



Figure 1

1. INTRODUCTION

The Tyco Electronics Double Action Hand Tool (DAHT) Adapter Assembly 2119483-1 is designed to couple any Tyco Electronics DAHT head assembly to the Electro-Hydraulic Hand Tool (2031400-[]). Refer to Figure 1 to see the hand tool, adapter, and DAHT tool head.

The Electro-Hydraulic Hand Tool and specific DAHT head assemblies must be ordered separately.

For specific DAHT crimp head information (including wire preparation, crimping procedures, maintenance

and inspection procedures, as well as repair and replacement procedures) refer to the appropriate instruction sheet for the associated hand tool and crimping head.

Refer to Customer Manual 409-10095 for information concerning Electro-Hydraulic Hand Tool 2031400-[].

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.

2. RECEIVING/INSPECTION

Adapter Assembly 2119483-1 is thoroughly inspected during and after assembly. Prior to packaging and shipping a final series of tests and inspections is made to ensure proper function of the adapter. The following inspections should be performed as a safeguard against potential problems generated in transit.

1. In a well-lighted area, carefully unpack the adapter and inspect each component as it is unpacked.
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 Tyco Electronics immediately.

NOTE



It is IMPORTANT that these instructions, and other documents shipped with the tooling (e.g., drawings, parts lists, tooling manual, etc.), remain with the adapter, head, and hand tool for the benefit of personnel responsible for installation, operation, and maintenance.

The adapter 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 OF ADAPTER ASSEMBLY AND DAHT II HEADS

CAUTION



Do not operate the Electro-Hydraulic Hand Tool without the DAHT head and adapter 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 hydraulic pressure, if applicable -- see 409-10095) before installing or removing the DAHT tool head or adapter assembly.

3.1. Adapter Installation/Removal

Refer to the Electro-Hydraulic hand tool manual (409-10095) for instructions on installing and removing the adapter assembly and the crimping heads.

Note that adapter 2119483-1 does not have a terminal grip thumb button. To remove the adapter, unscrew it completely and then pull the adapter away from the cylinder assembly.

3.2. DAHT Head Installation Removal

A. Installation

As supplied, the adapter assembly has two quick-release pins installed. Refer to Figure 1. The pins will be used to attach the DAHT Crimping Head to the DAHT Adapter Assembly.

These pins must be removed prior to installing the DAHT crimp head.

1. Remove the quick-release pins (see Figure 1).
2. Insert the DAHT tool head into the adapter cavity.
3. Insert the two quick-release pins through the holes in the adapter housing and the holes in the two jaws of the DAHT crimp head. See Figure 1.

NOTE



The quick-release pins will "snap" into position when they are properly inserted.

B. Removal

1. Remove the quick-release pins.
2. Remove the tool head from the adapter cavity.

4. OPERATION

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

DANGER



To avoid personal injury, keep fingers clear of the crimping area.

To operate the DAHT crimp head in the Electro-Hydraulic Hand Tool using the Adapter assembly, proceed as follows:

1. Insert the contact into the appropriate die cavity.
2. Pulse the trigger (Figure 1) 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 tool trigger until the jaws release. When the jaws release, the crimp is complete.

NOTE



It is not necessary to continue to hold the trigger 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, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release hydraulic pressure if applicable -- see 409-10095) before performing maintenance.

5.1. Daily Maintenance

Perform the following maintenance on a daily basis:

1. Inspect the dies for wear or damage such as cracks, gouges or chips. If damage is found, return the DAHT tool head to Tyco Electronics for inspection.
2. Clean the tooling, removing accumulations of dirt and grease on the adapter – particularly:
 - a. in areas where contacts are crimped, and
 - b. in the area where the DAHT head connects to the adapter assembly.
3. Wipe the tooling with a soft, lint-free cloth.

5.2. Yearly Maintenance

Once a year or every 10,000 cycles (whichever comes first) return the DAHT tool crimp head to Tyco Electronics for inspection.

6. REPLACEMENT AND REPAIR

DANGER

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

Replacement parts are identified in Figure 1 and the table in Figure 2. The recommended spares should be stocked for immediate replacement. Order replacement parts (or return parts) through your Tyco Electronics Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 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 2:

Spare Parts		
TE Part Number	Description	Qty.
18023-1	Head Retaining Screw	1
217873-3	Quick Pin	2
2063866-1	Pinch Caution Label	1

Figure 2

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

- Initial release of document

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[2119483-1](#)