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Operating instructions for Order No. RC-Z2504 4-arbor crimping pliers for machined contacts

General information

The RC-Z2504 4-arbor crimping pliers are for crimping the machined crimp contacts from Coninvers with conductor cross sections of 0.08 - 2.5 mm² as in the adjacent list. The settings for the crimping pliers have been calculated on the basis of the withdrawal forces given in DIN EN 60352-2 and by using a reference conductor. **Depending on the conductor used, the crimping pliers settings required may differ from the values given in the settings chart.**

Procedure

- Please refer to the enclosed settings chart for the crimp arbor and locator settings for the contact to be crimped.
- **Loosen the clamping screw (manufacturing state).**
- Set the crimping dimensions (crimping depth of the crimp arbors) using the adjustment mechanism.
- Lift the locator at the side to set it to the position defined in the chart. Insert the crimp contact as far as it will go into the recess provided and close the pliers in the first engagement position.
- Insert the prepared cable as far as it will go into the crimp contact in the pliers and close the pliers in the last engagement position.
- Remove the crimped contact from the pliers.

Setting crimping dimensions

The crimping dimensions (crimping depth of the crimp arbors) are set using the adjustment mechanism.
Depth settings clockwise (to reduce the crimping dimensions) / counter-clockwise (to increase the crimping dimensions).

Checking the crimping dimensions

The 4-arbor crimping pliers have factory default settings. We recommend, however, that you carry out a check of the crimping dimensions from time to time. This can be carried out as described below using the Ø 1.0 mm test pin included with the pliers: Use the adjustment knob to set the scale on the fixed pliers handle to 1.0 mm. Set the scale on the adjustment knob to zero and close the pliers (see section on setting crimping dimensions). In this setting, it must be possible to move the Ø 1.0 mm test pin with clearance fit.

If this is not the case, the deviation from the required dimensions (+/-) can be determined using the fine adjustment on the adjustment knob.

If the crimping dimension check shows that the pliers are outside the accepted tolerance of the contact manufacturer, please contact the manufacturer of the pliers to have them checked.

Service and maintenance

The manual crimping pliers must be clean and in good condition before starting work. Any residue from the crimping process must be removed from the crimping jaws and locator. The joints must be lubricated regularly with a light machine oil and protected against dirt. Please ensure that all bolts are secured with circlips. **Repairs to the 4-arbor crimping pliers may only be carried out by the manufacturer.**



Settings chart for Coninvers crimp contacts 4-arbor crimping pliers RC-Z2504

Order No. Contact	Plug-in Ø [mm]		Cross section mm ²	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Setting parameters	
	Pin	Socket					Locator	Crimping arbor setting [mm]
RC-11P2000	1		0.08	14.8	0.6	4	1	0.65
RC-11P2000	1		0.14	14.8	0.6	4	1	0.67
RC-11P2000	1		0.22	14.8	0.6	4	1	0.69
RC-11S2000		1	0.08	14.3	0.6	4	2	0.65
RC-11S2000		1	0.14	14.3	0.6	4	2	0.67
RC-11S2000		1	0.22	14.3	0.6	4	2	0.69
RC-12P2000	1		0.14	14.8	1.1	4	1	0.63
RC-12P2000	1		0.22	14.8	1.1	4	1	0.65
RC-12P2000	1		0.38	14.8	1.1	4	1	0.67
RC-12P2000	1		0.56	14.8	1.1	4	1	0.69
RC-12S2000		1	0.14	14.3	1.1	4	2	0.63
RC-12S2000		1	0.22	14.3	1.1	4	2	0.65
RC-12S2000		1	0.38	14.3	1.1	4	2	0.67
RC-12S2000		1	0.56	14.3	1.1	4	2	0.69
RC-1BP2000	1		0.75	14.8	1.7	4	1	0.85
RC-1BP2000	1		1.00	14.8	1.7	4	1	0.90
RC-1BS2000		1	0.75	14.3	1.7	4	2	0.85
RC-1BS2000		1	1.00	14.3	1.7	4	2	0.90
RC-1KP2000	1		0.50	14.8	1.5	4	1	0.75
RC-1KP2000	1		0.75	14.8	1.5	4	1	0.80
RC-1KS2000		1	0.50	14.3	1.5	4	2	0.75
RC-1KS2000		1	0.75	14.3	1.5	4	2	0.80
RC-43P2000	1		0.14	21.4	0.9	6	3	0.62
RC-43P2000	1		0.22	21.4	0.9	6	3	0.65
RC-43P2000	1		0.38	21.4	0.9	6	3	0.67
RC-46P2000	1		0.14	21.4	1.1	6	3	0.65
RC-46P2000	1		0.25	21.4	1.1	6	3	0.67
RC-46P2000	1		0.35	21.4	1.1	6	3	0.69
RC-46P2000	1		0.50	21.4	1.1	6	3	0.71
RC-47P2000	1		0.75	21.4	1.7	6	3	0.85
RC-47P2000	1		1.00	21.4	1.7	6	3	0.88
RC-4DP2000	1		0.50	21.4	1.4	6	3	0.85
RC-4DP2000	1		0.75	21.4	1.4	6	3	0.88
RC-58P2000	1		0.50	14.8	1.5	4	1	0.75
RC-58P2000	1		0.75	14.8	1.5	4	1	0.80
RC-58S2000		1	0.50	14.3	1.5	4	2	0.75
RC-58S2000		1	0.75	14.3	1.5	4	2	0.80
RC-59P2000	2		0.75	14.8	1.7	4	4	0.85
RC-59P2000	2		1.00	14.8	1.7	4	4	0.88
RC-59S2000		2	0.75	14.3	1.7	4	5	0.85
RC-59S2000		2	1.00	14.3	1.7	4	5	0.88
RC-5AP2000	2		1.50	14.8	2.4	4	4	0.85
RC-5AP2000	2		2.50	14.8	2.4	4	4	1.05

