## T1 Hand Crimping Tool

| AWG 28-26 | Part-Nr.: | 932507006 |
|---|---|---|
| | Part Description: | XZC0706 |
| AWG 24-22 | Part-Nr.: | 932507007 |
| | Part Description: | XZC0707 |

## Operation Manual

| Crimp-Tool: | 932507006 | XZC0706 |
|---|---|---|
| | | AWG 28-26 |
| | 932507007 | XZC0707 |
| | | AWG 24-22 |

| Crimp contacts: | 935079001 | RSCB 050/2 PdNi Au |
|---|---|---|
| | | AWG 28-26 |
| | 935079002 | RSCB 050/1 PdNi Au |
| | | AWG 24-22 |

## Scope of Application

The crimping tools were used to process crimp contacts with the article number 935079001 and 935079002, which are supplied on carrier strips with approx. 500 contacts per roll (2). Roll holder (1), feed unit (9) and two crimp profiles ensure good handling with the best crimp result. The crimp profile crimps the conductor and the insulation crimp area of the contact in one operation.

During the crimping process, the contact is also separated from the strip so that it can be removed with the conductor.
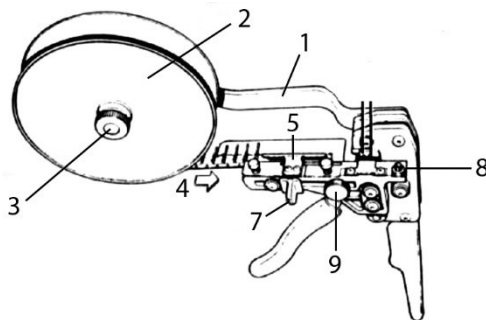
1 = roll holder
2 = Contact role
3 = knurled nut
4 = Arrow
5 = guide plate
6 = Contact strips
7 = Contact feeder
8 = buckling sheet
9 = knurled nut
10 = release lever
11 = pressure lock

## Feed Unit

With the help of the feed unit, the contact strip is positioned in the tool and processed as follows:

1.  Mount the contact roller (2) on the roller holder (1) with the knurled nut (3). **Contact tips point towards the reel seat!**

2.  Close the tool until the positive lock permits opening.

3.  Insert the contact strip (6) in the direction of the arrow (4) between the feed unit and the holding plate so that it is completely guided between the conductor and insulation crimp up to the end of the holding plate (5).
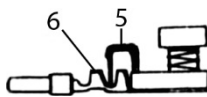
4.  Feed with contact transport (7).

## Adjusting the feed unit

1.  Loosen the knurled nut (9).

2.  Move the feed unit to the right or left to the stop.

3.  Tighten the knurled nut (9) again!

4.  Check whether the contact is centered in the respective crimp profile.

## Replace the contact strip

Unlock and hold the feed unit with the release lever (10) in the "release" direction.

- Pull out the contact strip against the feed to the roller (2)

- Remove the contact roller
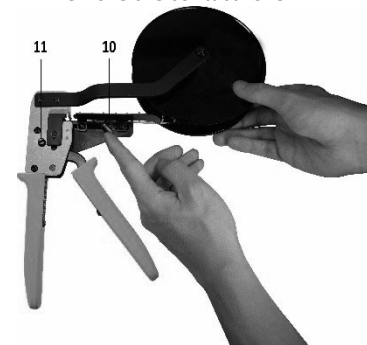
## Unlock prematurely

The hand tool can only be operated after it has been fully closed. Every crimping process must be completed before the tool opens again. This ensures a consistently good crimp quality.

However, early unlocking of the tool is possible:

- Lightly press the handles of the tool together.
- Release the forced lock (11) on the back of the tool by turning to the left.
- Tool handles can be opened.

## Quality Features

| | Crimp- height* | Extraction force |
|---|---|---|
| **AWG 28** | 0,80 mm $^{\pm 0,05mm}$ | >11 N |
| **AWG 26** | 0,80 mm $^{\pm 0,05mm}$ | >15 N |
| **AWG 24** | 0,92 mm $^{\pm 0,05mm}$ | >30 N |
| **AWG 22** | 0,92 mm $^{\pm 0,05mm}$ | >40 N |

*Stripping length of the strand:* $3{,}0 \text{ mm}^{+0,5 \text{ mm}}$

| lumbergautomation A BELDEN BRAND | English |
|---|---|
| **T1 Hand Crimping Tool** | |

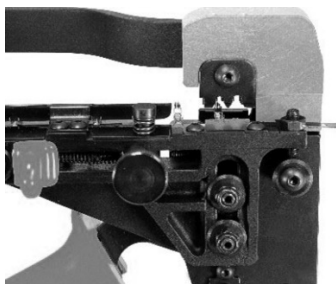| AWG 28-26 | Part-Nr.: | 932507006 |
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## Crimping

**Step 1**
Open crimping tool.



**Step 2**
Make sure that the contact is at the center of the crimp profile after being pushed forward.



**Step 3**

Bring the crimping tool into the locked position (1-2 clicks).



**Step 4**
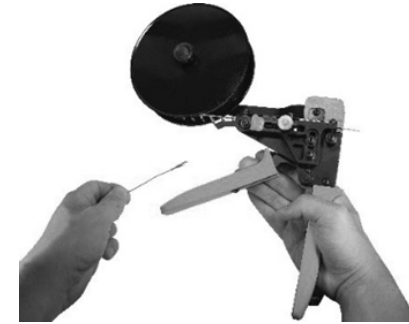Push the stripped conductor into the contact.



**Step 5**
Close the hand tool completely until the safety ratchet enables the tool to be opened.



**Step 6**
Remove crimped contact.



## Care and Maintenance

Possibly, remove existing material and dirt residues, clean crimp zone. Check the tool for correct closing of the profiles, clean moving parts and lightly oil it (machine oil SAE 20).

**Clean after 75 crimping.**
**Crimp check after 1,500 crimping.**
**Maintenance after 7,000 crimping or 3 years.**

- Use only for crimping!
- Only Belden crimp contacts can be processed with the tool!
- Protect the tool from dust and moisture!

**If damage is found, only have the repair carried out by authorized specialist personnel!**

**\* Specification for measuring the crimp dimensions:**