



S.C.P. s.a.

Suministros de Conectores
Profesionales, s.a.

M22520/1-01

GENERAL INFORMATION:

1. Designation AF8 (M22520/1-01) refers to basic tool without positioner.
2. Wire crimp range 26 to 12 AWG
3. The tool has a double action ratchet, and cannot be opened without completing the cycle.

INSTALLATION OF POSITIONER:

1. Tool must be in open position.
2. Press positioner trigger latch which releases turret to indexing position.
3. Place positioner onto retaining ring with alignment pin in alignment hole.
4. After positioner is seated against retainer ring, tighten socket head screws with 9/64" hex. key.
5. Refer to dataplate on positioner. From color code column, select the positioner color that corresponds with the appropriate part number and size of contact to be crimped.
6. With tool in open position, rotate until color coded insert is in line with the index mark. Press turret until it snaps in latched position.
7. Refer to dataplate. From wire size column, determine the selector setting that corresponds with the contact being used.
8. Remove spring clip from selector knob and rotate until correct setting is in line with selector mark.

CRIMPING INSTRUCTIONS:

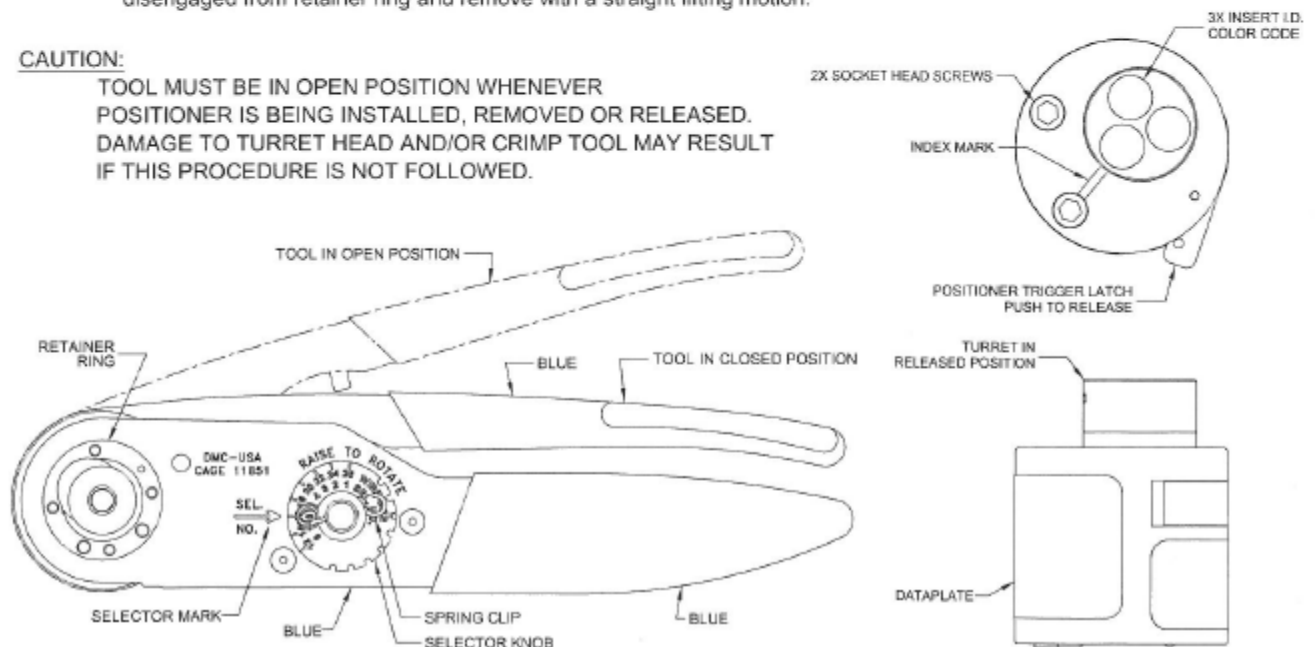
1. Insert contact and prepared wire through the indenter opening into the positioner.
2. Squeeze handles together until ratchet releases. Handle will return to open position.

REMOVING POSITIONER:

1. With tool in open position, release turret. Loosen screws until threads are disengaged from retainer ring and remove with a straight lifting motion.

CAUTION:

TOOL MUST BE IN OPEN POSITION WHENEVER POSITIONER IS BEING INSTALLED, REMOVED OR RELEASED. DAMAGE TO TURRET HEAD AND/OR CRIMP TOOL MAY RESULT IF THIS PROCEDURE IS NOT FOLLOWED.



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"GO" GAUGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.

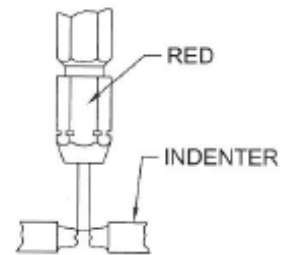
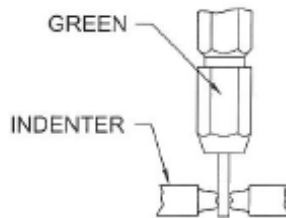
GAUGING INSTRUCTIONS

"NO-GO" GAUGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Try to insert the "NO-GO" gage end as shown. The "NO-GO" gage may partially enter the indenter opening, but must not pass completely through.

GAUGING LIMITS

SEL NO	INSPECTION GAGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0280	.0330
2	.0320	.0370
3	.0360	.0410
4	.0390	.0440
5	.0450	.0500
6	.0520	.0570
7	.0590	.0640
8	.0680	.0730



GAGE: USE G125 (M22520/3-1) ON SEL #4

CAUTION!
DO NOT CRIMP GAGE !!

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