

Figure 1

1. INTRODUCTION

DAHT (Double Action Hand Tool) Adapter Assembly 1213563-1 is designed to accept the crimp head from any Double Action Hand Tool to adapt the crimp head for use with 626 Pneumatic Tooling Assemblies. Double Action Hand Tools are sold separately and are available from Tyco Electronics. For information concerning the setup and operation of the pneumatic tools, refer to Customer Manual 409-5862.

This instruction sheet provides:

- Recommended procedures for crimp head removal from the hand tool
- Crimp head installation into the adapter
- Installation and removal of the cam and adapter from the pneumatic tool
- Maintenance, inspection, and repair information for the adapter

For crimp head information concerning wire preparation, crimping procedures, maintenance, inspection, and repair, refer to the associated instruction sheet for the appropriate hand tool.

Read these instructions thoroughly before proceeding.

NOTE *Dimensions are in millimeters [with inch equivalents in brackets]. Figures and illustrations are for identification only and are not drawn to scale.*

Reasons for reissue of this sheet are provided in Section 8, REVISION SUMMARY.

2. DESCRIPTION

The adapter facilitates the connection of the double action crimp head (typical crimp head shown in Figure 1) to the pneumatic tool and provides the necessary motion of the crimp head jaws when the pneumatic tool is actuated. When the tool is actuated, the cam extends into the adapter, contacting the crimp head jaws. When the cam retracts, the force is removed from the jaws and they return to their starting position.

The jaws may be opened and closed manually by simultaneously squeezing the two opposing clevises, which are coupled to the jaws. The quick pins secure the crimp head to the adapter.

3. CRIMP HEAD REMOVAL FROM HAND TOOL

Remove the two retaining rings from one side of the hand tool body and push the retaining pins, along with the two remaining retaining rings, through the opposite side of the tool body, as shown in Figure 2. Slide the crimp head out of the tool body.

4. CRIMP HEAD INSTALLATION INTO ADAPTER

(Figure 1)

As supplied, the adapter has two quick pins installed. The pins will be used to secure the crimp head to the adapter. Therefore, these quick pins must be removed prior to installing the crimp head; then proceed as follows:

1. Align the crimp head mounting holes with the adapter quick pin holes as shown in Figure 1; then insert the crimp head into adapter cavity.
2. Install the quick pins through the slotted holes in the adapter and into the crimp head mounting holes. See Figure 1.

NOTE *If quick pins become difficult to install, it may be necessary to jog the clevises to properly align the holes.*

DANGER *After crimp head is installed, make sure that the quick pins are FULLY inserted to avoid personal injury and damage to the tool.*

5. ADAPTER INSTALLATION AND REMOVAL (Figure 3)

DANGER *Air pressure must be removed from the unit while head or tool holder is detached.*

DANGER *DO NOT operate pneumatic tool without the proper adapter and crimp head installed.*

After the crimp head has been installed onto the adapter, the adapter is ready for installation onto the pneumatic tool. Refer to Customer Manual 409-5862 for instructions on removing previously installed cam and tool holder from pneumatic tool. Locate the adapter cam (supplied with the adapter assembly), then proceed as follows:

1. If cam setscrew is not installed in cam, thread setscrew into cam two to three turns.
2. Place cam (with setscrew) onto power unit piston rod, as shown in Figure 3. Cam should butt against the piston rod face. If not, turn cam setscrew counterclockwise until cam fits on piston rod properly.

