

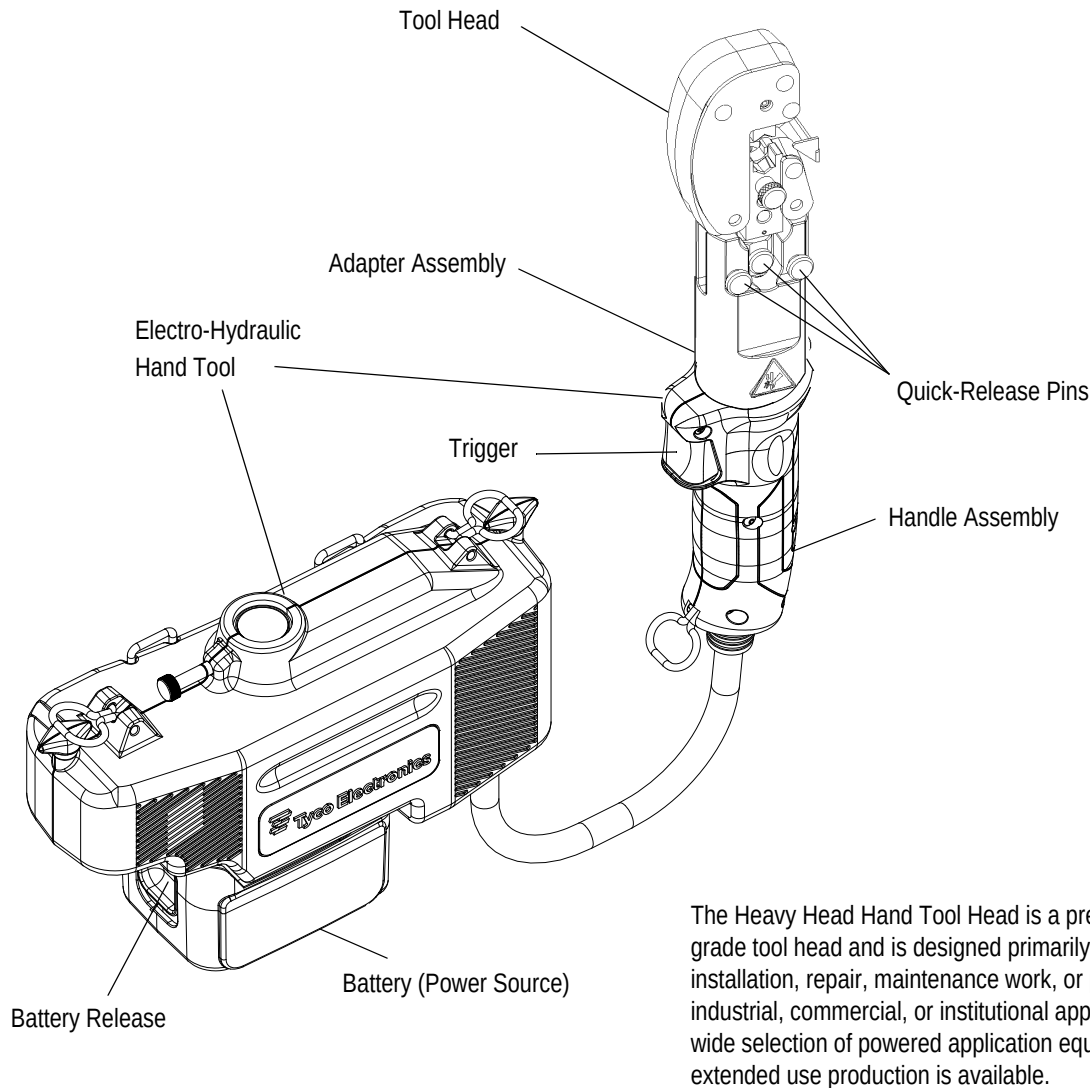


Figure 1

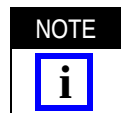
1. INTRODUCTION

The Tyco Electronics Heavy Head Hand Tool (HHHT) Head Adapter Assembly 2119840-1 is designed to couple any Tyco Electronics HHHT head assembly (example: 1-59239-4) to the Electro-Hydraulic Hand Tool (2031400-[]). Refer to Figure 1 to see the hand tool, adapter, and HHHT head.

The Electro-Hydraulic Hand Tool and specific HHHT head assemblies must be ordered separately.

For specific HHHT crimp head information (including wire preparation, crimping procedures, maintenance and inspection procedures, as well as repair and replacement procedures) refer to the appropriate instruction sheet for the associated hand tool and crimping head.

Refer to Customer Manual 409-10095 for information concerning Electro-Hydraulic Hand Tool 2031400-[].

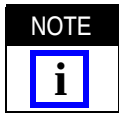


All dimensions on this instruction sheet are in metric units [with inches in brackets]. Figures and illustrations are for identification only, and are not drawn to scale.

2. RECEIVING/INSPECTION

Adapter Assembly 2119840-1 is thoroughly inspected during and after assembly. Prior to packaging and shipping a final series of tests and inspections is made to ensure proper function of the adapter. The following inspections should be performed as a safeguard against potential problems generated in transit.

1. In a well-lighted area, carefully unpack the adapter and inspect each component as it is unpacked.
2. Thoroughly inspect each component for evidence of damage that may have occurred in transit. If any of the components are damaged, file a claim against the carrier and notify Tyco Electronics immediately.



