

Crimping tools

Tools and accessories for crimp contacts

for contacts of inserts series:		page:
CX 6/12 *	(40A)	197
CX 6/36 *	(40A)	198
CX 12/2 *	(40A)	199
MIXO	(40A)	267 - 272

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

manual crimping tool positioner - gauge



removal tool



description

part No.

part No.

crimping tool for **40A**
DANIELS M309 model (turret excluded)

CXPZ D

positioner (see note)
for contacts **40A (CX and RX HNM series)**

CXTP 40

"go / no go" control gauge
to verify indenter closure (see note)

CXPNP

removal tool
for the extraction of contacts from the inserts
for **40A (CX)** contacts

CXES

Notes:

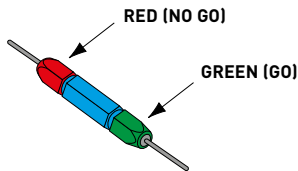
Positioner

- An interchangeable and indispensable accessory of the CXPZ D crimping tool, it precisely positions the contact where crimping is performed.

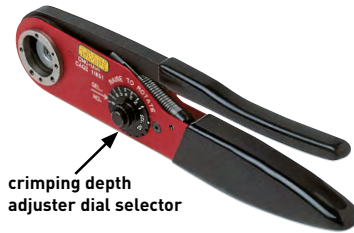
"go / no go" control gauge

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

CXPNP



CXPZ D



CXTP 40



CXTP 40

CONTACT	CXMA/CXFA	1.5	2.5	4.0	6.0	10
WIRE SIZE	mm ²	1,5	2,5	4	6	10
	AWG	16	14	12	10	8
SEL. NO.		5	5	5	7	8
USE WITH		M309				
		WA-27-309-EP				

Use and maintenance instructions

1. General specifications

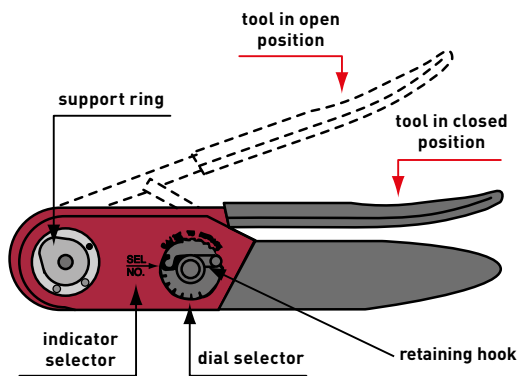
The **CXPZ D crimping tool** performed with 8 pressure points.
The tool is equipped with a geared mechanism to control the complete crimping cycle.
The tool must be equipped with an interchangeable turret (CXTP) according to the series of contacts to be crimped.

1.1 Crimping range

Conductor cross-sectional area range: from 1,5 mm² (16 AWG) to 6 mm² (10 AWG).

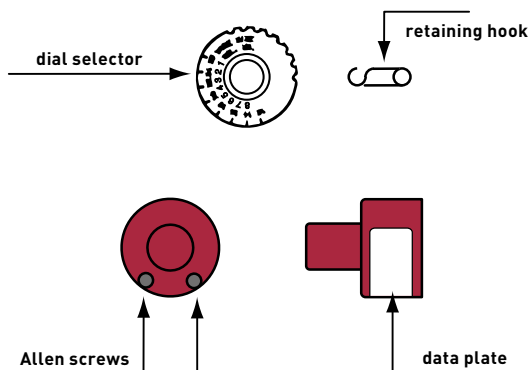
Caution!

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. CXTP positioner installation

- The crimping tool must be in the open position.
- Position the CXTP 40 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.
- With the CXTP 40 positioner positioned against the support ring, tighten the socket head screws with the 3,5 mm Allen wrench (supplied with the kit).
- Refer to the data plate on the CXTP 40 positioner.
From the column indicating the proper conductor cross-sectional area, determine the number that corresponds to the contact being used.
- 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).



3. Crimping instructions

- Insert the contact and the prepared * conductor through the opening of the indenter in the turret positioner.
- Tighten the crimping tool handle until the stop gear is released.
The tool will return to the open position.
- 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.

* i.e. stripped at the correct length and with strands lightly twisted to recover regular lay of strands

4. Removing the CXTP 40 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 positioner with a straight movement.

5. Instructions to check calibration

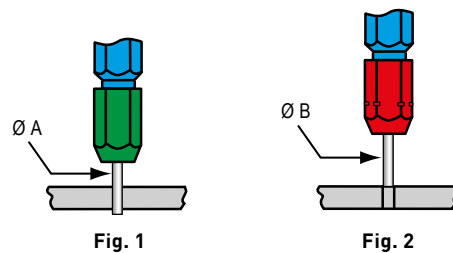
The operations to check the crimping tool must be carried out with the dial selector in position 4 and with the CXPNP gauge (formerly Daniels G425, now Daniels G436 or G1004 which are equivalent for the purpose).

ATTENTION! Do not crimp the gauge.

5.1 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
CXPNP	4	1,549 (mm) 0,0609 (in)	1,676 (mm) 0,0659 (in)



6. 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:

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

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