Contact Crimping
The crimping tools are only intended for contact crimping of COMBIFLEX pins and sockets. Leads with tinned strands must be used.

1) Strip the lead 10.5 mm +/- 0.5 mm
2) Fully open the pliers
3a) When crimping sockets; release the locking device on the locator and rest it against the flange
3b) When crimping pins; insert the pin against the flange
4) Insert the stripped end of the lead into the correct position
5) Hold the lead firmly and squeeze the plier handles until the release latch disengages
6a) When crimping sockets; remove the locking device on the locator and remove the connection
6b) When crimping pins; remove the connection from the pliers
7) Check the finished connection. Requirements on page 2 must be fulfilled for correct crimping.

Inspection
The pliers are checked by subjecting the lead and the attached socket/pin to a tensile test, and by means of preload and gauge testing.

Preload verification
1) Squeeze the plier handles together until the last ratchet releases (without pin or socket in place).
2) Read maximum force, F, about 40 mm from the top of the handles.
3) If necessary, adjust the preload (refer to “Adjustment of the preload”)

Gauge verification
1) Squeeze the crimping tool handles together until the last ratchet releases
2) Check with cylindrical “stop and go” gauges
3) If the stop gauge passes through, when the preload has been verified, the pliers have to be serviced

Adjustment of the preload
1) Remove the cover plate
2) Note the setting wheel position, and then remove it
3) Adjust the axel with a screw driver; turn counter-clockwise to tighten the preload
4) Replace the setting wheel, such that the pin locks the setting wheel. Replace the cover plate.
5) Verify the preload and make a testcrimping/tensile force test.

Correct tensile force, preload and gauge:

<table>
<thead>
<tr>
<th>Outlet</th>
<th>Conducting area (mm²)</th>
<th>Tensile force (N)</th>
<th>Preload F (N)</th>
<th>Gauge (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 A 0.25*</td>
<td>37.5</td>
<td>165-205</td>
<td>0.65/0.75</td>
<td></td>
</tr>
<tr>
<td>0.5</td>
<td>75</td>
<td>120-160</td>
<td>0.65/0.75</td>
<td></td>
</tr>
<tr>
<td>0.75</td>
<td>112</td>
<td>120-160</td>
<td>0.65/0.75</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>150</td>
<td>120-160</td>
<td>0.65/0.75</td>
<td></td>
</tr>
<tr>
<td>1.5</td>
<td>225</td>
<td>120-160</td>
<td>0.65/0.75</td>
<td></td>
</tr>
<tr>
<td>2.5</td>
<td>375</td>
<td>120-160</td>
<td>1.00/1.10</td>
<td></td>
</tr>
</tbody>
</table>

* The pliers are adjustable to 0.25 mm² for 10 A.

Changing to 0.25 mm²
1) Remove the cover plate
2) Remove the setting wheel
   (Refer to “Adjustment of the preload”, steps 3-5)
   Note: It is possible to use the crimping tool without the socket locking device on the locator

Maintenance
- For reliable contact crimping, make certain that all pins, joints, and bearing surfaces are clean and protected with a thin coat of oil
- The crimping tool should be adjusted when necessary, and be subjected to routine inspection twice/year. If the crimping tool is in continuous use, inspection should be more frequent
- When not in use, keep the pliers in the closed position

The crimping tool may be sent to ABB Network Partner AB for inspection and service.
A correct crimped pin/socket has to fulfil the following requirements:

- Crimped surface min. 1.5/min. 1
- Strands to be visible

The socket is to be crimped immediately over its joint.

Stop against flange
The locking device
Locator viewed from side
Locator

Crimped surface min. 1.5/min. 1
Strands to be visible

The socket is to be crimped immediately over its joint.

Position for crimping of 20 A pin/socket
Position for crimping of 10 A pin/socket
Figure with correct position of the insulation support of the socket
Ordering number
Serie number
Cover plate
Device for adjustment of the preload
Trigger device for the ratcher mechanism. (To be used when an already started crimping has to be interrupted)