

customer manual

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Safeguards are designed into this application equipment to protect operators and maintenance personnel from most hazards during equipment operation. However, certain safety precautions must be taken by the operator and repair personnel to avoid personal injury, as well as damage to the equipment. For best results, application equipment must be operated in a dry, dust-free environment. Do not operate equipment in a gaseous or hazardous environment.



Always wear approved eye protection while operating the equipment.



Always wear approved hearing protection while using the equipment.



Do NOT operate the tooling if the guards are removed.



Read and understand the entire manual before using the equipment.



DANGER



ELECTRIC SHOCK HAZARD:
This tool is not insulated. When using this unit near energized electrical lines, use proper personal protective equipment.
Failure to observe this warning could result in severe injury or death.



CAUTION

- Do not place the tool in a vice. The crimping tool is designed for hand-held operation.
- Protect the crimping tool from rain and moisture. Water will damage the crimping tool and battery.

Failure to observe these precautions may result in injury or property



DANGER



Do not use hands to check for oil leaks. Highly pressurized oil will puncture the skin causing serious injury, gangrene, or death. If injured, seek medical help immediately to remove the oil.



CAUTION

Do not allow anything to contact the battery terminals.

- Do not immerse the batteries in liquid. Liquid may create a short circuit and damage the battery. IF the batteries are immersed, contact your service center for proper handling.
- Do NOT place the battery into a pocket, tool pouch or tool box with conductive objects. Conductive objects may create a short circuit and damage the battery.
- Do not place a battery on moist ground or grass. Moisture may create a short circuit and damage the battery.

Failure to observe these precautions may result in injury or property damage.



DANGER



Do not use solvents or flammable liquids to clean the crimping tool. Solvents or flammable liquids could ignite and cause serious injury or property damage.



CAUTION

- Do not store the battery at more than 60°C (140° F). Damage to the battery can result.
- Do not use another manufacturer's charger. Other manufacturer's chargers may overcharge and damage the battery.
- Do not attempt to open the battery. It contains no user-serviceable parts.

Failure to observe these precautions may result in injury or property damage.



DANGER

Do NOT dispose of batteries in a fire. They will vent fumes and will explode. Instead, dispose of batteries in an environmentally responsible manner. Or send the battery back to TE. Failure to heed these warnings could result in severe injury from harmful fumes or burns from flying debris.



CAUTION

Do not perform any service or maintenance other than described in this manual. Injury or damage to the tool may result.

Failure to observe this precaution may result in injury or property damage.



DANGER

Inspect the tool and dies before each use. Replace any worn or damaged parts. A damaged or improperly assembled tool can break and strike nearby personnel.

Failure to observe this warning could result in severe injury or death.

NOTE: Keep all decals clean and legible, and replace when necessary.

TOOLING ASSISTANCE CENTER

CALL TOLL FREE 1-800-722-1111 (CONTINENTAL UNITED STATES AND PUERTO RICO ONLY)

The **Tooling Assistance Center** offers a means of providing technical assistance when required.

In addition, Field Service Specialists are available to provide assistance in the adjustment or repair of the application equipment when problems arise which your maintenance personnel are unable to correct.

INFORMATION REQUIRED WHEN CONTACTING THE TOOLING ASSISTANCE CENTER

When calling the Tooling Assistance Center regarding service to equipment, it is suggested that a person familiar with the device be present with a copy of the manual (and drawings) to receive instructions. Many difficulties can be avoided in this manner.

When calling the Tooling Assistance Center, be ready with the following information:

1. Customer name
2. Customer address
3. Person to contact (name, title, telephone number, and extension)
4. Person calling
5. Equipment number (and serial number if applicable)
6. Product part number (and serial number if applicable)
7. Urgency of request
8. Nature of problem
9. Description of inoperative component(s)
10. Additional information/comments that may be helpful

