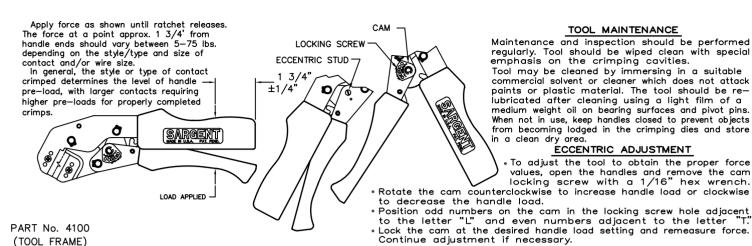
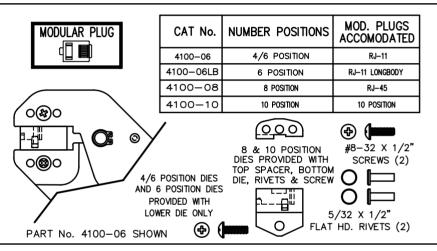
4100 CRIMP TOOL RGENT OPERATING PROCEDURE



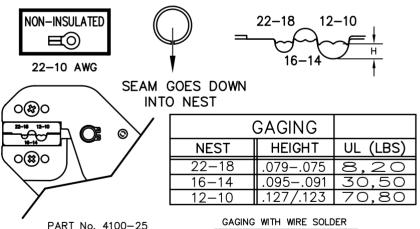


Strip cable according to manufacturer's specifications. Insert cable fully into connector. Place connector in die, end of modular plug butting against back of die cavity, and close tool completing crimp cycle. Grasp cable near connector and lift and pull to remove cable/plug assembly. Inspect crimp to assure all contacts are crimped and strain relief portion is latched. Test by holding plug and pulling firmly on cable.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

ADJUST RATCHET RELEASE HANDLE FORCE TO <u>5-15 LBS.</u> FOR MODULAR PLUGS AS INSTRUCTED ABOVE IN ECCENTRIC ADJUSTMENT SECTION.



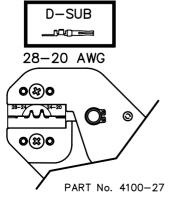
THE NON-INSULATED CRIMP DIE CRIMPS STANDARD NON-INSULATED RING, FORK AND SPADE BRAZED AND UNBRAZED CONNECTORS AS WELL AS MISCELLANEOUS OTHER TYPES OF NON-INSULATED CONNECTORS ALL CRIMPS SHOULD BE TESTED FOR ACCEPTABLE TENSILE VALUES FOR THE PARTICULAR TERMINAL AND WIRE

BEING USED AND COMPARED AGAINST ACCEPTED STANDARDS (UL OR MIL). VALUES FOR THE INTENDED WIRE SIZES ARE LISTED AND SHOULD BE CHECKED WITH AN APPROPRIATE TENSILE TESTING MACHINE OR OTHER DEVICE.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

15-30 LBS. ADJUST RATCHET RELEASE HANDLE FORCE TO FOR OPEN BARREL TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.



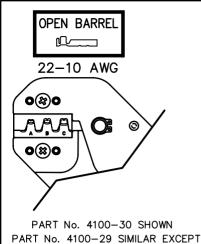
NEST	CONDUCTOR	INSULATION	
INEST	HEIGHT	HEIGHT	
28-24	.027/.025	.041 MAX.	
24-20	.029/.027	.062 MAX.	

GAGING WITH WIRE SOLDER

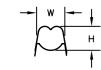
NOTE: SHOULD OVERCRIMPING OF CONTACT RESULT-ADJUST RATCHET RELEASE FORCE TO 30-50 LBS. FOR D-SUB. STYLE CONTACTS.

GAGE CRIMPS WITHIN SPECIFICATIONS- ADJUST HANDLE PRE-LOADS ACCORDINGLY.

REFER TO ECCENTRIC ADJUSTMENT PROCEDURE ABOVE.



FOR WIRE SIZES



4100-30 GAGING INFORMATION

NEST	WIRE SIZE	COND. JAW	
		HEIGHT	WIDTH
Α	22-18 AWG	.034 NOM.	.107 NOM.
В	16-14 AWG	.042 NOM.	.111 NOM.
_	12-10 AWG	.070 NOM.	.134 NOM.

4100-29 GAGING INFORMATION

NEST	WIRE SIZE	COND. JAW	
		HEIGHT	WIDTH
Α	16-20 AWG	.054046	.075071
В	14-16 AWG	.062055	.087083
С	22-30 AWG	.030025	.067063

GAGING WITH WIRE SOLDER

EARLY DESIGN CRIMP DIES HAD TO BE PINNED IN PLACE FOR PROPER OPERATION USING THE FOUR DOWEL PINS PROVIDED.

TAP PINS IN PLACE WHILE ALIGNING DIE/SPACER HOLES WITH HOLES IN TOOL FRAME.

REPEAT PROCEDURE FOR LOWER DIE.

REPLACE THE #8-32 SCREWS AS SHOWN.

LATER DESIGNS HAVE DIE HALVES PINNED TOGETHER AND ARE HELD IN PLACE BY THE CENTER SCREW ONLY.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR. 15-30 LBS.

ADJUST RATCHET RELEASE HANDLE FORCE TO FOR OPEN BARREL TERMINALS AS INSTRUCTED

FOR OPEN BARREL TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.

