

## 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
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CQEE (16A)	176 - 177
CMCE (16A)	137 - 145
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CX 8/24 (16A/10A)	194
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CX 12/2 (40A/10A)	199
CX 6/6 * (16A)	206
MIXO (40A/16A/10A)	267 - 306

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

#### manual crimping tool gauge



#### insertion tool - removal tools replacement tip



CCPR RN

description	part No.	part No.
crimping tool for <b>10A, 16A and 40A</b> contacts RENNSTEIG model (turret included)	<b>CCPZ RN</b>	
"go / no go" control gauge to verify indenter closure (see note)	<b>CCPNP RN</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> for <b>40A</b> (CX) contacts <sup>3)</sup> and cables Ø < 5 mm for <b>40A</b> (CX) contacts <sup>4)</sup> and cables Ø < 7,5 mm		<b>CCES</b> <b>CQES</b> <b>CXES</b> <b>CXES-10</b>
replacement tip for CCES removal tool		<b>CCPR RN</b>

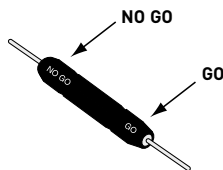
- 1) for CQ, CD, CDD, CX inserts (10A auxiliary contacts) and MIXO module (10A)
- 2) for CQ, CQE, CQEE, CCE, CMCE inserts (excluded 16+2), MIXO module (16A), CX6/6 (16A) and CDC. For CMCE (16+2), CX inserts (contacts 16A insert CX 8/24) using a flat 3 mm screwdriver.
- 3) for CX inserts (40A contacts) and MIXO module (40A)
- 4) for MIXO module CX 03 4B and contacts 10 mm<sup>2</sup>.

#### Notes:

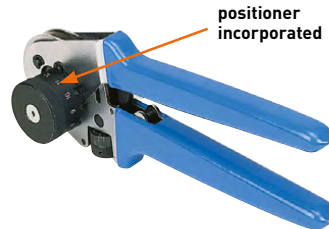
##### "go / no go" control gauge

- A tool used to periodically check that the crimping tool meets standard requirements.

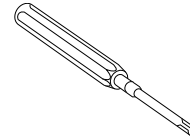
#### CCPNP RN



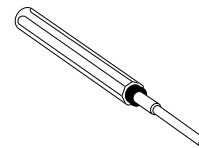
#### CCPZ RN



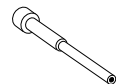
#### CCINA



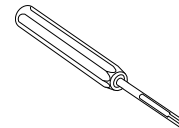
#### CCES



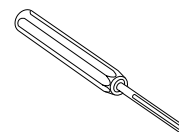
#### CCPR RN



#### CQES



#### CXES - CXES-10



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# Use and maintenance instructions

## 1. General specifications

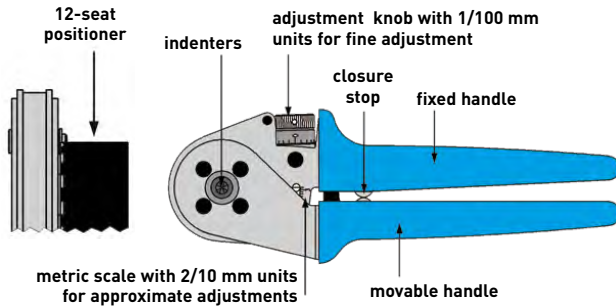
The **CCPZ RN crimping tool** crimps with 8 pressure points, obtaining similar results to the prescriptions of standard MIL-C-22520/1.

The tool has a geared mechanism for controlling the complete crimping cycle, and houses a positioning turret with 12 positions, six of which can be used for positioning the ILME male and female crimping contacts of series CD (10A max), CC (16A max) and CX (40A max).

### 1.1 Crimping range

Conductor cross-sectional area range: from 0,14 mm<sup>2</sup> (26 AWG) to 10 mm<sup>2</sup> (8 AWG).

**Caution!** The handle of the tool must be in the open position when the turret is installed, disassembled or opened. If not, the turret and the crimping tool may be damaged.



