

Operating Instructions

Four-indent crimping tool PEW 8.75 (8-impession crimp)

Art.-No. 8750 0414 6 IL (ILME code CCPZ RN)



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1 General information

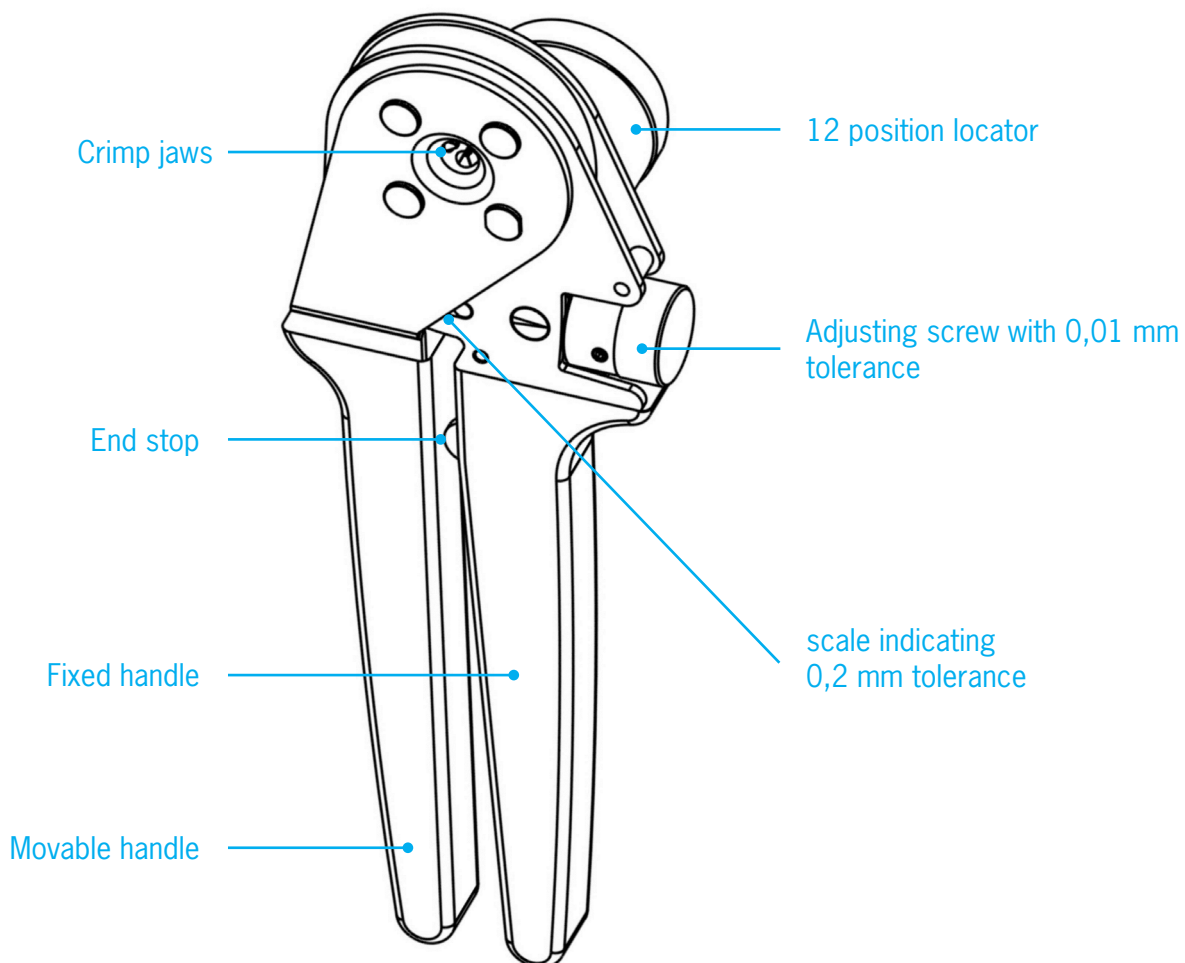
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Designed and manufactured pursuant to state-of-the-art technical requirements and latest safety standards, this four indent crimp tool PEW 8.75 to be used only when in order and in strict compliance with existing safety rules.

The tool has been developed for crimping of both male and female turned contacts. The tool is only to be used for the application described below. The manufacturer is not liable for damages caused by improper use or unauthorised technical modifications of the tool.

2 Application

The four indent crimp tool PEW 8.75 has been developed for optimal crimping of turned contacts for wire ranges 0.14 to 6.0 mm² (26 through 10 AWG).



3 Description of the tool

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The tool consists of a movable handle with precision ratchet mechanism, a fixed handle with a metric scale, an adjustment system by micro setting of 0.01 mm tolerance, four indenter jaws and a 12 position locator, fully rotatable, for accurate positioning of contacts. A reference table marked onto the crimp tool's surface informs on the locator position and crimp depth to be selected to match a particular contact. The tool can be adjusted to any crimp depths that might be requested by the contact manufacturer.

Pictograms mark the text as follows: Read and observe these notes, and exercise special care in these cases. Pass on all work safety precautions to users and specialist staff.



WARNING

This information indicates a potentially dangerous situation that may lead to serious injury or fatality.



