

## Instruction Sheet

### HAUPA Crimp System Pliers for Photovoltaics



**READ THESE INSTRUCTIONS COMPLETELY BEFORE USING THIS TOOL**

#### Instructions

#### Basic Safety Instructions

##### **CAUTION!**

This tool may be used only for the intended application and in strict compliance with all applicable safety rules, regulations and practices. It must be properly maintained, undamaged and in good working order. Unauthorized modification is prohibited and voids the manufacturer's warranty. Always wear safety glasses with side shields and other appropriate personal protective equipment.

**MISUSE MAY CAUSE PERSONAL INJURY.**

**KEEP OUT OF REACH OF CHILDREN!**

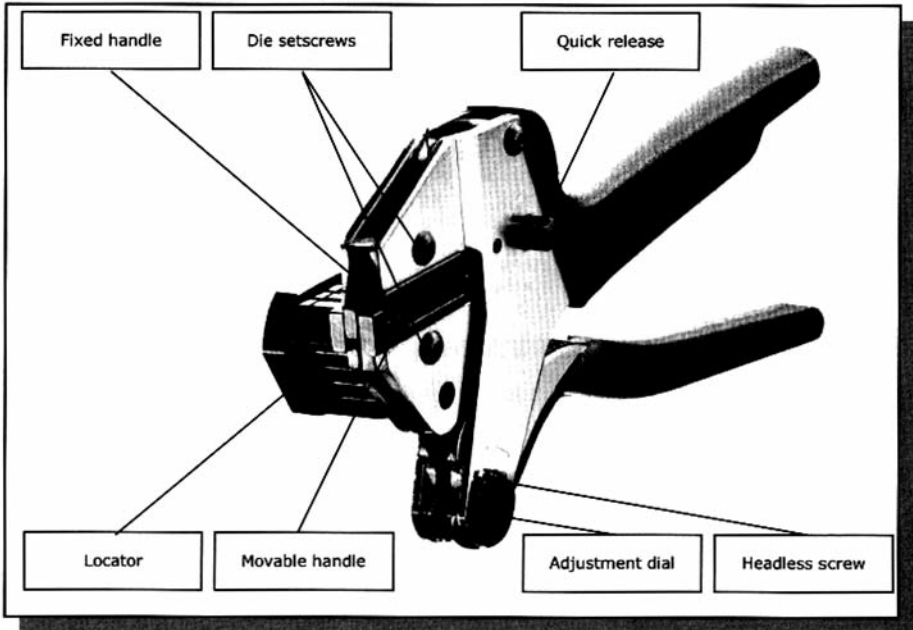
**NEVER INSERT FINGERS BETWEEN THE JAWS OF THE TOOL!**

#### Applications

The hand crimp tool (212200) has been developed for optimal crimping of a large variety of connectors and terminals by using different interchangeable crimping dies.

#### Description

The HAUPA Crimping System is comprised of the basic tool with adjustment dial and quick release, a set of dies, two setscrews for the dies and positioning feature. Positioning aids can be attached for the respective connector. The crimping force can be adjusted (refer to Adjustment of the Jaw Spread). The ratchet has six steps. It automatically opens after the sixth step has been passed (principle of compulsory completion). To prevent damage to the crimping die or connector, the built-in quick release enables the tool to be opened prematurely in the event of failed crimping.



## **Installation and Removal of Dies and Positioning Aid**

### **Installation and Removal of Dies**

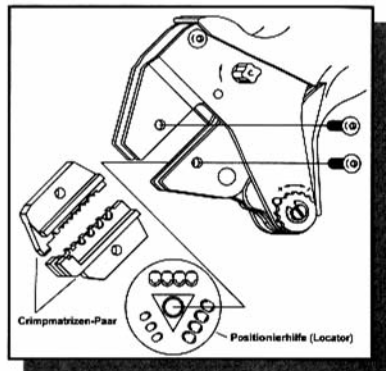
- ◆ Select the suitable die set.
- ◆ Open the tool.
- ◆ Loosen the die setscrew with an M4 Allen wrench.
- ◆ Remove the die set from the jaws, pulling it away from the tool and out of the jaws.
- ◆ Insert the new die set into the jaws, tighten them up enough so you can position the top and lower dies.

Secure the dies.

### **Installation and Removal of the Positioning Aid**

The HAUPA Crimping System can be fitted with a positioning aid when required.

Mounted on the side of the tool's jaws, the positioning aid can be loosened via Allen wrench or open-end socket wrench (positioning aid for open, non-insulated tab connectors) and turned clockwise by the die setscrew. Reverse the sequence to install.



### **Adjustment of the Jaw Spread**

HAUPA crimping strength is factory set. The hand force idle travel is 130 – 180 N. The tool and die set are designed to provide optimum crimping within this range. However, if the setting is not ideal for the connector manufacturer's specifications (opening and torque), one of the following problems could be the reason:

- a) Wear and tear due to excessive use of the tool → Adjustment of the crimping strength possible
- b) Worn dies → To avoid damage, the die set must be replaced

The crimping height (opening) should be regularly checked by qualified technical personnel and set as described in the following:



**CAUTION:** The following steps should only be performed by qualified technicians!

- (1) Loosen the headless screw **(A)** with a screwdriver.
- (2) Turn the dial counter **(B)** clockwise (+) to increase the crimping force. This also reduces the jaw spread.
- (3) Turn the dial clockwise (-) to reduce the strength of the crimping force. This also increases the jaw spread. Do not exceed 180 N.
- (4) After changing the setting, make sure the headless screw is adequately tightened.

### **Maintenance**

Before using the crimping tool, make sure it is in a clean and proper operating state. Always remove crimping residue. Protect the joints from soiling and apply light machine oil to them regularly. Check the bolts regularly to ensure that the lock washers and headless screw, securing the adjustment dial, are intact and tight. All other maintenance should be performed by the manufacturer.