## 2. Description of tool

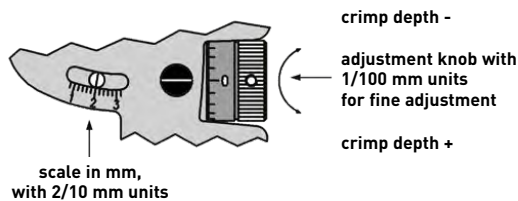
Crimping tool components: a first mobile handle, with a precision stop mechanism with teeth and an opening limiting guide; a second fixed handle with metric scale (units of 2/10 mm); an adjustment system with fine step adjustments of 1/100 mm; four indenters; a 12-seat positioner, fully rotating through 360° for accurate positioning of contacts. A reference table engraved on the tool surface provides the positioner (POS) number and crimping depth (SET) to select according to the type and size of the ILME contact (the crimping tool can be set to any crimping depth which may be required by the contact manufacturer).

## 3. Adjustment of crimp depth

Crimp depth to be adjusted as follows:  
the adjustment knob should be turned clockwise to reduce crimping depth, and anti-clockwise to increase it.

### 3.1 Adjustment tolerances:

- 1 scale mark on the knob = adjustment of 1/100 mm (0,01 mm);
- 1 complete rotation of knob = adjustment of 2/10 mm (0,2 mm, this indication can be read on the knob and on the approximate scale);
- 5 knob rotations = adjustment of 1,0 mm (this indication can be read on the scale).



## 4. Crimping instructions

The reference matrix on the crimping tool indicates the correct seat of the positioner (POS M1, F2, M3, F4, M5, F6) to select, and the crimping depth (SET) to adjust for the contact to be crimped.

The contact is inserted through the crimper entry hole on the opposite side of the positioner.

The contact is closed by closing the handles in the first stop position, in order to prevent the contact coming out off the crimper and to facilitate fitting the conductor in the contact.

The precision stop mechanism with teeth ensures consistently precise crimps, by forcing the crimper to close completely and finish the crimping cycle before the crimper can be re-opened.

## Tool adjustment

### Positioner seat = M1 (male) - F2 (female)

CDMA/D (male) CDFA/D (female)	Section (mm <sup>2</sup> )	Crimp depth (mm)
0,3	0,14	1,3
	0,25	
	0,37	
0,5	0,5	1,55
0,7	0,75	1,55
1,0	1,0	1,55
1,5	1,5	1,55
2,5	2,5	1,55

### Positioner seat = M3 (male) - F4 (female)

CCMA/D (male) CCFA/D (female)	Section (mm <sup>2</sup> )	Crimp depth (mm)
0,3	0,14	1,2
0,3	0,25-0,37	1,3
0,5	0,5	1,55
0,7	0,75	1,55
1,0	1,0	1,55
1,5	1,5	1,8
2,5	2,5	1,8
3,0	3,0	1,9
4,0	4,0	2,0

### Positioner seat = M5 (male) - F6 (female)

CXMA/D (male) CXFA/D (female)	Section (mm <sup>2</sup> )	Crimp depth (mm)
1,5	1,5	1,55
2,5	2,5	1,8
4,0	4,0	2,0
6,0	6,0	2,5
10,0	10,0	2,3

## 5. Calibration check

The crimping tool is adjusted in the manufacturer's plant.

To ensure correct calibration, we advise you to check the tool with a gauge every working day.

This is easily done with the CCPNP RN cylindrical gauge in the 2,0 mm Ø position.

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

Crimping depth of 2 mm can be adjusted with the adjustment knob (scale marked on "2", screw indicator on "0" as shown in the above figure).

Put the crimping tool in the completely position.

"GO" - Insert the end of the gauge as shown (Fig. 1).

The gauge must pass freely between the indenter tips.

"NO GO" - Insert the end of the gauge as shown (Fig. 2).

The gauge should not pass through the opening.

Gauge	tool selector pos. No.	Ø A GO	Ø B NO GO
CCPNP RN	2,00 (mm)	1,94 (mm)	2,06 (mm)

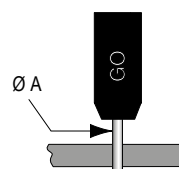


Fig. 1

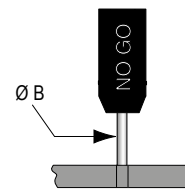


Fig. 2

## 6. Maintenance and repair

Keep the crimping tool clean and store it correctly when not in use.

The joints need to be lubricated periodically, and the pin stop circular clips must always stay in position.

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