

Figure 1

## 1. INTRODUCTION

CERTI-CRIMP II Large Die Straight Action Adapter 1901556-1 is used to accommodate large dies with a maximum wire size of 14 AWG [2.0 mm<sup>2</sup>] in the SDE electric bench terminator. See Figure 1.

**NOTE**



*Dimensions in this instruction sheet are in millimeters with [inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.*

This instruction sheet provides:

- Instructions for installing and removing the adapter to the electric bench machine terminator
- Instructions for installing the crimping dies onto the adapter
- Instructions for adjusting the crimp height

— Maintenance, inspection, and repair instructions for the adapter

For information concerning the setup and operation of the SDE electric bench terminator, refer to Customer Manual 409-10052.

Read this instruction sheet and the related customer manual thoroughly before using the adapter.

Reasons for reissue of this instruction sheet are provided in Section 8, REVISION SUMMARY.

## 2. DESCRIPTION

The adapter provides the necessary straight-line motion of the movable die when the SDE electric bench machine is actuated.

The adapter features a switch (handle) and three quick pins. See Figure 2. The switch (handle) can be used to manually open and close the dies of the crimping head for insertion and removal of the product.

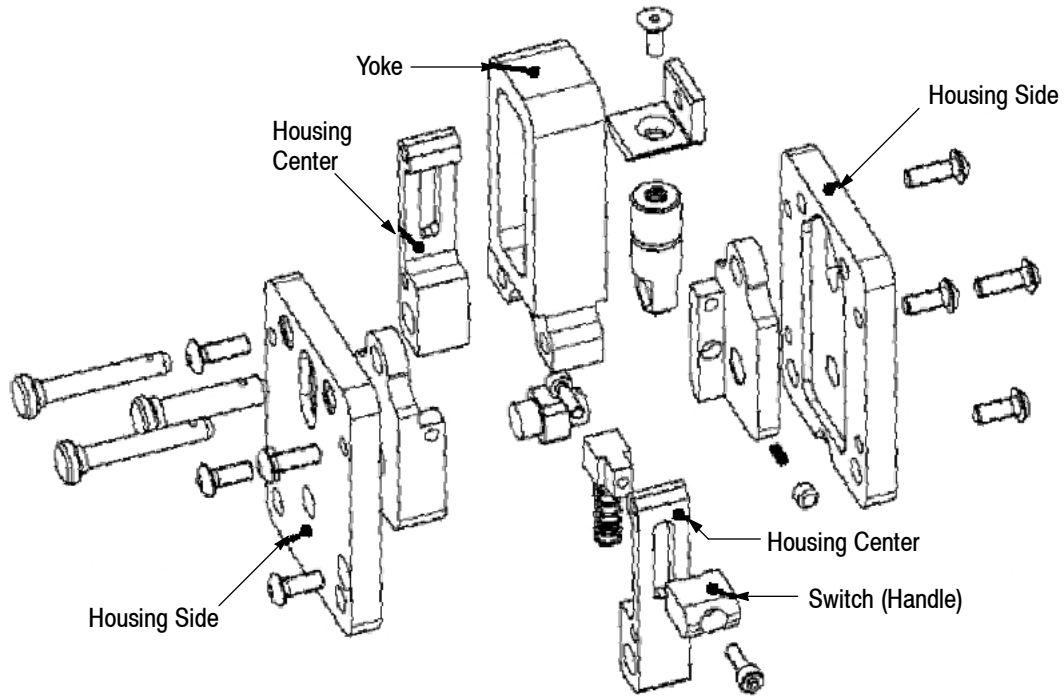



Figure 2

**3. INSTALLATION AND REMOVAL OF ADAPTER**

**3.1. Installation**

Before mounting the large die straight action adapter, always make sure the guide ram of the terminator is in the lowest position. See Figure 3.

**DANGER** To avoid personal injury, be sure the SDE electric bench terminator is disconnected from the power source prior to the installation or removal of the adapter.



1. Be sure that the terminator has been switched to “off”.
2. Be sure that the adapter is mounted with the switch (handle) in the front, to facilitate die opening and closing.
3. Mount the adapter from the back and lock with the guide (safety) pins. Refer to Figures 3 and 4.
4. Refer to Paragraph 3.3 to remove and install the crimping dies.

