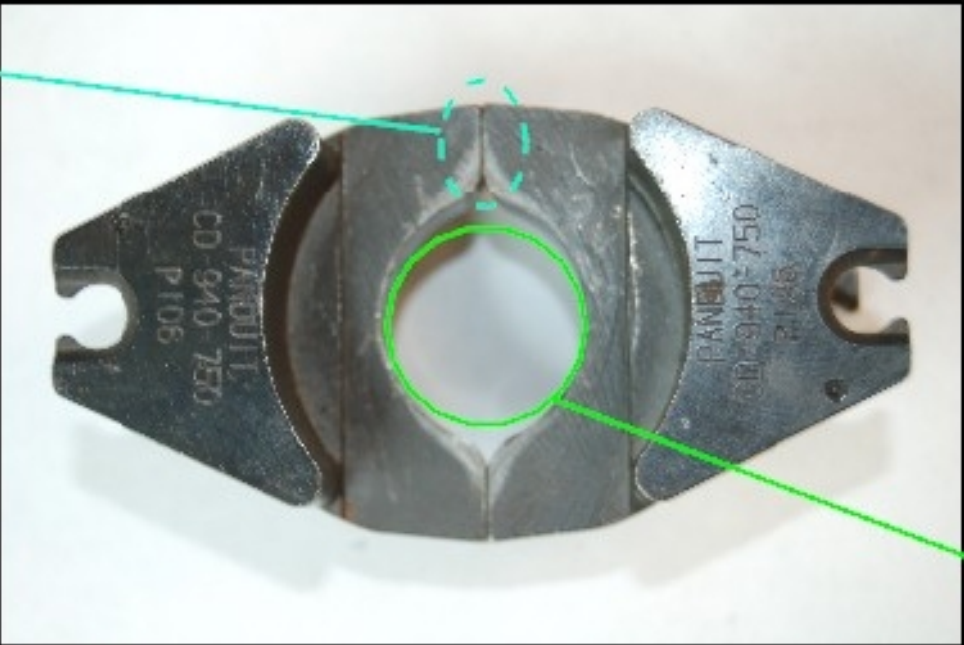


# INSTRUCTIONS FOR THE USE OF GO AND NO-GO PIN GAUGES FOR THE CD-940 STYLE CRIMP DIES

## HOW TO MEASURE CRIMP DIE WEAR

**CRIMP DIES  
CD-940-750 and CD-940-1000**

IN THIS PICTURE, PLEASE OBSERVE THAT THE CRIMP DIE HALVES ARE ALIGNED TOP TO BOTTOM AND FRONT TO BACK. THE DIES SHOULD BE CLAMPED IN A VISE IN THIS POSITION TO MEASURE WITH GAUGE PINS. THIS CLAMPED POSITION IS RECOMMENDED WHEN CHECKING WITH NO/NOGO GAUGES.



**NOTE:**  
NO SPECIAL CUSTOM GAUGES ARE CURRENTLY OFFERED. USE COMMERCIALY AVAILABLE STANDARD ROUND GAUGE PINS.\*

USE STANDARD ROUND PIN GAUGES (FOR DIAMETER - SEE DIAMETER RANGE BELOW)

### MEASUREMENT METHOD:

1. SET UP CRIMP DIES AS SHOWN ABOVE.
2. SPECIFICATION RANGE:
  - A. FOR THE CD-940-750, THE GO/NOGO GAUGE PINS ARE .835"/.896".
  - B. FOR THE CD-940-1000, THE GO/NOGO GAUGE PINS ARE .978"/1.039".
3. THE UPPER SIZED GAUGE PIN MUST NOT PASS THROUGH THE DIE POCKET FORMED WHEN THE TWO HALVES ARE HELD TOGETHER. THE LOWER SIZED GAUGE PIN MUST ENTER THE DIE POCKET FORMED WHEN THE TWO HALVES ARE HELD TOGETHER.