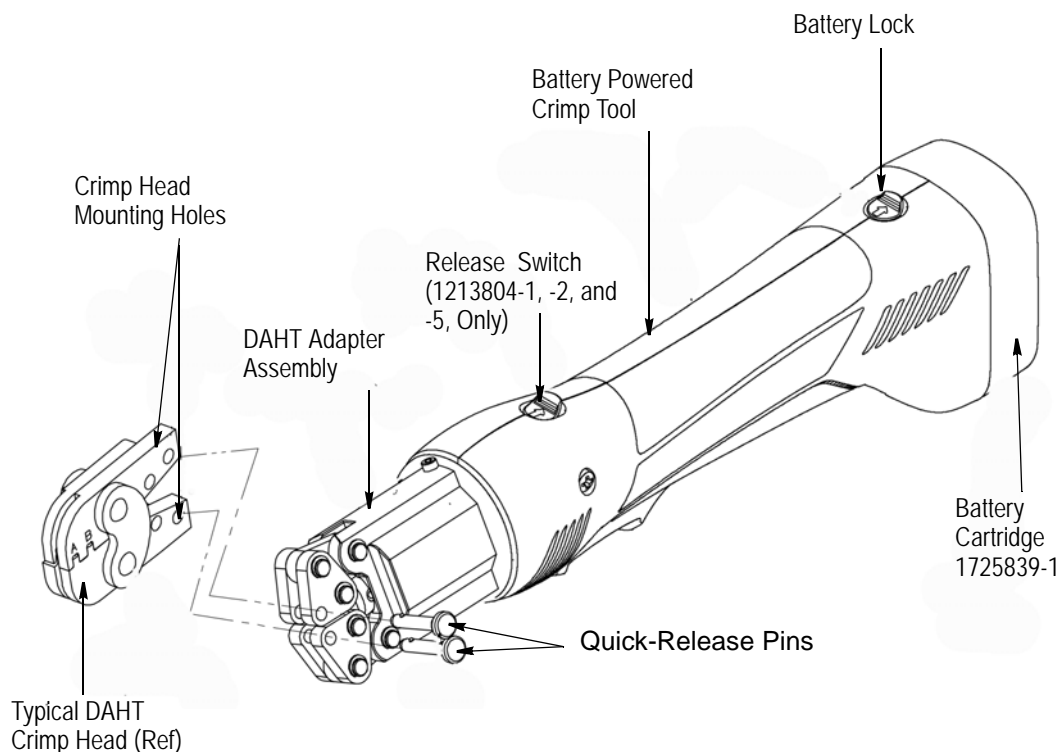


Figure 1

1. INTRODUCTION

The DAHT (Double Action Hand Tool) Battery Powered Crimp Tool Kit 1213804-[] is comprised of the battery crimp tool (with the DAHT Adapter installed), as well as two rechargeable battery cartridges (1725839-1) to power the tool. See Figure 1. Each kit has a battery charger.

The battery charger part number, its voltage, and the kit's region of use are listed in the table in Figure 2.

BATTERY TOOL KIT	REGION OF USE	BATTERY CHARGER	BATTERY CHARGER VOLTAGE	RAM RETRACT SWITCH
1213804-1	North America	1725840-1	110 V	Yes
1213804-2	Europe	1725840-2	220 V	Yes
1213804-3	North America	1725840-1	110 V	No
1213804-4	Europe	1725840-2	220 V	No
1213804-5	United Kingdom	1725840-3	220 V	Yes

Figure 2

A battery tool may have a release switch to retract the ram as listed in the table below. The DAHT Battery Powered Crimp Tool Kit is designed to accept the crimping head from any TE Connectivity Double Action Hand Tool to adapt the crimp head for use with the battery powered crimp tool. Double Action Hand Tools are sold separately and are available from TE. For crimp head information (including wire preparation, crimping procedures, maintenance and inspection procedures, as well as repair and replacement procedures) refer to the appropriate instruction sheet for the associated hand tool and crimping head.

Figure 3 contains the crimping tool specifications.

CRIMPING TOOL (With Battery Installed)	
Length	330 mm [13 in.]
Width	60 mm [2.362 (2 3/8) in.]
Depth	80 mm [3.149 (3 1/8) in.]
Mass/Weight (w/Battery)	1.3 kg [2.9 lb]
Sound Level	70 dBA at 1 meter
Vibration	< 2.5 m/s ²
Hydraulic Oil	Premium 15 Viscosity Grade Hydraulic Oil*
CRIMPING CAPACITIES	
Maximum Crimping Force	1.6 kN [1.75 tons]
Average Crimping Time	Two seconds
Average Crimps per Charge	Approximately 150
BATTERY	
Charging Voltage	9.6 V
Charging Time	40 min

Figure 3

When reading this manual, pay particular attention to **DANGER**, **CAUTION**, and **NOTE** statements.



