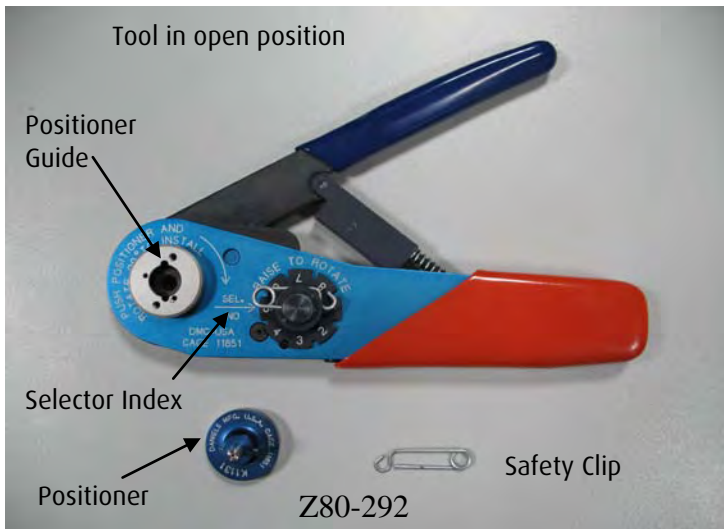


HAND CRIMP TOOLS Z80-292 & Z80-293 (MH800 & HX3-101)



These Hand Crimp Tools have been designed for use with the following Datamate Mix-Tek coax Crimp [when used with positioner Z80-291 & die set M22520/10-5 with cage 11851]:

- M80-305 to 307.....Straight female coax crimp contact
(Used in Mix-Tek female crimp connectors)
- M80-308 & 309... (Z80-293 only).....90° Female coax crimp contact.
(Used in Mix-Tek female crimp connectors)
- M80-315 to 317.....Straight male coax crimp contact.
(Used in Mix-Tek male crimp connectors)
- M80-318 & 319... (Z80-293 only).....90° male coax crimp contact.
(Used in Mix-Tek male crimp connectors)

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GENERAL INFORMATION

The Hand crimp tools Z80-292 & Z80-293 consist of a basic hand tool, which should be used with a positioner or die set.

The contact is correctly crimped when the tool is free to open at the fully closed position, i.e., when the ratchet releases. The tool cannot be opened without completing the cycle.

Table 1

Cable Type	Max. Insulation Diameter	Compatible contacts
RG 178	Ø2.0mm	M80-305, M80-308, M80-315, M80-318
PTFE cellular	Ø2.4mm	M80-306, M80-316
RG 174	Ø2.7mm	M80-307, M80-309, M80-317, M80-319
RG 179	Ø2.7mm	M80-307, M80-309, M80-317, M80-319
RG 316	Ø2.7mm	M80-307, M80-309, M80-317, M80-319

TOOL PREPARATION

Z80-292

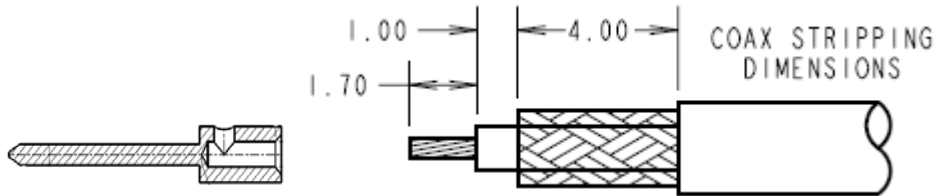
1. Check that the tool is in the open position. Remove the safety clip from the positioner guide (do not discard)
2. Insert the positioner (Z80-291) into the positioner guide and turn it 90° in the direction shown on the tool, until the bayonet pins lock.
3. Install the safety clip back into the positioner guide (optional).
4. Check Table 2 for the correct crimp tool setting of the wire size you wish to crimp.
5. Remove the safety clip from the selector knob (do not discard).
6. Lift and turn the selector knob until the correct crimp tool setting is lined up with the "Sel. No." arrow. Lower the selector knob, ensuring the locating peg lines up with a notch.
7. Install the safety clip back into the selector knob.

