

Figure 1

1. INTRODUCTION

"C"-Head Assembly 2031450-1 is designed to accept any TE shoulder-type SDE (Standard Die Envelope) die set. See Figure 1.

The Electro-Hydraulic Hand Tool and crimping dies must be ordered separately.

For specific die set information (including installation, wire preparation, crimping procedures, maintenance and inspection procedures, as well as repair and replacement procedures) refer to the instruction sheet supplied with the dies. For information concerning the Electro-Hydraulic Hand Tool, refer to Customer Manual 409-10095.

NOTE



All dimensions on this instruction sheet are in metric units [with inches in brackets]. Figures and illustrations are for identification only, and are not drawn to scale.

Reasons for revision may be found in Section 8, REVISION SUMMARY.

2. RECEIVING/INSPECTION

The Electro-Hydraulic Hand Tool Kit 2031400-[] and "C"-Head Assembly 2031450-1 are thoroughly inspected during and after assembly. Prior to packaging and shipping, a final series of tests and inspections are made to ensure proper function of the tooling. The following inspection should be performed as a safeguard against potential problems generated in transit.

1. In a well-lighted area, carefully unpack the tool and inspect each component as it is removed from the packaging.
2. Thoroughly inspect each component for evidence of damage that may have occurred in transit. If any of the components are damaged, file a claim against the carrier and notify TE immediately.

NOTE


Be sure to keep this instruction sheet, the manual for the electro-hydraulic hand tool, and all drawings with the tool for the benefit of operation and maintenance personnel.

The Electro-Hydraulic tool and “C”-Head assembly should be inspected at regularly scheduled intervals, depending on care, degree of operator skill, the type and size of product being crimped, and environmental conditions.

3. INSTALLATION/REMOVAL

CAUTION


Do not operate the Electro-Hydraulic Hand Tool without the head and dies installed. Repeated operation in this manner may result in damage to the Electro-Hydraulic Hand Tool.

DANGER


To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release the hydraulic pressure, if applicable -- see 409-10095) before installing or removing the “C”-Head Assembly or dies.

3.1. Installation/Removal of the Crimping Head Assembly

Refer to the Electro-Hydraulic hand tool manual (409-10095) for instructions on installing and removing the “C”-Head.

3.2. Installation/Removal of the Shoulder-Type SDE Dies (Figure 2)

CAUTION


These instructions are meant to be used as an example only. For specific instructions, refer to the instructions packaged with the dies.

DANGER


To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release the hydraulic pressure if applicable -- see 409-10095) before installing or removing the dies.

CAUTION


Be sure to use ONLY TE shoulder-type crimping dies. Although equipped with the required holes for pin-type dies, the use of such dies will result in failure. Use Closed-Head Assembly 2031460-1 for pin-type dies.

A. Installation of Dies

1. Remove the two die retaining screws and bushing from the crimp head.
2. Place the upper die in the upper jaw of the tool head so that the largest indenter or terminal cavity is facing **toward** the throat of the “C” head (see Figure 2).

