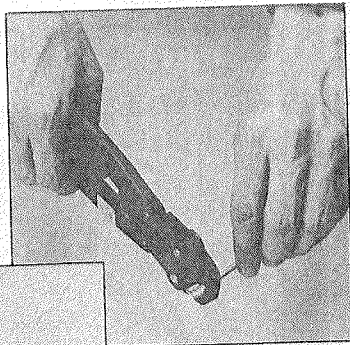
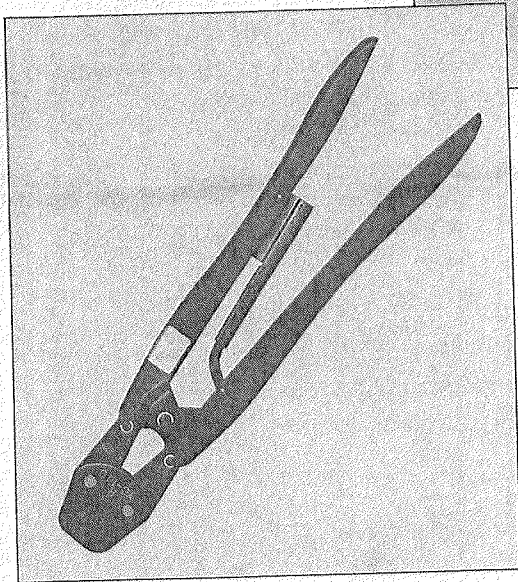
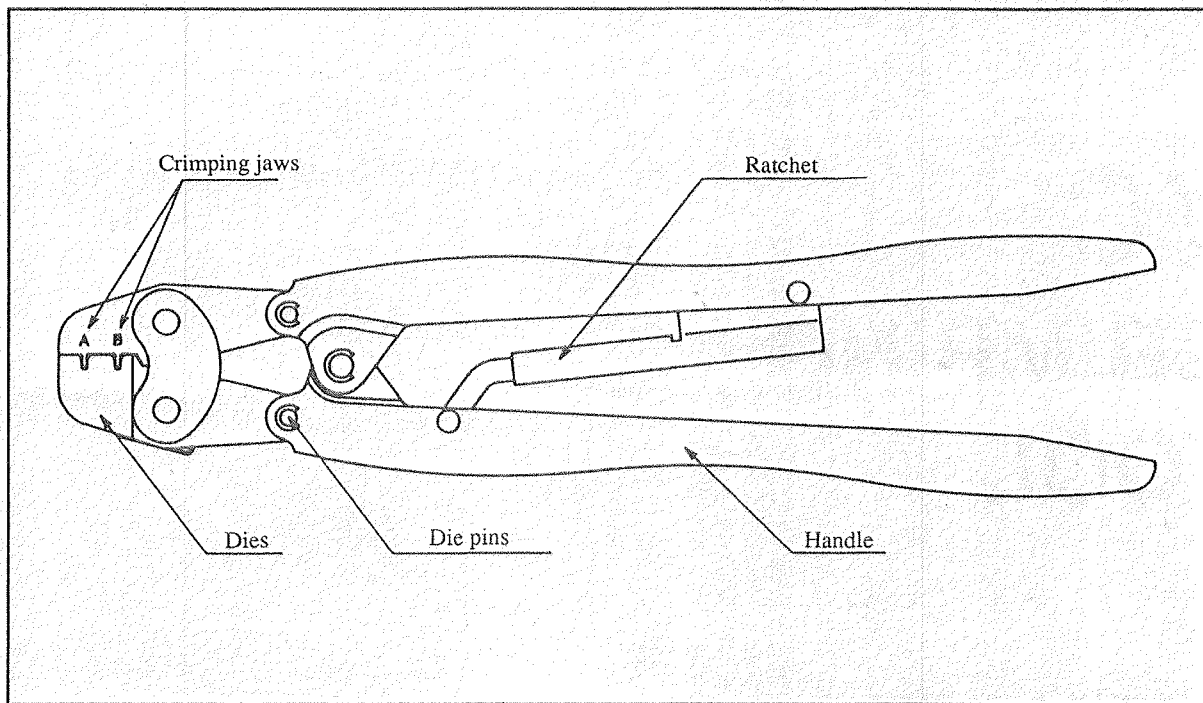


