

# PNEUMATIC CRIMP TOOL WA22P

**DMC** DANIELS  
MANUFACTURING  
CORPORATION  
**DATASHEET**

SEE PAGE 3 FOR IMPORTANT INFORMATION CONCERNING  
LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

## ACCESSORIES, GAGING PROCEDURES AND SPECIFICATIONS

### GENERAL SPECIFICATIONS:

- The WA22P is an 8-gage setting tool, changeable by a selector knob. The tool has a full cycle ratcheting control mechanism.
- The tool can be actuated by either the hand valve, or the WA10A foot valve. The working pressure of the tool is 80-120psi. It is recommended that each tool be set-up with the WA27RF, filter and regulator unit.
- All crimp tools, positioners, bench mounts, GAGes and foot valves can be ordered using their respective part numbers.

### SIZE:

Length: 8" Width: 2.25" Weight: 2.2lbs

### CRIMPING RANGE:

CONTACTS: Size 16 thru 22

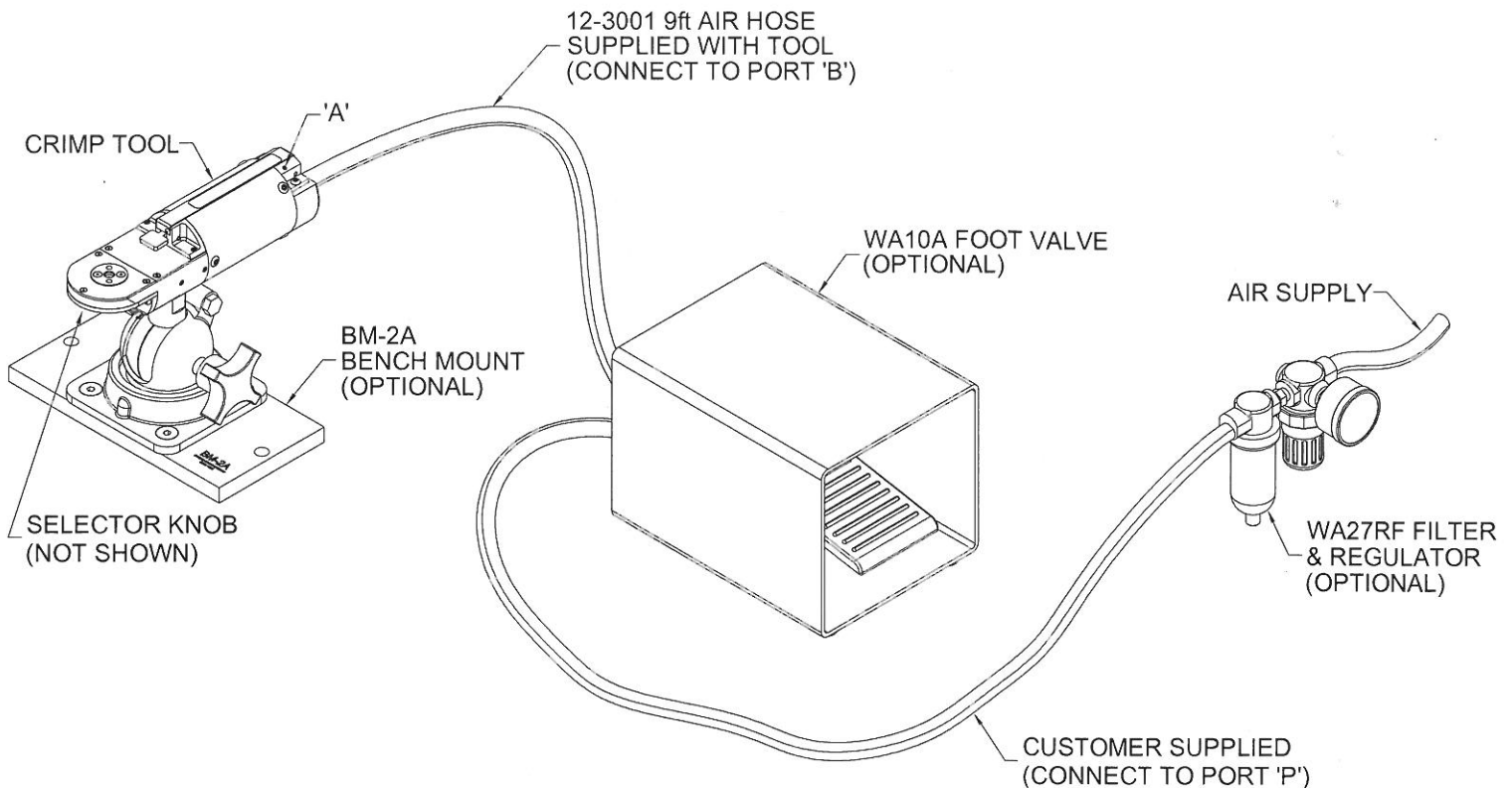
WIRE SIZE: Size 16AWG thru 28AWG

### TOOLING:

Will accommodate all MH860 positioners