Z80-293

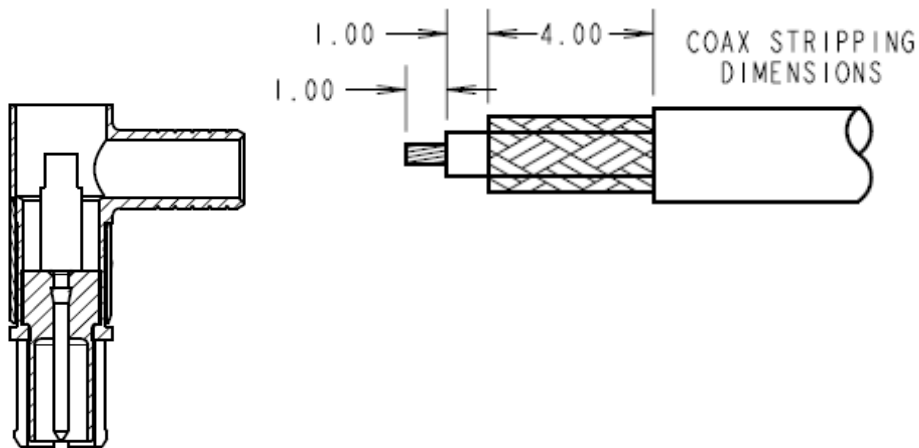
1. Align die rail slots in die halves (M22520/10-05, Cage 11851) with the rail in the crimp tool and push shank of dies into holes, dies will snap into place.
2. Close handle to make sure dies are properly seated.
3. The tool is now ready to use.

WIRE STRIPPING DETAILS

Straight coax connector Fig A



90° coax connector Fig B



CRIMPING PROCEDURE Z80-292

1. Ensure that the wire to be crimped is within the specified range of sizes for the contact and the crimp tool. Failure to use the specified wire size will result in poor quality crimps and possible tool damage.
2. See Figs. A & B for correct wire stripping dimensions for the appropriate contact. See also drawings M80-305 to 307 & M80-315 to 317 for cable diameter and type.
3. Place the prepared wire and contact into the positioner and squeeze the handles of the crimp tool fully together, until the ratchet releases. The handle will return to the open position. Remove the crimped contact and wire. Using the sight hole (Fig A) on the side wall of the contact, ensure that adequate insertion of strands into the crimp contact has been achieved.
4. For pull off forces for individual contacts see table 2.
5. Refer to component specification C005XX for details of coax assembly methods.

Table 2

Contact	Inner Contact	Crimp tool setting (inner contact only)	Min' Pull off force (Nm)
M80-305	M80-393	4	15
M80-306	M80-394	4	10
M80-307	M80-395	4	44
M80-315	M80-387	4	13
M80-316	M80-388	4	10
M80-317	M80-389	6	28

CRIMPING PROCEDURE Z80-293

1. Ensure that the wire to be crimped is within the specified range of sizes for the contact and the crimp tool (see table 1). Failure to use the specified wire size will result in poor quality crimps and possible tool damage.
2. See Figs. A & B for correct wire stripping dimensions for the appropriate contact. The straight coax contact (Fig A) will need to be crimped to the wire before insertion into outer contact. For the 90° coax contact (Fig B) the wire is inserted into the coax body and soldered before assembly, see component specification C005XX for further details of coax assembly methods.
3. Place contact with crimp sleeve in position into the smaller of the two hexes with the flat against the surface (the side with the manufacturers ID plate on), gently squeeze the handle until it will go no further the crimp is now complete, squeeze handle again to release completed crimp.
4. A correctly crimped contact & sleeve will achieve a pull off force of 30N minimum.

CARE OF TOOL

There is virtually no maintenance required for the Z80-292 & Z80-293 (M22520/10-05 & HX3-101) tools. However, it is good practice to keep the indenter tips free of residual colour band deposits and other debris. A small wire brush may be used for this purpose.

We strongly recommend that you:

1. **DO NOT** immerse tools in any cleaning solution.
2. **DO NOT** spray oil into tool to lubricate.
3. **DO NOT** attempt to disassemble tool or make repairs

This is a precision crimp tool and should be handled as such.