

Operating instructions Article No. SF-Z0014 Pneumatic crimping tool for machined contacts

General

The pneumatic crimping tool SF-Z0014 is used for crimping the machined Coninvers crimp contacts as in the adjacent list. The settings of the crimping pliers have been calculated on the basis of the withdrawal forces stated in DIN EN 60352-2 and by using a reference conductor. **Depending on the conductor used, the required settings of the crimping pliers can differ from the values stated.**

Compressed-air supply

- Operation of the pneumatic crimping pliers requires a supply of compressed air at 5.5 to 8.3 bar. We recommend using filtered and oiled compressed air (filtered oil without additives, viscosity SAE 10 or less, 1 to 3 drops per minute).

Setting the crimping parameters

- The crimping head must be secured on the crimping pliers.
- Use the corresponding positioner with **D**, **E** or **F** marking for the contact to be crimped (see table below and setting matrix). See setting matrix for setting parameters for positioner and eccentric.
- The eccentric setting (crimping depth of the crimp arbors) is performed by pulling out and turning the red adjustment knob on the front, and read on the scale situated at the side. **As the setting scale cannot be read with sufficient precision, we recommend using dimensionally accurate testing pins for exact setting (see setting parameters eccentric [mm]).** To do this, set the red adjustment knob such that the testing pin can be moved between the crimp arbors without play. **Caution: Do not crimp the testing pins.**
- Insert crimp contact into the crimping recess as far as it will go. The crimp contact is positioned precisely using the positioner.
- Insert the prepared cable into the crimp contact on the pliers as far as it will go and operate the release lever. Following crimping, the release lever automatically returns to its original position.
- Remove the crimped contact from the pliers.



Maintenance and repair

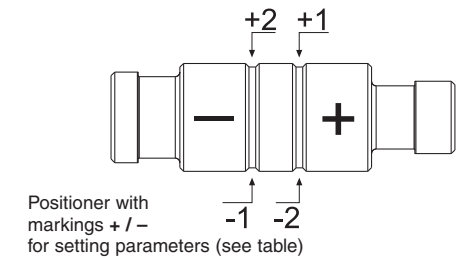
The crimping pliers must be clean and in good order prior to starting work. Crimping residue must be removed from the crimping jaws, the crimping head and the positioner. The joints must be lubricated regularly with a light machine oil and protected against dirt. Please ensure that all bolts are secured with circlips. **As a fundamental rule, repair work on the crimping pliers must only be carried out by the manufacturer.**

Art.-No.	Description
SF-Z0014	Crimping tool pneumatic for machined crimp contacts, conductor cross section 4 to 10 mm ²
SF-Z0003	Crimping head for crimping tool SF-Z0014
SF-Z0011	Positioner for panel mounting connectors ConPower P30 / P70, marked with "D"
SF-Z0012	Positioner for cable connectors and cable connecting receptacles ConPower P30, marked with "E"
SF-Z0013	Positioner for cable connectors and cable connecting receptacles ConPower P70, marked with "F"

Settings for ConPower P30 / P70 power connectors

Use of the positioner: Find the setting parameters in the table. The data corresponds to the marking +/- as well as the stop position on the positioner. Insert the + or - side into the crimping head. The indicated number describes the first (1) or the second (2) stop position.

Do not fully insert the positioner into the crimping head.



Setting matrix for ConPower P30 (M23 SF series) panel mounting connectors, male crimp contacts

Type No. Contact	Plug-in Ø [mm]		Cross section [mm ²]	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Type No. Positioner	Setting parameters	
	Pin	Socket						Positioner	Eccentric [mm]
SF-7MP2000	2		4.0	25.2	2.85	8	SF-Z0011	+1	1.67

Setting matrix for ConPower P30 (M23 SF series) cable connectors/cable connecting receptacles, female/male crimp contacts

Type No. Contact	Plug-in Ø [mm]		Cross section [mm ²]	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Type No. Positioner	Setting parameters	
	Pin	Socket						Positioner	Eccentric [mm]
SF-7MP2000	2		4.0	25.2	2.85	8	SF-Z0012	-2	1.67
SF-7MS2000		2	4.0	25.5	4.5	8	SF-Z0012	-2	1.67

Setting matrix for ConPower P70 (M40 SM series) panel mounting connectors, male crimp contacts

Type No. Contact	Plug-in Ø [mm]		Cross section [mm ²]	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Type No. Positioner	Setting parameters	
	Pin	Socket						Positioner	Eccentric [mm]
SF-7MP2000	2		4.0	25.2	2.85	8	SF-Z0011	+1	1.67
SM-36KP002	3.6		4.0	35.8	2.85	7	SF-Z0011	-1	2.15
SM-36KP003	3.6		4.0	35.8	3.6	12	SF-Z0011	-1	2.15
SM-36KP003	3.6		6.0	35.8	3.6	12	SF-Z0011	-1	2.25
SM-36KP004	3.6		6.0	35.8	4.5	12	SF-Z0011	-1	2.67
SM-36KP004	3.6		10.0	35.8	4.5	12	SF-Z0011	-1	3.00

Setting matrix for ConPower P70 (M40 SM series) cable connectors/cable connecting receptacles, female/male crimp contacts

Type No. Contact	Plug-in Ø [mm]		Cross section [mm ²]	Total length [mm]	Conductor insert Ø [mm]	Stripping length [mm]	Type No. Positioner	Setting parameters	
	Pin	Socket						Positioner	Eccentric [mm]
SF-7MS2000		2	4.0	25.5	4.5	8	SF-Z0013	+2	1.67
SM-20KP008	2		4.0	37.4	4.5	8	SF-Z0013	+2	1.67
SM-36KS002		3.6	4.0	36.95	4.5	10	SF-Z0013	-2	2.15
SM-36KS003		3.6	4.0	36.95	5.4	10	SF-Z0013	-2	2.15
SM-36KS003		3.6	6.0	36.95	5.4	10	SF-Z0013	-2	2.25
SM-36KS004		3.6	6.0	36.95	6.4	10	SF-Z0013	-2	2.67
SM-36KS004		3.6	10.0	36.95	6.4	10	SF-Z0013	-2	3.00
SM-36KP006	3.6		4.0	49.7	4.5	10	SF-Z0013	-2	2.15
SM-36KP007	3.6		6.0	49.7	6.4	10	SF-Z0013	-2	2.67
SM-36KP007	3.6		10.0	49.7	6.4	10	SF-Z0013	-2	3.00
SM-36KP008	3.6		4.0	49.7	5.4	10	SF-Z0013	-2	2.15
SM-36KP008	3.6		6.0	49.7	5.4	10	SF-Z0013	-2	2.25