### FOOT VALVE OPERATION:

Attach WA10A foot valve between air supply and air inlet. Depress hand valve, and lock in down position with set screw (A) using 1/16" hex Allen wrench. Do not overtighten setscrew as this could lead to valve damage .. !!



## GAGING INSTRUCTIONS

### "GO" GAGING

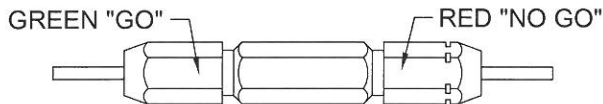
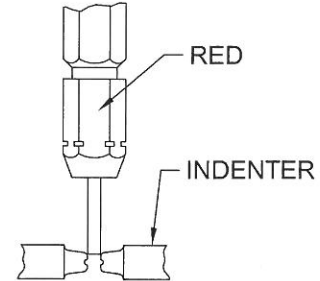
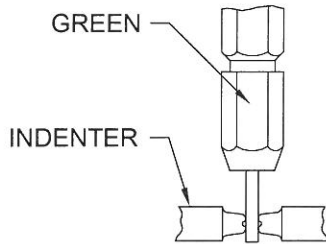
Operate the tool to the fully closed position. Insert the "GO" GAGE end as shown. The GAGE must pass freely between the indenter tips.

### "NO-GO" GAGING

Operate the tool to the fully closed position. Try to insert the "NO-GO" GAGE end as shown. The "NO-GO" GAGE may partially enter the indenter opening, but must not pass completely through.

### GAGING LIMITS

SEL NO	INSPECTION GAGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0160	.0210
2	.0190	.0240
3	.0220	.0270
4	.0250	.0300
5	.0290	.0340
6	.0330	.0380
7	.0370	.0420
8	.0410	.0460



