

ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

Operation Instructions for Portable Hex Die Crimp Tool No. EUSP175

BASIC DESCRIPTION

The Astro Tool Corp. Portable Pneumatic Hex Die Crimper has all the features of the EUS175 "C" frame hand crimp tool. It accepts all standard Huber/Suhner or equivalent style die sets.

TOOL REQUIREMENTS

The EUSP175 requires a 80-120 P.S.I. regulated, filtered and lubricated air supply. Astro offers the 11413 air regulator for this purpose.

BASIC OPERATION

1. Observe all caution labels on the tool before assembling dies or connecting the air supply to the tool.
2. Select the appropriate die set for the connector or contact to be crimped.

DIE INSTALLATION

3. Raise the safety shield by depressing the safety shield lever on the side of the crimp tool.
4. Insert the stationary die in the front of the tool, slide die along slot in the tool and into die nest until die stops and tighten 6-32 set screw with wrench provided. See figure #1.

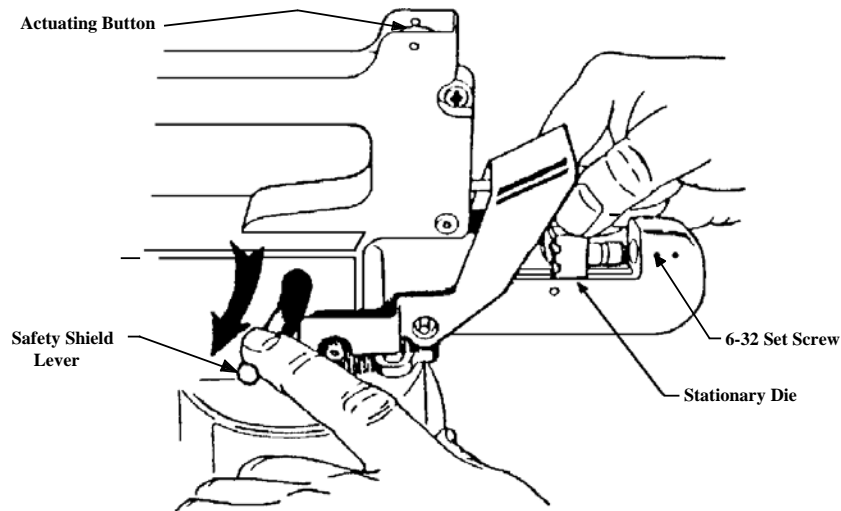


Figure # 1

5. With the safety shield raised, insert the movable die into the drive shaft die nest located in the back of the frame. Slide die along slot and into drive shaft die nest until die stops and tighten 6-32 set screw with wrench provided. Release the safety shield after die installation.
6. Connect a regulated, filtered and lubricated air supply to the tool.

CRIMPING OPERATION

7. Pre-assemble the connector or contact to the prepared wire or cable following the manufacturer's specifications.
8. Raise the safety shield by depressing the safety lever.
9. Insert and position the connector in the stationary die.
10. Release the safety shield lever. The dies will hold the connector in place.
11. Depress the actuating button on top of the tool. The tool will complete one cycle.
12. Raise the safety shield and remove the crimped assembly.

DIE REMOVAL

13. Disconnect the air supply from the tool.
14. To remove the stationary and movable die set, use wrench provided. Loosen 6-32 set screws and remove dies from tool.

EMERGENCY RELEASE

If the crimp tool should jam in the crimp position; release the tool by depressing the Emergency Release Lever. This releases air pressure from the air cylinder allowing the movable die to retract. See figure # 2.

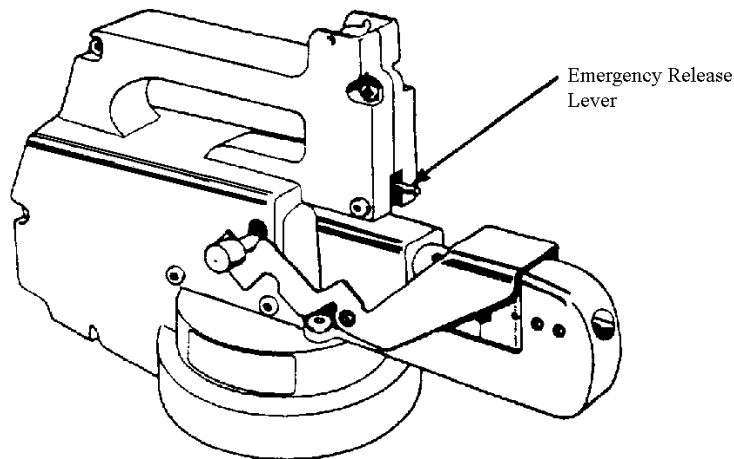


Figure # 2

INSTRUCTIONS FOR 621201 AND 621202 BENCH MOUNT

The Astro Tool Corp. EUSP175 portable pneumatic C-Frame crimping tool can be bench mounted for improved operating efficiency. The bench mount can be positioned at any angle to suit the operator. A foot pedal may be added to increase the versatility of the tool.

There are two versions of the bench mount assembly:

Part number 621201; A 360 degree swivel bench mount assembly.

Part number 621202; A 360 degree swivel bench mount assembly with a foot pedal actuator.

