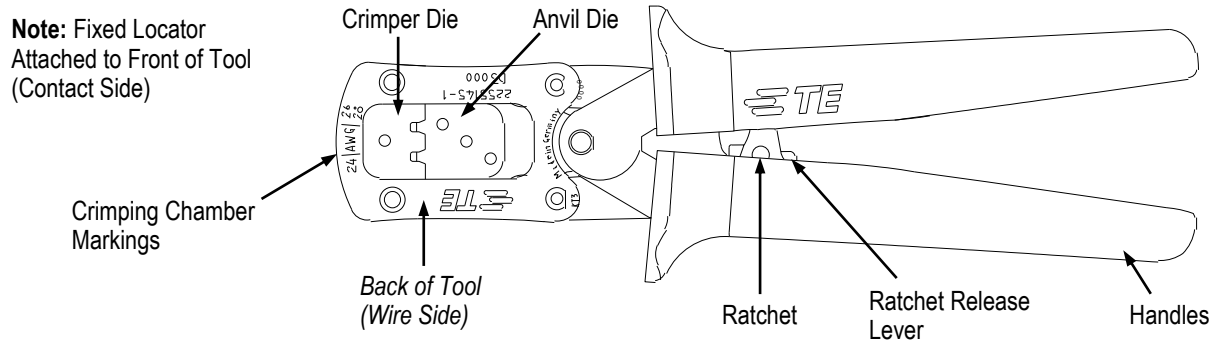
Straight Action Hand Tools (SAHT) 2255145-1, 2255146-1, 2255147-1, 2255148-1, and 2255149-1 with Fixed Locator for D3000 Dynamic Series Contacts

PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.

SAHT (2255145-1 Shown)



STRANDED WIRE		LOOSE-PIECE CONTACT SIZE	TOOL		LOOSE-PIECE CONTACT CRIMP HEIGHT mm [in.]
SIZE	STRIP LENGTH mm [in.]		PART NUMBER	CRIMPING CHAMBER MARKING	
28-26	3.8-4.8 [.150-.189]	S	2255145-1	28-26	0.67-0.96 [.026-.038]
24				24	0.84-1.03 [.033-.040]
24	3.8-4.8 [.150-.189]	M	2255146-1	24	0.90-1.08 [.035-.042]
22-20				22-20	0.97-1.13 [.038-.044]
20-18	3.8-4.8 [.150-.189]	L	2255147-1	20-18	1.05-1.22 [.041-.048]
16				16	1.35-1.52 [.053-.060]
16	4.3-5.3 [.169-.209]	2L	2255148-1	16	1.34-1.52 [.053-.060]
14				14	1.57-1.76 [.062-.069]
16	4.3-5.3 [.169-.209]	3L	2255149-1	16	1.34-1.52 [.053-.060]
14				14	1.57-1.76 [.062-.069]

Figure 1

NOTE

Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

1. CRIMPING PROCEDURE

1. Refer to Figure 1 and ensure compatibility between the wire size, loose-piece contact, and tool. The wire size must be within the specified range for the contact size. The contact size is marked on the contact.
2. Strip the wire to the length given in Figure 1.

CAUTION

Do not cut or nick the wire strands.

3. Make sure that the ratchet is released by squeezing the tool handles and allowing them to open *fully*.

NOTE

Once engaged, the ratchet will not automatically release until the handles have been fully closed. To manually release the ratchet, push the ratchet release lever.

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4. From the back of the tool, choose the applicable crimping chamber (the wire size range is marked above each crimping chamber), and insert the contact (mating end first) into the fixed locator.

5. Close the tool handles slightly, then from the back of the tool, insert the wire into the contact insulation barrel until it stops. Squeeze the tool handles until the ratchet releases.

CAUTION
The ratchet ensures full crimping of the contact. Do not re-adjust the ratchet.

6. Remove the contact (with the wire) from the fixed locator.

2. TOOL INSPECTION

2.1. Daily Maintenance

It is recommended that each operator of the tool be made aware of, and responsible for, the following four steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean brush, or a soft lint-free cloth. Do not use objects that could damage the tool.

2. Make sure that the proper retaining pins are in place and secured with the proper retaining rings.

3. Make certain all pins, pivot points, and bearing surfaces are protected with a thin coat of any good SAE 20 motor oil. *Do not oil excessively*.

4. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the dies and store the tool in a clean dry area.

2.2. Periodic Inspection

Regular inspections should be performed. Though recommendations call for at least one inspection a month, the inspection frequency should be based on the amount of use, ambient working conditions, and operator training and skill. These inspections should be performed in the following sequence:

A. Visual Inspection

1. Remove all lubrication and accumulated film by immersing the tool (handles partially closed) in a suitable commercial degreaser that will not affect paint or plastic material.

2. Make certain all retaining pins are in place and secured with retaining rings.

3. Close the tool handles until the ratchet releases, then allow the handles to open freely. If they do not open quickly and fully, return the tool to TE Connectivity for evaluation and repair.

4. Inspect the head assembly with special emphasis on checking for worn, cracked, or broken dies. If damage to any part of the head assembly is evident, return the tool to TE for evaluation and repair.

B. Crimp Height Inspection

This inspection requires the use of a micrometer with a modified anvil. Refer to instruction sheet 408-7424 for detailed information on obtaining and using a micrometer.

1. Refer to Figure 1, and select a contact and maximum size wire for each crimping chamber of the tool.

2. Crimp the contacts according to Section 1.

3. Measure the wire barrel of the crimped contact. If the crimp height conforms to the measurement given in Figure 1, the tool is considered dimensionally correct. If not, return the tool to TE for evaluation and repair.

3. REVISION SUMMARY

Initial release of instruction sheet