DIE FRONT VIEW **INSULATED** BUTT STOP TANG UP RED 18-22 BLUE 14-16 YELLOW 10-12 0(48)0 0 0(8)0 BUTT or SPLICE **INSULATED** CONNECTOR LOCATION CONNECTOR LOCATION PART No. 4100-40

Select the appropriate nest for the terminal or wire splice being crimped.

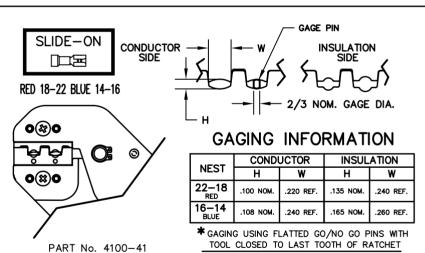
Position terminal or splice as shown in diagram. Close tool carefully until jaws grip the terminal without distortion.

Insert the properly stripped wire into the terminal. Holding the wire in place close the tool past the ratchet release position and allow the jaws to spring open.

Remove and inspect the crimp.

ADJUST RATCHET RELEASE HANDLE FORCE TO <u>30-50 LBS.</u> FOR INSULATED TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION DEPENDING ON WIRE SIZE AND CONNECT—ON OR BRAND AND STYLE OR TYPE.

NOTE: 4100-20 & -22 INSULATED TERMINAL DIES CRIMP CONDUCTOR PORTION ONLY!



SELECT THE APPROPRIATE NEST FOR THE TERMINAL BEING CRIMPED.

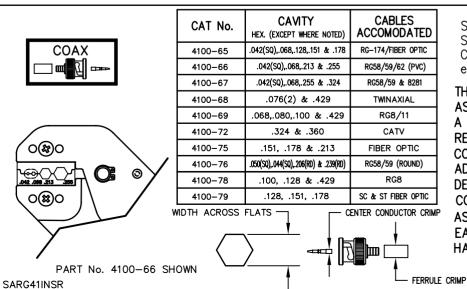
POSITION THE TERMINAL WITH INSULATION SIDE TOWARDS THE FRONT OF THE TOOL.

CLOSE THE TOOL CAREFULLY UNTIL THE JAWS GRIP THE TERMINAL WITHOUT DISTORTION.

INSERT THE PROPERLY STRIPPED WIRE INTO THE TERMINAL. HOLDING THE WIRE IN PLACE, CLOSE THE TOOL PAST THE RATCHET RELEASE POSITION AND ALLOW THE JAWS TO OPEN.

REMOVE AND INSPECT THE CRIMP.

ADJUST RATCHET RELEASE HANDLE FORCE TO <u>60-75 LBS.</u> FOR SLIDE-ON TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.



Strip cable according to manufacturer's specifications. Select proper hex cavity for size of cable being used. Crimp center conductor in area shown. Assemble connector and crimp outer ferrule.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

ADJUST RATCHET RELEAS HANDLE FORCE TO 30-50 LBS. DEPENDING ON SIZE OF CONNECTOR & CABLE. LARGER CONNECTORS REQUIRE HIGHER HANDLE PRE-LOADS TO ASSURE A SECURE AND SYMMETRICAL CRIMP. MEASURE EACH CRIMP ACROSS THE FLATS AND ADJUST THE HANDLE PRE-LOAD TO OBTAIN SYMMETRY WITHIN .003.



Компания «Океан Электроники» предлагает заключение долгосрочных отношений при поставках импортных электронных компонентов на взаимовыгодных условиях!

Наши преимущества:

- Поставка оригинальных импортных электронных компонентов напрямую с производств Америки, Европы и Азии, а так же с крупнейших складов мира;
- Широкая линейка поставок активных и пассивных импортных электронных компонентов (более 30 млн. наименований);
- Поставка сложных, дефицитных, либо снятых с производства позиций;
- Оперативные сроки поставки под заказ (от 5 рабочих дней);
- Экспресс доставка в любую точку России;
- Помощь Конструкторского Отдела и консультации квалифицированных инженеров;
- Техническая поддержка проекта, помощь в подборе аналогов, поставка прототипов;
- Поставка электронных компонентов под контролем ВП;
- Система менеджмента качества сертифицирована по Международному стандарту ISO 9001;
- При необходимости вся продукция военного и аэрокосмического назначения проходит испытания и сертификацию в лаборатории (по согласованию с заказчиком);
- Поставка специализированных компонентов военного и аэрокосмического уровня качества (Xilinx, Altera, Analog Devices, Intersil, Interpoint, Microsemi, Actel, Aeroflex, Peregrine, VPT, Syfer, Eurofarad, Texas Instruments, MS Kennedy, Miteq, Cobham, E2V, MA-COM, Hittite, Mini-Circuits, General Dynamics и др.);

Компания «Океан Электроники» является официальным дистрибьютором и эксклюзивным представителем в России одного из крупнейших производителей разъемов военного и аэрокосмического назначения «JONHON», а так же официальным дистрибьютором и эксклюзивным представителем в России производителя высокотехнологичных и надежных решений для передачи СВЧ сигналов «FORSTAR».



«JONHON» (основан в 1970 г.)

Разъемы специального, военного и аэрокосмического назначения:

(Применяются в военной, авиационной, аэрокосмической, морской, железнодорожной, горно- и нефтедобывающей отраслях промышленности)

«**FORSTAR**» (основан в 1998 г.)

ВЧ соединители, коаксиальные кабели, кабельные сборки и микроволновые компоненты:

(Применяются в телекоммуникациях гражданского и специального назначения, в средствах связи, РЛС, а так же военной, авиационной и аэрокосмической отраслях промышленности).



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