

Electric Crimping Machine for Plastic Strip Terminals Instruction Manual EBP22-10



IMPORTANT: Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.



WARNING

DO NOT CRIMP ON HOT ENERGIZED WIRES.

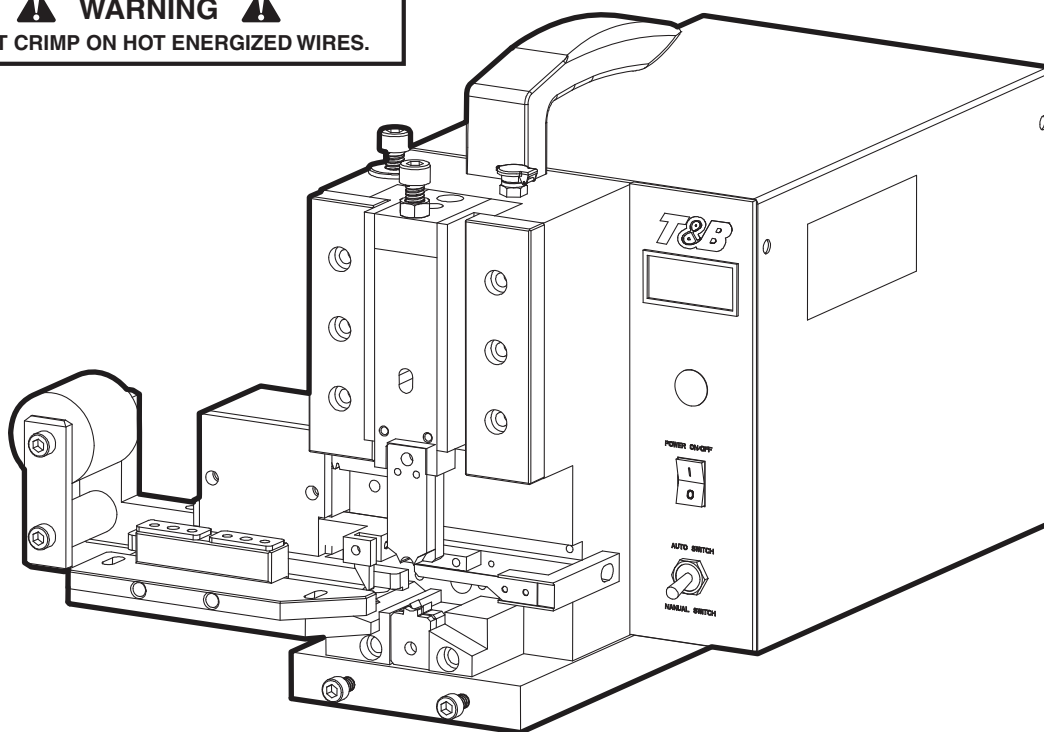


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1.0

GENERAL CHARACTERISTICS

1.1

⚠ WARNING ⚠

1. BEFORE USING THE TOOL, CAREFULLY READ INSTRUCTIONS IN THIS MANUAL.
2. WHEN OPERATING THE TOOL, KEEP HANDS AND OTHER BODY PARTS AWAY FROM CRIMPING DIES AND MOVING PARTS.
3. ALWAYS WEAR SAFETY GLASSES AND GLOVES WHEN OPERATING THIS TOOL.

1.2

DESCRIPTION

The EBP22-10 electric crimping machine is an easy, fast way to crimp a large number of plastic strip terminals for mass production. The EBP22-10 can crimp up to 3,600 crimps per hour, faster and more precisely than a manual operated crimping tool.

1.3

SPECIFICATIONS

Dimensions:

Length.....	13.78 inches
Width.....	10.63 inches
Height.....	10.24 inches
Weight.....	66 lbs
Wire Range.....	22 AWG - 10 AWG
Speed.....	60 PCS/minute maximum
Terminal Type.....	Nylon Plastic Strip

2.0

SET-UP INSTRUCTIONS

2.1

PLASTIC STRIP REEL HOLDER INSTALLATION

⚠ WARNING ⚠

TURN POWER OFF BEFORE SERVICING, CHANGING DIES OR PERFORMING MAINTENANCE.

