PHX3
PNEUMATIC CRIMP TOOL

DANIELS MANUFACTURING CORPORATION
DATASHEET

SEE PAGE 3 FOR IMPORTANT INFORMATION CONCERNING LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

HOW TO USE THE DANIELS PHX3 CRIMP TOOL AND DIES

GENERAL INFORMATION

The DANIELS PHX3 crimp tool is designed to crimp various sizes and types of ferrules, coaxial connectors, contacts, splices and terminal lugs to cables and wires. Interchangeable dies may be installed and locked in place with pins.

The DANIELS PHX3 crimp tool utilizes a system of interchangeable dies. A wide variety of dies are available from DANIELS. As new requirements evolve, new die sets are developed.

CAUTION: BEFORE ATTEMPTING TO REMOVE DIES FROM TOOL, ASSURE THAT ALL LOCK PINS HAVE BEEN REMOVED (SEE FIGURE 4). FAILURE TO DO SO MAY RESULT IN SERIOUS DAMAGE TO THE TOOL.

DIE INSTALLATION

1. Align die rail slots in die halves with the rail on the crimp head and push shanks of dies into holes. Dies will snap into place. (See Figure 1)
2. Activate the tool by pressing the thumb button to make sure dies are properly seated. The tool is now ready for use.

DIE REMOVAL

1. With dies in the "open" position, place die removal tool against end of knockout pin and tap gently with small hammer (See Figure 2). The die will be released from the front die holder. It can now be removed by hand.

NOTE: Die removal tool part number HX3–82 is furnished with crimp tool. (If die removal tool is not available, a rod approximately 3/16" diameter X 1 3/4" long may be used)

2. Activate the tool and slide the die removal tool between the movable die and crimp head (See Figure 3). Release thumb button to allow the pushrod to retract. The die will be released and can then be removed by hand.

PERMANENT DIE ASSEMBLY

1. Install dies in crimp tool.
2. Drive lock pins, supplied with dies, through holes and flush with outside surfaces. Long pin through tool body and short pin through push rod. (see Figure 4)

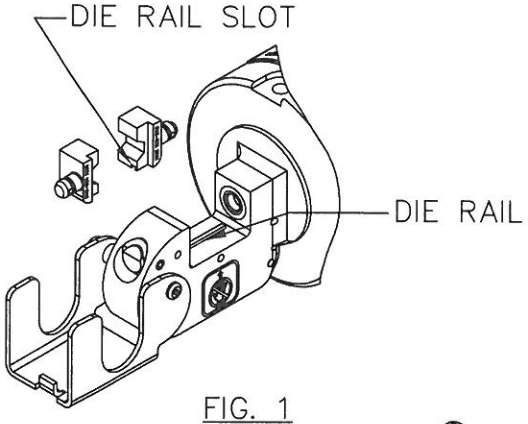


FIG. 1



FIG. 2

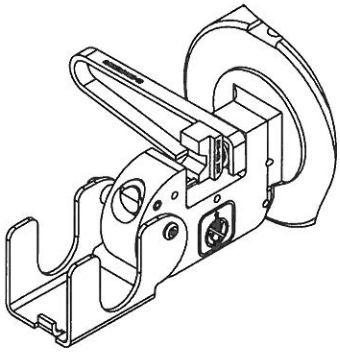


FIG. 3

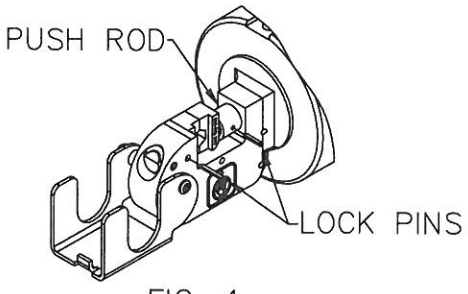


FIG. 4

NOTE: Use only "X" series dies with the PHX3 pneumatic tool.

