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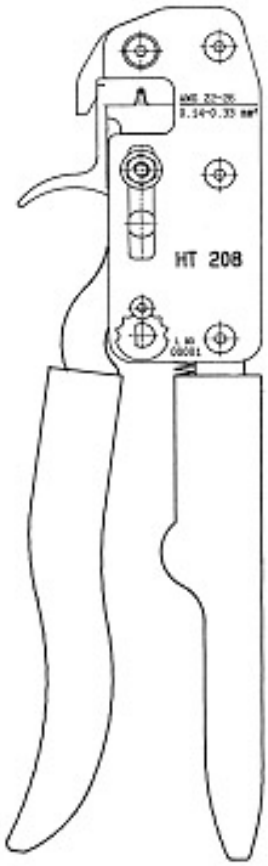
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HT208

Hand Crimp Tool for Mini-PV

AWG 22-26

User's Guide



Föhrenbach®
Application Tooling

www.foehrenbach.be

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1. DESCRIPTION

The handtool HT 208 is designed to crimp Mini-PV terminals in the wire range AWG 22-26.

2. OPERATING INSTRUCTIONS

1. Place the handtool in your left hand, so that the movable handle (item 17) and connector fixture (item28) can be actuated by your thumb.
2. Actuate connector fixture and place terminal in its correct position, touching the wire stop, and with the U-shape facing the crimper.
3. Use wire which is stripped over a length of 4 ± 0.25 mm.
4. Place the wire into the barrel of the terminal, so that the end of the wire touches the wire stop.
5. Close the handtool by moving the handle (item 10), while the wire is held in position.
6. When the handtool is completely closed, the movable handle (item 17), may be returned to its starting position.
7. Finally take the crimped terminal from the handtool.

Note: The handtool has stops, which prevents opening the tool before the crimp action is completed.
Should it be necessary, the stop can be released by turning the stop ring (item 7) at the back side of the tool in the direction indicated by the two yellow arrows.
Keep the movable handle under light pressure during this operation.

3. SPECIFICATIONS

3.1 Product information:

- Mini-PV
- Wire range AWG 22-26, 0.14 - 0.33 mm^2
- Crimp height 0.81 - 0.86 mm
  .0319 - .0339 inches

Adjusted crimp height by manufacturer: ……. mm

4. ADJUSTMENTS

4.1 Adjustment of bell-mouth

1. Take an open-ended spanner or a ring spanner number 8 (8 mm).
2. Place the spanner around the nut (item 26), on the site opposite the connector fixture (item 28).
3. To increase the bell-mouth at the box side of the terminal, the nut (item 26) should be turned to the left.

   NOTE: After adjusting, give with a hammer a slight touch on the stud (item 22), to ensure that nut and washer (item 25) are positioned against the cover plate (item 1).

