

## Crimping tools

### Tools and accessories for crimp contacts

for contacts of inserts series:		page:
CD	(10A)	66 - 74
CDD	(10A)	76 - 83
CDC	(16A)	104 - 106
CCE	(16A)	130 - 135
CMCE	(16A)	137 - 145
CQE	(16A)	168 - 173
CQEE	(16A)	176 - 177
CQ	(10A/16A)	186 - 193
CX 8/24	(16A/10A)	194
CX 6/ <u>36</u> *	(10A)	198
CX 12/ <u>2</u> *	(10A)	199
CX 6/ <u>6</u> *	(16A)	206
MIXO	(10A/16A)	271 - 306

\* the underlined polarities indicate those contacts that require the tools shown in this page

#### pneumatic crimping tool positioner - gauge



#### insertion tool - removal tools replacement tip



description	part No.	part No.
pneumatic crimping tool for <b>10A</b> and <b>16A</b> contacts model DANIELS WA27F (turret excluded)	<b>CCPZP</b>	
positioner (see note) for <b>10A</b> contacts (CDF and CDM series) for <b>16A</b> contacts (CCF and CCM series)	<b>CCTP 10</b> <b>CCTP 16</b>	
bench support for CCPZP pneumatic crimping tool (DANIELS BM-2A)	<b>CCSPZP</b>	
pneumatic foot valve (DANIELS WA10A)	<b>CCVPP</b>	
"go / no go" control gauge to verify indenter closure (see note)	<b>CCPNP</b>	
insertion tool for insertion of the contacts into the inserts for crimped contacts up to 0,75 mm <sup>2</sup>		<b>CCINA</b>
removal tools for the extraction of contacts from the inserts for <b>10A</b> (CD) contacts <sup>1)</sup> for <b>16A</b> (CC) contacts <sup>2)</sup>		<b>CCES</b> <b>CQES</b>
replacement tip for CCES removal tool		<b>CCPR RN</b>

- 1) for CQ, CD, CDD, CX inserts (10A auxiliary contacts) and MIXO module (10A)  
 2) for CQ, CQE, CQEE, CCE, CMCE inserts (excluded 16+2), MIXO module (16A), CX6/6 (16A) and CDC. For CMCE (16+2), CX inserts (contacts 16A insert CX 8/24) using a flat 3 mm screwdriver.

#### Notes:

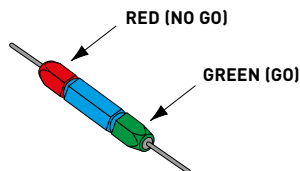
##### Positioner

conforms to international standard MIL-C-22520/1  
 - An interchangeable and indispensable accessory of the CCPZP crimping tool, it precisely positions the contact where crimping is performed. Each series of contacts requires its own turret.

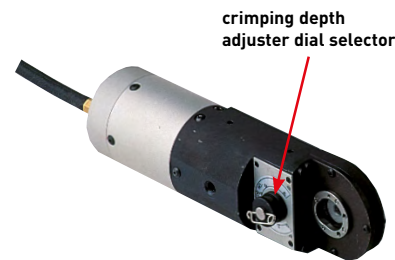
##### "go / no go" control gauge

conforms with international standard MIL-C-22520/3  
 - A tool used to periodically check that the crimping tool meets standard requirements.

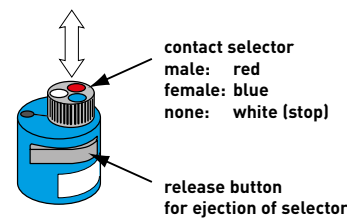
#### CCPNP



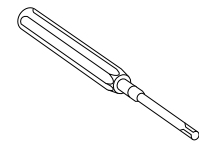
#### CCPZP



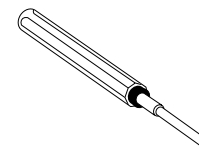
#### CCTP



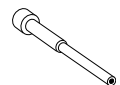
#### CCINA



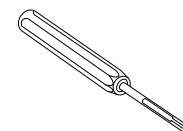
#### CCES



#### CCPR RN



#### CQES



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# Use and maintenance instructions

## 1. General specifications

This is the pneumatic version of the **DANIELS AF8 crimping tool** (CCPZ MIL). Crimping is performed with 8 pressure points.

The tool is equipped with a geared mechanism to control the complete crimping cycle.

**The tool must be equipped with an interchangeable turret (CCTP) according to the series of contacts to be crimped.**

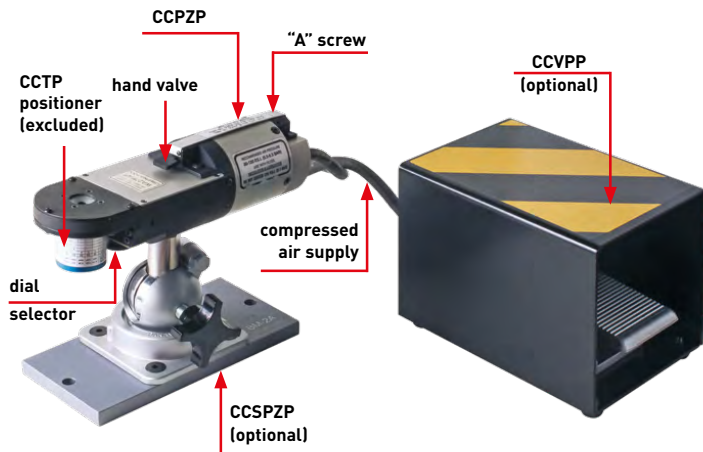
It is possible to use a hand valve (located on the crimping tool) or a foot valve (optional). The tool operating pressure is 5,5 - 8,3 bar. It is recommended to utilise an adjustment and air filtering unit.

