

# WA22-CC PNEUMATIC CRIMP TOOL WITH CYCLE COUNTER

## DATASHEET

SEE PAGE 4 FOR IMPORTANT INFORMATION CONCERNING LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

### 1.0 ACCESSORIES, GAGING PROCEDURES, AND SPECIFICATIONS

#### 1.1 GENERAL SPECIFICATIONS

- 1.1.1 The WA22-CC pneumatic crimp tool is designed with 8 die closures, changeable by a selector knob. The tool has a full cycle ratcheting control mechanism. It also has a resettable digital counter for tracking the number of crimp cycles.
- 1.1.2 Either the hand operated valve, or the optional foot valve may be used to actuate the tool. The working pressure of the tool is 80-120 psi. It is recommended that each tool be set up with a regulator and filter (WA27RF).
- 1.1.3 All positioning heads, bench mounts, gages, and foot valves must be ordered separately by part number.

#### 1.2 SIZE

- 1.2.1 Length: 8 in
- Width: 2.25 in
- Weight: 2.2 lb.

#### 1.3 CRIMPING RANGE

- 1.3.1 Contacts: Size 20 thru 28
- Wire Sizes: 20 thru 32 AWG

#### 1.4 ACCOMMODATIONS

- 1.4.1 Tool will accommodate all DMC "K" series positioners relating to DMC tool part numbers AFM8, MH800, and WA22.

#### 1.5 FOOT VALVE OPERATION

- 1.5.1 Attach the foot valve between the air supply, and the tool air inlet. Depress the hand valve, and lock it in the down position with set screw "A" (See Figure 1) using a 3/32 inch hex Allen™ wrench.

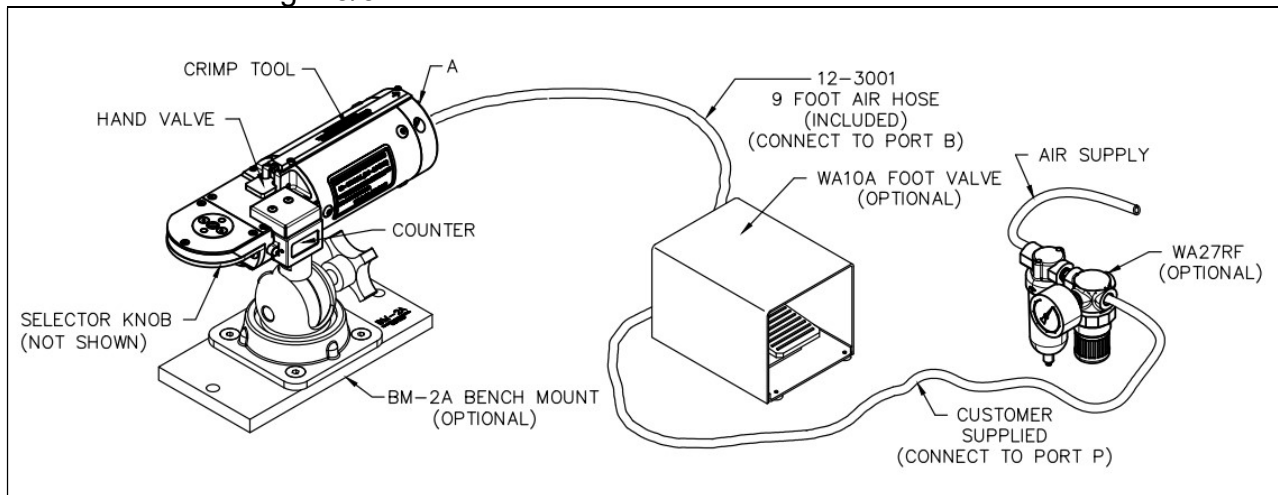


Figure 1

# WA22-CC PNEUMATIC CRIMP TOOL WITH CYCLE COUNTER

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### 2.0 GAGING INSTRUCTIONS

**CAUTION!**  
**DO NOT CRIMP GAGE!**

GAGE PART NO.	ØA "GO"	ØB "NO-GO"	SELECTOR NO.
G125	.0390	.0440	8

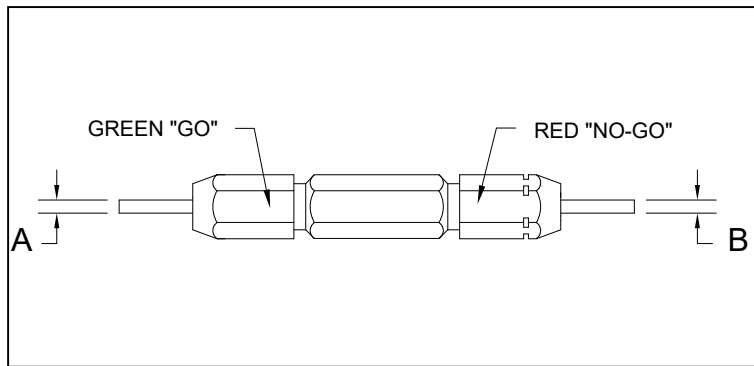


Figure 2

#### 2.1 "GO" GAGING

2.1.1 Operate tool to fully closed position. Insert "GO" gage end as shown. Gage must pass freely between indenter tips.

#### 2.2 "NO-GO" GAGING

2.2.1 Operate tool to fully closed position. Insert "NO-GO" gage end as shown. The gage may partially enter the indenter opening, but must not pass completely through the opening.

