RCY21234

Manual Crimp Hand Tool
For Dubox Contacts AWG 22-30
User's Manual

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Föhrenbach®
Application Tooling

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1. Purpose

Crimping of Dubox AWG 22-30 loose piece contacts onto dedicated stranded wire.

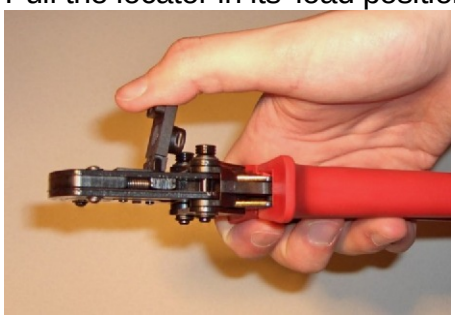
2. Tool description

- Cat. No.: RCY21234
- Single head crimp tool. The tool crimps one contact per cycle.
- The crimper is equipped with two crimp forms.
- Short set-up times.
- Releasable ratchet ensures the complete crimping process.
- Ergonomically handles for comfortable working.
- Optimal force transmission ratio.
- The tool head can be easily separated from the handles.
- The hand tool features a locator that keeps the contact in position during the entire crimp cycle.
- A spring loaded wire stop is integrated in the tool head.
- The tool kit consists of:
  - The hand tool
  - This user's manual

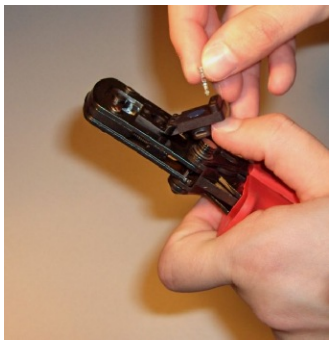
3. The process

Be sure that the crimp tool is open. If not, activate the levers of the tool till you observe the last 'click'. Further release the levers, the crimping die will open automatically.

Pull the locator in its 'load position'.



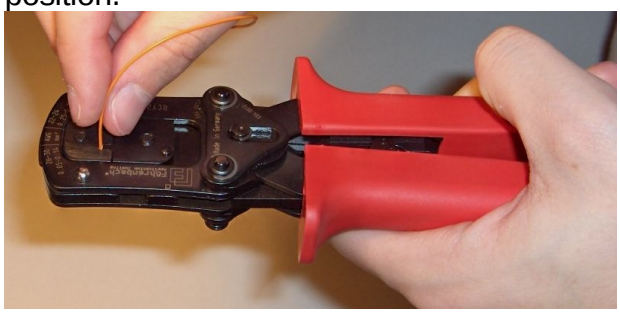
Introduce the contact. Push the contact till it reaches the hard stop.



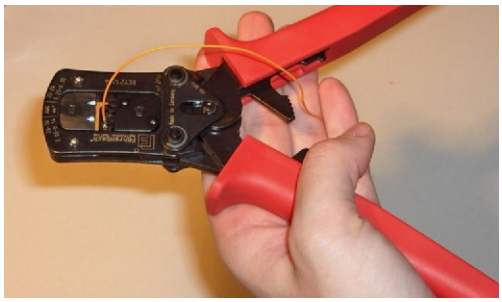
Push the locator towards the crimping die. A magnet will keep the locator in position.
Attention! This is only possible when the crimping die is open.

Close the hand tool till you observe the first 'click' of the ratchet. Introduce the stripped wire. Push the wire till it touches the wire stop. For obtaining the striping length, please refer to the contact application specification.

Keep the wire fixed in position and activate the levers till they reach the end position.



Release the levers and pull out the crimped contact.



4. Adjustments

- The tool is adjusted by Föhrenbach Application Tooling engineers. In order to maintain the performance of the tool, don't carry out any adjustments.

