

Owner's Manual **Hand Crimping Tool PEW15**



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Rennsteig Werkzeuge

An der Koppel 1
98547 Viernau/Thüringen, Germany
Telephone +49 3 68 47 / 4 41-0
Fax +49 3 68 47 / 4 41-14
E-Mail info@rennsteig.com

www.rennsteig.com

1. General Information

The Hand Crimping Tool PEW15 is manufactured by using the latest technology and the generally accepted safety regulations. The tool may only be used in proper working condition with all safety and hazard regulations in mind and should only be used for the purpose for which it is intended for and described in this manual.

Attention

Any unauthorized modification or improper use of the Hand Crimping Tool excludes the manufacturer from any liabilities from damages resulting from this. Only work on disconnected cables and connectors!

2. Intended Use

- For crimping of stamped/rolled male and female contacts (with and without a seal) up to a diameter of 10mm²
- The use of exchangeable crimping dies allows for a broad range of applications.

3. Description

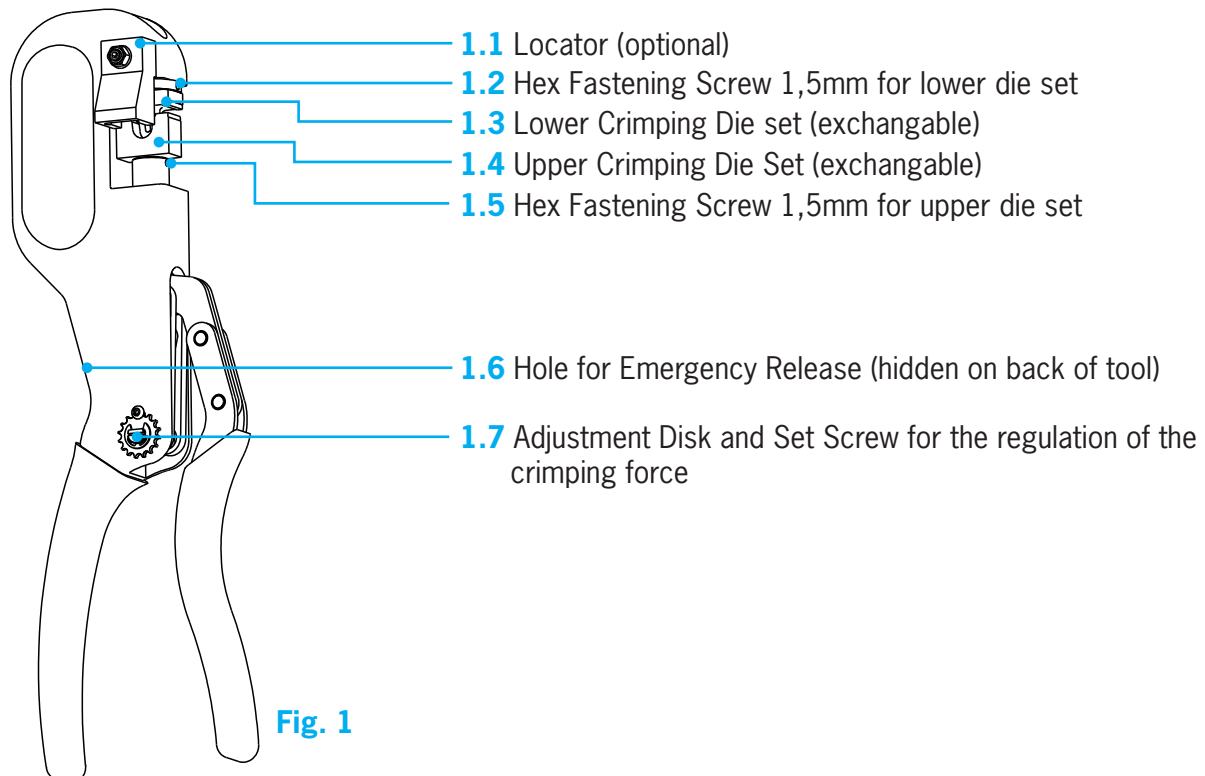


Fig. 1

4. Functional Operation / Crimping Process

1. Verify if connector, crimping die and cable diameter match in capacity values.
2. Open the tool: Press the tool handles together up to the stop. The forced lock is released and the tool may now be opened.
3. Place connector into the crimping die set, possibly with the use of a locator.
4. Close the tool up to the first ratcheting notch (one click); connector is locked in tight.
5. Place stripped cable (depending if the connector is crimped with or without seal) into the locked in connector (see also [figure 2](#)).
6. Press tool handles together completely until the locking mechanism (forced lock) opens.
7. Open the tool and remove crimped connector (the flexible tool handle must be moved manually); no spring reset)

