



Operation Manual

HTV10L Hand tool TAB2.8 – SWS

HTV10L crimping head TAB2.8 - SWS

Customer Manual No.: 411-18585-1 Rev. A

Customer Manual PN: 1-744017-4

Language: en (Translation of the original German version)

- The data specified above only serve to describe the product. No statements concerning a certain condition or suitability for a certain application can be derived from our information. The information given does not release the user from the obligation of own judgment and verification. It must be remembered that our products are subject to a natural process of wear and aging.

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- The cover page shows a sample configuration. The delivered product may thus differ from the figure.

- The original operation manual is written in German.

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1 General information

1.1 Copyrights, industrial property rights

- © This document, as well as the data, specifications and other information set forth in it, are the exclusive property of **TE Connectivity Ltd.**
This manual is exclusively meant for the carrier of the „HTV10L Hand tool TAB2.8 - SWS“
TE PN 1579024-6 and „HTV10L crimping head TAB2.8 - SWS“ TE PN 8-1579016-4 (in further course called “hand tool and crimping head”)
- The additional device-specific manual includes descriptions, engineering drawings, instructions and references, that you may not copy, reproduce or distribute without written consent neither completely nor in parts.
- If the competition tries to discover and inspect this manual, we do expect the same fairness, that you may expect from your customers in that case.

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Subject to change without notice. Errors and omissions excepted.

2 Using the operation manual

- These instructions contain important information on the safe and appropriate operation and simple troubleshooting of the hand tool and crimping head.
- Read these instructions completely, especially section 3 “General safety instructions”, before working with the hand tool and crimping head.
- **TE Connectivity Ltd.** declines to accept any liability for damages that are incurred due to the fact that the instructions in the operation manual have been disregarded.
- The user is responsible for supplementing the operation manual with any instructions resulting from current national regulations for accident prevention and protection of the environment.
- Also observe the generally applicable, legal or otherwise binding regulations of the European or national legislation and the rules for the prevention of accidents and for environmental protection applicable in your country.

2.1 Abbreviations used

Abbreviation	Meaning
SWS;EDS	Single wire seal; Einzeldichtungssystem
PN	Part Number
RoHS	Restriction of (the use of certain) hazardous substances; Beschränkung (der Verwendung bestimmter) gefährlicher Stoffe

3 General safety instructions

The hand tool and crimping head has been manufactured according to the accepted rules of current technology. There is, however, still a risk of personal injury or damage to equipment if the following general safety instructions and the warnings before the steps contained in these instructions are not complied with.

- ▶ Read these instructions completely and thoroughly before working with the hand tool and crimping head.
- ▶ Keep these instructions in a location where they are accessible to all users at all times.
- ▶ Always include the operating instructions when you pass the hand tool and crimping head to third parties.

RoHS Information

Information on the presence and location of any substances subject to RoHS (Restriction on Hazardous Substances) can be found at the following website:

- <http://www.tycoelectronics.com/customersupport/rohssupportcenter/>
- Click on “Find Compliance Status” and enter equipment part number.

3.1 Intended use

The hand tool and crimping head has been designed to apply TAB 2.8 contacts with single wire seals according to TE application specification and drawing, see section 5.
It is permitted to use the hand tool and crimping head exclusively for repair purposes or preparation of samples. Do not use it for serial production.

- ▶ The hand tool and crimping head is not a product in terms of the EU-Machinery Directive 2006/42/EG.
- ▶ Intended use includes having read and understood these instructions, especially section 3, "General safety instructions".

Note related to the use:

- ▶ Cumulative Trauma Disorders can result from a prolonged use of manually powered hand tools. **TE Connectivity Ltd.** hand tools are intended for occasional use and low volume applications. For extended use or production operations **TE Connectivity Ltd.** offers a wide selection of powered application equipment.

3.2 Improper use

Any use of the hand tool and crimping head other than described in section 3.1 "Intended use" is considered as improper.

3.3 Reasonably foreseeable misuse

Any attempt to use the hand tool and crimping head with other than the specified contacts, described in section 3.1 "Intended use", is considered as a reasonable foreseeable misuse.

Moreover, the hand tool and crimping head may be used exclusively within the limits of its intended use (section 3.1).

In order to ensure operating safety, these activities may therefore only be carried out by qualified technical personnel or an instructed person under the direction and supervision of qualified personnel. Qualified personnel are those who can recognize possible hazards and institute the appropriate safety measures due to their professional training, knowledge and experience, as well as their understanding of the relevant conditions pertaining to the work to be done. Qualified personnel must observe the rules relevant to the subject area.