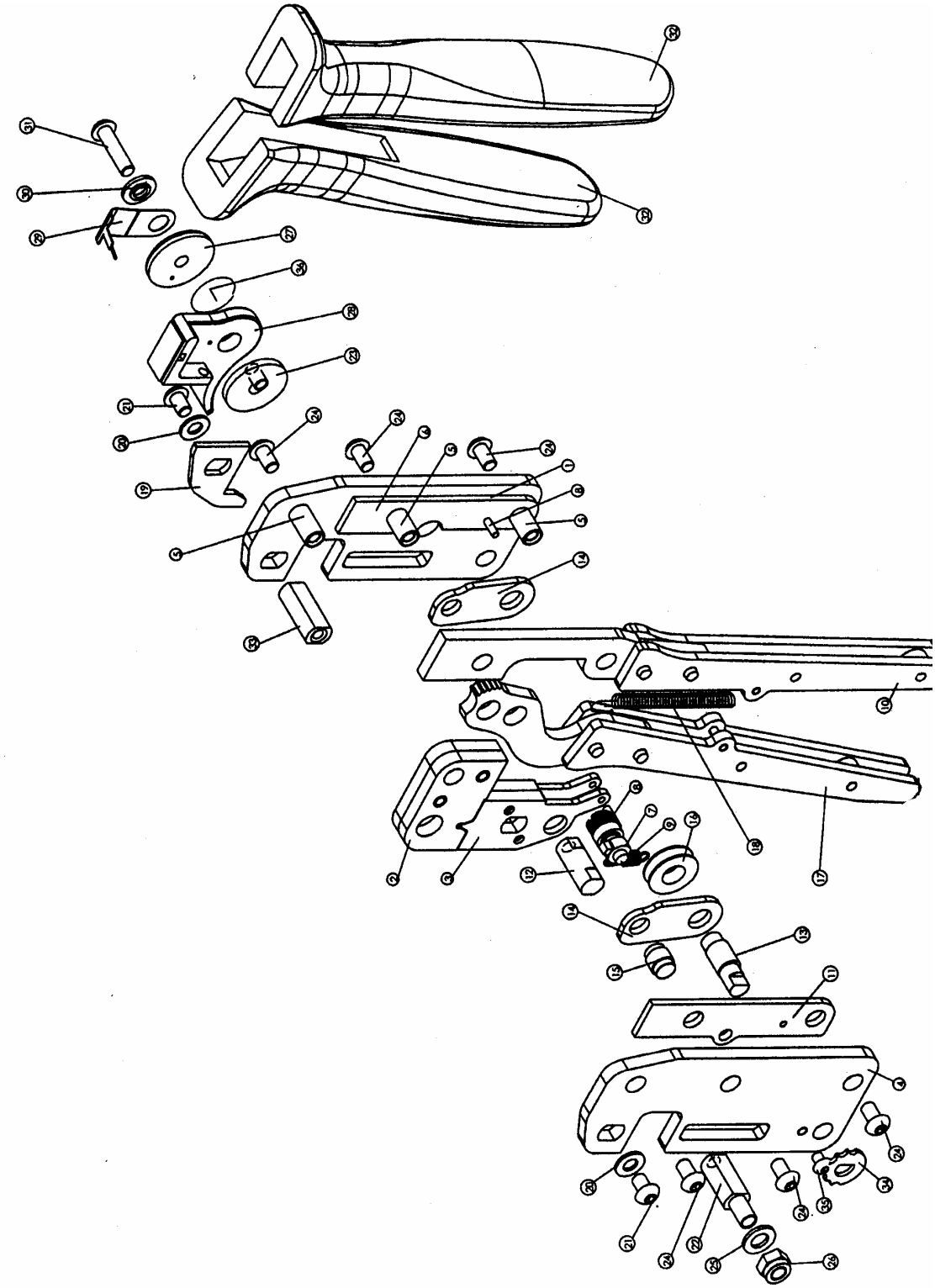
4. To decrease the Bell-mouth at the box side of the terminal, the nut (item 26) should be turned to the right.

4.2 Adjustments of crimp height:

Eventually the crimp height must be readjusted, due to wear of the tool hinges. (For specified crimp heights see below.)
Readjusting is done by loosening screw (item 35) and turning the stop ring (item 13) one step, to change the crimp height approximately 0,05 mm

5. MAINTENANCE

- Regular checks must be made for possible gold or tin build-up on the crimper and the anvil.
- If necessary, these parts may be carefully cleaned.
- Damaged parts must be replaced immediately. For part numbers, see EPL list.
  Because of the coating used on the movable parts of this handtool, oiling of parts is not necessary.



6. PARTS

Epl list

item no	part No	description	qty per ass'y
1		Cover plate, lower	1
6		Lower spacer plate	1
7		Pawl	1
10		Handle, permanent	1
5		Connecting pin	3
8		Pin dia 2x7,8	2
9		Extension spring No 19	1
11		Upper spacer plate	1
13		Eccentric pin	1
14		Connecting plate	2
15		Hinge pin	1
12		Guide pin	1
17		Handle, mobile	1
16		Stop roll	1
18		Extension spring No 35	1
4		Cover plate, upper	1
34		Stop ring	1
35		But. hd. cap screw M3 x 4	1
24		But. hd. cap screw M4 x 7	6
2 + 3	177531	Crimper & Anvil set	1
33		Thread bush, crimper	1
20		Washer B 4,3 Din 125-ST	2
19		Connector fixture block	1
22	173576	Stud	1
23	173577	Bush	1
28	190055	Connector fixture	1
36	173579	Torsion spring No.30	1
21	5305-003-051	But. hd. cap screw M4 x 6	2
27	173580	Disc	1
29	173581	Wire stop	1
30	190585	Spacer	1
31	5305-003-009	But. hd. cap screw M4 x 16	1
25		Washer B 5,3 Din 125-ST	1
26		Hex nut M5 Din 934	1

Parts available at distributors like Mouser, Newark, TTI, Avnet, Arrow & Digikey listed as from FCI.

7. CONTACT

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