Depending on the conductor used, the crimping pliers settings required may differ from the values given in the settings chart.

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Settings chart for Coninvers crimp contacts
4-arbor crimping pliers RC-Z2504 (Continued)

Order No. Contact	Plug-in Ø [mm]		Cross section [mm²]	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Setting parameters	
	Pin	Socket					Locator	Crimping arbor setting [mm]
RC-5AS2000		2	1.50	14.3	2.4	4	5	0.92
RC-5AS2000		2	2.50	14.3	2.4	4	5	1.03
RC-5CP2000	2		1.00	14.8	2.0	4	4	1.00
RC-5CP2000	2		1.50	14.8	2.0	4	4	1.07
RC-5CS2000		2	1.00	14.3	2.0	4	5	0.97
RC-5CS2000		2	1.50	14.3	2.0	4	5	1.02
RC-5NP2000	2		1.00	16.3	2.0	4	9	1.00
RC-5NP2000	2		1.50	16.3	2.0	4	9	1.07
RC-5PP2000	2		1.50	16.3	2.4	4	9	0.85
RC-5PP2000	2		2.50	16.3	2.4	4	9	1.05
RC-5QP2000	2		0.75	16.3	1.7	4	9	0.85
RC-5QP2000	2		1.00	16.3	1.7	4	9	0.88
RC-5SP2000	2		0.50	14.8	1.4	4	5	0.93
RC-5SP2000	2		0.75	14.8	1.4	4	5	0.96
RC-5SS2000		2	0.50	14.3	1.4	4	5	0.86
RC-5SS2000		2	0.75	14.3	1.4	4	5	0.88
RC-67P2000	1		0.75	24.3	1.7	6	6	0.85
RC-67P2000	1		1.00	24.3	1.7	6	6	0.88
RC-67S2000		1	0.75	16.5	1.7	6	7	0.85
RC-67S2000		1	1.00	16.5	1.7	6	7	0.88
RC-6EP2000	1.5		0.75	24.3	1.7	6	8	0.85
RC-6EP2000	1.5		1.00	24.3	1.7	6	8	0.88
RC-6ES2000		1.5	0.75	16.6	1.7	6	9	0.85
RC-6ES2000		1.5	1.00	16.6	1.7	6	9	0.88
RC-6FP2000	1.5		0.75	26	1.7	6	9	0.85
RC-6FP2000	1.5		1.00	26	1.7	6	9	0.88
RC-6FS2000		1.5	0.75	16.6	1.7	6	9	0.85
RC-6FS2000		1.5	1.00	16.6	1.7	6	9	0.88
RC-6HP2000	1.5		0.08	24.3	0.6	6	8	0.69
RC-6HP2000	1.5		0.14	24.3	0.6	6	8	0.74
RC-6HP2000	1.5		0.22	24.3	0.6	6	8	0.78
RC-6HS2000		1.5	0.08	16.6	0.6	6	9	0.69
RC-6HS2000		1.5	0.14	16.6	0.6	6	9	0.74
RC-6HS2000		1.5	0.22	16.6	0.6	6	9	0.78
RC-6KP2000	1		0.14	24.3	1.4	6	6	0.60
RC-6KP2000	1		0.25	24.3	1.4	6	6	0.70
RC-6KP2000	1		0.34	24.3	1.4	6	6	0.75
RC-6KP2000	1		0.50	24.3	1.4	6	6	0.80
RC-6KP2000	1		0.75	24.3	1.4	6	6	0.83
RC-6KP2000	1		1.00	24.3	1.4	6	6	0.88
RC-6KS2000		1	0.14	16.5	1.4	6	7	0.60
RC-6KS2000		1	0.25	16.5	1.4	6	7	0.70
RC-6KS2000		1	0.34	16.5	1.4	6	7	0.75
RC-6KS2000		1	0.50	16.5	1.4	6	7	0.80
RC-6KS2000		1	0.75	16.5	1.4	6	7	0.83
RC-6KS2000		1	1.00	16.5	1.4	6	7	0.88
RC-6LP2000	1		0.25	24.3	1.1	6	6	0.72
RC-6LP2000	1		0.38	24.3	1.1	6	6	0.75
RC-6LP2000	1		0.50	24.3	1.1	6	6	0.77

