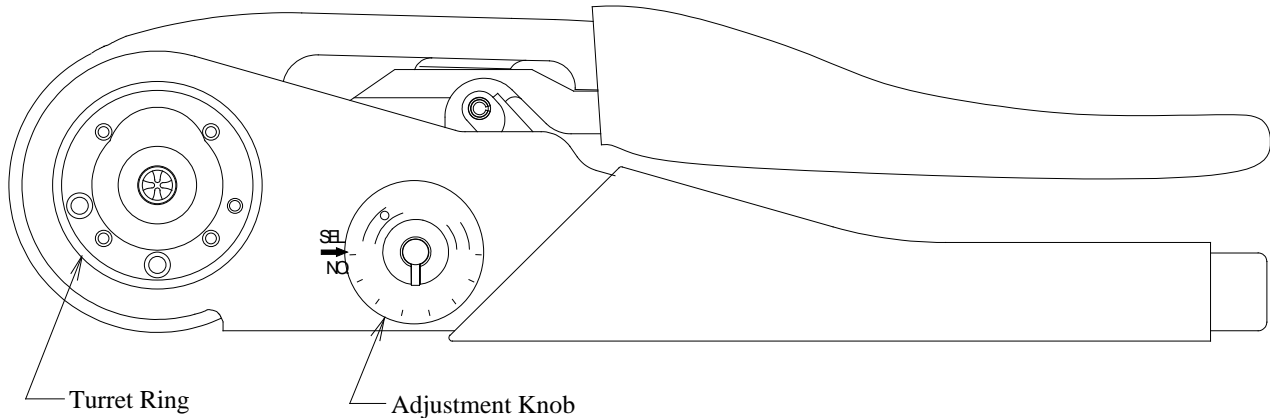




ASTRO TOOL CORP.

CONNECTOR ASSEMBLY TOOLING



TGV300 8-STEP ADJUSTABLE CRIMP TOOL

GENERAL

The Astro Tool TGV300 8-step crimp tool is a cycle controlled, precision crimp tool capable of crimping wire barrel sizes 12-8.

Observe the precision ratchet action by opening and closing the tool several times. Note that the tool cannot be opened without fully completing the crimp cycle. When held, the tool fits your hand for less fatiguing one hand operation.

BASIC TOOL OPERATION

NOTE: For proper crimping, the Basic Tool must be used with an appropriate Positioner.

1. Select the proper Positioner or Three Position Turret Assembly for the contact to be crimped.

2. Attach the head to the turret ring on the tool using the captive socket head cap screws. A 9/64 hex wrench is required. Verify that the guide pin is properly located prior to tightening the cap screws.

3. Consult the Data Plate for correct selector setting. Raise and rotate Adjustment Knob until the proper selector setting is lined up with the arrow on the Top Handle. Release the Adjustment Knob. The tool is now ready to crimp.

4. Insert the wire and contact through the Indenter Opening and into the Positioner Assembly. Squeeze the handles until the Tool comes to a positive stop. Release the handles and the tool will return to the full open position.

5. Remove the completed crimped assembly.

CAUTION:

Do not press down on the wire during the crimp cycle.

GAGING INSTRUCTIONS

Gaging the tool requires a .085 diameter GO pin and a .095 NO GO pin.

1. Set the tool to selector setting # 4.
2. Close the handles to the fully closed position.
3. Holding the tool closed, insert the GO pin into the indenter opening as shown, see figure # 1 The gage must pass freely between the indenter tips.
4. Holding the tool closed, insert the NO GO pin into the indenter opening. The gage pin must NOT go between the indenter tips.

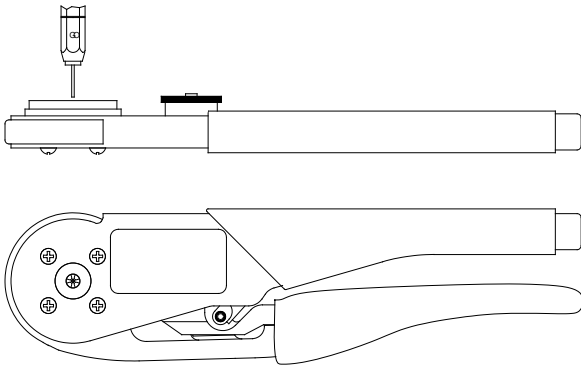


Figure # 1

CAUTION:
DO NOT CRIMP GAGE.
TOOL DAMAGE WILL RESULT.

GAGING INFORMATION

SELECTOR SETTING NUMBER	GO SIZE ± .0001	NO GO SIZE ±.0001
1	.0700	.0800
2	.0750	.0850
3	.0800	.0900
4	.0850	.0950
5	.0920	.1020
6	.0990	.1090
7	.1080	.1180
8	.1180	.1280

TOOL SERVICE

Astro Tool's TGV300 Crimp Tool is designed for long, reliable service. If the tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the tool to our factory.

Upon receipt of the tool, Astro will inspect and overhaul each tool to put the tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired. Please note that Astro's Quality Control system is traceable to The National Institute of Standards and Technology (N.I.S.T.).

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charge for such parts.

ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL, CRIMP TOOLS AND CONNECTOR SERVICE KITS

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