YC CRIMPING TOOL

OPERATION
MANUAL



JST
The Quality Connection



1. Outline

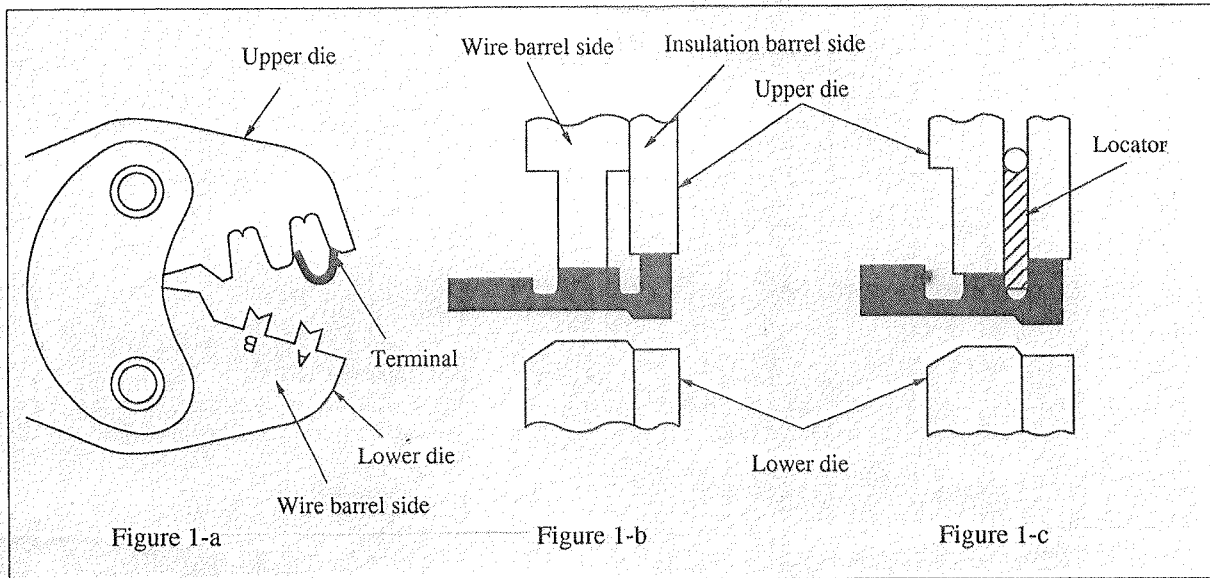
- (1) The YC series hand tool crimps loose piece, open barrel terminals, and was designed to be used for small preproduction lots, samples and repairs. There are 2 styles available; one has a locator to position the terminal, and the other doesn't. The tool with the locator has an "R" suffix after the part number.
- (2) The crimp height of tool is not adjustable, so you may not get the desired crimp height. That is, since wire sizes vary, you may not get the same crimp height you get from an adjustable automatic crimping machine. Accordingly, the YC series hand crimp tool rarely provides the same crimp quality (including appearance of the crimped terminal) as an automatic crimping machine. Some practice may be required. Make sure terminals are properly crimped before use.

