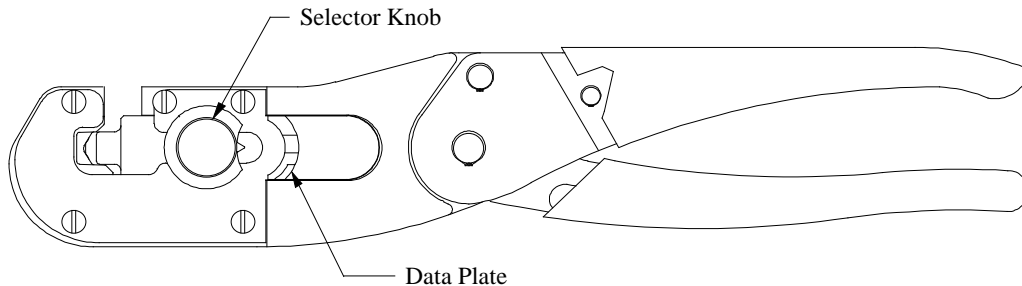




# ASTRO TOOL CORP.

## CONNECTOR ASSEMBLY TOOLING



## INSTRUCTIONS FOR 11545 TERMINAL HAND CRIMPING TOOL

### GENERAL

The Astro Tool Corp. 11545 tool is a three position, cycle controlled, open frame tool for crimping size 26 to size 10 insulated terminals, per MS25036, and splices, per MS25181.

Observe the precision ratchet mechanism by opening and closing the tool fully several times. Note that the tool cannot be opened or closed without completing the cycle.

### INSTRUCTIONS FOR TERMINALS

The tool must be in the open position.

Turn the Selector Knob so that the indicator points to the desired terminal-wire size combination.

NOTE: Be sure to use the proper setting for your application. The color coding on the Data Plate will match the color of the terminal.

Slide the locator into the extended position so that it will accept the lug end of the terminal. See figure # 1.

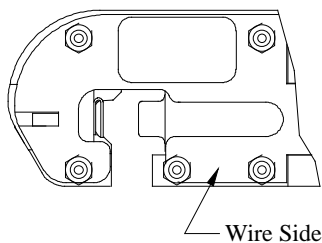


Figure # 1

Insert the prepared terminal and wire into the wire side of the tool, the lug should be in the locator. Use the locator as a stop.

Squeeze the handles together until the positive stop is reached. The tool will release and return to the fully open position.

Remove the crimped terminal and wire.

### INSTRUCTIONS FOR SPLICES

The tool must be in the open position.

Turn the Selector Knob so that the indicator points to the desired splice-wire size combination.

NOTE: Be sure to use the proper setting for your application. The color coding on the Data Plate will match the color of the splice.

Slide the locator back to the retracted position above the die surface. See figure # 2.

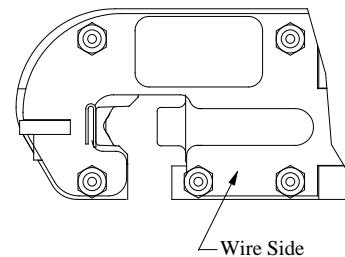


Figure # 2

Insert the prepared splice and wire, placing the locating shoulder in the space between the two crimping dies.

NOTE: During the crimping operation, the wire must be protruding from the wire side of the tool.

Squeeze the handles together until the positive stop is reached. The tool will release and return to the fully open position.

Remove the crimped splice and wire.

**GAGING**

Gaging the tool requires Astro part number 612406.

Set the tool on the #26-18 setting.

Holding the tool closed, insert the GO pin between the dies on the wire side. The gage should pass freely between the dies.

Holding the tool closed, insert the NO-GO pin between the dies on the wire side. The gage must NOT pass between the dies. See figure # 3.

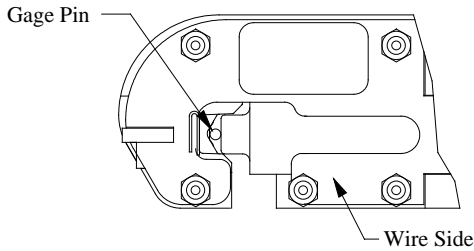


Figure #3

**CAUTION:  
DO NOT CRIMP GAGE.  
TOOL DAMAGE WILL RESULT.**

**GAGING INFORMATION**

Selector Setting	Contact Side		Wire Side	
	GO ±.0001	NO-GO ±.0001	GO ±.0001	NO-GO ±.0001
12/10	.1270	.1310	.1610	.1750
16/14	.0960	.1010	.1160	.1360
26/18	.0960	.1010	.1040	.1240

**TOOL SERVICE**

Astro Tool's 11545 Crimp Tool is designed for long, reliable service. If the Tool becomes inoperative or does not gage properly, it is suggested that you contact our Customer Service Department for a Return Goods Authorization number and return the Tool to our factory.

Upon receipt of the Tool, Astro will inspect and overhaul each Tool to put the Tool back into acceptable and efficient operating condition. Worn parts will be replaced or repaired. Please note that Astro's Quality Control system is traceable to The National Institute of Standards and Technology (N.I.S.T.).

Service charges for tools not under warranty will be advised upon request.

Parts that Astro deems to have been damaged due to neglect, misuse or accident; and parts that have been altered or repaired by persons other than Astro Tool Corp. employees will be replaced subject to additional charge for such parts.

**TOOL HAS BEEN PERMANENTLY LUBRICATED  
AT THE FACTORY  
DO NOT OIL**

**ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL,  
CRIMP TOOLS AND CONNECTOR SERVICE KITS**

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