

Operating instructions for Order No. SF-Z0054 4-arbor crimping pliers with digital display for machined contacts

General information

The SF-Z0054 4-arbor crimping pliers are for crimping the machined crimp contacts from Coninvers 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

- **To switch on:** Press the "ON" button or turn the adjustment knob. The standard display appears in mm.
- **Power saving function:** If after a period of 1 min. there has been no change in the display or if no button has been pressed, the digital display switches off automatically.
- **Mode function:** The "MODE" button is used to select the display functions in mm or in inches, or the selector positions from 1-8 in acc. with MIL 22520. Use the enclosed gauge to press the sunken "MODE" button as often as necessary to select the desired display:



Setting the crimping parameters

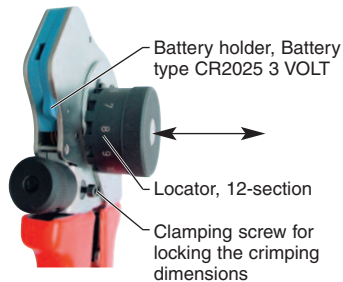
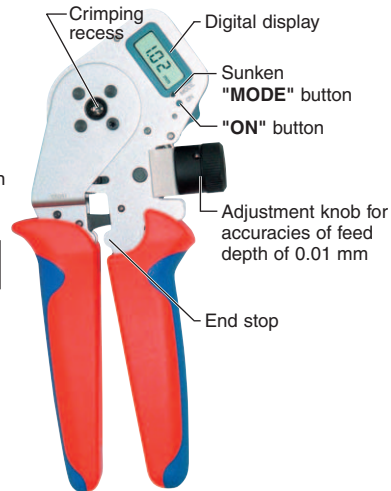
- Please refer to the enclosed settings chart for the crimp arbor and locator settings for the contact to be crimped.
- **Loosen the clamping screw (manufacturing state).**
- The crimping dimensions (crimping depth of the crimp arbors) are set by turning the adjustment knob until the digital display shows the required value. Depth settings clockwise reduce the crimping dimensions, while counter-clockwise increases the crimping dimensions.
- Lock the crimping dimensions using the clamping screw.
- 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. The locator moves the crimp contact to the exact position.
- Insert the prepared cable as far as it will go into the crimp contact in the pliers and close the pliers tightly.
- Remove the crimped contact from the pliers.

Changing the battery

The service life of the battery for the digital display is approximately one year, depending on how often it is used. To change the battery (type CR2025, 3 VOLT), the battery holder is pulled out so that the battery can be removed. **After changing the battery, it is necessary to perform a reset and adjust the pliers accordingly.**

Service and maintenance

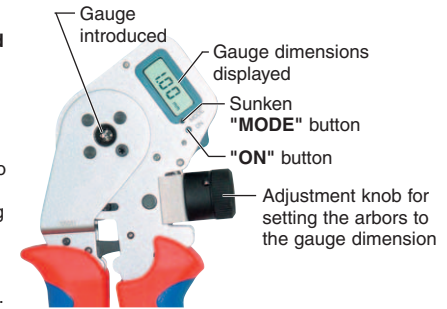
The manual crimping pliers must be clean and in good condition before starting work. Any residue from the crimping process must be removed from the crimping jaws and locator. The joints must be lubricated regularly with a light machine oil and protected against dirt. Please ensure that all bolts are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



Adjusting pliers/Reset

The crimping pliers may only be adjusted by authorized trained personnel since improper adjustment can lead to incorrect crimping.

- Using the adjustment knob, set the crimp arbors so that the enclosed gauge can move between the crimp arbors without play. Please note that a larger gauge dimension must always be selected than that to be set, e.g. select 1.4 mm and adjust down to gauge dimension 1.0 mm. **Caution: Do not crimp the gauge.**
- Keep the "ON" button pressed and press the "MODE" button using the gauge. Keep the "MODE" pressed for at least 4 seconds.
- Release the "MODE" button after 4 seconds and then the "ON" button
- The digital display automatically jumps to the gauge value 1.0 mm. The pliers are adjusted and ready for the crimping parameters to be set.



