

APPLICATION
Connectors
 AF / SF Explosionproof StarLine.
 QD / VS2 Industrial Series.

Contact Types
 MOD II and MOD III

Contact Sizes
 16 thru 4/0 AWG

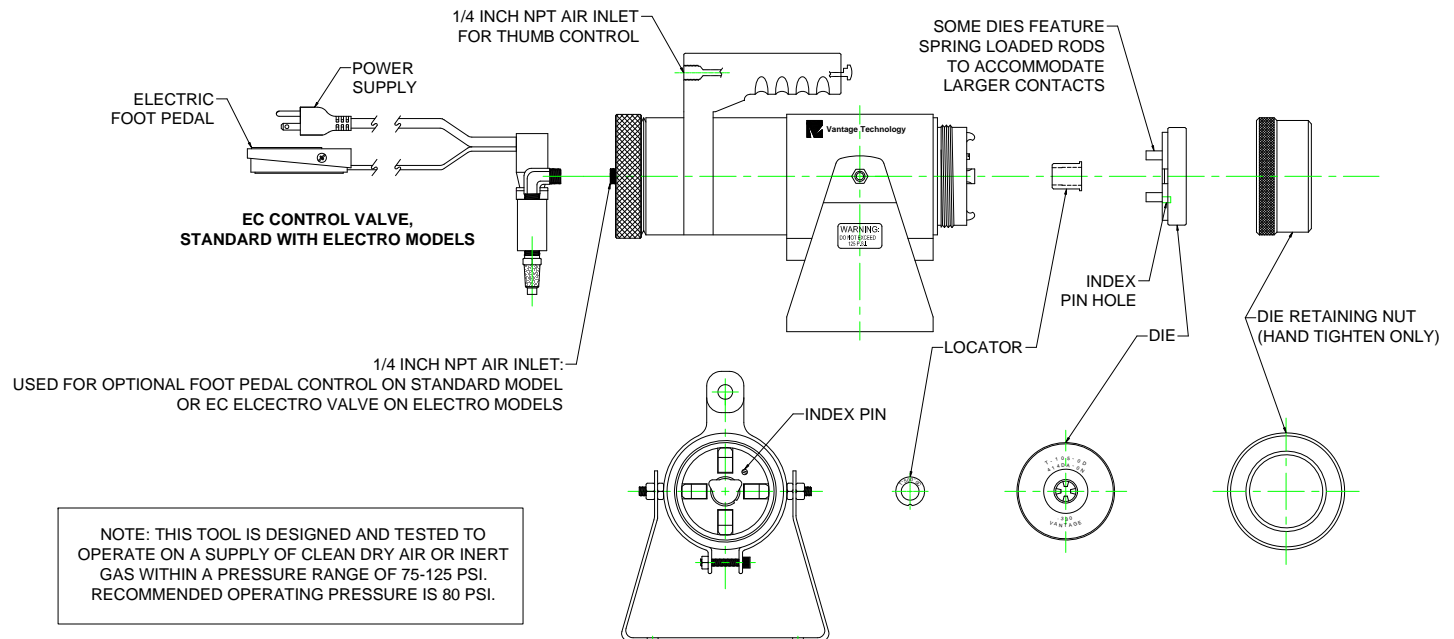
MODELS

T-105
 Standard tool with thumb control and optional foot pedal.

T-105E
 Electro tool with foot pedal. *The Electro models decrease cycle time from 8 sec/cycle for the standard model to 2.5 sec/cycle.*

T-105HE
 Heavy duty Electro tool with foot pedal. *The heavy duty feature assures extended maintenance free duty cycles particularly when used on large gauge contacts/wires.*

This full cycle crimp tool accurately positions four double indent crimps onto the contact using either a thumb-activated button or foot pedal. It is required when crimping 8 gauge or larger contacts for which hand tools are not available and to improve productivity for 10 gauge and smaller contacts. This bench mountable tool is powered by standard shop air supplies. For field terminations a portable tank of nitrogen or CO₂ can be used.



PART NUMBERS	Contact Size And Length	Wire Size	Die Number	Check Gage	Locator		Die Check Gage	Check Gage Dimensions (Inches)	
					MOD II	MOD III		Go	No-Go
	16 W	16 - 18	T-105-16D	T-105-16G	T-105-16L2	T-105-16L3	T-105-16G	.0550	.0620
	12 W 12 C	12 - 14	T-105-12D	T-105-12G	T-105-12L2 T-105-12CL2	T-105-12L3	T-105-12G	.0630	.0700
	10 W 10 C	10 - 12	T-105-10D	T-105-10G	T-105-10L2 T-105-10CL2	T-105-10L3	T-105-10G	.0850	.0920
	8 W 8 C	8 - 10	T-105-8D	T-105-8G	T-105-8L2 T-105-8CL2	T-105-8L3	T-105-8G	.1290	.1360
	4 W 4 C	4 - 6	T-105-4D	T-105-4G	T-105-4L2 T-105-4CL2	T-105-4L3	T-105-4G	.1950	.2020
	1/0	1/0 - 1	T-105-0D	T-105-0G	T-105-0L2	T-105-0L3	T-105-0G	.3250	.3320
	4/0	4/0 - 3/0	T-105-41D	T-105-41G	T-105-41L2	-	T-105-41G	.4250	.4320

USAGE INSTRUCTIONS

Air Supply.