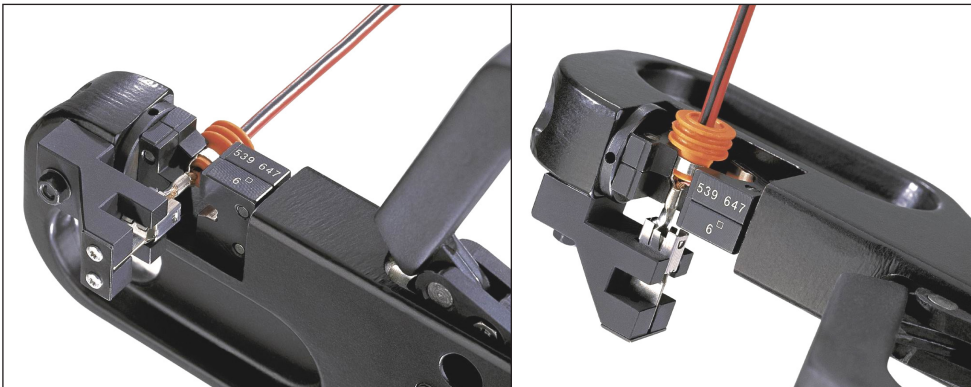


Fig. 2

5. Exchange of Crimping Dies

The crimping dies of Hand Crimping Tool PEW15 can be exchanged depending on the application and is done as follows:

1. Remove locator by loosening the fastening nut with a wrench SW8 (Schlüsselweite= Wrench Size).
2. Remove crimping die set by closing the tool handles; use an Allen wrench 1,5mm and loosen the hex screws of the upper and the lower crimping die. Then open the handles and remove the crimping dies.
3. Place the new crimping die into the marked bore holes.
4. Close the tool handles and secure the hex screws of the crimping dies with an Allen wrench 1,5mm.
5. Attach the optional locator onto the threaded bolt and fasten the nut with a wrench SW8.

6. Emergency Release of Forced Lock

The forced lock will open automatically after the crimping process is completed. In order to avoid any damage to the crimping dies or the connector, the tool may be opened prematurely through the emergency release feature before a crimping error can occur. Place an appropriate tool (i.e. screw driver) carefully into the hole on the back of the tool (see also **figure 3**) and push against the locking pawl and keep pressed down. The tool handles can now be opened by moving the flexible handle of the tool.



Fig. 3

7. Setting the Crimp Height

Attention

The crimp height should be checked regularly and maybe adjusted by technical Quality Control personnel and is performed as described below.

The crimping force is set at the manufacturer. The crimping die set and the tool are coordinated with each other that an optimal crimping result is achieved. Should the crimping results not meet the required specification of the contact manufacturer (crimping height, Pull-out Force), the following errors may have occurred:

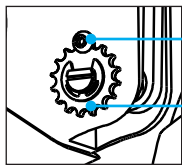
Error	Possible Cause	Solution
Crimping results do not meet the required specification of the contact manufacturer	Wrong crimping die set	Install the correct application-related crimping die set and crimp with the correct die set.
	Wrong cable	Use only cable as recommended by the contact manufacturer.
	Application-related wear and tear of the tool	Re-adjustment of crimping force (as described below).
	Worn out crimping die set	Exchange crimping dies to avoid any damages.

The adjustment of the crimping force is done as follows:

1. Open crimping tool.
2. Remove hex screws **(4.1)** with an Allen wrench 2,0mm.
3. Turn the adjustment disk **(4.2)** with a screw driver **counterclockwise**: a higher crimping force and therefore a lower crimping height is achieved.
4. Turn the adjustment disk **(4.2)** with a screw driver **clockwise**: a lower crimping force and therefore a higher crimping height is achieved.
5. Secure hex screw **(4.1)** with an Allen wrench 2,0mm.

Attention

Please ensure that the hex screws are tightened securely prior to using the tool.



4.1 Hex Screw 2,0mm

4.2 Adjustment Disk

Fig. 4

8. Warranty

RENNSTEIG- Products are thoroughly checked by the Quality Control Department. The general terms and conditions apply.

9. Maintenance and Service

The Hand Crimping Tool must be in clean and proper working conditions prior to usage. Crimping residue needs to be removed. The joints need to be oiled regularly with light machine oil and need to be protected from dirt. Please ensure that all screws are secured by retaining rings. The tightness of the hex screws of the adjustment disk needs to be checked. All repairs are carried out by the tool manufacturer only.