- For any support, please contact Föhrenbach Application Tooling:

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5. General specifications

- Colour : Black metal with red levers.
- Weight of tool : 240 g
- Weight of tool plus cardboard box : 250 g
- Size (cardboard box) : l: 215 mm x w: 75 mm x h: 25 mm

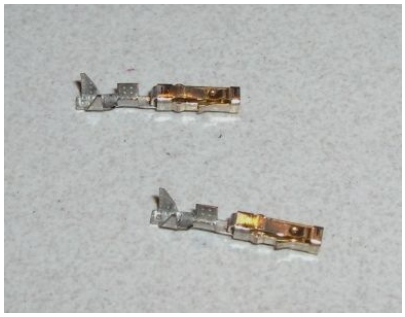
6. Input material and functional requirements

6.1. Wire

- Stranded wire dedicated for the mentioned contacts. AWG 22-30 (0.05 – 0.35 mm^2).

6.2. Components

- Dubox AWG 22-30 loose piece contacts. (Cat. Nr. 76347-x0x)



7. Process output

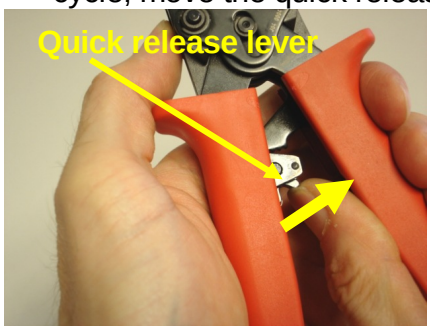
- Due to the manual process, the output capacity is highly depended on the skills of the operator.

8. Safety and ergonomics

- Apply the tool only for the target as mentioned in chapter 1. Purpose.
- For operator safety, it's necessary to apply eye protection.
- Apply the tool only in a dry and clean environment.
- Apply the tool only in a well lighted environment (1000 Lux).

- Only skilful operators who are trained by Föhrenbach Application Tooling engineers are allowed to apply the tool.

- In normal operation, the hand tool can only be opened after a complete closing cycle. In order to open the tool before completing the entire crimp cycle, move the quick release lever in the direction of the arrow.



9. Environmental conditions

9.1. Ambient temperature

The ambient temperature is measured at a height of 1.5 m above the floor.

a.	Normal range	: + 15 to +30°C
b.	Average value	: ± 23°C
c.	Maximum variation within a 5 min. period	: ± 5°C

9.2. Humidity

a.	Normal range (no condensation)	: 40 to 70% R.H.
b.	Range not resulting in constantly reduced operation	: 10 to 90% R.H.

9.3. Atmospheric pressure

Normal range: 533 - 1060 m bar.

10. Power connections

10.1. Electrical

No electrical supply required.

