PNEUMATIC CRIMP TOOL WA27F

DMC DANIELS MANUFACTURING CORPORATION
DATASHEET

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

ACCESSORIES, GAUGING PROCEDURES AND SPECIFICATIONS

GENERAL SPECIFICATIONS:

- The WA27F is an 8-gauge 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, gauges and foot valves can be ordered using their respective part numbers.

SIZE:
Length: 10"   Width: 2.75"   Weight: 3.1lbs

CRIMPING RANGE:
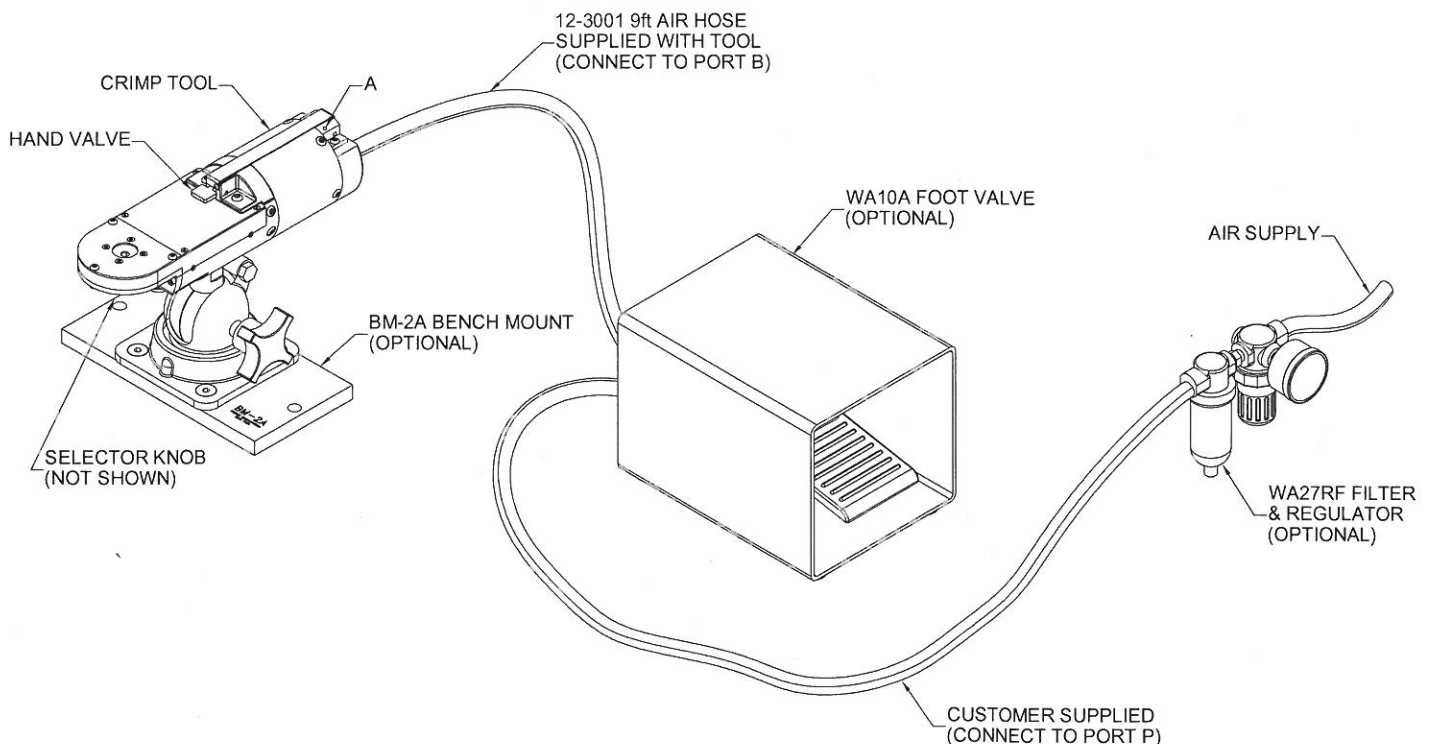CONTACTS: Size 12 thru 20
WIRE SIZE: Size 12AWG thru 26AWG

TOOLING:
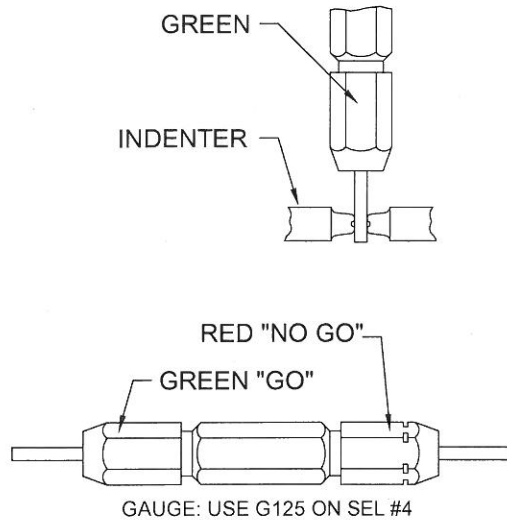Will accommodate all AF8 Turret and Single Position Heads

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 .. !!