It is IMPORTANT that these instructions, and other documents shipped with the tooling (e.g., drawings, parts lists, tooling manual, etc.), remain with the adapter, head, and hand tool for the benefit of personnel responsible for installation, operation, and maintenance.

The adapter should be inspected at regularly scheduled intervals, depending on care, degree of operator skill, the type and size of product being crimped, and environmental conditions. At a minimum, the adapter should be inspected on a weekly basis.

3. INSTALLATION/REMOVAL OF ADAPTER ASSEMBLY AND HHHT HEADS



Do not operate the Electro-Hydraulic Hand Tool without the HHHT head and adapter installed. Repeated operation in this manner may result in damage to the Electro-Hydraulic Hand Tool.



To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release hydraulic pressure, if applicable -- see 409-10095) before installing or removing the HHHT tool head or adapter assembly.

3.1. Adapter Installation/Removal

Refer to the Electro-Hydraulic hand tool manual (409-10095) for instructions on installing and removing the adapter assembly and the crimping heads.

Note that adapter 2119840-1 does not have a terminal grip thumb button. To remove the adapter, unscrew it completely, and then pull the adapter away from the cylinder assembly.

3.2. HHHT Head Installation Removal

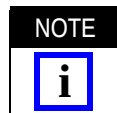
A. Installation

As supplied, the adapter assembly has three quick-release pins installed. Refer to Figure 1. The two outer pins will be used to secure the outer housing tabs of the HHHT crimp head to the adapter assembly.

The center pin will be used to secure the movable die of the HHHT crimp head to the ram of the adapter assembly.

These pins must be removed prior to installing the HHHT crimp head.

1. Remove the quick-release pins (see Figure 1).
2. Insert the HHHT tool head into the adapter cavity.
3. Insert the two outer quick-release pins through the holes in the adapter housing and the holes in the two outer tabs of the HHHT crimp head. See Figure 1.



The quick-release pins will "snap" into position when they are properly inserted.

4. Insert the center quick-release pin into the adapter ram and through the moveable die of the HHHT crimp head.
5. Squeeze the trigger on the handle assembly until the tool completes an advance cycle and retracts to join the handle assembly ram to the adapter ram.

B. Removal

1. Remove the quick-release pins.
2. Remove the HHHT head from the adapter cavity.

4. OPERATION

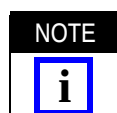
The following procedure provides only general information concerning crimping. Refer to the instructions packaged with the HHHT crimp head for detailed information, including wire stripping dimensions and instructions for positioning terminals and splices in the crimpers.



To avoid personal injury, keep fingers clear of the crimping area.

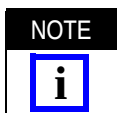
To operate the HHHT crimp head in the Electro-Hydraulic Hand Tool using the Adapter assembly, proceed as follows:

1. Insert the contact into the appropriate die cavity.
2. Pulse the trigger to advance the lower tooling and hold the contact in place. Do not deform the terminal insulation or wire barrel.
3. Place a pre-stripped wire in the barrel of the contact.
4. Squeeze the tool trigger until the jaws release. When the jaws release, the crimp is complete.



It is not necessary to continue to hold the trigger to retract the tooling. The tooling will retract automatically.

5. Remove the terminated wire.



To abort a crimp, press the pressure release device on the power tool. Information on the pressure release device is contained in 409-10095, Section 6, PRESSURE RELEASE/ RESET TOOL.

5. PREVENTATIVE MAINTENANCE



To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release hydraulic pressure if applicable -- see 409-10095) before performing maintenance.

5.1. Daily Maintenance

Perform the following maintenance on a daily basis:

1. Inspect the dies for wear or damage such as cracks, gouges or chips. If damage is found, return the HHHT head to Tyco Electronics for inspection.
2. Clean the tooling, removing accumulations of dirt and grease on the adapter - particularly:
 - a. In areas where contacts are crimped, and
 - b. in the area where the HHHT head connects to the adapter assembly.
3. Wipe the tooling with a soft, lint-free cloth.

5.2. Yearly Maintenance

Once a year or every 10,000 cycles (whichever comes first) return the HHHT tool crimp head to Tyco Electronics for inspection.

6. REPLACEMENT AND REPAIR



To avoid personal injury, be sure to exercise extreme caution when handling the Electro-Hydraulic Hand Tool. Remove the power source (and release hydraulic pressure, if applicable -- see 409-10095) before replacing or repairing components.

SPARE PARTS		
TE PART NUMBER	DESCRIPTION	QTY
217873-4	Quick-Release Pin	1
217873-1	Quick-Release Pin	2
18023-1	Screw, Head Retaining	1
2063866-1	Label, Warning	1

Figure 2

Replacement parts are identified in Figure 2. The recommended spares should be stocked for immediate replacement. Order replacement parts (or return parts) through your Tyco Electronics Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605. Or write to:

CUSTOMER SERVICE (38-35)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

For repair services, call the Tooling Assistance Center at 1-800-722-1111.

For spare parts, refer to the table in Figure 2:

7. RoHS INFORMATION

Information on the presence and location of any substances subject to RoHS (Restriction on Hazardous Substances) can be found at the following web site:

<http://www.tycoelectronics.com/customersupport/rohssupportcenter/>

Click on "Find Compliance Status" and enter equipment part number.

8. REVISION SUMMARY

- initial release of document