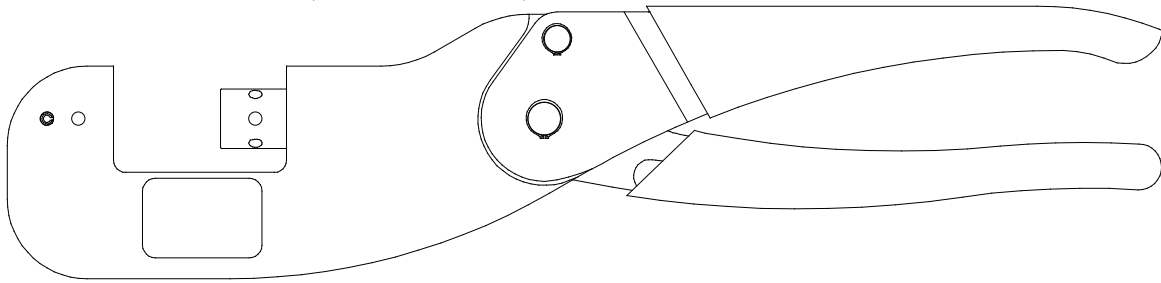




ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING CYCLE CONTROLLED C-FRAME STYLE CRIMP TOOL 620175 (M22520/5-01) AND ASSOCIATED TYPES



INSTRUCTIONS FOR USE OF 620175 CRIMP TOOL

GENERAL:

The Astro Tool Corp. 620175 Hex Die Crimping Tool is a cycle controlled, manually operated, C-frame tool for crimping shield terminating ferrules, RF connector fittings, and other terminations requiring an open frame crimp tool.

There is only one set up operation required - installing the required die set. Die sets are available in single, double and triple hex cavities. Special form crimps are also obtainable, consult the factory for details.

The Tool's precision cycle control mechanism assures a high quality, repeatable crimp. The in-line action of the dies and toggle mechanism reduces the compression force required to complete the crimp.

For long life and optimum performance, this tool should be kept clean and handled with the care of any other precision device.

OPERATION

a. Open and close the tool several times and observe the precision cycle-control mechanism. Note that the tool cannot be opened without completing its cycle.

b. Identify the parts in figure #1:

1. Ratchet Handle
2. Movable Die Nest
3. Stationary Die Nest
4. Key

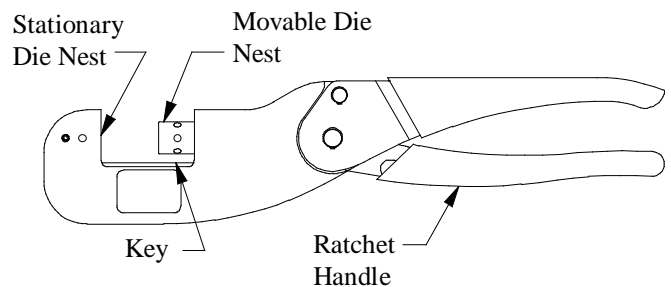


Figure #1

c. Die Installation

1. The tool must be in the fully open position as shown in figure #2.
2. Locate the Stationary Die and engage the keyway of the die with the key of the tool. Press the die into place. See figure # 2.

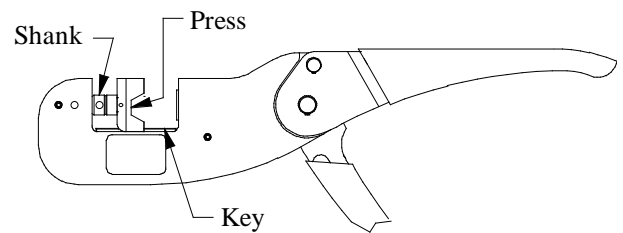


Figure #2

3. Locate the Movable Die and engage the keyway of the die with the key of the tool. Press the Die into place. See figure # 3.

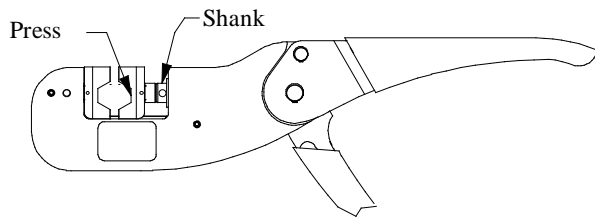


Figure # 3

NOTE: To determine which Die is Stationary or Movable; Die Post must align with Die Nest when Die Half is engaged with key.

4. Cycle the tool to insure that the dies are seated properly. See figure # 4.

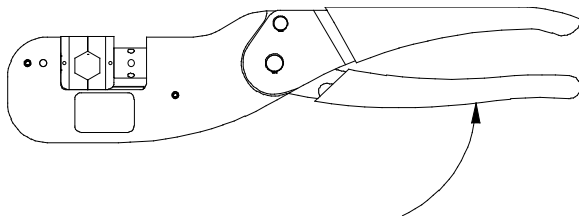


Figure # 4

d. Crimping Operation

1. The tool must be in the fully open position. Insert the prepared connector through the tool opening and place in the appropriate cavity. For RF connector fittings, use the die face as a locational stop. For shield terminations, locate the crimp by eye.

2. Squeeze the handles together until the positive stop is reached. The tool will release and return to the fully open position.

3. Remove the crimped termination.

e. Die Removal

1. The tool must be in the fully open position.

2. To remove the Stationary Die, locate the Die removal Tool (P/N DRT5). Place the tool against the button at the end of the tool. Gently tap Die Removal Tool. The die will release from the retainer and slide out of the die nest. See Figure # 5.

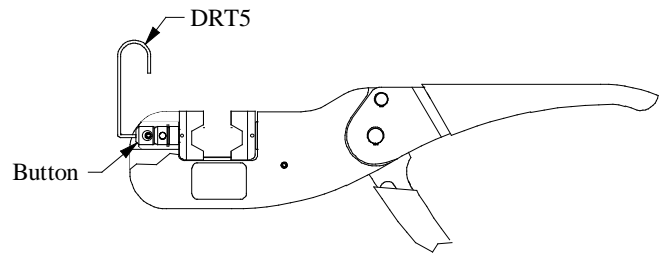


Figure #5

NOTE: Always remove the Stationary Die First.

3. To remove the Movable Die, hold the tool in the fully closed position. Hook the Removal Tool around the Movable Die nest as shown in figure # 6. Move the handles to the fully open position and the die will release from the retainer and slide out of the die nest.

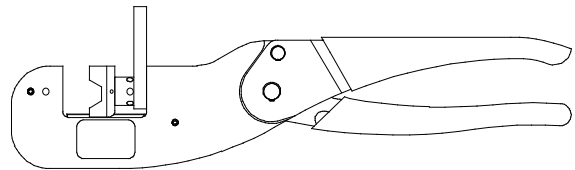


Figure # 6

TOOL SERVICE

Astro Tool's 620175 Crimp Tool is designed for long, reliable service. If the tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the tool to our factory.

Upon receipt of the tool, Astro will inspect and overhaul each tool to put the tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired. Please note that Astro's Quality Control system is traceable to The National Institute of Standards and Technology (N.I.S.T.).

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charge for such parts.

ASTRO TOOL CORP. MANUFACTURERS OF INSTALLING, REMOVAL, CRIMP TOOLS AND CONNECTOR SERVICE KITS

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