CRIMP TOOL — A
HAND VALVE
12-3001 9ft AIR HOSE SUPPLIED WITH TOOL (CONNECT TO PORT B)
WA10A FOOT VALVE (OPTIONAL)
AIR SUPPLY
BM-2A BENCH MOUNT (OPTIONAL)
SELECTOR KNOB (NOT SHOWN)
WA27RF FILTER & REGULATOR (OPTIONAL)
CUSTOMER SUPPLIED (CONNECT TO PORT P)

GAUGING INSTRUCTIONS

"GO" GAUGING

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

"NO-GO" GAUGING

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

GREEN

INDENTER

RED

INDENTER

GAUGING LIMITS

SEL NO	INSPECTION GAUGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0280	.0330
2	.0320	.0370
3	.0360	.0410
4	.0390	.0440
5	.0450	.0500
6	.0520	.0570
7	.0590	.0640
8	.0680	.0730

RED "NO GO"

GREEN "GO"

GAUGE: USE G125 ON SEL #4
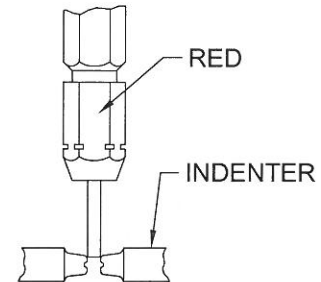
CAUTION!
DO NOT CRIMP GAUGE !!

INSTALLATION OF POSITIONER:

1. Indenters must be in fully open position.
2. Place positioner onto retaining ring with alignment pin in alignment hole.
3. After positioner is seated against retainer ring, tighten socket head screws with 9/64" hex Allen wrench.
4. Refer to dataplate. From selector No column, determine the setting that corresponds with the contact/wire assembly being crimpe
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, loosen screws until threads are disengaged from retainer ring and remove.

SELECTOR KNOB

2X SOCKET HEAD SCREWS

DATAPLATE

RETAINER RING

SELECTOR PIN

SPRING CLIP
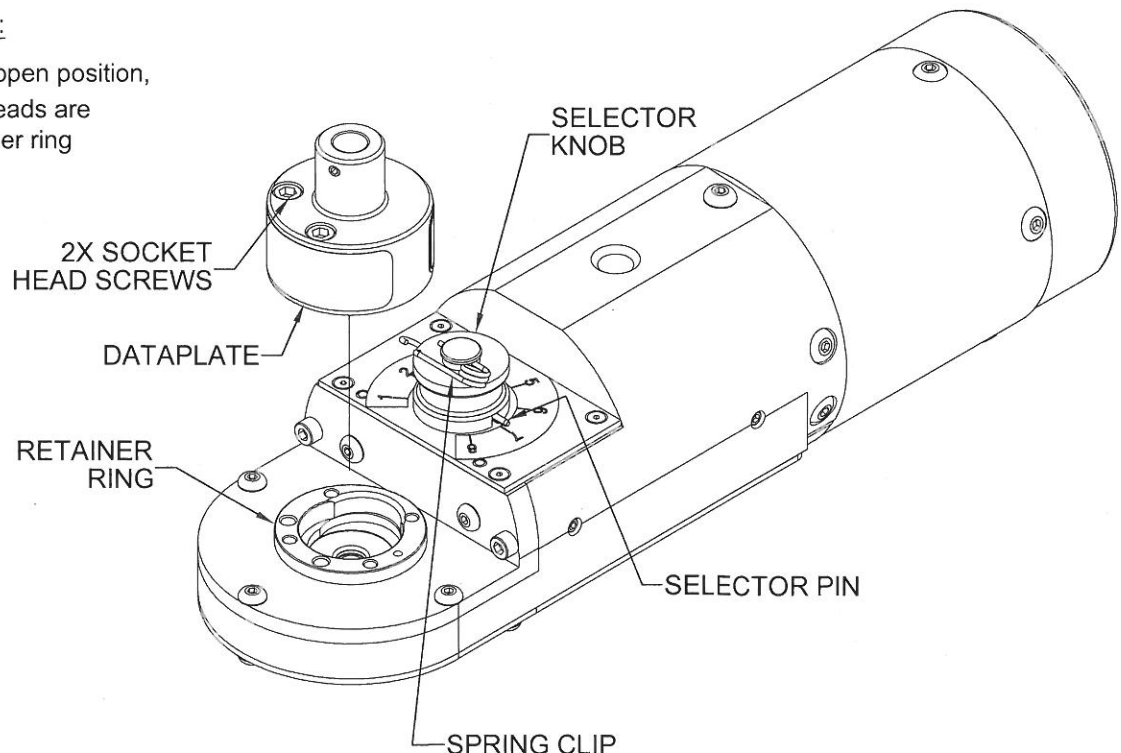
CHECKING THE FULL CYCLE RATCHETING MECHANISM

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 CONTACT ASSEMBLY

To release a partially crimped contact 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.

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 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.

Mouser Electronics

Authorized Distributor

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