### 1.1 Crimping range

Conductor cross-sectional area range: from 0,14 mm<sup>2</sup> (26 AWG) to 4 mm<sup>2</sup> (12 AWG).

### 1.2 Operation with pneumatic foot valve (optional)

Connect the foot valve between the compressed air source and the tool air inlet. Lower the hand valve on the tool and stop it in the lowered position with the stop screw (A) using a 1,5 mm Allen wrench.



## 2. Checking the crimping complete cycle control mechanism

Correct operation can be checked based on the following procedure:

- 1 Install a CCTP turret (see 3).
- 2 Reduce the pressure to 1 bar.
- 3 Using a contact that corresponds to the installed turret, with size 0,5, and a wire with section 0,5 mm<sup>2</sup>, use the crimping tool, referring to the crimping instructions.

The indenters will not reach the fully closed position and the contact will be internally blocked if the geared mechanism is operating correctly.

- 4 To release the partially crimped contact, increase the air pressure of the line to 5,5 - 8,3 bar and again use the crimping tool. It will then complete the crimping, allowing the indenters to return to the fully open position.

## 3. CCTP positioner installation (Fig. A)

- 1 Position the previously selected CCTP positioner on the support ring located on the crimping tool (matching the special pin on the base of the turret with the corresponding hole on the support ring), aligning the tapped holes with the socket head screws.
- 2 With the CCTP positioner positioned against the support ring, tighten the socket head screws with the 3,5 mm Allen wrench (supplied with the kit).
- 3 Refer to the data plate on the CCTP positioner. From the colour code column, select the colour of the positioner that corresponds to the appropriate code and dimension of the contact to be crimped.
- 4 With the CCTP positioner in the adjustment position, turn the turret selector until the colour-coded positioner is aligned with the indicator line. Press the turret until it clicks into the connected position.
- 5 Refer to the data plate on the CCTP positioner. From the column indicating the proper conductor section, determine the number that corresponds to the contact being used.
- 6 Remove the retaining hook from the crimping tool dial selector. Lift the dial selector and turn it until the selector number is aligned with the indicator (SEL.NO.). Replace the retaining hook (if necessary).

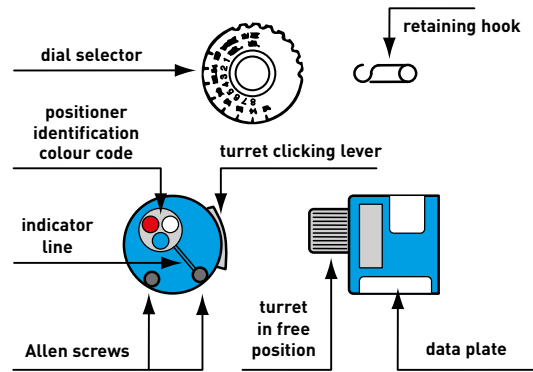


Fig. A

## 4. Crimping instructions

- 1 Insert the contact and the prepared conductor through the opening of the indenter in the turret positioner.
- 2 Activate the hand valve or the foot valve. Once crimping has been completed, the tool will return to the open position.
- 3 Check the position of the crimping on the contact crimping foot. Ideally, the crimping should be between the inspection hole and the top edge of the crimping foot.

The head of the contact should not be squared and the inspection hole should be intact.

## 5. Releasing a partially crimped contact

To release a partially crimped contact, do the following:

- 1 Increase the air pressure to 8,3 bar and use the crimping tool. If the increase in air pressure does not release the contact, do the following.
- 2 Turn the dial selector clockwise to the highest lockable setting (the dial selector must be in the blocked position before continuing). Use the crimping tool.
- 3 If it does not release after several attempts, contact the ILME offices.

## 6. Removing the CCTP positioner

With the crimping tool in the open position, to disassemble the turret, loosen the socket head screws using the 3,5 mm Allen wrench (supplied with the kit). After the threads are released from the support ring, pull off the turret with a straight movement.

## 7. Instructions to check calibration

The operations to check the crimping tool must be carried out with the dial selector in position 4 and the CCPNP gauge.

**ATTENTION! Do not crimp the gauge.**

### 7.1 Calibration check

Put the crimping tool in the completely closed position.

“GO” - Insert the end (green) of the gauge as shown (Fig. 1).

The gauge must pass freely between the indenter tips.

“NO GO” - Insert the end (red) of the gauge as shown (Fig. 2).

The gauge should not pass through the opening.

Gauge	tool selector pos. No.	Ø A ± 0,00254 mm (GO) green	Ø B ± 0,00254 mm (NO GO) red
CCPNP	4	0,991 (mm) 0,0390 (in)	1,118 (mm) 0,0440 (in)

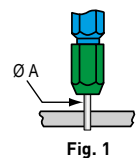


Fig. 1

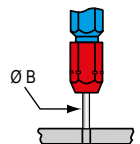


Fig. 2

## 8. Crimping tool maintenance

No maintenance is required.

However, it is good practice to keep the indenter tips free from residual deposits of the coloured band (some types of crimp contacts as per MIL standards are identified by coloured bands in the crimping area) and any other debris. A metal brush may be used for this purpose.

The following is strongly recommended:

- 1 DO NOT immerse the tools in a solution to clean them.
- 2 DO NOT brush oil in the tools to lubricate them.
- 3 DO NOT try to disassemble the tool or repair it.

This is a high-precision manual crimping tool and must be used as such.