Crimping tool settings see reverse side

Settings chart for Coninvers crimp contacts
4-arbor crimping pliers Order No. SF-Z0054

Contact Type	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]
SF-6AP2000	1		0.14	20.8	2.0	4.5	1	0.60
SF-6AP2000	1		0.25	20.8	2.0	4.5	1	0.65
SF-6AP2000	1		0.35	20.8	2.0	4.5	1	0.70
SF-6AP2000	1		0.50	20.8	2.0	4.5	1	0.78
SF-6AP2000	1		0.75	20.8	2.0	4.5	1	0.90
SF-6AP2000	1		1.00	20.8	2.0	4.5	1	1.00
SF-6AS2000		1	0.25	14.2	2.0	4.5	3	0.65
SF-6AS2000		1	0.35	14.2	2.0	4.5	3	0.70
SF-6AS2000		1	0.50	14.2	2.0	4.5	3	0.78
SF-6AS2000		1	0.75	14.2	2.0	4.5	3	0.90
SF-6AS2000		1	1.00	14.2	2.0	4.5	3	1.00
SF-6CP2000	1		0.08	20.8	1.6	4.5	1	0.55
SF-6CP2000	1		0.14	20.8	1.6	4.5	1	0.60
SF-6CP2000	1		0.25	20.8	1.6	4.5	1	0.65
SF-6CS2000		1	0.08	14.2	1.6	4.5	3	0.55
SF-6CS2000		1	0.14	14.2	1.6	4.5	3	0.60
SF-6CS2000		1	0.25	14.2	1.6	4.5	3	0.65
SF-10KP004	1		0.14	20.8	1.8	4.5	1	0.70
SF-10KP004	1		0.25	20.8	1.8	4.5	1	0.75
SF-10KP004	1		0.35	20.8	1.8	4.5	1	0.80
SF-10KP004	1		0.50	20.8	1.8	4.5	1	0.88
SF-10KS004		1	0.14	14.25	1.8	4.5	3	0.70
SF-10KS004		1	0.25	14.25	1.8	4.5	3	0.75
SF-10KS004		1	0.35	14.25	1.8	4.5	3	0.80
SF-10KS004		1	0.50	14.25	1.8	4.5	3	0.88
SF-10KS010		1	0.14	14.25	2.0	4.5	3	0.60
SF-10KS010		1	0.25	14.25	2.0	4.5	3	0.65
SF-10KS010		1	0.35	14.25	2.0	4.5	3	0.70
SF-10KS010		1	0.50	14.25	2.0	4.5	3	0.78
SF-10KS010		1	0.75	14.25	2.0	4.5	3	0.90
SF-10KS010		1	1.00	14.25	2.0	4.5	3	1.00

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

Settings chart for Coninvers crimp contacts (continuation)
4-arbor crimping pliers Order No. SF-Z0054

Contact Type	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]
ST-20KP010	2		0.35	19.8	1.5	6	5	0.80
ST-20KP010	2		0.50	19.8	1.5	6	5	0.88
ST-20KP010	2		0.75	19.8	1.5	6	5	1.00
ST-20KP010	2		1.00	19.8	1.5	6	5	1.10
ST-20KS010		2	0.35	15.6	1.5	6	4	0.80
ST-20KS010		2	0.50	15.6	1.5	6	4	0.88
ST-20KS010		2	0.75	15.6	1.5	6	4	1.00
ST-20KS010		2	1.00	15.6	1.5	6	4	1.10
ST-20KP020	2		1.50	19.8	2.3	6	5	1.40
ST-20KP020	2		2.50	19.8	2.3	6	5	1.65
ST-20KS020		2	1.50	15.6	2.3	6	4	1.40
ST-20KS020		2	2.50	15.6	2.3	6	4	1.65
ST-06KP010	0.6		0.08	23.3	0.75	5.5	6	0.50
ST-06KP010	0.6		0.14	23.3	0.75	5.5	6	0.55
ST-06KP010	0.6		0.25	23.3	0.75	5.5	6	0.60
ST-06KS010		0.6	0.08	17.1	0.75	5.5	7	0.50
ST-06KS010		0.6	0.14	17.1	0.75	5.5	7	0.55
ST-06KS010		0.6	0.25	17.1	0.75	5.5	7	0.60
ST-06KP020	0.6		0.14	23.3	0.9	5.5	6	0.55
ST-06KP020	0.6		0.25	23.3	0.9	5.5	6	0.60
ST-06KP020	0.6		0.35	23.3	0.9	5.5	6	0.65
ST-06KS020		0.6	0.14	17.1	0.9	5.5	7	0.55
ST-06KS020		0.6	0.25	17.1	0.9	5.5	7	0.60
ST-06KS020		0.6	0.35	17.1	0.9	5.5	7	0.65
ST-06KP030	0.6		0.35	23.3	1.1	5.5	6	0.65
ST-06KP030	0.6		0.50	23.3	1.1	5.5	6	0.73
ST-06KS030		0.6	0.35	17.1	1.1	5.5	7	0.65
ST-06KS030		0.6	0.50	17.1	1.1	5.5	7	0.73

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