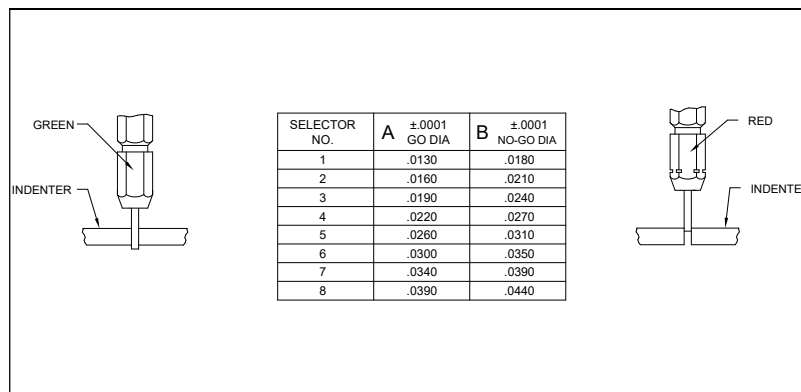


Figure 3

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### 3.0 CHECKING THE FULL CYCLE RATCHETING MECHANISM

3.1 The ratcheting mechanism can be checked for proper function by the following procedure.

- 3.1.1 Adjust the air line pressure to 15 psi.
- 3.1.2 Use a size 20 contact with a size 20 AWG wire, and operate the tool until the indenters stop. The indenters will not reach the fully closed position, and the contact will be locked in place if the ratcheting mechanism is functioning properly.
- 3.1.3 To release the partially crimped contact, increase the air line pressure to 80-120 psi, and operate the tool. The tool will then complete the crimp allowing the indenters to return to the fully open position.

### 4.0 RELEASING A PARTIALLY CRIMPED CONTACT

4.1 To release a partially crimped contact, proceed as follows.

- 4.1.1 Increase the air pressure to 120 psi, and operate the unit. (If increasing the air pressure does not release the contact, proceed to 4.1.2)
- 4.1.2 Turn the selector knob clockwise to the highest lockable setting. (Selector knob must be in the locked position before proceeding.) Operate the unit.
- 4.1.3 If the contact has still not been released after several attempts, contact the DMC service department.

### 5.0 CRIMP CYCLE COUNTER

5.1 The WA22-CC crimp tool is equipped with a battery powered electronic cycle counter.

- 5.1.1 This feature allows the end user to keep track of the number of crimp cycles the tool has performed. This information can be used to determine calibration cycles, number of crimps performed per shift, or total number of crimps in a tool's lifetime.

### 5.2 RESETTING THE CYCLE COUNTER

- 5.2.1 The cycle counter can be reset if desired.
  - 5.2.1.1 To reset the counter remove the two screws securing the digital display to the side of the tool.
  - 5.2.1.2 Loosen the two set screws securing the housing to the digital readout. **DO NOT** remove them completely.
  - 5.2.1.3 Slide the battery on the back of the display unit completely out of its holder.
  - 5.2.1.4 Re-insert the battery, and the counter will go back to "0".
  - 5.2.1.5 Re-install the display into the housing using the set screws.
  - 5.2.1.6 Re-install the housing to the tool using the two screws.

### 5.3 REPLACING THE CYCLE COUNTER BATTERY

- 5.3.1 The cycle counter has a battery life of 3 to 4 years.
  - 5.3.1.1 When the display goes blank, the battery can be replaced.
  - 5.3.1.2 To replace the battery, remove the housing, and digital display as previously described.

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- 5.3.1.3 After removing the old battery, replace it with a new type 386 or SR43 battery.
- 5.3.1.4 Re-install the display and housing as previously described.

### 6.0 CARE OF TOOL

**6.1 It is good practice to keep the indenter tips free of residual color band deposits, and other debris. A small wire brush may be used for this purpose.**

**6.2 We strongly recommend that you.**

- 6.2.1 DO NOT immerse tools in cleaning solution.
- 6.2.2 DO NOT spray oil into tool to lubricate it.
- 6.2.3 DO NOT attempt to disassemble tool, or make repairs.
- 6.2.4 This is a precision crimp tool, and should be handled as such.

DMC offers complete refurbishing, and recalibration services.

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

### ***Limitation of Liability***

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