3.4 Safety instructions in this document

3.4.1 General instructions

- ▶ Observe the regulations for accident prevention and environmental protection for the country where the hand tool is used and at the workplace.
- ▶ Use the hand tool and crimping head exclusively in good technical order and condition.
- ▶ Check the hand tool and crimping head for visible defects, for example missing parts in set case or broken parts.
- ▶ You must generally not modify or retrofit the hand tool and crimping head.
- ▶ Only use the hand tool and crimping head appropriate to the intended use described in this manual.
- ▶ Individuals who assemble, operate, disassemble or maintain the hand tool and crimping head must not consume any alcohol, drugs or pharmaceuticals that may affect their ability to respond.
- ▶ Before putting the hand tool and crimping head into operation, it is always important to check whether all devices are at hand and functioning correctly.
- ▶ If the hand tool and crimping head are apparently damaged or do not work proper, you must send it in for repair.
- ▶ The warranty only applies to the delivered configuration. The warranty will not apply if the hand tool and crimping head are incorrectly assembled, not used as intended and/or handled improperly.

3.4.2 During operation

Only persons who have been authorized by the operator may be granted access to the direct use of the hand tool and crimping head.

3.4.3 During disposal

For environmentally friendly disposal please observe the notes in section 10.

3.5 Obligations of the operator

The operator of the **TE Connectivity Ltd.** products is bound to provide for personnel training on a regular basis regarding the following subjects:

- ▶ Observation and use of the operating instructions and the legal regulations
- ▶ Intended use and operation of the hand tool and crimping head.

4 Scope of delivery

According customer order, the scope of delivery may include the following:

- 1 Crimping head TE PN 8-1579016-4 or
- 1 Hand tool TE PN 1579024-6
 - Consist of:
 - 1 Crimping head TE PN 8-1579016-4
 - 1 Basic Hand tool grip, long TE PN 2-1579005-2
- 1 Operation manual 411-18585 / TE PN 1-744017-4

5 Description of processed contacts

Following TAB2.8 x 0.8 contacts can be applied with the hand tool and crimping head:

	Contact	Contact PN	TE - Application Specification
0,5 mm ²	TAB2,8 x 0.8	962915 / Strip ware 963748 / Loose- piece	114-18018 (SWS) 114-18051 TE PN 1579024-6 TE PN 8-1579016-4
0,75 mm ²	TAB2,8 x 0.8	962915 / Strip ware 963748 / Loose- piece	114-18018 (SWS) 114-18051 TE PN 1579024-6 TE PN 8-1579016-4
1,0 mm ²	TAB2,8 x 0.8	962915 / Strip ware 963748 / Loose- piece	114-18018 (SWS) 114-18051 TE PN 1579024-6 TE PN 8-1579016-4

6 Dismounting the crimping head

You can dismount the crimping head to fit a different crimping head on the HTV10 / HTV10L tool.

Note: The emergency ratchet-release mechanism of the hand tool has detents that are audible as “clicks” as the handles will be closed. The emergency ratchet-release mechanism releases on the last click.