Settings chart for Coninvers crimp contacts
4-arbor crimping pliers RC-Z2504 (Continued)

Order No. Contact	Plug-in Ø [mm]		Cross section [mm²]	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Setting parameters	
	Pin	Socket					Locator	Crimping arbor setting [mm]
RC-6LS2000		1	0.25	16.5	1.1	6	7	0.72
RC-6LS2000		1	0.38	16.5	1.1	6	7	0.75
RC-6LS2000		1	0.50	16.5	1.1	6	7	0.77
RC-6MP2000	1		0.75	25.8	1.7	6	9	0.85
RC-6MP2000	1		1.00	25.8	1.7	6	9	0.88
RC-6MS2000		1	0.75	16.5	1.7	6	7	0.85
RC-6MS2000		1	1.00	16.5	1.7	6	7	0.88
RC-6RP2000	1		0.08	24.3	0.6	6	6	0.69
RC-6RP2000	1		0.14	24.3	0.6	6	6	0.74
RC-6RP2000	1		0.22	24.3	0.6	6	6	0.78
RC-6RS2000		1	0.08	16.5	0.6	6	7	0.69
RC-6RS2000		1	0.14	16.5	0.6	6	7	0.74
RC-6RS2000		1	0.22	16.5	0.6	6	7	0.78
SC-79P2000	2		0.75	27	1.7	6	10	1.00
SC-79P2000	2		1.00	27	1.7	6	10	1.03
SC-7AP2000	2		2.00	27	2.7	6	10	1.10
SC-7AP2000	2		2.50	27	2.7	6	10	1.20
SC-7CP2000	2		1.00	27	2.0	6	10	0.90
SC-7CP2000	2		1.50	27	2.0	6	10	1.00
SC-7GP2000	2		1.50	27	2.2	6	10	1.00
SC-7GP2000	2		2.00	27	2.2	6	10	1.10
SC-7SP2000	2		0.50	27	1.4	6	10	0.80
SC-7SP2000	2		0.75	27	1.4	6	10	0.83
SC-7UP2000	2		0.50	27	1.4	6	10	0.80
SC-7UP2000	2		0.75	27	1.4	6	10	0.83
SC-7VP2000	2		2.00	27	2.7	6	10	1.10
SC-7VP2000	2		2.50	27	2.7	6	10	1.20
SC-7XP2000	2		1.00	27	2.0	6	10	1.05
SC-7XP2000	2		1.50	27	2.0	6	10	1.10
SI-7JS2000		2	1.50	16.5	2.4	6	11	0.95
SI-7JS2000		2	2.00	16.5	2.4	6	11	1.10
SI-7JS2000		2	2.50	16.5	2.4	6	11	1.25
SI-7UP2000	2		0.50	29	1.4	6	12	0.73
SI-7UP2000	2		0.75	29	1.4	6	12	0.76
SI-7US2000		2	0.50	16.5	1.4	6	11	0.73
SI-7US2000		2	0.75	16.5	1.4	6	11	0.76
SI-7WP2000	2		0.75	29	1.7	6	12	0.85
SI-7WP2000	2		1.00	29	1.7	6	12	0.88
SI-7WS2000		2	0.75	16.5	1.7	6	11	0.85
SI-7WS2000		2	1.00	16.5	1.7	6	11	0.89
SI-7XP2000	2		1.00	29	2.0	6	12	1.05
SI-7XP2000	2		1.50	29	2.0	6	12	1.10
SI-7XS2000		2	1.00	16.5	2.0	6	11	0.90
SI-7XS2000		2	1.50	16.5	2.0	6	11	0.95

Depending on the conductor used, the crimping pliers settings required may differ from the values given in the settings chart.