- 1) Loosen screw and slide in Reel Holder Bracket under the screw and washer (Figure 1).
- 2) Once reel holder bracket is firmly in place, under the screw and washer, tighten screw firmly (Figure 2).

Figure 1

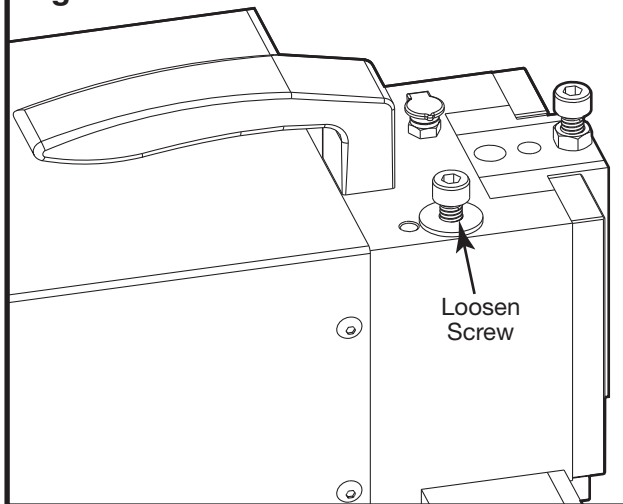
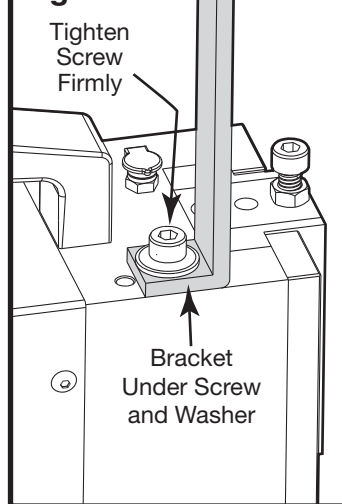


Figure 2



2.2

CRIMPING DIE INSTALLATION

- 1) Remove the two screws and remove protective cover. (Figure 2).

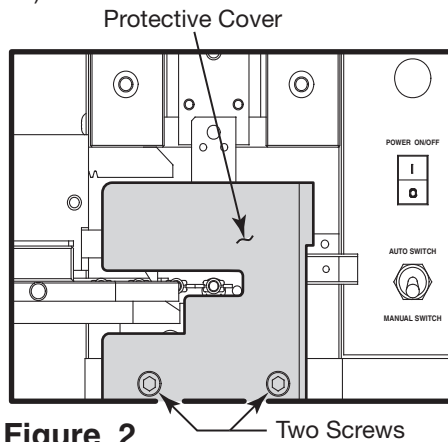


Figure 2

- 2) Remove the holding screws, remove die A and die B (Figure 3).

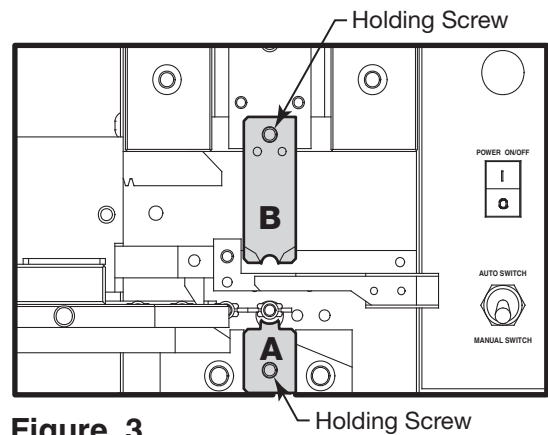


Figure 3

- 3) See Table 1 to choose correct die set.
- 4) Add new dies and tighten holding screws, refer back to Figure 3. **IMPORTANT:** Make sure the text on the die is facing towards the operator.

TABLE 1

Wire Range	Die Set Catalog Number
22-16	RAH22-16
16-14	BAH16-14
12-10	YAH12-10

2.3

REEL AND TERMINAL STRIP INSTALLATION

REEL INSTALLATION (Figure 4)

- 1) Remove knob from spindle.
- 2) To be certain that reel terminal unwinds properly, place reel over the spindle with the label facing the front of the machine.
- 3) Replace knob by sliding it over the end of spindle.
- 4) Check if the reel is fully seated and can be turned freely.