ASSEMBLY INSTRUCTIONS FOR 621201 BENCH MOUNT:

1. Firmly attach the base plate to the bench before attaching the tool; to prevent tipping.
 2. Remove the stem from the base by loosening the hand screw.
 3. Assemble the tool to the stem with the two screws and washers supplied. Before tightening the screws, center the tool on the stem plate.
 4. Insert the stem into the base, select a desired angle and tighten the hand screw firmly.
- See figure # 3

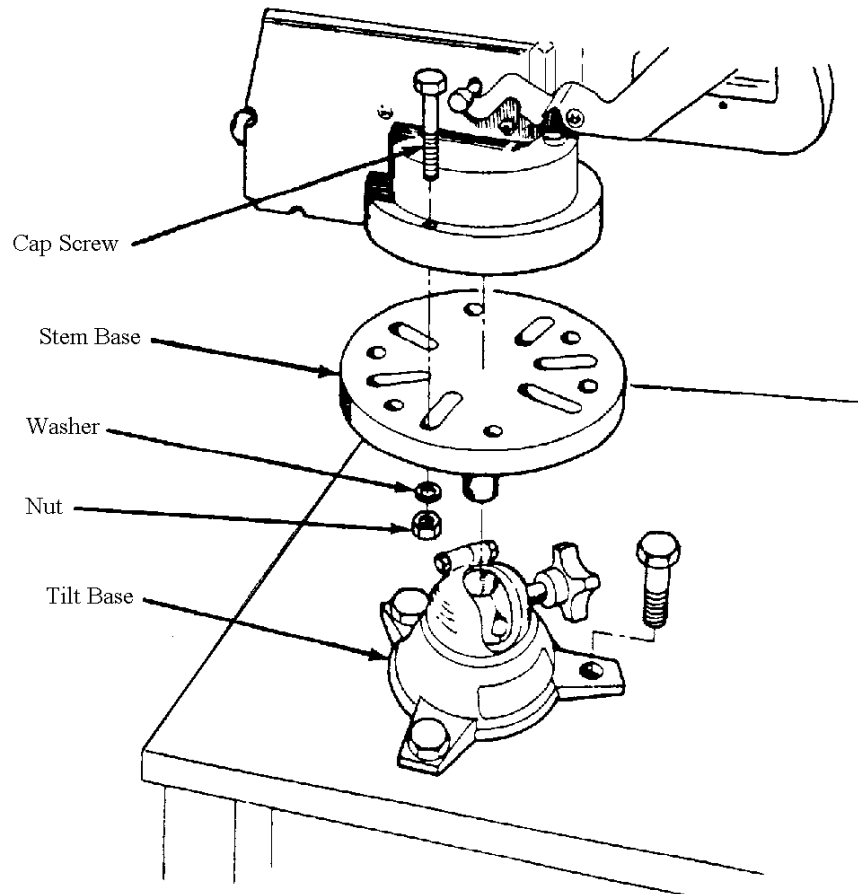


Figure # 3

5. The tool is now ready for hand actuated operation as described in the BASIC OPERATION section of this manual.

621202 BENCH MOUNT AND FOOT SWITCH INSTALLATION:

1. Mount tool as described in instructions for 621201 Bench Mount Assembly Instructions section of this manual.

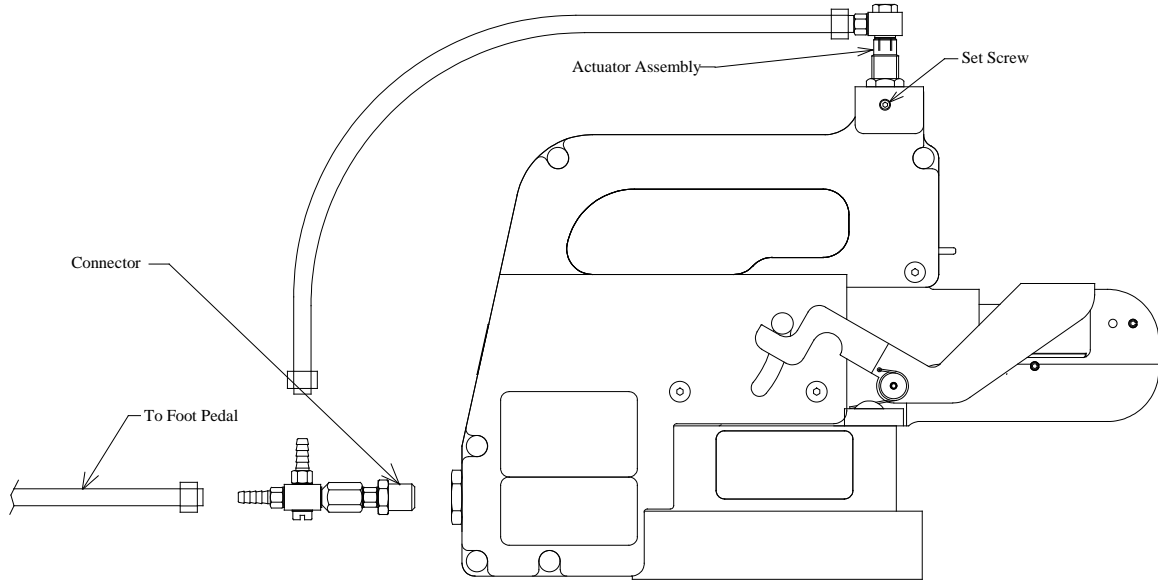


Figure # 4

2. Connect Foot Switch and Actuator Assembly to tool using supplied connectors. See Figure # 4.
3. Install the appropriate die set for the connector or contact to be crimped. Refer to DIE INSTALLATION section of this manual.
4. Connect filtered and lubricated air supply to the foot pedal assembly.
5. The tool is now ready for use. Follow the crimping instructions as described in the CRIMPING OPERATION section of this manual.

**ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL,
CRIMP TOOLS AND CONNECTOR SERVICE KITS**

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