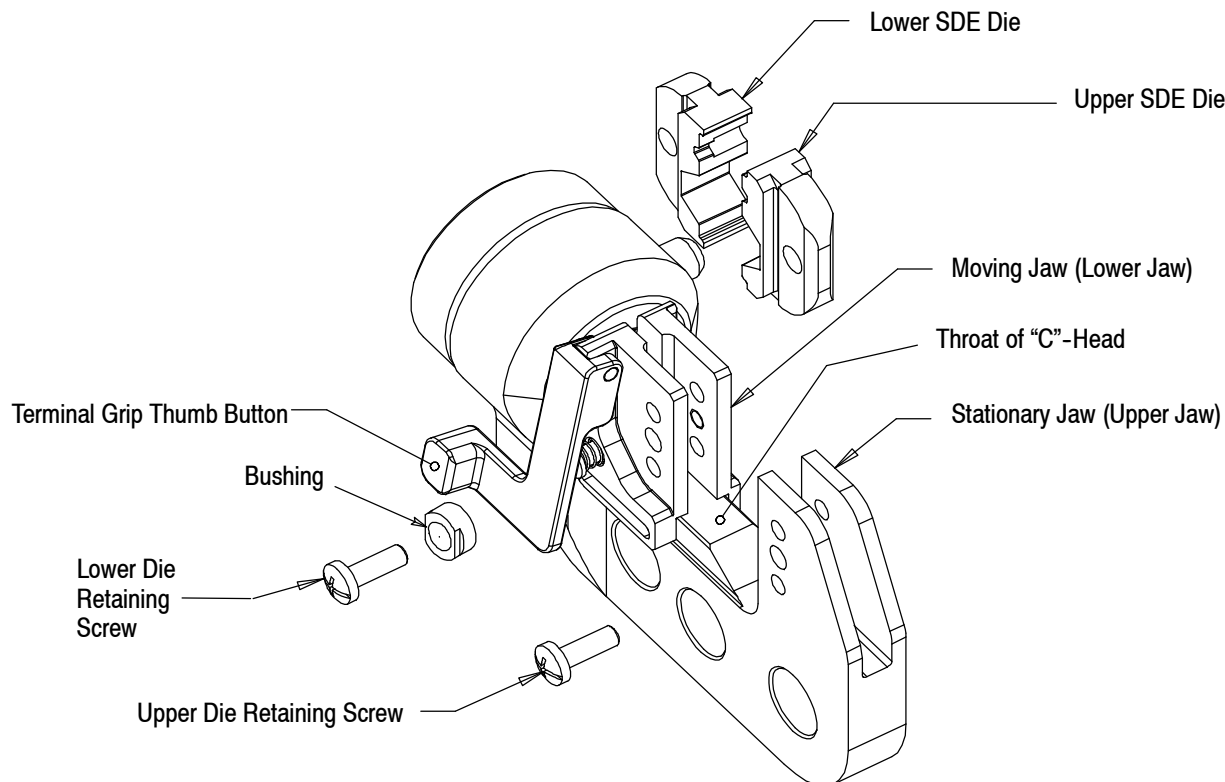


Figure 2

3. Insert the die retaining screw through the upper jaw and through the die. Tighten the screw *just enough* to hold the die in place. Do **NOT** tighten the screw completely at this time. See Figure 2.

4. Place the lower die in the moving jaw of the crimp head so that the largest anvil is also facing toward the throat of the “C” head.

5. Slide the bushing over the die retaining screw and insert the die retaining screw through the lower jaw and through the die. Tighten the screw *just enough* to hold the die in place. Do **NOT** tighten the screw completely at this time.

6. Release the lower jaw by pressing the terminal grip thumb-button to close the crimp jaws and fully seat the dies together. See Figure 2.

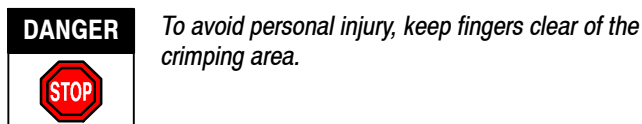
7. When the anvils and indenters are aligned, tighten the retaining screws.

B. Removal of Dies

1. Remove the die retaining screws and bushing.
2. Lift the dies out of the “C”-Head Assembly.

4. OPERATION

The following procedure provides only general information concerning crimping. Refer to the instructions packaged with the dies for detailed information, including wire stripping dimensions and instructions for positioning terminals and splices in the dies.



To produce a crimp with TE SDE shoulder-type dies in a “C”-Head Assembly using the Electro-Hydraulic Hand Tool:

1. Insert the contact into the appropriate die cavity.
2. Press the terminal grip thumb button (Figure 2) to advance the lower tooling and hold the contact in place. Do not deform the terminal insulation or wire barrel.
3. Place a pre-stripped wire in the barrel of the contact.
4. Squeeze the trigger until the jaws release – indicating the crimp is complete. Then release the trigger.

NOTE



It is not necessary to continue to hold the tool trigger in order to retract the tooling. The tooling will retract automatically.

5. Remove the terminated wire.

NOTE



To abort a crimp, press the pressure release device on the power tool. Information on the pressure release device is contained in 409-10095, Section 6, PRESSURE RELEASE/RESET TOOL.

5. PREVENTIVE MAINTENANCE

DANGER



To avoid personal injury, ALWAYS remove the power source (and release hydraulic pressure if applicable -- see 409-10095) from the tool BEFORE performing any maintenance to the tool.

5.1. Daily Maintenance

Perform the following maintenance on a daily basis:

- Inspect the dies for wear or damage such as cracks, gouges or chips. If damage is found, replace the die set.
- Clean the tooling, removing accumulations of dirt and grease – particularly in areas where contacts are crimped. Wipe clean with a lint-free cloth.

5.2. Yearly Maintenance

Once a year or every 10,000 cycles (whichever comes first) return the “C”-Head Assembly crimp head to TE for inspection.

6. RETURN/REPAIR

DANGER



To avoid personal injury, ALWAYS remove the power source (and release hydraulic pressure, if applicable -- see 409-10095) from the tool BEFORE performing any maintenance on repair to the tool.

Order replacement parts through your TE Representative, or call 1.800.526.5142; or send a facsimile of your purchase order to 1.717.986.7605; or write to:

CUSTOMER SERVICE (38-35)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

For repair services, call the Tooling Assistance Center at 1.800.722.1111.

For spare parts, refer to the table in Figure 3:

Spare Parts		
TE Part Number	Description	Qty
986964-1	Die Screw	2
2031486-1	Head Retainer	1
2063861-1	Friction Ring	1
986963-1	E-Ring	1
1213501-1	Bushing	1

Figure 3

7. RoHS INFORMATION

Information on the presence and location of any substances subject to RoHS (Restriction on Hazardous Substances) can be found at the following website:

<http://www.tycoelectronics.com/customersupport/rohs/supportcenter/>

Click on “Find Compliance Status” and enter equipment part number.

8. REVISION SUMMARY

- Updated document to corporate requirements
- Added bushing to artwork in Figure 2,
- Added bushing terminology to Paragraph 3.2.A.1; 3.2.A.5; 3.2.B.1; and Figure 3

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[TE Connectivity:](#)

[2031450-1](#)