

# DANIELS WA27R PNEUMATIC CRIMP TOOL

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

## GENERAL SPECIFICATIONS

- \* This is a single purpose tool which has one crimp setting.
- \* The tool also has a full cycle ratchet control mechanism.
- \* Either the hand operated valve or the air foot valve may be used. The working pressure of the tool is 80–120 p.s.i. It is recommended that each tool be set up with a Regulator and a Filter (WA27RF).
- \* All Crimp Tools, Bench Mounts, Gages and Foot Valves must be ordered separately by part number.

## SIZE

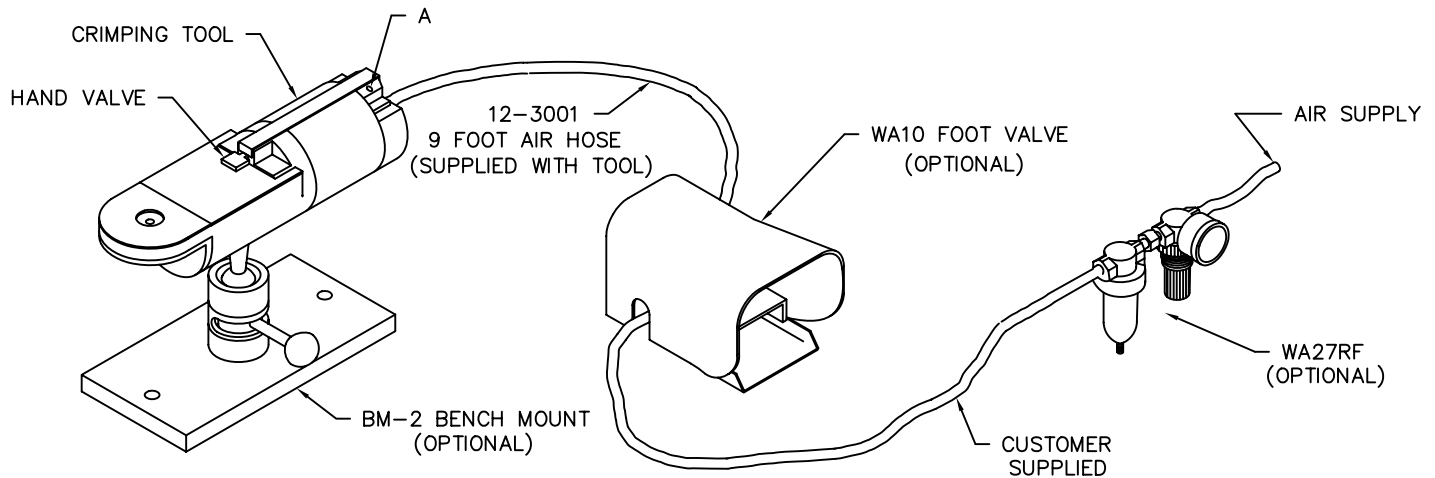
Length: 10" Width: 2.75" Weight: 3.1 lbs.

## CONTACTS ACCOMMODATED

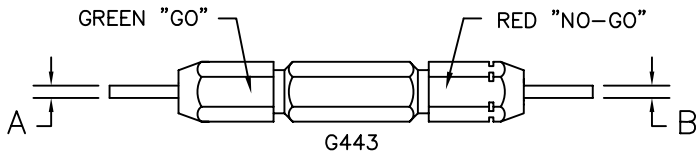
When used with the positioner part number, G2P330, this tool produces a circular crimp on the outer contacts, part numbers M39029/27, M39029/28 AND M39029/75.

## FOOT VALVE OPERATION

Attach foot valve between air supply and tool air inlet. Depress hand valve and lock in down position with set screw (A) using 1/16 hex Allen wrench.

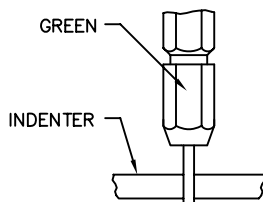


## GAGING INSTRUCTIONS



### "GO" GAGING

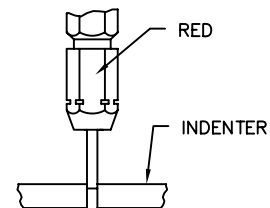
Operate the tool to the fully closed position. Insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.



GAGE PART NO.	A GO DIA	B NO-GO DIA	CRIMP TOOL
G443	.1420	.1460	WA27R

### "NO-GO" GAGING

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



**CAUTION!**  
DO NOT CRIMP GAGE!

### CHECKING THE FULL CYCLE RATCHETING MECHANISM

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

1. Adjust the air line pressure to 15 p.s.i.
2. Conduct a crimp using the specified contact and wire outlined on Page 1. The indenters will not reach the fully closed position and the contact will be locked in if the ratcheting mechanism is functioning properly.
3. To release the partially crimped contact, increase the air line pressure to 80–120 p.s.i. and operate. The tool will then complete the crimp allowing the indenters to return to the fully open position.

### RELEASING A PARTIALLY CRIMPED CONTACT

To release a partially crimped contact, proceed as follows:

1. Increase the air pressure to 120 p.s.i. and operate the unit.
2. If release has not been achieved after several attempts, contact DMC Service Department.

## CARE OF TOOL

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

We strongly recommend that you:

1. DO NOT immerse tool 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 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.