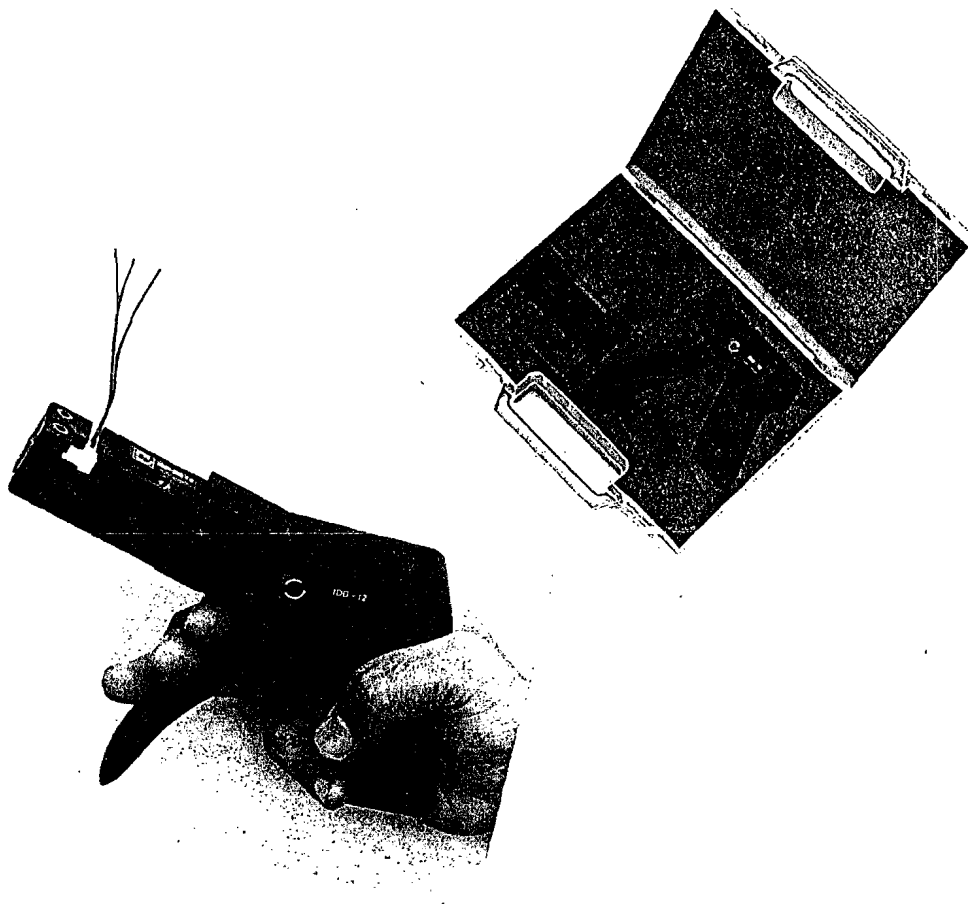


Operation Manual
for
IDB-12
(handy pitch-feed hand press for IDC)

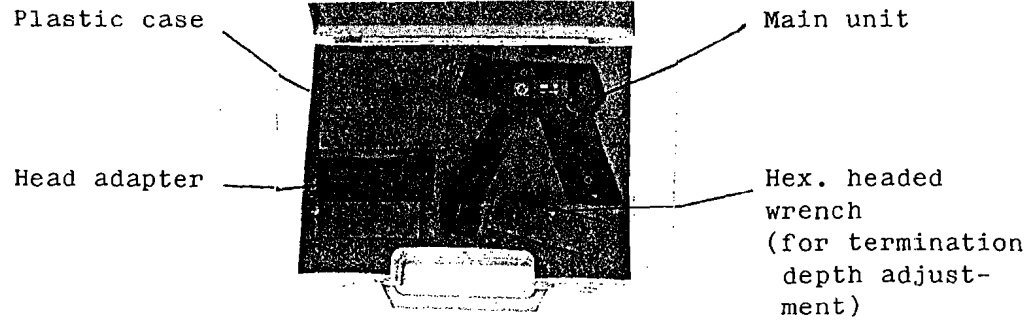
TE-4048



J. S. T.

1. Check of the kit

Confirm that the following items are in your kit.