CAUTION *Over-tightening the cam setscrew may damage the setscrew or cam.*

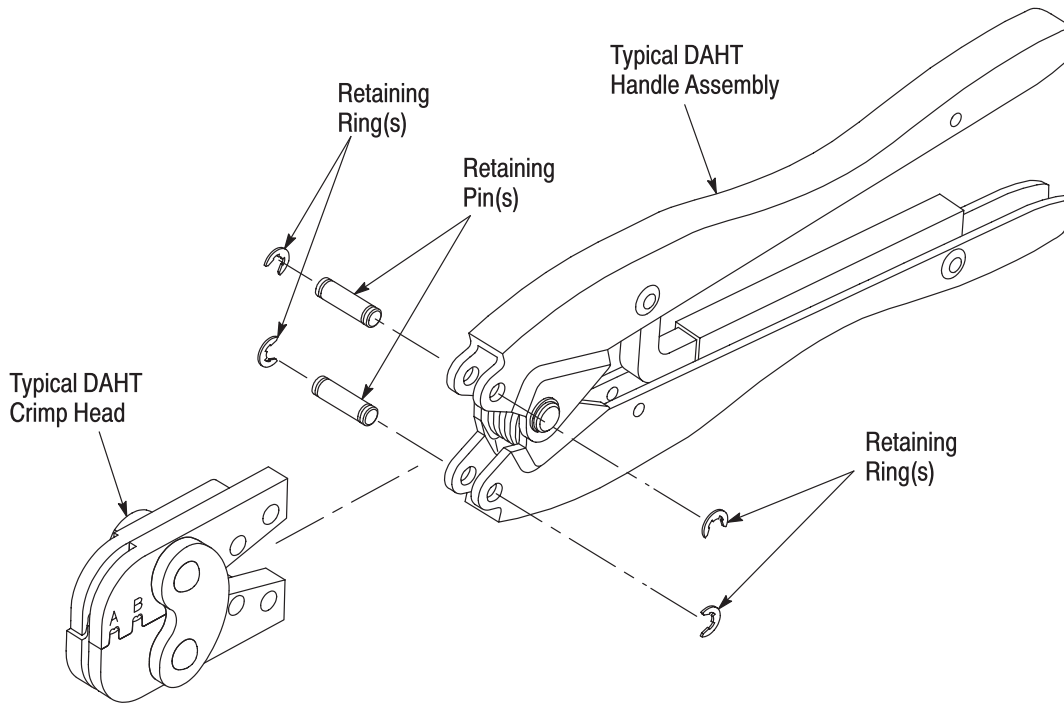


Figure 2

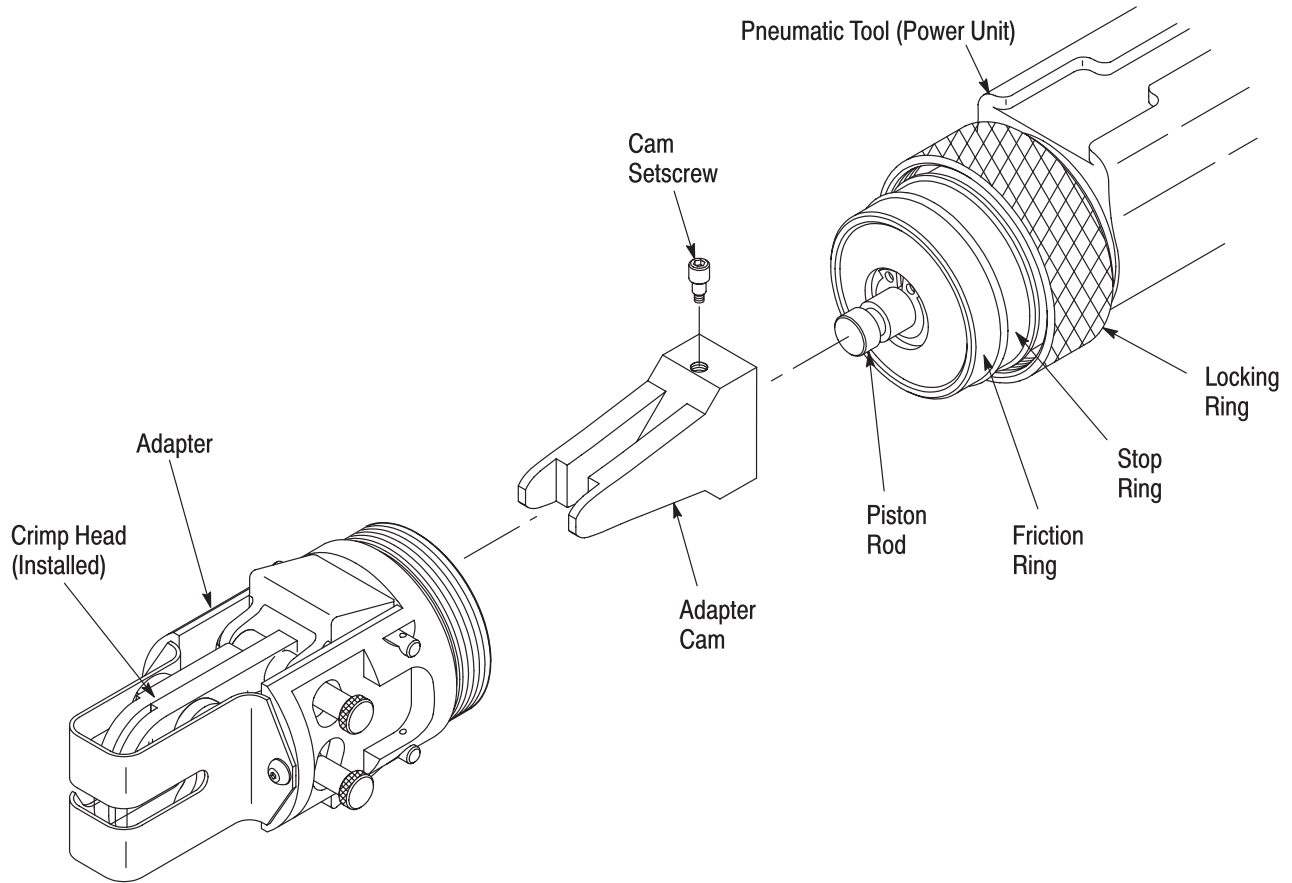


Figure 3

3. Using hex wrench supplied with adapter, tighten cam setscrew, then pull on cam to ensure that it is firmly attached.
4. Properly align adapter with cam and push adapter onto power unit so that it passes over the friction ring on the power unit.
5. Slide locking ring toward adapter until it butts against the stop ring on the power unit. Then turn locking ring clockwise to engage threads on the bottom of the adapter. Tighten locking ring to fully secure the adapter.



When adapter is properly installed, the locking ring should be butted against the stop ring and threads of the adapter should not be visible. If not properly installed, check that correct combination of cam and adapter was used and that they are aligned properly.

6. Rotate the adapter one full turn in each direction and note that the locking ring rotates with the adapter.



To avoid personal injury, periodically check that locking ring is tightly securing the adapter.

7. Connect pneumatic tool to an adequate air supply between 620–690 kPa [90–100 psi]. For specific information on air line requirements and air hose installation, refer to Customer Manual 409-5862.
8. Removal is the reverse of installation.

6. MAINTENANCE AND INSPECTION

Tyco Electronics recommends that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations.



To avoid personal injury, ALWAYS disconnect the main air supply and electrical supply (if applicable) of the pneumatic tool before performing maintenance or inspection.

6.1. Daily Maintenance

Tyco Electronics recommends that each operator be responsible for the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a lint-free cloth. DO NOT use objects that could damage the adapter.
2. Make sure that all pins, rings, and other components are in place and secure.

3. Make certain all surfaces are protected with a thin coat of any good SAE 20 motor oil. DO NOT oil excessively.

4. When the adapter assembly is not in use, store it in a clean, dry area.

6.2. Periodic Inspection

Regular inspections should be performed by quality-control personnel. A record of scheduled inspections should remain with the adapter or be supplied to supervisory personnel responsible for the adapter. Though recommendations call for at least one inspection a month, the frequency should be based on amount of use, working conditions, operator training and skill, and your established company policies. These inspections should include the following:

1. Remove all lubrication and accumulated film by immersing the adapter in a suitable commercial degreaser that will not affect paint or plastic.
2. Make certain all components are in place. If replacements are necessary, refer to Section 7, REPLACEMENT AND REPAIR.
3. Check all bearing surfaces for wear. Replace worn parts.