2. Precautions

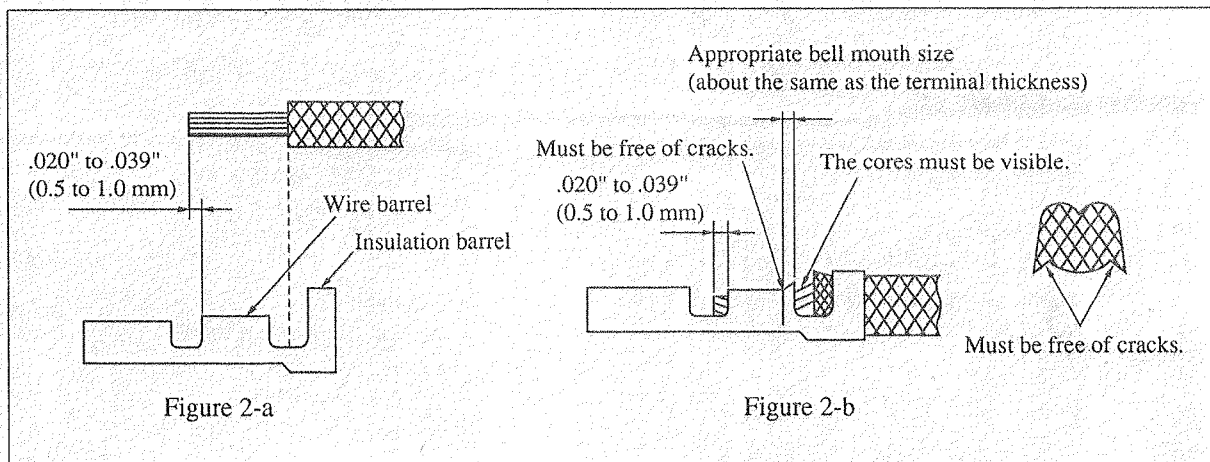
- (1) Make sure the correct combination of wire, terminal, and tool is used.
- (2) Because the tool has a ratchet, the handles will not open until the terminal is completely crimped. **DO NOT FORCIBLY OPEN THE HANDLES WHILE CRIMPING.** If you need to open the handles because, for example, a terminal is positioned incorrectly, or a foreign body is stuck in the crimp tool, remove one of the die pins to open the handles.
- (3) Check the following items before use:
 - a. Make sure there are no scratches, rust, or dust on the crimping jaws.
 - b. When crimping a terminal to a wire, does the ratchet operate normally after the crimping jaws are completely close?
 - c. Are both the tensile strength and appearance adequate?
- (4) Do not use the crimp tool for purposes other than crimping.
- (5) Periodically add oil to the moving parts and the pins of the crimping tool. If you don't plan on using the tool for a long time, apply oil to the entire body of the tool, and put it in a rust preventive bag, or wrap it with a oiled cloth before storing.
- (6) Consult JST if the tool breaks or needs to be repaired.

3. Crimping Operation

- (1) Squeeze the handles until the jaws are completely closed. The ratchet will then release and the handles will open.
- (2) Position a terminal in the upper die (see Figure 1-a). The exact position depends on the terminal type, however in general, set the terminal as shown in Figure 1-b. At this time, do not confuse the wire barrel side and insulation barrel side of the die. The wire barrel side has "A" and "B" marks. Determine the final terminal position by checking the bell mouth size (see Figure 2-b).
- (3) When you are using a locator-equipped tool, place the terminal so the locator is set between the wire barrel and insulation barrel (see Figure 1-c).

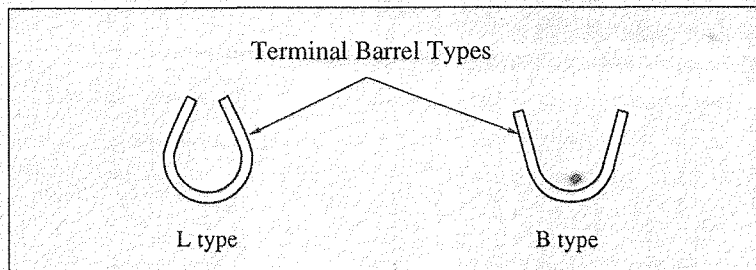


- (4) Grip the handles so the terminal is just held in the dies. Do not too much pressure on the terminal at this point. If you deform it, you may not be able to insert the wire.
- (5) Insert a stripped wire to the terminal barrel. Make sure the conductors sticks out about .020" to .039" (0.5 to 1.0 mm) from the front end of the terminal wire barrel (see Figure 2-a).
- (6) Squeeze the handles to crimp the terminal while holding the wires in the terminal barrel until the ratchet releases.
- (7) Remove the terminal and make a visual inspection (Figure 2-b).



4. Notes

- (1) For terminals that are soldered after crimping (board-in type terminals), the terminal may not solder well because the board insertion area of the terminal is pinched during the crimping process and may become contaminated. Clean the board-in terminal with flux after crimping.
- (2) Terminal barrels come in 2 configurations and are designated with a terminal part No. prefix of either "B" or "L" (see the figure below). You can also use chain terminals that are cut with a nipper—handle these as you would B-type barrels. Terminals with an L-type barrel are recommended because they are easier to set than B-type.



• Specifications are subject to change without notice.

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1998. 06. 500 TE-4063(E)

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