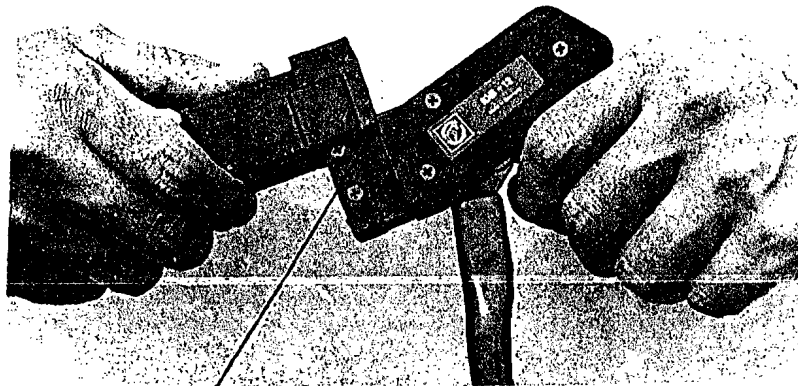


2. Assembly

Install the head adapter on the main unit. -

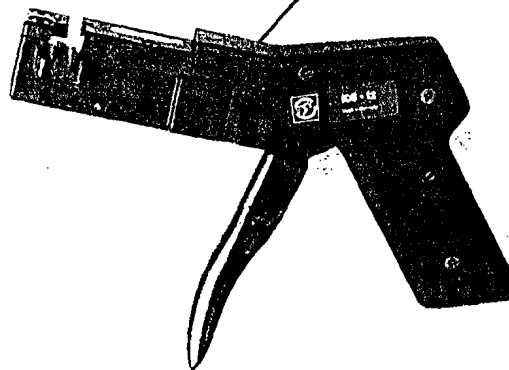
Slide the mating part of the head adapter into the mating part of the main unit for assembly.

Slide it out to reverse direction for disassembly.



Slide the mating part of the head adapter into the mating part of the main unit.

Assembled



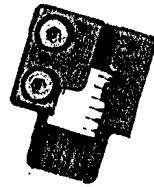
3. Operation Procedure

Step 1 : Insert a connector into the guide groove of the head adapter.

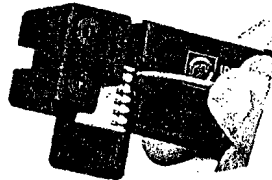
At this time, check that the connector sets its face correctly.



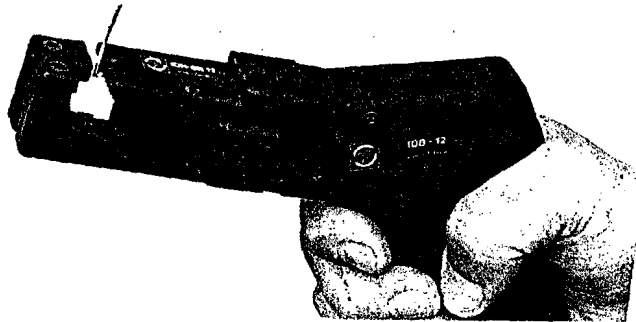
Step 2 : Feed the connector until its first U slot is in front of the wire insertion groove. The center of U slot and that of the groove must be in an alignment.



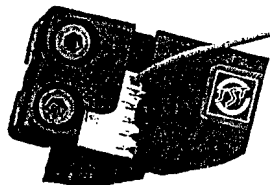
Step 3 : Insert a wire into the wire insertion groove.



Step 4 : Squeeze the trigger until the ratchet mechanism functions. Dies will come out to terminate the wire to the slot.

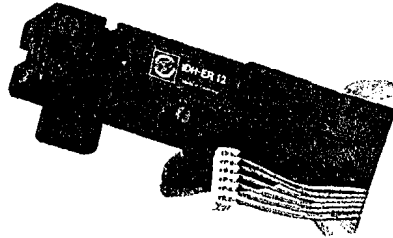


Step 5 : Now the trigger is in the original position. The connector is fed one pitch automatically and now the next U slot is facing the wire insertion groove.



Step 6 : Repeat Step 3 to Step 5 until wires are terminated to all of the U slots of the connector.

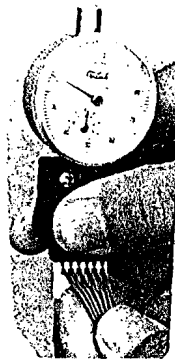
Step 7 : Extract the finished connector from the head adapter.



4. Termination depth adjustment

Check that the termination depth of the finished harness meets the requirements.

If not, adjust the tool according to the following procedure.



Step 1 : Take off the head adapter from the main unit.

Step 2 : Take the hex. headed wrench out of the plastic case.

Step 3 : Adjust the termination depth by tightening or loosening the termination adjustment screw with the hex. headed wrench.

Termination depth will get smaller when the screw is tightened(clockwise), and vice versa.



Termination adjustment screw

Step 4 : Install the adjusted head adapter on the main unit. Try a termination and check the termination depth again.

Repeat Step 1 to Step 4 until required termination depth can result.

5. Suggestions

- 1) Make use of the quality control manual for each connector to inspect and control the harnesses.
- 2) When you terminate a wire which is not prescribed in the QC manual, performance testing must be done.
Contact JST.