CAUTION

This information indicates a potentially dangerous situation that may lead to slight or minor injury, or damage to property.



INFORMATION

This information refers directly to the description of a function or operating sequence.

4 Function

- Loosen the clamping screw on the opposite site of the adjusting screw before using the tool (don't remove the clamping screw!).
- The reference table indicates the correct locator position to be selected and the crimp depth to be adjusted for the contact to be crimped.
- The contact is then inserted through the entry hole of the tool on the opposite side of the locator.
- The contact is fixed by closing the handles to the first lock-in position thus preventing the contact falling out of the tool and facilitating insertion of cable into the contact.

The precision ratchet assures consistently accurate crimps every time by forcing the tool to be closed to its fullest extent, completing the crimping cycle before the tool opens automatically.

Changing the Locators

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Loosen the hexagon socket with the enclosed allen key. Remove the locator by turning it counterclockwise.



CAUTION!

Do not crimp onto the gauge when inserted or any other items that are not meant for the intended application! Do not crimp on solid material exceeding 35 HRC (e.g. steel)!

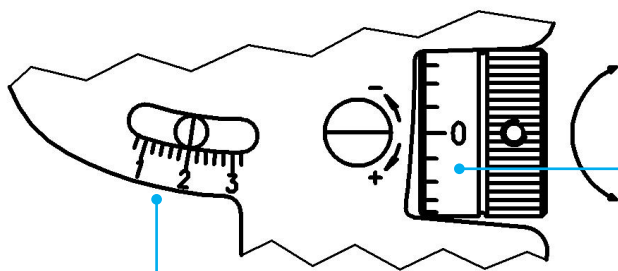
5 Adjustment of crimp depth

The crimp depth has to be adjusted as follows:

Adjusting screw turned clockwise for reducing of crimp depth and anticlockwise for increasing of crimp depth.

Adjustment tolerances

- 1 scale spacing on the screw = adjustment by 1/100 mm
- 1 full rotation of screw = adjustment by 0.2 mm (indication on the screw as well as on the rough scale)
- 5 rotations of the screw = adjustment by 1 mm (indication on the scale)



adjusting screw with 0.01 mm tolerance

- Crimp depth lower (-)
- Crimp depth higher (+)

scale indicating 0.2 mm tolerances

6 Gauging the crimp depth

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Crimp tool adjustment is carried out in the factory. Gauging every working day is recommended to ensure accurate calibration. This is easily accomplished with a GO–NOGO gauge (Ilme art. CCPNP RN) at \varnothing 2.0 mm position. The crimp depth of 2.00 mm is set by means of the adjusting screw (scale mark at „2“, screw mark at „0“ as shown in the fig. above) and the tool is to close. In case the GO-side doesn't go or the NOGO-side goes, i.e. the tolerances required by the manufacturer are overstepped, please contact your distributor for action.



CAUTION!

Do not crimp onto the gauge when inserted or any other items that are not meant for the intended application! Do not crimp on solid material exceeding 35 HRC (e.g. steel)!

7 Maintenance and repair

Keep the tool clean and properly stored when not in use. The joints need to be oiled regularly and the circlips securing the bolts should always be in place. For any repair please return the tool to your distributor.

Repairs/Service



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Adjustment PEW 8.75 - ILME CCPZ RN

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Number	Wire size [mm ²]	Setting value [mm]	Locator position
CDMA 0,3	0,35	1,30	M1
CDMA 0,5	0,50	1,55	
CDMA 0,7	0,75	1,55	
CDMA 1,0	1,00	1,55	
CDMA 1,5	1,50	1,55	
CDMA 2,5	2,50	1,55	
CDFA 0,3	0,35	1,30	F2
CDFA 0,5	0,50	1,55	
CDFA 0,7	0,75	1,55	
CDFA 1,0	1,00	1,55	
CDFA 1,5	1,50	1,55	
CDFA 2,5	2,50	1,55	
CCMA 0,3	0,14	1,20	M3
	0,25	1,30	
	0,35		
CCMA 0,5	0,50	1,55	
CCMA 0,7	0,75	1,55	
CCMA 1,0	1,00	1,55	
CCMA 1,5	1,50	1,80	
CCMA 2,5	2,50	1,80	
CCMA 3,0	3,00	1,90	
CCMA 4,0	4,00	2,00	
CCFA 0,3	0,14	1,20	F4
	0,25	1,30	
	0,35		
CCFA 0,5	0,50	1,55	
CCFA 0,7	0,75	1,55	
CCFA 1,0	1,00	1,55	
CCFA 1,5	1,50	1,80	
CCFA 2,5	2,50	1,80	
CCFA 3,0	3,00	1,90	
CCFA 4,0	4,00	2,00	
CXMA 1,5	1,50	1,55	M5
CXMA 2,5	2,50	1,80	
CXMA 4,0	4,00	2,00	
CXMA 6,0	6,00	2,50	
CXMA 10,0	10,00	2,30	
CXFA 1,5	1,50	1,55	F6
CXFA 2,5	2,50	1,80	
CXFA 4,0	4,00	2,00	
CXFA 6,0	6,00	2,50	
CXFA 10,00	10,00	2,30	