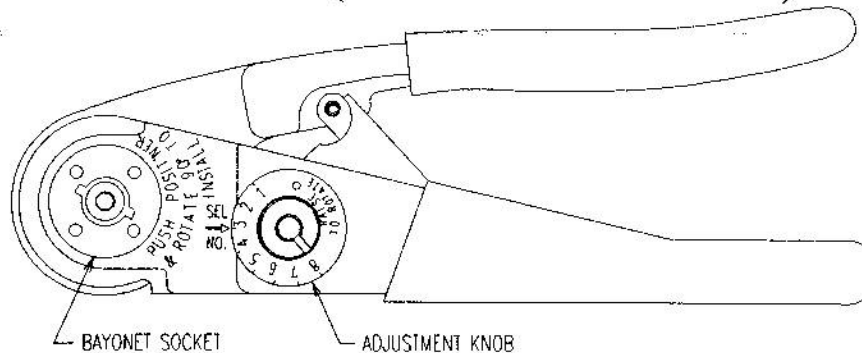




ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

615717 8-STEP ADJUSTABLE CRIMP TOOL M22520/2-01(NSN# 5120-00-165-3910)



GENERAL

The Astro Tool 615717 8-step crimp tool is a cycle controlled, precision crimp tool capable of crimping wire barrel sizes 20 to 28.

All Astro tools are designed to comfortably fit in your hand for less fatiguing hand operation. 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.

BASIC TOOL OPERATION

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

1. Select the proper Positioner for the contact to be crimped.

2. Place the Positioner in the Bayonet Socket. Line up the pins on the Positioner with the slots on the Bayonet Socket. Depress the Positioner and rotate 90° clockwise and release. The Positioner will then be locked in place.

3. Consult the Data Plate on the face of the Positioner for the proper selector setting. Grasp the Adjustment Knob; raise and rotate until the proper selector setting is lined up with the arrow on the Top Handle. Release the Adjustment Knob.

4. Insert the contact through the Indenter Opening and into the Positioner.

5. Insert the wire into the contact. 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.