GAGE: USE G145 ON SEL #8

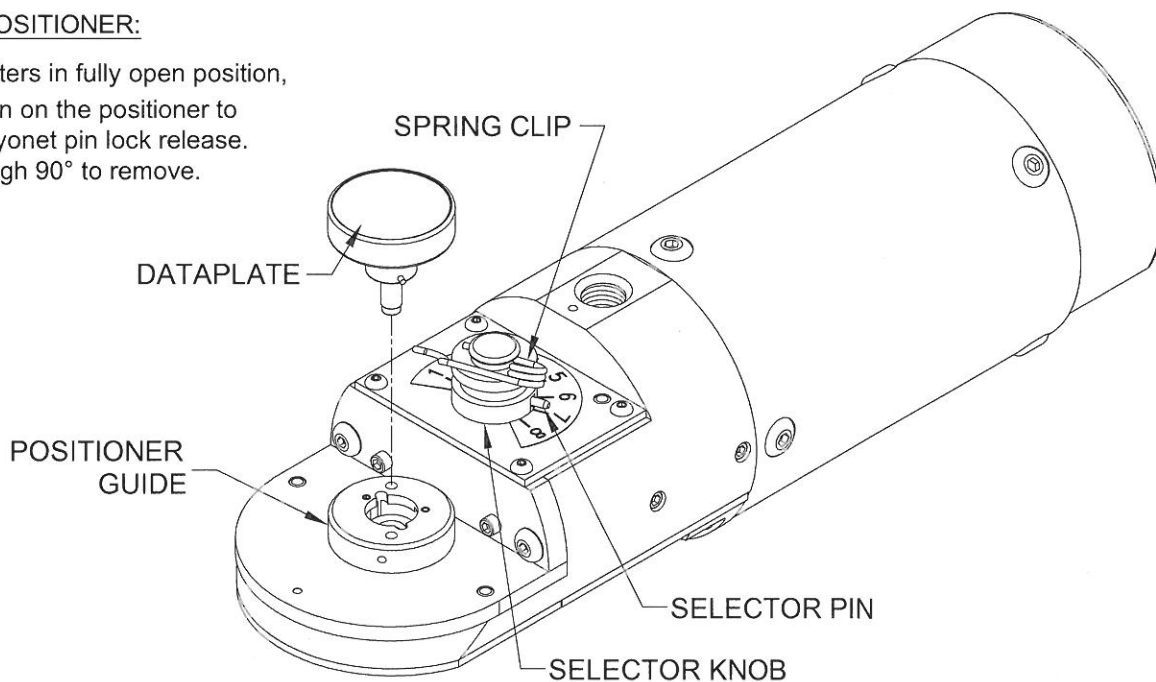
**CAUTION!**  
**DO NOT CRIMP GAGE !!**

## INSTALLATION OF POSITIONER:

1. Indenters must be in fully open position.
2. Remove spring clip from positioner guide, and select correct positioner for component to be crimped.
3. Insert positioner into tool positioner guide and turn through 90° until bayonet pins lock in place.
4. Components to be crimped, and selector settings to be used, will be identified on the positioner dataplate.
5. Remove spring clip from selector knob, then raise and rotate until number indicated on dataplate is inline with selector pin.

## REMOVING POSITIONER:

1. With indenters in fully open position, press down on the positioner to enable bayonet pin lock release. Turn through 90° to remove.



## CHECKING THE FULL CYCLE RATCHETING MECHANISM

The ratcheting mechanism can be checked for proper functioning by using the following procedure .....

1. Adjust the air line supply pressure to 15psi
2. Using components to be crimped, operate the tool until the indenters stop.  
The indenters will not reach the fully closed position, and the crimped assembly will be locked in position if the ratcheting mechanism is functioning correctly.
3. To release the partially crimped assembly, increase the air line supply pressure to 80-120psi and operate. The tool will now complete the crimp cycle allowing the indenters to return to the fully open position.

## RELEASING A PARTIALLY CRIMPED ASSEMBLY

To release a partially crimped assembly, proceed as follows .....

1. Increase the air pressure to 120psi and operate the tool. If increasing the air pressure does not release the assembly, proceed to step 2
2. Turn the selector knob clockwise to the highest lockable setting. Selector knob must be in the locked position before proceeding. Cycle the tool.
3. If the assembly is not released after several attempts, please contact DMC service department.

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## CARE OF TOOL

There is virtually no maintenance required. However, it's good practice to keep indenter tips free of residual deposits and other debris. A small wire brush may be used for this purpose.

We strongly recommend that you:

1. DO NOT immerse tools in cleaning solution.
2. DO NOT spray oil into tool to lubricate.
3. DO NOT attempt to disassemble tool or make repairs.

This is a precision pneumatic crimp tool and should be handled as such.

DMC offers complete refurbishing and recalibrating services.

DMC specially engineers and manufactures complete tool kits to satisfy individual customer requirements, such as total aircraft support, general shop maintenance or production, on board ship and vehicle service, etc.

### LIMITATION OF LIABILITY

DANIELS MANUFACTURING CORPORATION IS NOT LIABLE FOR CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY NATURE OR KIND RESULTING FROM THE USE, MISUSE, OF ANY OF ITS PRODUCTS. OWNERS AND USERS OF DMC PRODUCTS ASSUME FULL RESPONSIBILITY FOR INSTRUCTING THEIR EMPLOYEES IN THE PROPER AND SAFE USE OF SUCH PRODUCTS.

### LIMITED WARRANTY

DMC (Daniels Manufacturing Corporation) warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. DMC's obligation under this warranty is limited to the free correction or, at DMC's option, the refund of the purchase price of any such product which proves defective in normal service within ninety (90) days after delivery to the first user, provided that the product is returned to DMC with all transportation charges prepaid and which shall appear to DMC's satisfaction, after DMC's inspection, to have been defective in material or workmanship, it being understood that DMC products are not consumer products. This warranty shall not cover any damage to any products which, in the opinion of DMC, was caused by normal wear, misuse, improper operation, tampering, neglect or accident. This warranty is in lieu of all other warranties express or implied. No warranty, express or implied, is made or authorized to be made or assumed with respect to products of Daniels Manufacturing Corporation other than those herein set forth.

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