

TBM45S, TBM41E, AND TBM45BB COMFORT CRIMP® COMPRESSION TOOL WITH SHURE STAKE® MECHANISM CALIBRATION AND GAGING VERIFICATION



IMPORTANT: Read and understand all of the instructions and safety information in this document.

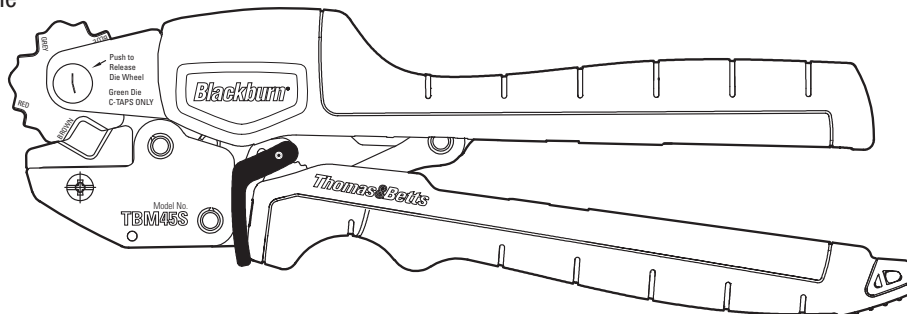


WARNING
KEEP ALL BODY PARTS AWAY FROM DIE NEST
DURING GAGING OR CRIMPING PROCEDURE.



WARNING
HANDLES ARE NON-INSULATING.
DO NOT CRIMP ON HOT ENERGIZED WIRES.

See gaging table
on back page.



In the event the SHURE STAKE® mechanism must be released, please see Figure 2.

Figure 1

1.0

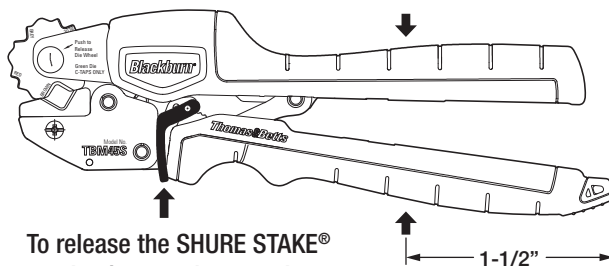
CALIBRATION VERIFICATION

1.1

SHURE STAKE® Mechanism Check



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To release the SHURE STAKE®
mechanism, push up on the
release bar until the ratchet
teeth are disengaged.

Figure 2

1. Make certain all pins, pivot points, and bearing surfaces are protected with a THIN coat of any good SAE No. 20 motor oil. DO NOT oil excessively.
2. Squeeze handles until jaws are fully closed but before SHURE STAKE® mechanism releases.
3. Apply a force gradually at 1-1/2" from end of handles until SHURE STAKE® mechanism releases, see Figure 2.
4. The force required to release the SHURE STAKE® mechanism should be 18 lbs minimum and 36 lbs maximum.

2.0

GAGING VERIFICATION

NOTE: Perform Gaging and Calibration Verification anytime damage to the tool is suspected and on a regular basis to ensure consistent tool performance.

2.1

Visual Inspection

Tool must be free of cracks, sharp edges and any other obvious imperfections that may affect performance of the tool. Nest area must be free of burrs, dents or scratches.

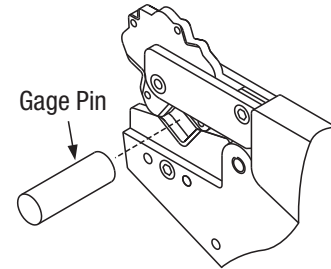
TABLE 1

TBM45S GAGING REQUIREMENTS	
NEST	GAGING MIN – MAX.
RED	.175 – .187
BLUE	.212 – .224
GREY	.265 – .277
BROWN	.324 – .336
GREEN	.406 – .418

2.2

Gaging Procedure

1. Wipe die nest before gaging.
2. Rotate wheel to desired nest.
3. Close handles until SHURE STAKE® mechanism just trips.
4. Insert gage pin into nest. The correct gage pin size should enter nest area freely with a minimum amount of finger pressure. The gaging shall fall within the limits specified in Table 1.



For parts, service, repair and calibration, contact the Thomas & Betts Tool Service Center at 1-800-284-TOOL (8665).

NOTICE: If tool fails any of the above tests, do not attempt repair or adjustment. Call nearest T&B® tool service center to arrange for repair service. Any change, modification or alteration of the tool or use by the customer in a manner other than as specified by T&B® shall void all warranties express or implied and the customer shall, therefore, assume all liability for any damage or injury caused by said changed, modified or altered tool or improper usage or such tool.

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