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
03	9/4/14	BJPU	BSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
02	8/6/14	BJPU	BSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
01	7/29/14	BJPU	BSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
00	7/9/14	BJPU	BSFU	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763

TITLE <b>INSTRUCTIONS, GAGING CD-920 / CD-940 DIE FMY'S</b>	
CONTROL DRAWING	
ITEM REVISION NAME R27416AB/03	<b>PANDUIT</b>
DATASET FILE NAME R27416AB_DS_TP27416B01/09A Page6	
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]	
.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]
.xx ± .01 [ .25 ]	ANGLES ± 5 °
THIRD ANGLE PROJECTION	
DRAWN BY BSFU	DATE 9-4-14
CHK JSF	SCALE NONE
DRAWING NUMBER: TP27416B01	
SHT 6 OF 7	
SIZE B	





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## GO AND NOGO PIN GAUGE SIZES FOR CD-920 / CD-940 STYLE CRIMP DIES

CRIMP DIE PART NUMBER	DIE COLOR CODE	DIE INDEX NUMBER	GAUGING - MAX/MIN FOR RECESSED LETTER CRIMP DIES IN INCHES		GAUGING - MAX/MIN RAISED LETTER CRIMP DIES (CD-920) IN INCHES CD-920 NEW MANUFACTURER CRIMP DIES	
			(GO)	(NO-GO)	(GO)	(NO-GO)
CD-920-8	RED	P21	.197"	.223"	.154"	.204"
CD-920-6	BLUE	P24	.237"	.263"	.174"	.224"
CD-920-4	GREY	P29	.283"	.309"	.226"	.276"
CD-920-2	BROWN	P33	.335"	.361"	.286"	.336"
CD-920-1	GREEN	P37	.377"	.403"	.336"	.386"
CD-920-1/0	PINK	P42	.427"	.453"	.364"	.414"
CD-920-2/0	BLK/GLD	P45	.449"	.475"	.396"	.446"
CD-920-3/0	ORN/TAN	P50	.517"	.543"	.426"	.476"
CD-920-4/0	PUR/OLV	P54	.567"	.593"	.506"	.556"
CD-920-250	YEL/RBY	P62	.617"	.643"	.564"	.614"
CD-920-300	WHITE	P66	.697"	.723"	.638"	.688"
CD-920-350	RED	P71	.737"	.763"	.682"	.732"
CD-920-400	BLUE	P76	.797"	.823"	.750"	.800"
CD-920-500	BROWN	P87	.903"	.929"	.844"	.894"
CD-920-500A*	PINK	P99	.819"	.845"	.746"	.796"
CD-920-600	GREEN	P94	.967"	.993"	.906"	.956"
CD-920-750*	BLACK	P106	.867"	.893"	.820"	.870"
CD-940-750*	BLACK	P106	.835"	.896"	-	-
CD-940-1000*	WHITE	P125	.978"	1.039"	-	-

\* THESE DIES DO NOT BOTTOM WHEN IN THE TOOL. THEY MUST BE PIN GAUGED IN VISE LIKE CLAMP. SEE SHT 6 FOR DETAILS.

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
03	9/4/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
02	8/6/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
01	7/29/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763
00	7/9/14	BJPU	JSF	JSF	SEE PAGE 1 FOR DRAWING CHANGES	4763

<b>TITLE</b>		<b>INSTRUCTIONS, GAGING CD-920 / CD-940 DIE FMY'S CONTROL DRAWING</b>	
ITEM REVISION NAME		R27416AB/03	
DATABASE FILE NAME		R27416AB_DS_TP27416B01/09A Page7	
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.xx ± .01 [ .25 ]	ANGLES ± 5 °	DRAWING NUMBER: TP27416B01	
		THIRD ANGLE PROJECTION	
DRAWN BY	DATE	CHK	SCALE
JSF	9-4-14	JSF	NONE
SHT 7 OF 7			B