DANGER

Denotes an imminent hazard which may result in moderate or severe injury.

* TE Engineering recommends Shell Tellus T 15. Shell Tellus is a trademark of Shell Oil.

**CAUTION**

Denotes a condition that may result in product or equipment damage.

**NOTE**

Highlights special or important information.

**NOTE**

Dimensions in this manual are in metric units [with U.S. customary units in brackets].

2. RECEIVING/INSPECTION

DAHT Battery Powered Crimp Tool Kit 1213804-[] is thoroughly inspected during and after assembly. Prior to packaging and shipping, a final series of tests and inspections is made to ensure proper function of the tool. The following inspection should be performed as a safeguard against potential problems generated in transit.

1. In a well-lighted area, carefully uncrate the tool kit and inspect each component as it is removed from the crate.
2. Thoroughly inspect each component for evidence of damage that may have occurred in transit. If any of the components are damaged, file a claim against the carrier and notify TE immediately.
3. Keep this manual and all drawings and product samples with the tool for the benefit of operation and maintenance personnel.

The crimp tool should be inspected at regularly scheduled intervals, depending on care, degree of operator skill, the type and size of product being crimped, and environmental conditions. At a minimum, the tool should be inspected after every 40 hours of use.

3. REMOVAL/INSTALLATION

**CAUTION**

Do not operate the tool without the DAHT adapter installed. Damage to the ram or seals can result.

**CAUTION**

Do not operate the tool without a crimp head installed. Damage to the adapter can result.

DAHT Battery Powered Crimp Tool Kit 1213804-[] comes with the hand DAHT adapter already installed on the battery powered hand tool. The only installation required is the installation of the crimp heads.

**DANGER**

To avoid personal injury, be sure to exercise extreme caution when handling the crimp tool. Remove the battery before installing or removing crimping heads.

3.1. Removal of the Crimp Heads

Remove the two retaining rings from one side of the crimp tool body and push the retaining pins, along with the two remaining retaining rings, through the opposite side of the tool body. See Figure 4.