6.3. Lubrication

Lubricate all pins, pivot points, and bearing surfaces with a high quality grease. Tyco Electronics recommends the use of Molykote‡ paste, which is a commercially available lubricant. Lubricate according to the following schedule:

Adapter used in daily production—lubricate daily
Adapter used daily (occasional)—lubricate weekly
Adapter used weekly—lubricate monthly

7. REPLACEMENT AND REPAIR

Replacement parts and recommended spares are listed in Figure 4. The recommended spares should be stocked for immediate replacement. Replacement parts can be ordered from, or when repair is necessary, return adapter (along with a written description of the problem) to:

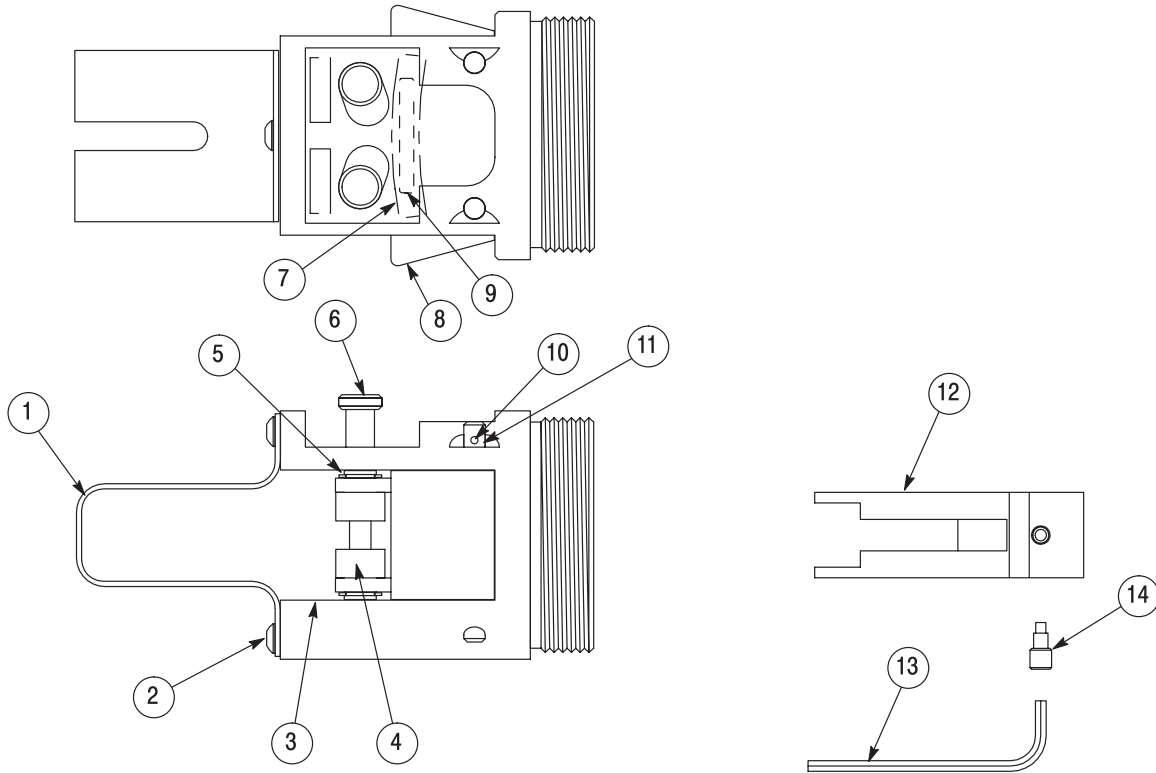
CUSTOMER SERVICE (38-35)
TYCO ELECTRONICS
P.O. BOX 3608
HARRISBURG, PA 17105-3608

For further repair and replacement information, call the Tooling Assistance Center at 1-800-722-1111.

8. REVISION SUMMARY

- Updated document to corporate requirements
- Changed text in first DANGER in Section 5

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REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER ASSEMBLY
1	224984-1	GUARD	1
2	1-21002-6	SCREW, BHC 6-32 x .25	2
3	1213564-1	ADAPTER	1
4	224938-1 ■	ROLLER	4
5	21985-7	RING, Retaining	4
6	318018-1 ■	PIN, Quick	2
7	5-22280-4	SPRING, Compression	1
8	1213565-1	CLEVIS	2
9	21030-6	PIN, Dowel	1
10	21028-2	PIN, Slotted Spring	2
11	1213566-1	PIN, Hinge	2
12	189763-1	CAM, Small	1
13	21027-6	WRENCH, Hex .094	1
14	189765-1	SCREW, Set 10-32	1

■ Recommended Spare Parts

Figure 4