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GENERAL SPECIFICATIONS

* This tool contains an internal mechanical ratchet to assure the tool will complete its crimp cycle.
* The thumb button must be held down until die faces come into contact with each other to complete the crimp.
* The working pressure of the tool is 100–120 psi. It is recommended that each tool be set up with a Regulator and Filter (WA27RF).
* All Crimp Tools, Bench Mounts and Gages must be ordered by separate part number.

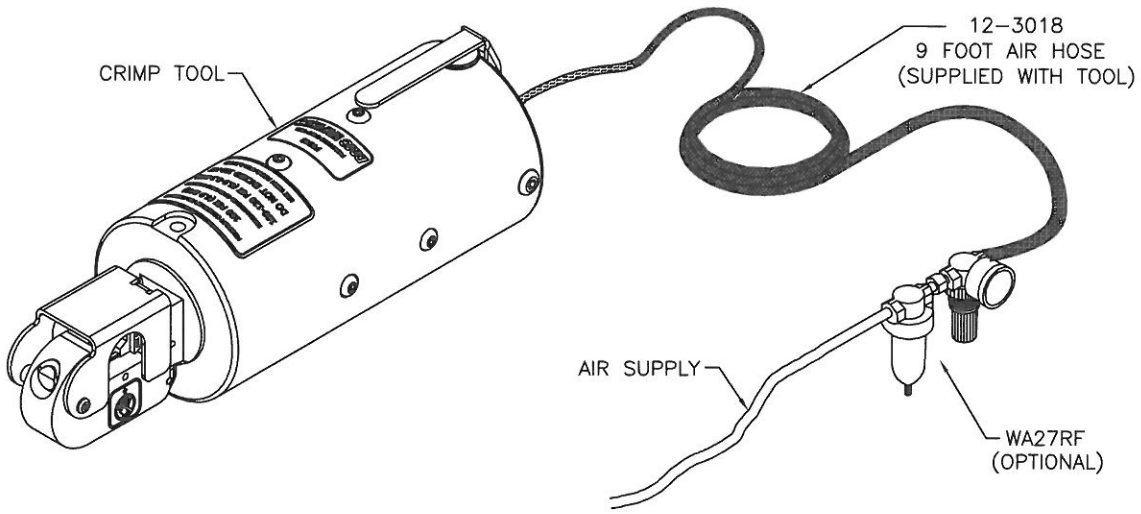
SIZE

Length: 8.5" Width: 2.75" Weight: 3.25 lbs.

TOOL OPERATION

* Position item to be crimped into the appropriate cavity.
* Place wire into the crimp item. Procedures for wire selection, loading, processing, etc., shall be provided by the user.
* Close safety cover.
* Activate tool by depressing the activation lever.
* Hold the activation lever down until die faces come into contact with each other.
* When crimp is completed, release the activation leve and allow the movable die to return to its open position before depressing the activation lever again.
* Open the safety cover and remove the crimped iten

CAUTION!
BEFORE ATTEMPING TO ADJUST TOOL OR DIES, DISCONNECT TOOL FROM AIR SUPPLY!



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HEX DIE GAGING

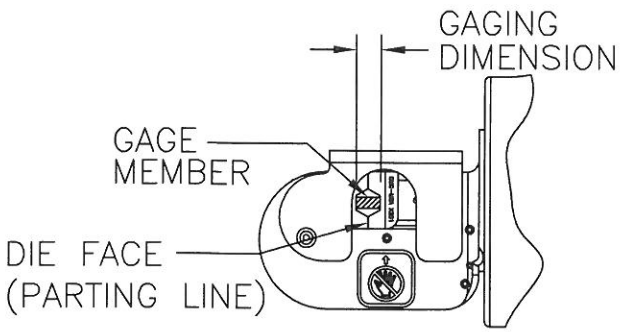
1. Activate the tool by depressing the thumb button.

2. Insert the GO gage (green) member as shown; gaging only those hex flats parallel to the die face (parting line). The GO gage member should freely enter the die cavity.

