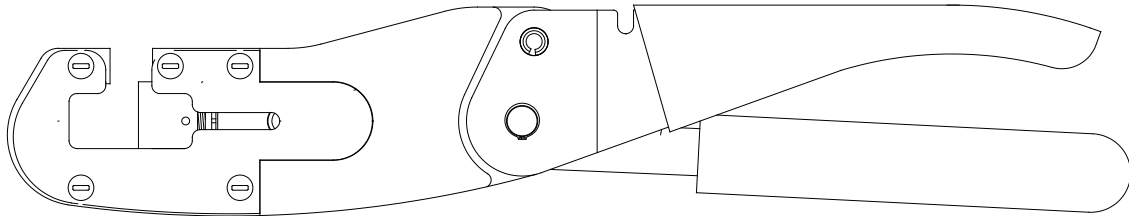




ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING

Instructions for the 613214 Miniature C-Frame Tool



GENERAL

The Astro Tool Corp. Miniature Hex Pop-in Die Crimping Tool is a cycle controlled, manually operated, C-frame tool for crimping shield terminating ferrules, RF connector fittings, and other terminations requiring an open frame crimp tool.

There is only one set up operation required - installing the required die set. Die sets are available in single hex cavities. Special form crimps are also obtainable, consult the factory for details.

The Tool's precision cycle control mechanism assures a high quality, repeatable crimp. The in-line action of the dies and toggle mechanism reduces the compression force required to complete the crimp.

For long life and optimum performance, this tool should be kept clean and handled with the care of any other precision device.

OPERATION

Open and close the tool several times and observe the precision cycle-control mechanism. Note that the tool cannot be opened without completing its cycle.

Identify the following parts, shown in Figure #1:

1. Ratchet Handle
2. Pop-In Die Holder
3. Plunger
4. Die Retaining Plate

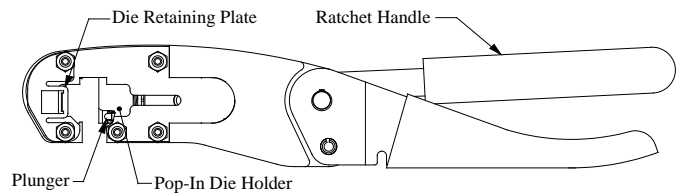


Figure # 1

DIE INSTALLATION

1. The tool must be in the fully closed position. Orient the Movable Die Half so that the Detent Hole will be in line with the Plunger. Slide the die into position. See figure #2.

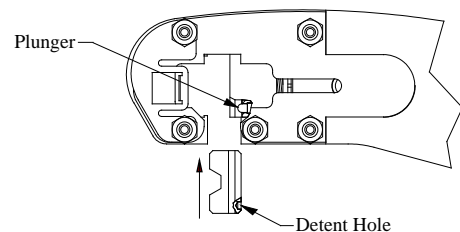


Figure #2

2. With the tool in the fully open position, insert the Stationary Die Half as shown in Figure #3. Making sure that the die is between the Side Plates, press down and rotate the die clockwise into position.

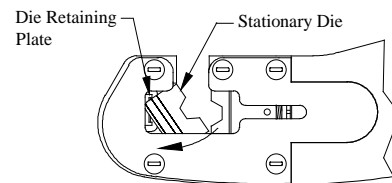


Figure # 3

CAUTION:

VERIFY THAT THE STATIONARY DIE IS INSTALLED CORRECTLY. IMPROPER INSTALLATION WILL RESULT IN DAMAGE TO THE TOOL OR THE DIE SET.

3. Cycle the tool to set the dies.

CRIMPING OPERATION

1. The tool must be in the fully open position. Insert the prepared connector through the tool opening and place in the cavity. For RF connector fittings, use the die face as a locational stop. For shield terminations, locate the crimp by eye.
2. Squeeze the handles together until the positive stop is reached. The tool will release and return to the fully open position.
3. Remove the crimped termination.

DIE REMOVAL

1. The tool must be in the fully open position. Using a flat blade screw driver or suitable device, gently lift on the Die Retaining Plate and remove the Stationary Die. See Figure #4.

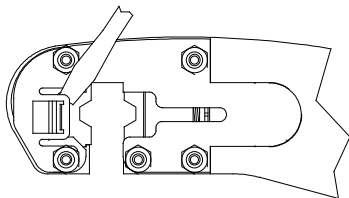


Figure #4

2. With the tool fully closed, slide the Movable Die out of the tool, as shown in Figure #5.

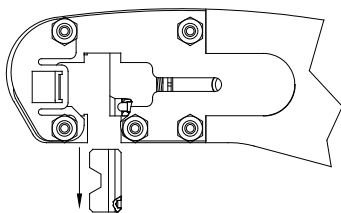


Figure # 5

NOTE: Always remove the Stationary Die first.

TOOL CALIBRATION

1. Hand pressure of 15-25 lbs. is required to cycle the tool with a nominal set of dies installed. Astro has the AT903 spring tester available for calibration purposes.
2. If calibration of the hand pressure is required, locate the adjustment screw in the Movable Die Nest by closing the tool. Using a flat blade screwdriver, rotate the screw to the right to decrease the pressure, to the left to increase the hand pressure. See figure #6.

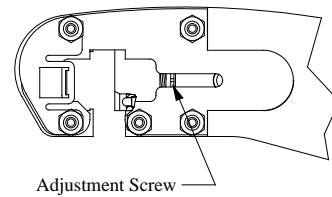


Figure # 6

3. When hand pressure calibration is achieved, lock the screw in place using an appropriate NON-PERMANENT sealant.

TOOL GAGING

1. Astro Tool Corp. manufactures flat GO-NO GO pin assemblies for many of the dies used by the 613214 crimp tool. Contact the factory for your specific requirements.
2. With a die set properly installed, cycle the tool into the fully closed position. Insert the appropriate GO sized flat pin into the hex cavity. It shall freely enter the hex cavity. See figure #7. Remove the GO pin and attempt to insert the NO-GO pin into the hex cavity. It should not enter the cavity.

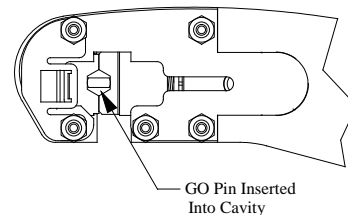


Figure #7

**DO NOT CRIMP GAGE,
TOOL DAMAGE WILL RESULT.**

TOOL SERVICE

Astro Tool's 613214 Crimp Tool is designed for long, reliable service. If the Tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the Tool to our factory.

Upon receipt of the Tool, Astro will inspect and overhaul each Tool to put the Tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired. Please note that Astro's Quality Control system is traceable to The National Institute of Standards and Technology (N.I.S.T.).

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charge for such parts.

**TOOL HAS BEEN PERMANENTLY
LUBRICATED AT THE FACTORY
DO NOT OIL**

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

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