

INSTRUCTION MANUAL

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1. INTRODUCTION AND TOOL FEATURES

1.1. Instruction sheet provides application and maintenance procedures for Compact hand tools. The hand tool consists of the tool frame and integrated die set.





With this tool **only** plugs of **appropriate type** have to be used. Crimping plugs of unsuitable type may result with unsatisfactory characteristics of crimped connections and eventually with damaging of the tools and is to be strictly avoided.

1.2. FEATURES

- Crimp nests are fully machined in high carbon steel, heat treated, polished and nickel coated.
- Quality crimp due to parallel crimping performance
- Precise eccentric adjustment
- Safety ratchet relief
- Precise and easy positioning due to integrated locator system (BC3)

2. DIE SET CHART

Chart of corresponding die sets for Compact tool line.

This tool is intended for crimping of variety of crimp terminals			
For crimping of	Die set code	Profile geometry	Weight (g)
Non insulated terminals 0.75; 1.5- 2.5; 4-6; 10 mm ²	BC1		433
Insulated terminals 0.5;1.5;2.5;4-6 mm ²	BC2		433
Tab connectors 0,5-1; 1,5-2,5; 4-6mm ²	BC3		433
Wire end ferrules 0,25; 0,5; 1; 1,5; 2,5; 4; 6; 10, 16 mm ²	BC4		433

3. STRIPPED WIRE CONDITION

Correct stripping length: Cable stripping dimension should be as specified by plug manufacturer.
Plug should be free from any damage or broken strands.
The center conductor and crimp sleeve measures must be within the manufacturer's specifications.

4. CONFIGURATION OF THE TOOL

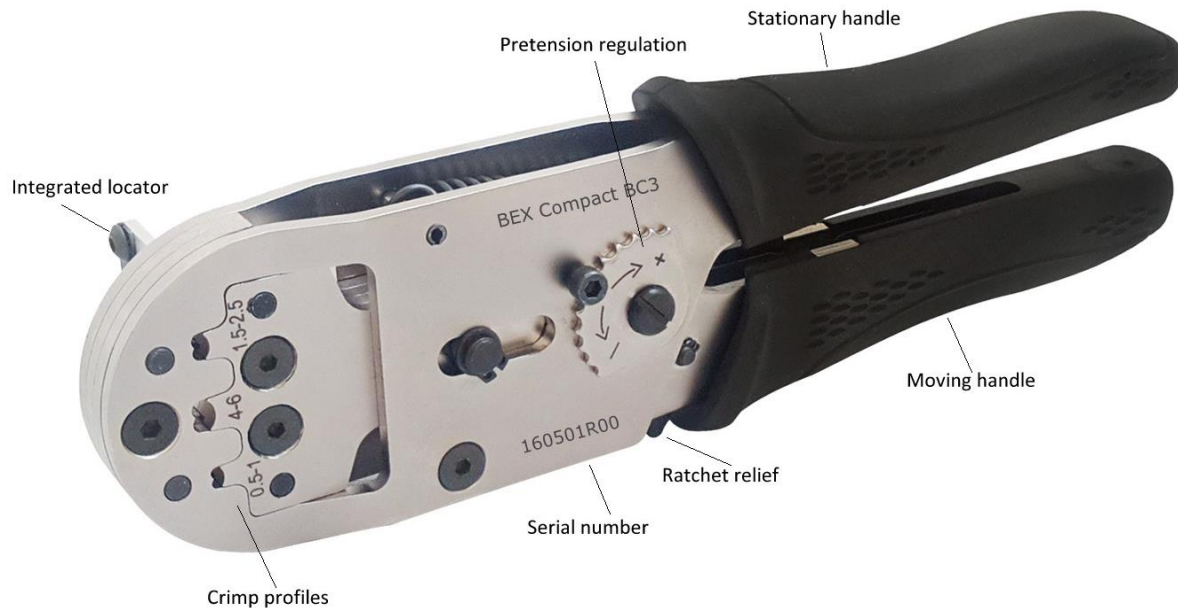


Fig. 1. Tool configuration

5. CRIMPING PROCEDURE

Prepare plug and cable according to the instructions packaged with the plug.
Crimp contact should be positioned in the corresponding crimping section of the lower die set (Fig 2, 3, 4). Ensure that appropriate contact is inserted into right crimping section. Slowly close tool handles completely to perform full cycle crimping.
Ⓜ In case the tool becomes block for any reason, please follow unblocking procedure (Fig. 17.)



Fig. 2



Fig. 3

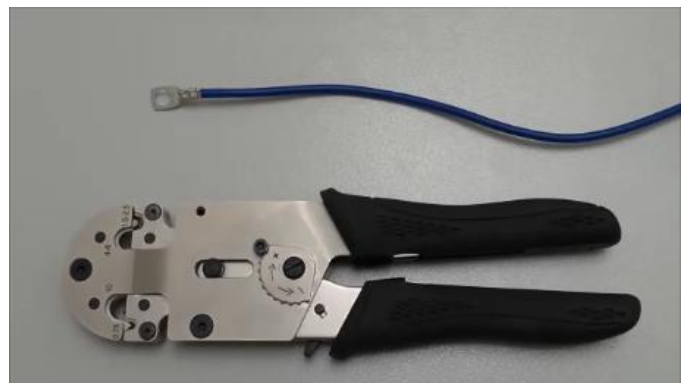


Fig. 4

□ After the full crimping cycle is done, let the tool open fully by itself in order to remove crimped plug. Pull out the plug assembly. The tool is ready for next crimping

6. UNBLOCKING THE TOOL

- **IMPORTANT: Apply working force on the tool handles while unblocking. It will prevent hurting yourself and possible damages on the tool.**
- In case of improper crimp, push the ratchet relief (Fig. 5) in direction shown to unblock the tool and remove obstruction before continuing with the work.