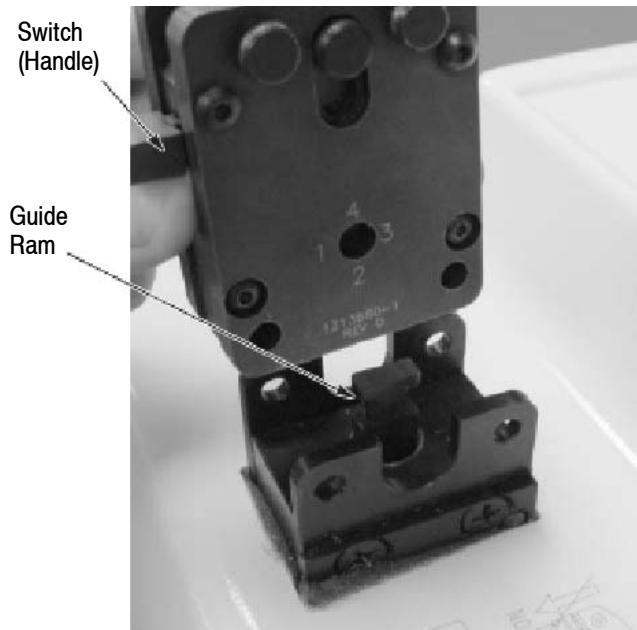



Figure 3

**3.2. Removal**

**DANGER** To avoid personal injury, be sure the SDE electric bench terminator is disconnected from the power source prior to the installation or removal of the adapter.



1. Be sure that the terminator has been switched to “off”.
2. Remove the locating pins from the adapter.
3. Remove and/or replace the adapter.
4. When removing the adapter, make sure that the guide ram of the terminator is in the lowest position.
5. If installing or removing crimping dies, refer to Paragraph 3.3.

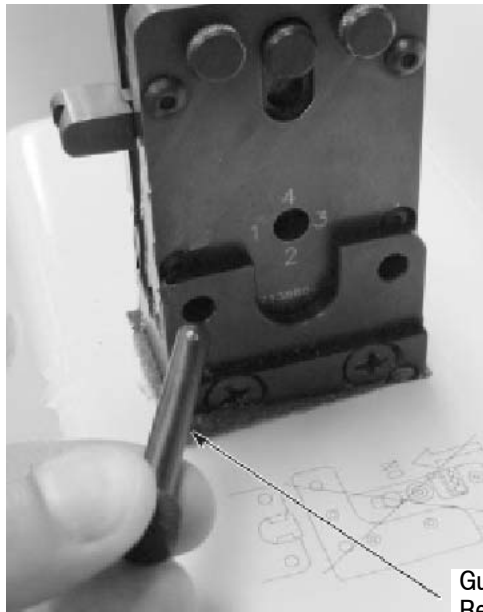


Figure 4

2. Press down on the switch (handle) to move the moving die holder to its lowest position.
3. Place the moving die in the moving die holder. Turn die holding screw enough to hold die in place. DO NOT tighten the screw.
4. Release the switch (handle) to align the dies, then tighten the die holding screws.
5. To remove the dies, loosen the die holding screws, and remove the dies.

**4. CRIMP HEIGHT ADJUSTMENT**

Crimp height adjustments is required only if the crimp height listed in the Tyco Electronics die specification is not achieved.

Adjust the crimp height with a flat-bladed screwdriver.

There are four different crimp heights. See Figure 6.

**NOTE** Although Tyco Electronics normally recommends Position No. 2 (adjustment of the manufacturer), Positions No. 3 and 4 increase the travel of the tool head, which decreases the crimp height. Position No. 1 decreases the travel of the head, which increases the crimp height.

**3.3. Installation and Removal of Crimping Dies** (Figure 5)

**DANGER** To avoid personal injury, be sure the SDE electric bench terminator is disconnected from the power source prior to the installation or removal of the crimping dies.

