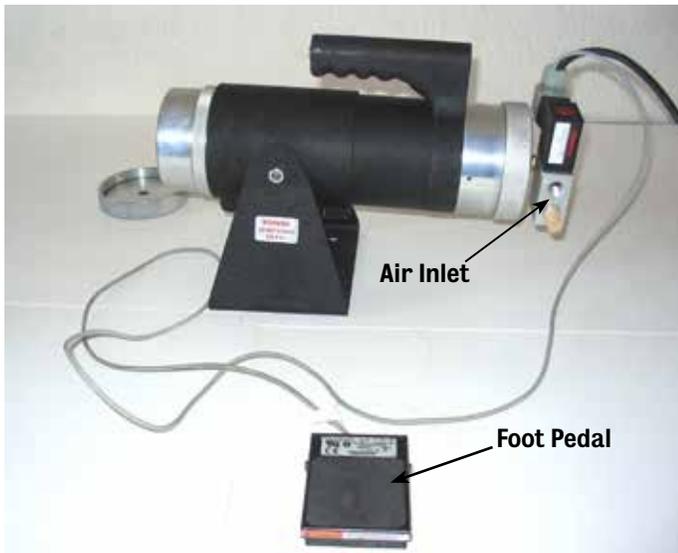


400/500 SERIES

PNEUMATIC CRIMPING TOOL EC-2

PICO



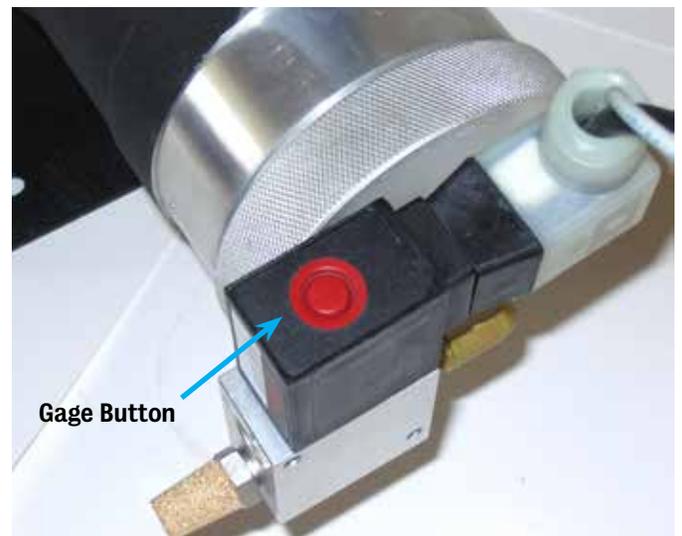
Typical EC Setup



With Air Connected



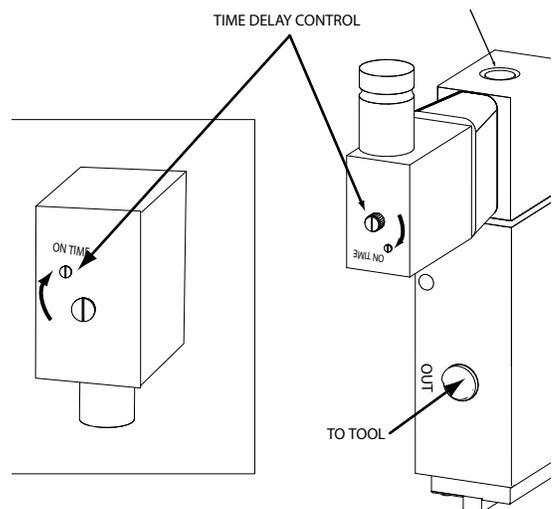
Close - View - Air line connected



Close - View - Gage Button



Close - View - Time Delay



OPERATION & ADJUSTMENT

1

Adjust Regulator

With the air supply connected, adjust the regulator to provide approximately 80 lbs PSI.

2

Test Crimp Cycle

Without a contact and wire in place, depress the foot pedal. It is not necessary to hold pedal down. The cycle is controlled by the EC system. Observe the action of the indentors to be sure they operate freely.

3

Normal Operation

Insert the contact or terminal and wire assembly and proceed to crimp.

After operating personnel have become accustomed to using the tool, the air need not be turned off while changing dies and locators.

If a die set fails to calibrate within an acceptable range, calibrate the tool following the steps below to insure that the tool is within specification.

EC ADJUSTMENT

The EC time delay adjustment controls the cycle time for the crimp. This “dwell” time controls the time that the indentors are in the closed position.

Cycle time can be adjusted from 0, instantaneous, to 5 seconds. This is accomplished by turning counter-clockwise [decrease dwell], to clock-wise [increase time]. The knob sensitivity is low, and it might require a few full turns to set the correct timing.

With small gage contacts, generally 8 AWG or less, dwell time can be set to 0. For larger contacts, the indentors should be closed for a period of 1-3 seconds. The spring-back, which depends on the elastic modulus and material thickness, is such that to produce the best crimp, maintaining constant force, closed indentors, ensures this result.

P/N EC-2