Supply the tool with 70 to 125 (max) PSI (1-2 CFM) of clean dry air. Recommended air pressure is 80 PSI. Make certain the installation has a good regulator and filter installed within 25 feet of tool. Do not use oiler. A ¼ inch I.D. air hose is recommended. Use non-sealing pipe thread compound or Teflon tape on connections. Tighten connection to prevent leakage but do not over tighten.

Connections.

T-105. For thumb control, attach air supply to the ¼ inch NPT inlet port on the rear of handle. For optional foot control remove the ¼ inch NPT socket head plug from center or rear casing and re-install plug in rear of handle. Connect hose from foot pedal to tool. Connect air supply to the inlet port of foot pedal.

T-105E / HE. Connect power cord to 120V service. Connect ¼ inch air supply to port marked "IN" on EC control valve using threaded fitting or quick disconnect.

EC Valve Adjustment.

The Electro tool models are equipped with an adjustment valve to control the time the indentors remain fully closed, ideally 1 -2 seconds. To adjust, cycle tool by depressing foot pedal and note the length of time the indentors close. If less than one second, adjust tool. To **increase time** turn the time delay control screw (labeled "on time") Clockwise; to **decrease time** turn the time delay control screw Counterclockwise. Test tool after each adjustment until desired closure time is achieved.

Die and Locator Setup.

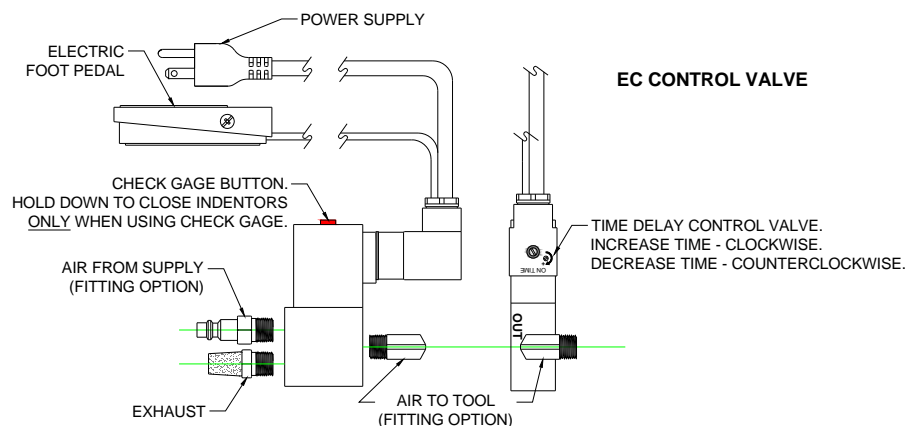
To install the locator and die assembly, unscrew the die retaining nut. Seat locator in tool such that its counter bore aligns with tool and lies flush. Install die by aligning tool's index pin with the corresponding hole in die such that the die sits flat on the tool's face. Replace retaining nut and hand tighten. Never crimp without the correct locator: contacts can fall into tool causing it to jam.

Calibrating Dies.

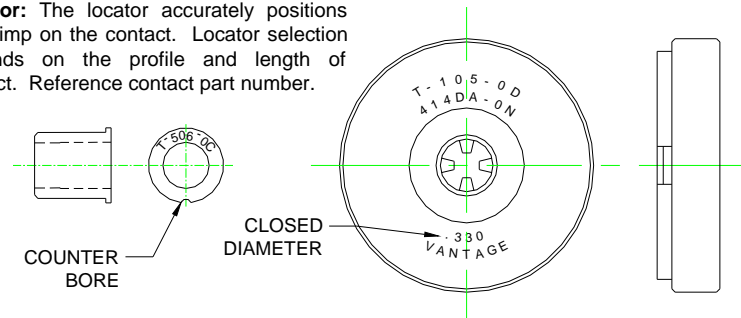
Periodically calibrate die. All dies are marked with their "closed" diameter. The "Go" pin is sized .005" under the die's diameter and the "No-Go" pin is sized .002" over the die's diameter. To calibrate, set up tool with die to be inspected. Cycle tool and check that indentors operate freely. Cycle tool again but hold the trigger or pedal down so that indentors remain closed for gaging. For the EC tool hold the red button down (do not depress foot pedal). Use corresponding check gage to test that the "Go" gage shall enter freely (snug fit is acceptable) and that the "No-Go" gage shall not enter. Do not crimp gage.

Crimping.

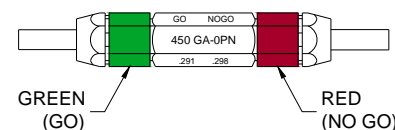
Turn on air supply and air pressure to approximately 80 PSI. Without a contact or wire, cycle tool several times with trigger to test that indentors operate freely. Insert contact loaded with wire and crimp. A full crimp cycle should take 1 to 3 seconds. Turn off air supply after each session.



Locator: The locator accurately positions the crimp on the contact. Locator selection depends on the profile and length of contact. Reference contact part number.



Dies: Dies have four indentors which make the crimp. Die selection must match the wire size. If ferrules are used, consider how ferrule affects the wire size.



Gages: All dies are marked with their "closed" diameter and should be periodically inspected with check gages to assure the contacts are crimped to specification. This eliminates "over" or "under" crimping. Go - No-go check gages are available for each die size to determine if calibration is required.