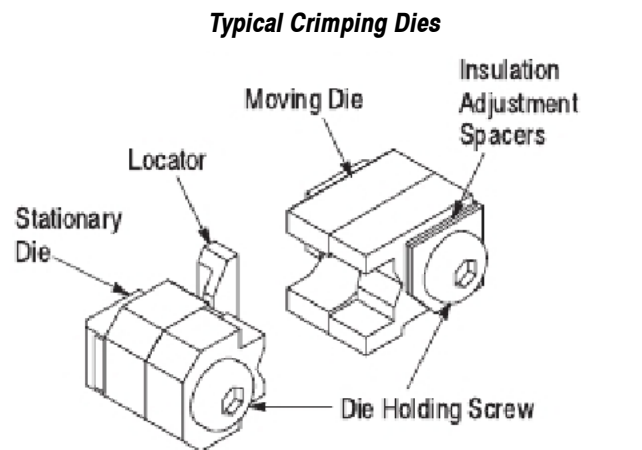
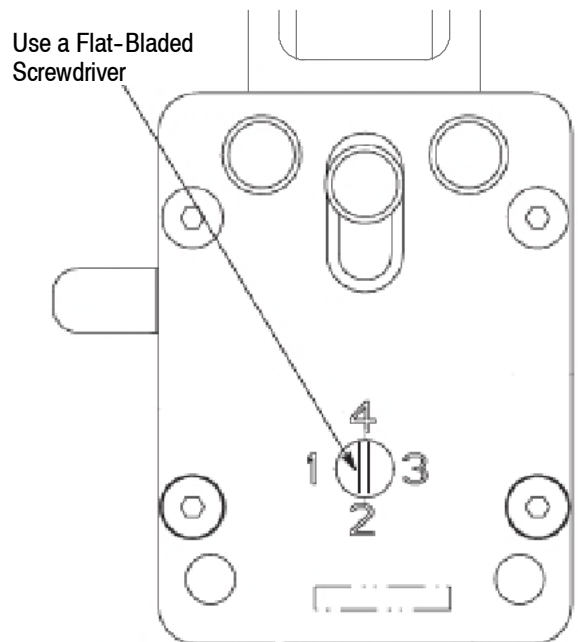


Figure 5

If the crimping dies require an insulation adjustment, refer to the instruction sheet packaged with the dies for the adjustment procedure, then proceed as follows:

1. Place the stationary die in the stationary die holder. Turn the die holding screw enough to hold the die in place. Do NOT tighten the screw.



Crimp Height Adjustment (One Step Equals 0.1 mm [.004 in.])

Figure 6

**5. OPERATION**

For operating instructions, refer to Customer Manual 409-10052.

## 6. MAINTENANCE AND INSPECTION

It is recommended that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations.



*To avoid personal injury, ALWAYS DISCONNECT the SDE electric bench terminator before performing maintenance or inspection.*

### 6.1. Daily Maintenance

1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a lint-free cloth. Do NOT use objects that could damage the adapter.
2. Make sure that all components are in place and secure.
3. Make certain all surfaces are protected with a thin coat of any good SAE 20 motor oil. Do NOT oil excessively.
4. When the adapter assembly is not in use, store it in a clean, dry area.

### 6.2. Lubrication

Lubricate all pins, pivot points, and bearing surfaces with a high quality grease. It is recommended using Molykote paste which is commercially available lubricant. Lubricate according to the following schedule:

- If the adapter is used daily, lubricate daily
- If the adapter is used occasionally, lubricate weekly
- If the adapter is used weekly, lubricate monthly

### 6.3. Visual Inspection

Regular inspections should be performed by quality-control personnel. A record of scheduled

inspections should remain with the adapter or be supplied to personnel responsible for the adapter. Though recommendations call for at least one inspection a month, the frequency should be based on amount of use, working conditions, operator training and skill, and established company policies.

1. Remove all lubrication and accumulated film by immersing the adapter in a suitable commercial degreaser that will not affect paint or plastic.
2. Make certain all components are in place.
3. Check all bearing surfaces for wear. Replace any worn parts. If replacements are necessary, refer to Section 7, REPLACEMENT AND REPAIR.

## 7. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 7.

A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Parts other than those listed should be replaced by Tyco Electronics to ensure quality and reliability. Order replaceable parts through your local Tyco Electronics Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