Picture 1: Pressing out the locking pins from the front

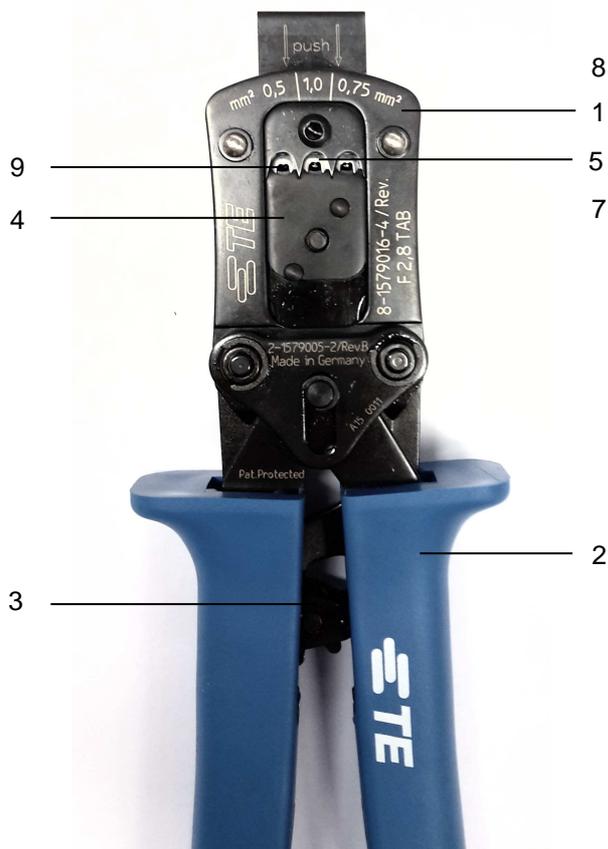


Picture 2: Removing the locking pins

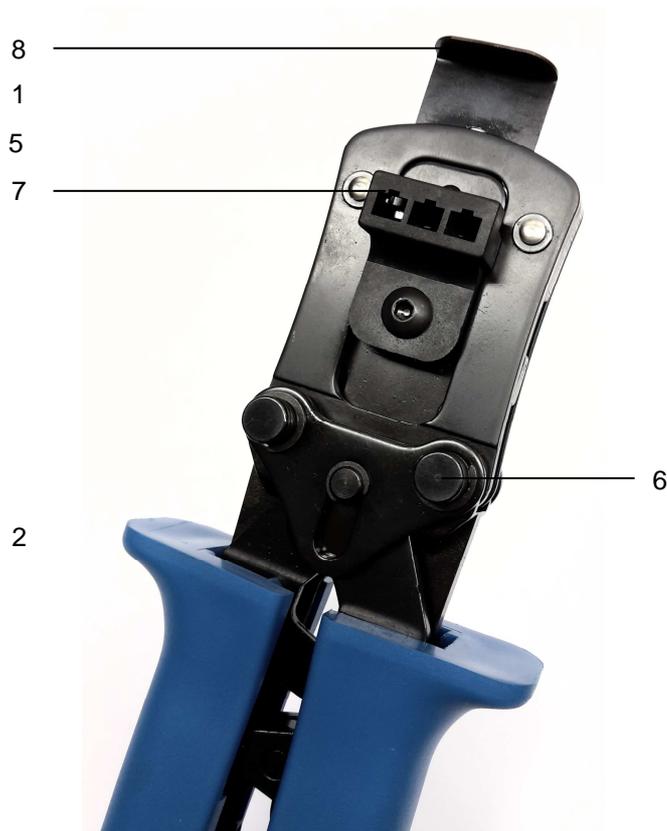
- ▶ Release the locking pin at the front and press it out as far as possible.
- ▶ Then pull out the locking pin at the rear far enough to detach the crimping head from the grip.
- ▶ After you have pulled out both locking pins, you can remove the crimping head horizontally upwards.

7 Hand tool description

The HTV10 / HTV10L hand crimping tool essentially consists of a crimping head and a moveable grip with a ratchet mechanism. The ratchet mechanism ensures proper crimping in accordance with TE specifications. The crimping head is fitted with one or more crimp nests corresponding to the product to be processed. Engraved cross-section markings on the front indicate which crimp nest should be used for which wire cross-section.



Picture 3: Hand tool components, front view



Picture 4: Hand tool components, back view

- 1 Crimping head
- 2 Hand grip
- 3 Emergency ratchet-release
- 4 Die set
- 5 Resilient insulation stop

- 6 Locking pins
- 7 Folding contact Locator
- 8 Sliding positioner / wire stop
- 9 Crimping nests

8 Crimping procedure

Decide in consideration of the wire cross section and corresponding application specification or drawing the appropriate crimping nest for the contact which will be processed. In order to crimp the contact proceed as follows:

- ▶ Squeeze the handles together until the emergency ratchet-release mechanism releases and allow them to open fully.

Note: The emergency ratchet-release mechanism of the hand tool has detents that are audible as “clicks” as the handles will be closed. The emergency ratchet-release mechanism releases on the last click.

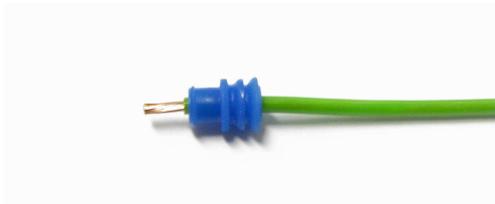
- ▶ Insert the terminal to be processed into the right terminal holder for the wire cross-section. Make sure the terminal is pushed into the stop in the terminal holder.
- ▶ Then slide the moveable positioner in the direction shown by the arrow to hold the terminal in place and position the wire stop.



Picture 5: Inserting the contact



Picture 6: Push the sliding positioner downwards



Picture 7: Place a sealing ring on the wire



Picture 8: Insert the wire with the sealing ring

- ▶ Assemble the wire and sealing ring according to Processing Specification 114-18018.
- ▶ Insert the wire into the terminal until it reaches the stop.



Picture 9: Closed crimp tool (crimping head)



Picture 10: Checking the crimping contact

- ▶ Squeeze the crimp tool completely closed.

Note: The crimp tool (crimping head) opens automatically after it is completely closed; otherwise it remains closed.

- ▶ Then you can remove the crimped terminal from the crimping die. If the terminal is stuck, wiggle it slightly to remove it.
- ▶ Check the crimp height of the crimped terminal, based on the information in the TE Connectivity processing specification and the drawing (see Section 5).

9 Maintenance and Repair

9.1 Daily Maintenance

For the daily maintenance following steps have to be taken by the responsible operator:

- Clean up the tool from dust, humidity and other residues by means of a clean, soft scrubber or a lint free cloth. Never use rigorous or abrasive substances to avoid damaging the tool.
- Make sure the mounting pins of the tool are inserted and fixed.
- All pins, pivot points and bearing surfaces must be provided with a high quality SAE20 motor oil. Avoid excessive lubrication.
- If the hand tool is no longer required, pinch the handles and store the hand tool dry and clean.

9.2 Periodically Maintenance

- Depending on the degree of utilisation an inspection of the hand tool should be done by an appropriate qualified personnel.
- Make sure the mounting pins of the tool pinch are inserted and fixed.
- Squeeze the handles and check the emergency ratchet-release mechanism releases.
- Check the hand tool on abrasion and damaging, in particularly in the field of the crimping nests and all pivot points.

10 Disposal

In case of disposal, please send the hand tool and its components back to the address specified in section 10.1 Contact Information.

11 Appendix

11.1 Contact information

TE Connectivity

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