3. Attempt to insert the NO–GO gage (red) member in the same manner. The NO–GO gage member may enter slightly into the die cavity, but shall not pass fully through the cavity. If the NO–GO gage member does enter the cavity fully, the die is worn and should be replaced.

* Each individual die set has an appropriate gage(s).

CAUTION: DO NOT CRIMP THE GAGE MEMBER; TO DO SO MAY SERIOUSLY DAMAGE THE DIE SET.



CARE OF TOOL

There is virtually no maintenance required. We strongly recommend that you:

1. DO NOT immerse tools in cleaning solution.
2. DO NOT spray oil into tool to lubricate.
3. DO NOT attempt to disassemble tool or make repairs.

This is a precision crimp tool and should be handled as such.

DMC offers complete refurbishing and recalibration services.

DMC specially engineers and manufactures tools, dies, and complete tool kits to satisfy individual customer requirements, such as total aircraft support, general shop maintenance or production, on board ship and vehicle service, etc.

LIMITATION OF LIABILITY

DANIELS MANUFACTURING CORPORATION IS NOT LIABLE FOR CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY NATURE OR KIND RESULTING FROM THE USE, OR MISUSE, OF ANY OF ITS PRODUCTS. OWNERS AND USERS OF DMC PRODUCTS ASSUME FULL RESPONSIBILITY FOR INSTRUCTING THEIR EMPLOYEES IN THE PROPER AND SAFE USE OF SUCH PRODUCTS.

LIMITED WARRANTY

DMC (Daniels Manufacturing Corporation) warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. DMC's obligation under this warranty is limited to the free correction or, at DMC's option, the refund of the purchase price of any such product which proves defective in normal service within ninety (90) days after delivery to the first user, provided that the product is returned to DMC with all transportation charges prepaid and which shall appear to DMC's satisfaction, after DMC's inspection, to have been defective in material or workmanship, it being understood that DMC products are not consumer products. This warranty shall not cover any damage to any product which, in the opinion of DMC, was caused by normal wear, misuse, improper operation, tampering, neglect or accident. This warranty is in lieu of all other warranties express or implied. No warranty, express or implied, is made or authorized to be made or assumed with respect to products of Daniels Manufacturing Corporation other than those herein set forth.

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IMPORTANT SAFETY INSTRUCTIONS/USER'S RESPONSIBILITIES

Under no circumstances should the crimp tool be attached to any control box or power system other than standard plant air. It is imperative that operators using this tool follow these Safety Precautions, be alert at all times and observe the highest level of operator safety.

This tool is very powerful requiring 100–120 psi (6.9–8.3 BAR) air pressure to operate while producing a force of up to 1,500 pounds in the crimp area which can crush fingers and other body parts if inserted into the "crimp area" of the tool.

1. Disconnect tool from air supply when tool is not in use.
2. Keep all body parts clear of the crimping area while loading and operating the tool.
3. Only operate tool while safety cover is covering the crimp area.
4. Follow directions on all warning labels.
5. Do not alter the tool or operate outside the guidelines specified in this data sheet.

WARNING LABELS

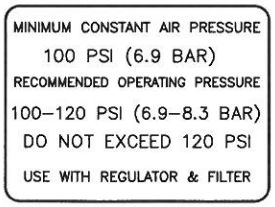
Warning labels are placed on the PHX3 Pneumatic Crimp Tool to make the operator aware that this tool could seriously injure or maim if care is not used while operating it.

These labels are intended as a constant reminder of the potential risk involved. These labels should never be removed and should be replaced as needed.

LABELS ALONE WILL NOT PREVENT ACCIDENTS FROM OCCURING. OPERATORS MUST BE TRAINED IN THE USE OF THIS EQUIPMENT AND BE AWARE OF THE RISKS INVOLVED. WHILE USING THIS TOOL, IT IS IMPORTANT TO BE ALERT AND AVOID DISTRACTIONS.



FINGER FREE AREAS



AIR PRESSURE LIMITS

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