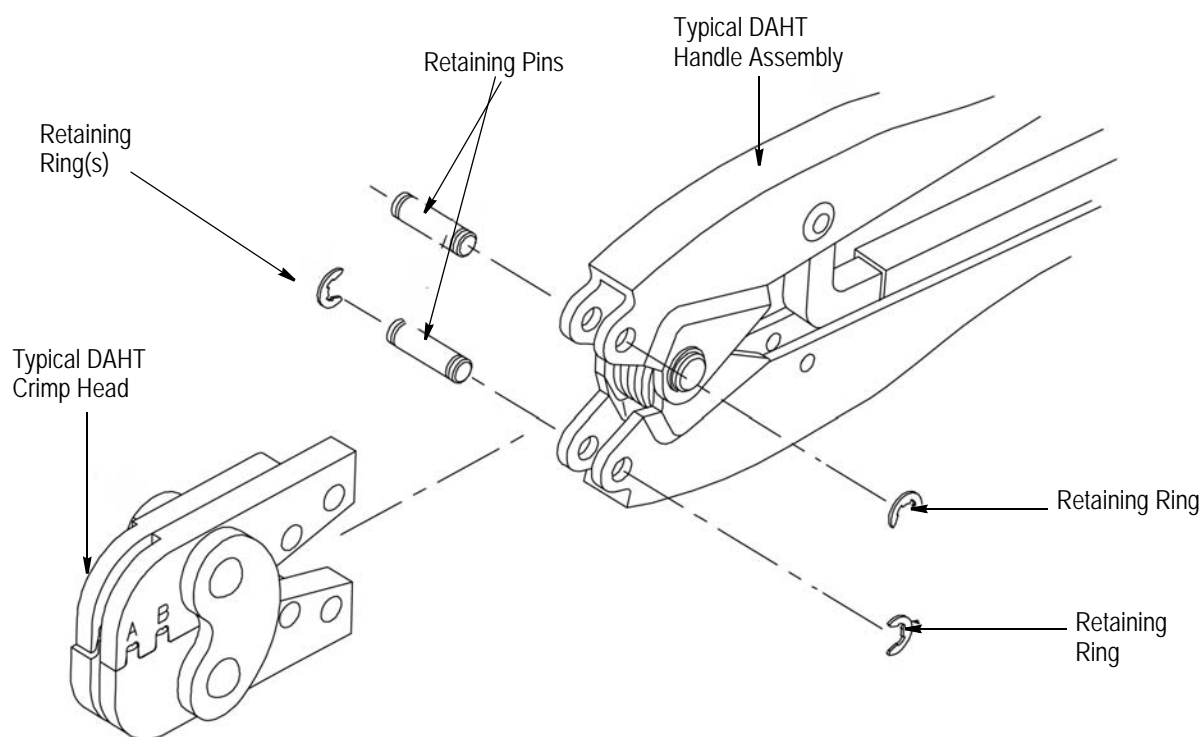


Figure 4

3.2. Installation of Crimp Heads into the DAHT Adapter

As supplied, the adapter has two quick-release pins installed (Figure 5). The pins will be used to secure the crimp head to the adapter.

These pins must be removed prior to installing the crimping head.

1. Remove the battery from the tool.
2. Remove the quick-release pins, described above.
3. Align the crimp head mounting holes with the quick-release pin holes, as shown in Figure 5.
4. Insert the quick-release pins through the two holes in the adapter, and through the holes in the crimp heads.



NOTE

The quick-release pins will "snap" into position when they are properly inserted.



DANGER

After the crimp head is installed, make sure the quick-release pins are fully inserted to avoid personal injury and damage to the tool.

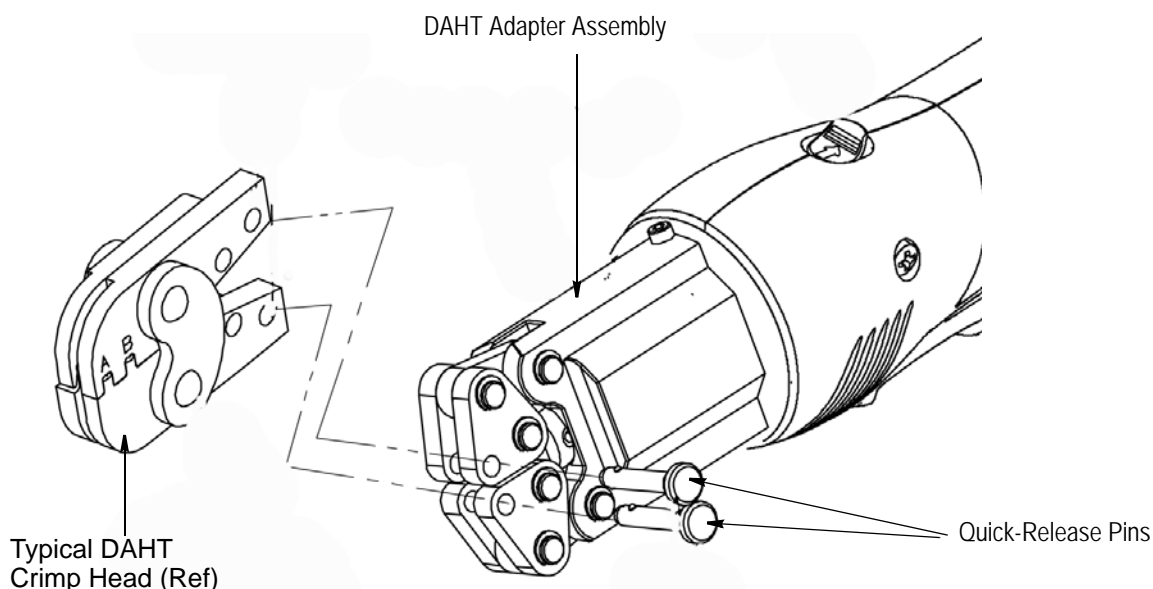


Figure 5

4. OPERATION

4.1. Battery Installation and Removal



NOTE

The Batteries Directive 2006/66/EC introduces new requirements from September 2008 on removability of batteries from waste equipment in EU Member States. To comply with this Directive, this device is designed to allow the rechargeable battery pack to be easily removed by the end-user when it needs to be replaced.

To install the battery, slide the battery into the bottom of the crimp tool until it can go no further. There will be an audible "click" of the battery lock to indicate that the battery has been properly installed.

To remove the battery, disengage the battery lock (see Figure 1) by applying pressure on the lock toward the bottom of the tool and slide the battery away from the tool.



