

# W2 Standard Adjustable Crimping Tool

Upper Range Crimping Tool – W2 (M22520/1-01)

## Production Manual

### 1. Applications and Features

The W2, qualified to MIL-DTL-22520/1, has virtually limitless application within the specified wire range of 12AWG (3.33mm<sup>2</sup>) through 26AWG (0.128mm<sup>2</sup>). Over a thousand turret heads are available to adapt the tool frame to your specific military or proprietary contact/wire combination. The 8 impression crimp, which is standard in the W2, assures absolute maximum tensile strength with almost every closed barrel contact. Special indent configurations and gaging are available upon request.

| Adjustment | Crimping working Dia.(mm/inch) |            |
|------------|--------------------------------|------------|
|            | A(GO)                          | B(NO GO)   |
| 1          | 0.71/0.028                     | 0.84/0.033 |
| 2          | 0.81/0.032                     | 0.94/0.037 |
| 3          | 0.91/0.036                     | 1.04/0.041 |
| 4          | 0.99/0.039                     | 1.12/0.044 |
| 5          | 1.14/0.045                     | 1.27/0.050 |
| 6          | 1.32/0.052                     | 1.45/0.057 |
| 7          | 1.50/0.059                     | 1.63/0.064 |
| 8          | 1.73/0.068                     | 1.86/0.073 |



### 2. Structure and Principle



The crimping tool use curve-promoting organization; the force from four curves in the head cavity of right clamp handle transfer to the four crimper heads; the crimper head do linear motion to the heart; the crimping teeth in the front of crimper head crimp contact body and complete crimping with connect of wire and contact body. After crimping in place, eliminate the force of pressure on the clamp handle; under the action of the spring, the four crimper heads automatically reset. Four crimper heads forward back action coordination, indentation depth consistent, to ensure reliably crimp quality of wire and contact body.

### 3. Notice Item

1. Not use hard-steel crimping pieces or not crimp wantonly solid or thick-walled cylindrical into the crimper teeth cavity, otherwise will damage the rack and relevant parts
2. The working surface of cam and the corresponding surface of the adjustable clamp handle which contact with the surface of cam, particularly pay attention to clean, otherwise will affect the indentation depth, reduce crimp quality.
3. Note the action of rack and pawl when used, when abnormal please stop use and contact us.
4. When the large diameter contacting bodies stray into small stall or the cavity of crimper teeth is stuck with a hard object, if continue the clamp teeth will close that will make the clamp teeth or other parts damage. At this time please contact us.
5. After use pliers should be cleaned and put into the box or bag to prevent dust and impurities entering the clamp body to cause affecting the performance.



## 4. Operation steps

Step 1



Step 2



Step 3



Step 4