Fig. 5

7. TOOL REGULATION PROCEDURE

- After prolonged work period, tool crimping performance can change slightly due to final self-adjustment of the tools' components. This handtool is equipped with eccentric axle which allows periodical adjustment of crimping force and tool recalibration to maintain correct crimp performance.

1. Loosen and remove allen head screw (A) using a 2.5 mm allen wrench. (Fig.6)
2. Using a screw driver turn eccentric axle (B) and toothed adjustment wheel (C) into new position.
direction + for enlarging crimping force and reducing gap between crimping dies
direction - for reducing crimping force and enlarging gap between crimping dies
3. Reinstall allen head screw (A) and tighten it.

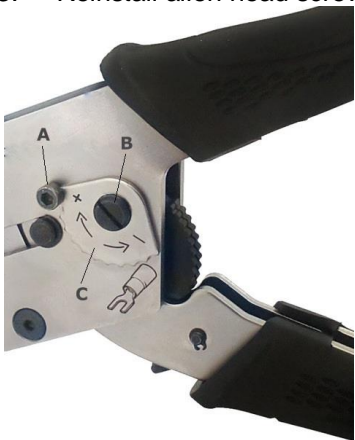


Fig. 6

8. SHAPE CONFIRMATION

Confirmation of the shape of contact after crimping

Acceptable crimp implies:

- A. The crimp height is in the specified range.
- B. The contact section of the contact is not deformed.
- C. There is no noticeable burr.
- D. The finished crimped section is free from any material crack or rough surface.

9. PULL OUT TEST

END SLEEVES		PULL OUT TEST ACCORDING TO DIN 46228			TEST BEX COMPACT BC4
AWG	MM2	KILOGRAMS	POUNDS	NEWTON	NEWTON
24	0,25	1	2,2	10	
20	0,5	2	4,4	20	60
18	1	3,5	7,8	35	108
16	1,5	4	8,9	40	150
14	2,5	5	11	50	240
12	4	6	13	60	310
10	6	8	17	80	360
8	10	9	20	90	380
6	16	10	22	100	960

INSULATED		PULL OUT NORM ACCORDING TO UL-486A			TEST BEX COMPACT BC2
AWG	MM2	KILOGRAMS	POUNDS	NEWTON	NEWTON
20	0,5				
16	1,5	13,6	30	150	280
14	2,5	22	50	240	350
	4				
10	6	36	80	360	450

NON INSULATED		PULL OUT NORM ACCORDING TO UL-486A			TEST BEX COMPACT BC1
AWG	MM2	KILOGRAMS	POUNDS	NEWTON	
	0,75				
16	1,5	13,6	30	150	230
14	2,5	22	50	240	310
12	4	31	70	310	330
10	6	36	80	360	400
8	10	40	90	380	490

TAB CONNECTORS		PULL OUT NORM ACCORDING TO UL-310			TEST BEX COMPACT BC3
AWG	MM2	KILOGRAM	POUNDS	NEWTON	
20	0,5	8		36	

18	1	9,0	20	89	140
16	1,5	13,6	30	133	200
14	2,5	22	50	223	290
12	4	31	70	311	330
10	6	36	80	356	450

10. MAINTENANCE AND INSPECTION

- ❑ Crimping hand tool Compact is intended to be used for crimping terminals. Using this hand tool for any other purpose, or for crimping of any other objects, can result in damaging the tool and the objects being crimped and prevention of its normal further functioning, for what manufacturer cannot be held responsible.
- ❑ Hand tool is equipped with full cycle ratchet mechanism which with optimized leverage system within the tools makes working with these tools easy and simple. In case of improper crimp, ratchet release mechanism allows you to easily open the hand tool and remove obstruction before work is continued. Check unblocking procedure.
- ❑ Tool itself also incorporates possibility of periodical adjustment of the crimping force and tool recalibration via eccentric axle to maintain correct crimp performance. Check recalibrating procedure
- ❑ For removal of dust, moisture and other contaminants usage of clean brush or soft, lint-free cloth is recommended. Do not use aggressive agents (thinner, alcohol,...) or hard objects that could damage the tool.
- ❑ Make sure that during the work bearing surfaces, shafts and pivot points are protected with thin coat of quality machine or motor oil. Do not oil excessively.
- ❑ When the tool is not in use, store it in a closed position – with handles closed. That will keep other objects from becoming stuck between crimping dies and damaging them. Keep the tool in a dry and clean area.
- ❑ Use only original spare parts.

11. WARRANTY

This tool is made of the best quality materials. All vital components are long life tested. All tools are warranted to be free of manufacturing defects for a period of 30 days. Should such a defect occur, we would exchange the tool free of charge. This will not be applicable to altered, misused, or damaged tools. This tool is designed for hand use only. Any clamping, fastening, or use of handle extensions voids this warranty.