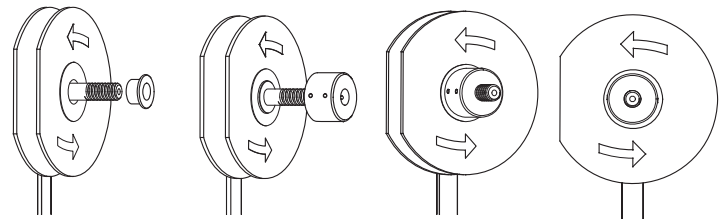


Figure 4

TERMINAL STRIP INSTALLATION (Figure 5)

- 5) Pass strip end through left side of machine and along strip guides until the 1st terminal falls into the die nest.
- 6) Loosen screws 1, 2 and 3 to adjust strip guide width. Make sure the plastic strip engages the strip guides.
- 7) Go to section 2.4 for adjustment of terminal holder and crimp location.

DETAIL A

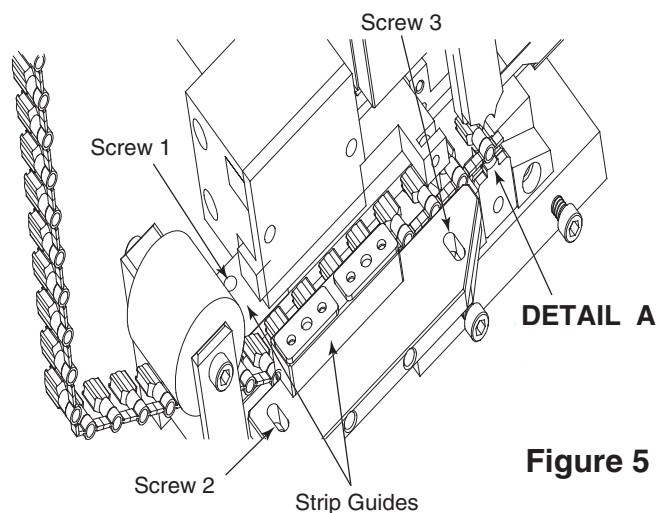
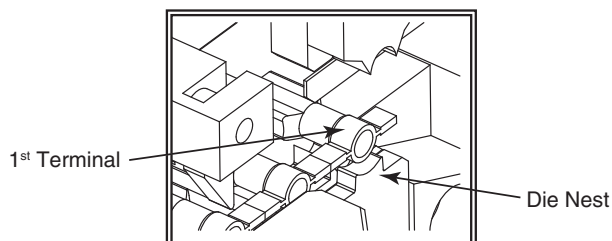


Figure 5

2.4

ADJUSTMENT OF TERMINAL HOLDER AND CRIMP LOCATION

The purpose of the terminal holder crimp adjustment is to vary the closure of the crimp on the insulation portion of the terminal barrel. This provides a secure grip on the wire insulation.