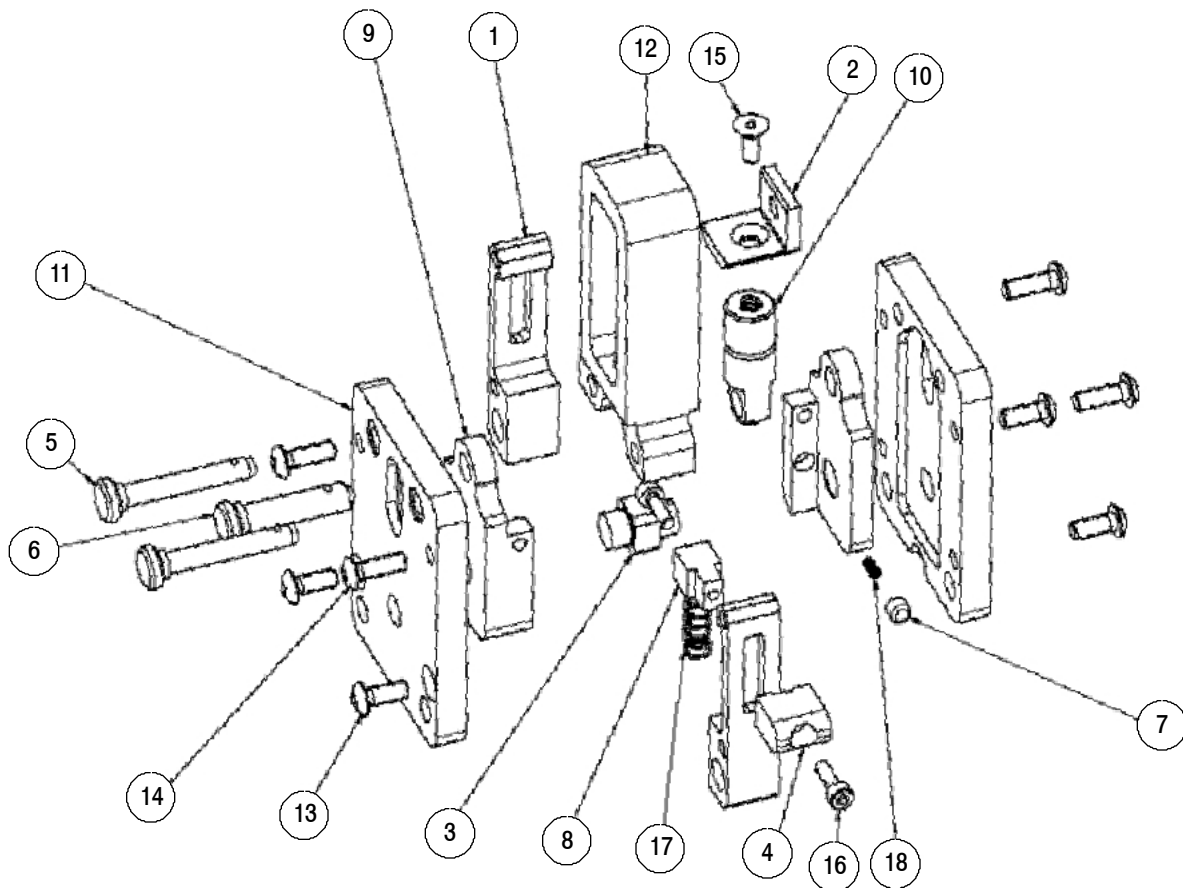
CUSTOMER SERVICE (038-035)  
 TYCO ELECTRONICS CORPORATION  
 PO BOX 3608  
 HARRISBURG PA 17105-3608

For customer repair service, call 1-800-526-5136.

## 8. REVISION SUMMARY

Revisions to this instruction sheet include:

- Added "Original Instructions" to page 1



ITEM	PART NUMBER	DESCRIPTION	QTY PER ADAPTER
1	1213854-1	HOUSING, Center	2
2	1901610-1	DIE HOLDER, Lower Straight Action	1
3	1213859-1	ECCENTRIC	1
4	1213856-1	HANDLE	1
5	217873-1	PIN, Quick	2
6	217873-2	PIN, Quick	1
7	1213858-1	PLUNGER	1
8	1213861-1	POST, Spring Stop	1
9	1213857-1	RAM	2
10	1901609-2	RAM, Modified	1
11	1213853-1	HOUSING, Side	2
12	1901608-1	YOKE, Single	1
13	18024-7	SCREW, Button, Socket Head Cap (M4 x 10.0)	4
14	18024-8	SCREW, Button, Socket Head Cap (M4 x 12.0)	4
15	1-21003-9	SCREW, Flat, Socket Head Cap (6-32 x .375)	1
16	18023-4	SCREW, Socket Head Cap (M3 x 10.0)	2
17	22280-9	SPRING, Compression	1
18	6-22278-0	SPRING, Compression	1

Figure 7