DANGER

Always dispose of the old battery pack in an environmentally-responsible way, in accordance with local waste regulations. Where possible, please recycle the battery cartridge. Contact your local authority for details of battery recycling locations in your area.

4.2. Crimping

The following procedure provides only general information concerning crimping. Refer to the instructions packaged with the hand tool for detailed information, including wire stripping dimensions and instructions for positioning terminals and splices in the crimp heads.

To operate DAHT Battery Powered Crimp Tool 1213804-[]:



DANGER

To avoid personal injury, keep fingers clear of the crimping area.

1. Center the terminal or splice wire barrel in the appropriate crimp chamber.
2. Depress the trigger to advance the moving ram. This closes the crimp jaws in order to hold the terminal or splice in place. Do NOT deform the wire barrel.
3. Place a pre-stripped wire in the barrel, making sure the wire insulation does not enter the wire barrel.
4. Depress and hold the trigger to complete the crimp. The crimp tool returns automatically to the first position of its cycle when the crimp is complete.

**NOTE**

If it is necessary to retract the ram before a crimping cycle is completed, push the release switch. Pushing the release switch will result in the complete retraction of the ram. Only kits 1213804-1, -2, and -5 have a ratchet release switch.

**CAUTION**

This tool is not designed for continuous operation. After 100 cycles, allow the crimp tool to cool for 15 minutes.

5. PREVENTIVE MAINTENANCE

5.1. Daily Maintenance

Perform the following maintenance on a daily basis:

1. Inspect the crimp head and adapter assembly for wear or damage such as cracks, gouges, or chips.
2. Inspect the tool for damage or leaks. If damage is detected, return the tool to TE for repair.
3. Clean the tool, removing accumulations of dirt and grease on the adapter, particularly in areas where heads are installed and terminals are crimped. Wipe the entire tool frequently with a clean, lint-free cloth. Do NOT use objects that could damage the tool.
4. Make sure that the retaining pins are in place and that they are secured with retaining rings.

5.2. Yearly Maintenance

Once a year, or every 10,000 cycles (whichever comes first) the DAHT Battery Powered Crimp Tool should be returned to TE for inspection.

5.3. Lubrication

Lubricate all pins, pivot points, and bearing surfaces with a high quality grease. TE recommends the use of MolyKote* paste, which is a commercially available lubricant.

Lubricate the DAHT adapter according to the following schedule:

- Adapter used in daily production should be lubricated daily;
- Adapter used occasionally in daily production should be lubricated weekly;
- Adapter used weekly should be lubricated monthly.

6. SPARE PARTS

- Battery: 1725839-1
- Charger: 1725840-1 (120 V, US), 1725840-2 (220 V, EU), 1725840-3 (220 V, UK)

7. TROUBLESHOOTING

Prior to beginning troubleshooting procedures, be sure the battery is operational.

1. Be sure that the battery is charged. Recheck the battery after several minutes to ensure that the battery is holding its charge.
2. Use a nonflammable contact cleaner or pencil eraser to clean the the electrical contacts on the battery and crimp tool.
3. Reinstall the battery and check the crimp tool again.

Refer to Figure 6.*

*Molycote is a trademark of Dow Corning.

PROBLEM	PROBABLE CAUSE	REMEDY
Tool is inoperative.	Dirt, contaminants, etc in ram area of tool.	Return to TE.
	Crimp tool battery contacts damaged.	Reform contacts.
	Tool components are worn or damaged.	Return tool to TE.
Dies stop during operation.	Oil level is low.	Return tool to TE.
	Air in hydraulic system.	Pull the trigger and hold the retract button simultaneously. Hold for approximately 10 seconds.
Crimp tool loses oil.	Damaged Internal seal	Return tool to TE.

Figure 6

8. RETURN

Order replacement parts through your TE Representative, or call 1-800-526-5142; or send a facsimile of your purchase order to 1-717-986-7605; or write to:

CUSTOMER SERVICE (38-35)

TYCO ELECTRONICS CORPORATION

PO BOX 3608

HARRISBURG, PA 17105-3608

9. REVISION SUMMARY

- Added Figure 5
- Corrected text in Section 1, INTRODUCTION
- Removed "Figure 3" from TROUBLESHOOTING section.
- Added decimal numbers to Figure 3.

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