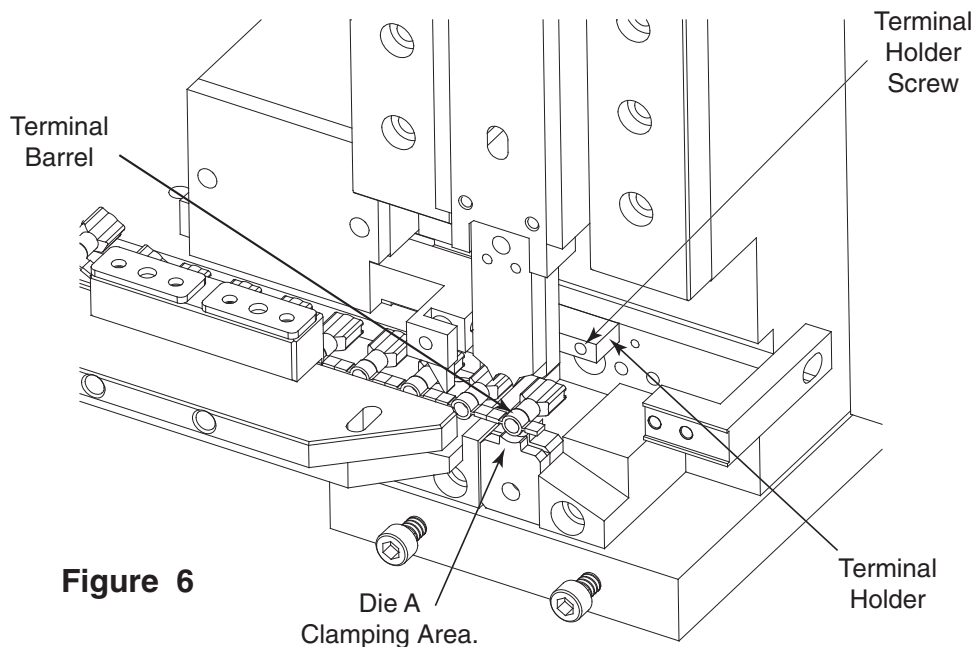


Figure 6

- 1) To move the terminal holder away from terminal, rotate screw on terminal holder (see Figure 6).
- 2) Position the terminal barrel in Die A's Crimping Area (see figure 6) forward or back, to desired position and adjust strip guide (if needed).
- 3) Tighten screws 1, 2 and 3 (See Figure 5 in section 2.3).
- 4) Rotate screw of terminal holder back to engage with terminal.
- 5) Re-attach the protective cover (Figure 2).

2.5

CONNECTING PEDAL AND POWER CORD

- 1) Connect the pedal cord into the pedal connector on back of the machine.
- 2) Connect the power cord into the power socket on back of the machine.

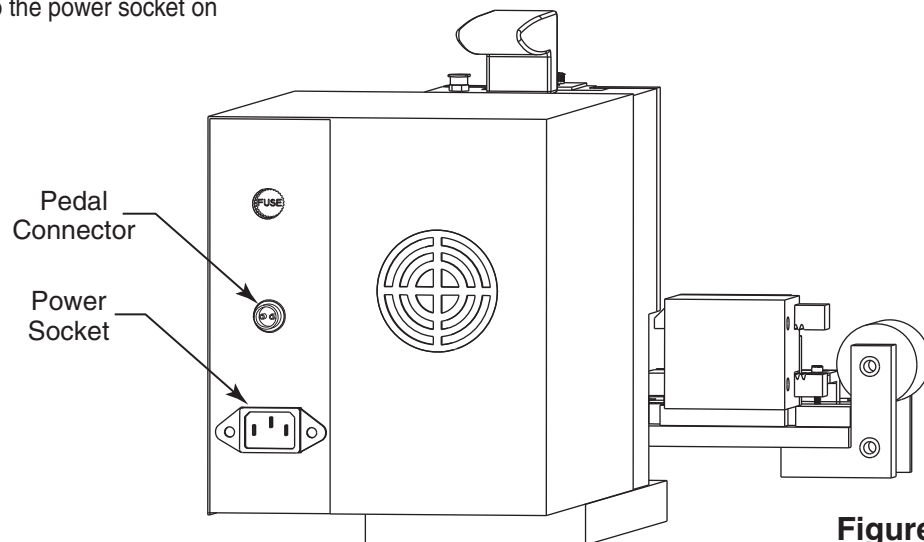


Figure 7

3.0

CRIMPING PROCEDURE

3.1

CRIMPING TERMINALS

- 1) Turn the power switch on.
- 2) Select desired operation mode (Figure 8)
AUTO SWITCH: When operator activates the pedal (see Figure 9), the machine will perform automatically one complete terminal crimp.
MANUAL SWITCH: When operator activates the pedal (see Figure 9), the machine keeps running. When the operator de-activates the pedal, the machine stops running.
- 3) Cycle crimping by depressing pedal until first terminal is clamped between crimping dies. If terminal does not line up properly between dies, check for misalignment. Terminal should be set squarely inside crimping dies. Misalignment may cause damage to the terminal or may make a defective crimp.
- 4) Insert properly stripped wire into terminal barrel and activate pedal. Terminal will be crimped and automatically moved by the strip to the right of the dies.
- 5) To remove, pull wire with crimped terminal out through slot on protective cover.

