Suggested Preventative Maintenance Schedule for Applicators

1. PURPOSE

The figures quoted within this document are estimates and for reference only. Tooling life is dependent upon severity of application. Preventative Maintenance Schedules should be defined by each customer specific application.

2. DAILY CLEANING

Applicators MUST be cleaned and lubricated every eight hours of operation or when removed from terminating unit to be stored.

CAUTION

DO NOT CLEAN APPLICATOR WITH AIR HOSE.

1. Remove applicator from terminating unit. Remove terminal strip.
2. Remove applicator ram from applicator. DO NOT REMOVE TOOLING FROM RAM.
3. Wipe complete ram assembly with a cloth to remove old grease and dirt.
4. Check crimpers, anvil, and shear for excessive wear or damage and replace if necessary.
5. Check alignment of terminal stripper and tightness of stripper, anvil, and crimper mounting bolts.
6. Lubricate the bearing surfaces of the ram and the feed cam with a light film of grease (recommended grease is Chevron Ultra Duty EP NLGI No 2).
7. Clean applicator body. Make sure all chips, dirt, and grease are removed. Place a drop of oil (recommended oil is 3-IN-ONE) at all pivot points.
8. Replace ram in applicator. If applicator is to be stored, install the transportation collar onto the ram. If no transportation collar is present, lower the ram assembly to hold lead terminal between crimpers and anvil.

3. MONTHLY CLEANING

Applicators MUST be cleaned completely every thirty days to remove all grease, oil, and dirt.

1. Remove ram from applicator. DO NOT REMOVE TOOLING FROM RAM.
2. Remove terminals from applicator.
3. Use clean, dry cloth, remove dirt and chips from the applicator.

CAUTION

DO NOT CLEAN IN VAPOR DEGREASER.

4. Lubricate the bearing surfaces of the ram and feed cam with a light film of grease (recommended grease is Chevron Ultra Duty EP NLGI No 2).
5. Place a drop of oil (recommended oil is 3-IN-ONE) at all pivot points.
6. Replace ram in applicator. If applicator is to be stored, install the transportation collar onto the ram. If no transportation collar is present, lower the ram assembly to hold lead terminal between crimpers and anvil.

4. STORAGE

If applicator is to be stored, a light application of rust inhibitor LPS3 or equivalent is recommended.

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	8 Hours Or 25,000 Cycles	Weekly Or 250,000 Cycles	Bi-Weekly Or 500,000 Cycles	Monthly Or 1,000,000 Cycles	Comments
GREASE/OIL/RUST INHIBITOR					
Daily Cleaning 	X				Clean complete applicator and inspect general function.
Ram Assembly 	X				Grease Lightly
All Pivot Parts 	X				Oil 2 or 3 Drops
Storage 					Apply rust inhibitor before storage
●●●Reference applicator assembly print for critical locations and preventative maintenance for daily cleaning. ●●●					
VISUALLY INSPECT FOR EXCESSIVE WEAR OR DAMAGE					
Wire Crimper 	X				Replace if excessive wear or damage is detected.
Insulation Crimper 	X				Replace if excessive wear or damage is detected.
Anvil 	X				Replace if excessive wear or damage is detected.
Hold Down 	X				Replace if excessive wear or damage is detected.
Floating Shear 			X		Inspect cutting edges. Replace if excessive wear or damage is detected.
Shear Holder 			X		Inspect cutting edges. Replace if excessive wear or damage is detected.
Upper Shear Tooling 			X		Inspect cutting edges. Replace if excessive wear or damage is detected.
Lower Shear Tooling 			X		Inspect cutting edges. Replace if excessive wear or damage is detected.
Feed Finger (Pawl) 			X		Replace if excessive wear or damage is detected.
Stock Drag 				X	Replace if excessive wear or damage is detected.
Drag Springs 				X	Replace if wear or fatigue is detected.
Shear Spring 			X		Replace if fatigue is detected.

Figure 1 (cont)

Feed Return Spring 				✘	Replace if cracks or return action is slowed..
Pneumatic Components 				✘	Replace if air leakage is detected, binding or air cylinder fails to activate.
Complete Cleaning and Inspection 				✘	Any parts that show excessive signs of damage or wear should be replaced.
●●●Reference preventative maintenance for monthly cleaning procedure. ●●●					

Figure 1 (end)

5. REPLACEMENT AND REPAIR

To order replacement dies, call 1-800-522-6752, send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)

TE CONNECTIVITY CORPORATION

PO BOX 3608

HARRISBURG PA 17105-3608

Call 1-800-522-6752 for customer repair services.

6. REVISION SUMMARY

1. Added "**Hold Down**" and "✘" in the respective column "**8 Hours Or 25,000 Cycles**" in Figure 1.
2. Moved "✘" for "Insulation Crimper "and "Anvil " to column "8 Hours Or 25,000 Cycles" in Figure 1.

Unikeyic Electronics

Global Electronic Components Distributor

Click to view pricing, inventory, delivery, and lifecycle information:

TE Connectivity:

3-1393225-0 650075-000 CRGCQ2010J3K3 SBCHE64R7K 1743455-2 1-794222-0 2380312-2 2834055-1 936348-1 SBCHE154R7K 141991-2 175977-2 2377783-2 RH73H2A40MKTN U5254-000005-030PA 1969656-1 1903112-2 2005330-1 3430B2F51RTDF SMW73R0JT TE50BR39J 2-292161-3 2310537-1 917696-1 CPF0402B37K4E1 3631B101LL MPT100C18RF ROX05SJ18R 1-962915-1 1393431-1