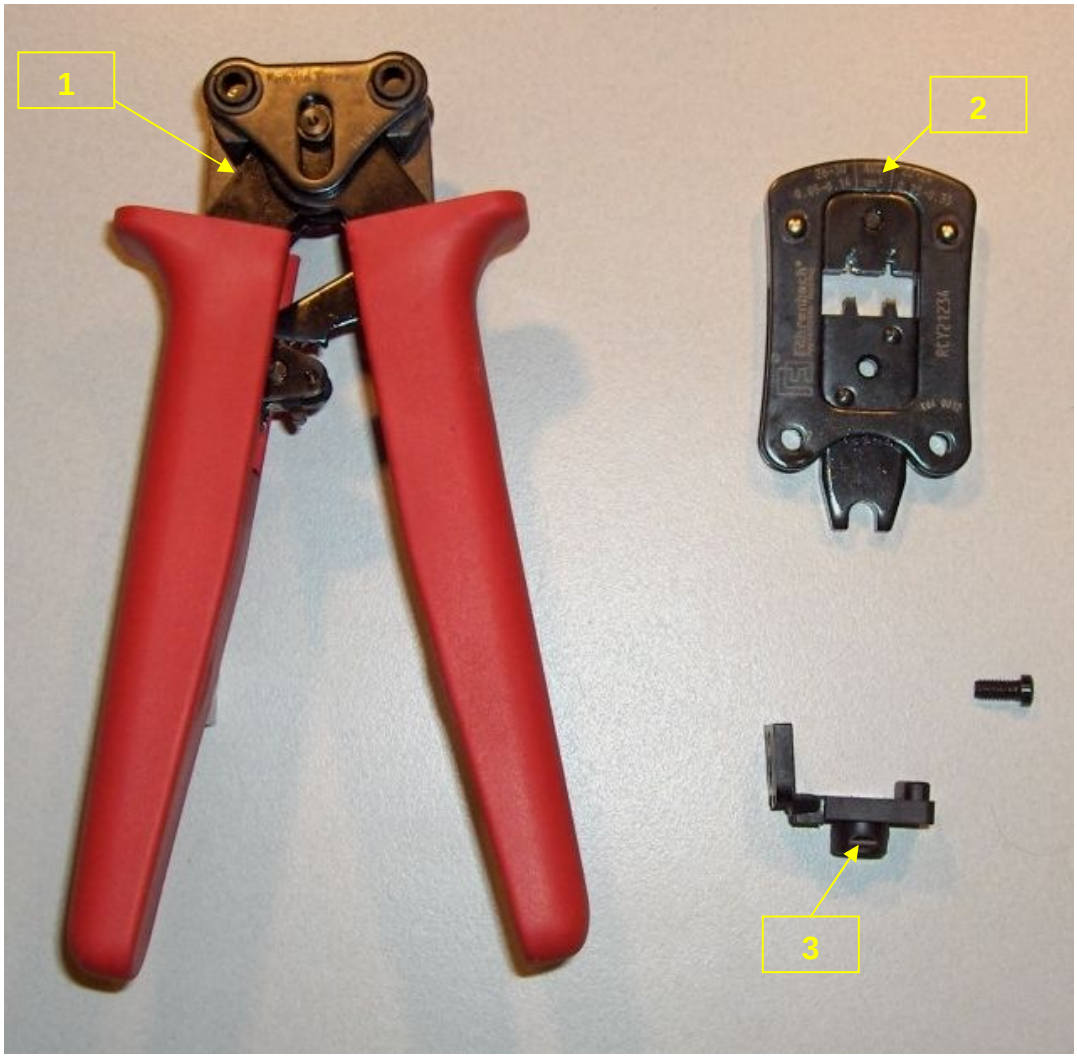
10.2. Pneumatic

No air supply required.

11. Warranty

Please refer to our Terms and Conditions of Sale.

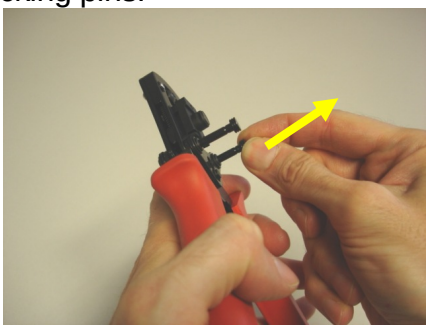
12. Spare parts



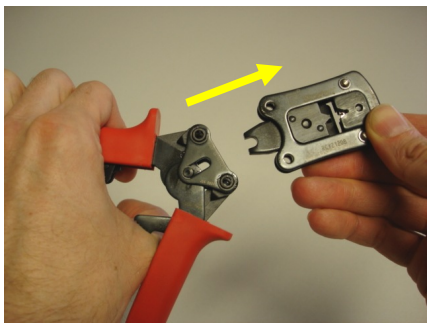
Item	Description	Cat. No.
1	Handle	RCY21000A1
2	Tooling head	RCY21234A1
3	Locator	RCY21234A2

Appendix A: Separate the tool head from the levers

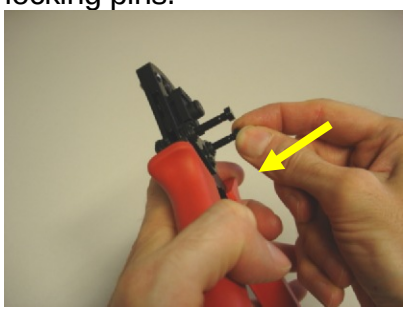
Open the tool and pull the two locking pins.



Lift the tool head. For re-installing, please do the opposite operation.

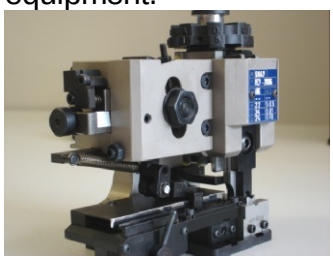


After a proper installation of the tool head, you can lock them by pushing the two locking pins.



Appendix B:

In order to apply the mentioned Dubox contacts, Föhrenbach Application Tooling provides also mini-applicators and other dedicated semi-automatic equipment.



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