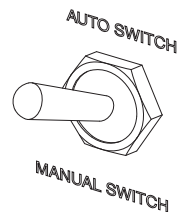
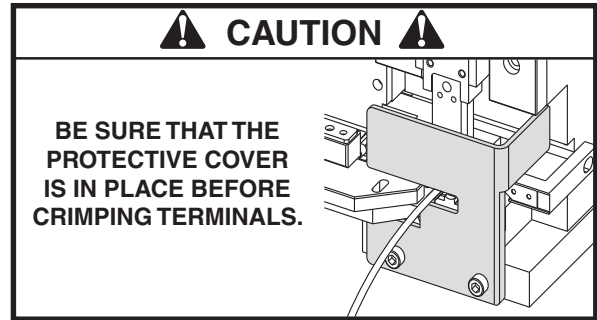


Figure 8

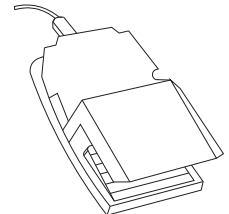


Figure 9

4.0

OTHER ADJUSTMENTS

All other adjustments to the machine not described here should be performed by Thomas & Betts Tool Service Center at 1-800-284-TOOL (8665).

5.0

TERMINAL REMOVER

5.1

CHANGING THE TERMINAL REMOVER

The function of the terminal remover is to assist in removing the crimped terminal from the die area. In general, the operator does not need to change or adjust it. In the event the terminal remover needs to be changed, perform the following steps.

- 1) Turn the power switch off before servicing the machine.
- 2) Remove the protective cover, refer to section 2.2
- 3) Remove the upper die nest.
- 4) Remove the terminal remover by unscrewing the two screws.
- 5) Add new terminal remover and tighten the two screws.
- 6) Re-attach the upper die nest.
- 7) Re-attach protective plate.

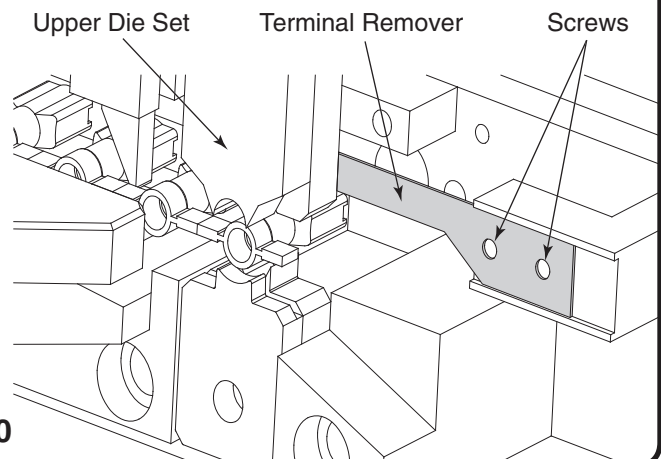


Figure 10

6.1

MAINTENANCE PROCEDURE

- 1) Perform maintenance weekly.
- 2) Inject lubricant into oiling hole in order to lubricate sliding blocks.
- 3) Clean dies and die nest thoroughly making sure no residual oil is left on the dies.

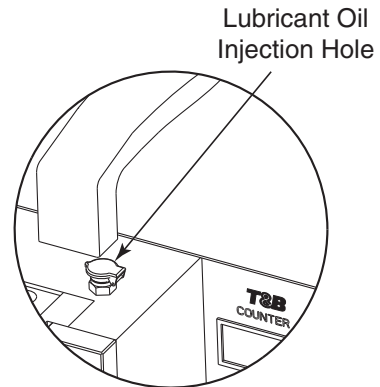


Figure 11

For parts or service, contact the tool service center at 1-800-284-TOOL (8665).

WARRANTY: Thomas & Betts sells this product with the understanding that the user will perform all necessary tests to determine the suitability of this product for the user's intended application. Thomas & Betts warrants that this product will be free from defects in materials and workmanship for the period stated on the enclosed warranty card. Upon prompt notification of any warranted defect, Thomas & Betts will, at its option, repair or replace the defective product or refund the purchase price. Proof of purchase is required. Misuse or unauthorized modification of the product voids all warranties.

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