

COMFORT CRIMP® COMPRESSION TOOL TBM21E, TBM25S & TBM4BB SHURE STAKE® TOOL CALIBRATION VERIFICATION



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



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

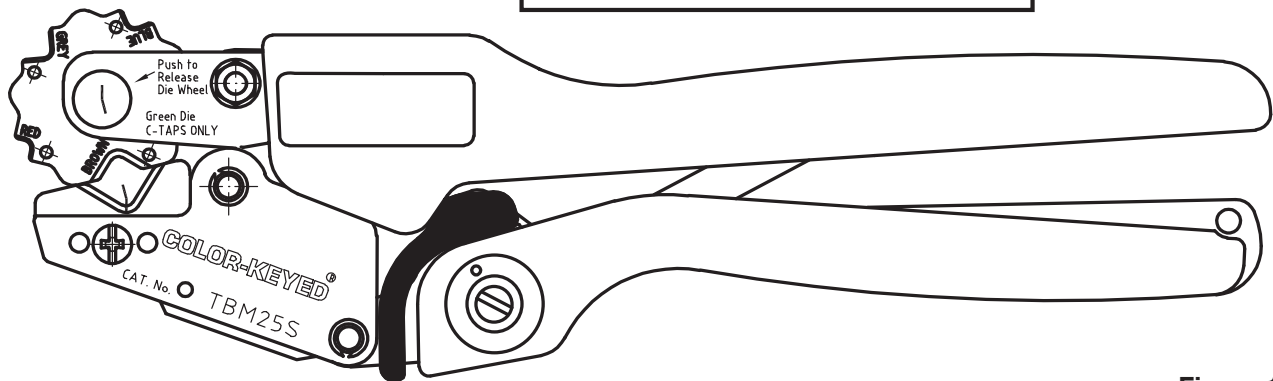


Figure 1

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

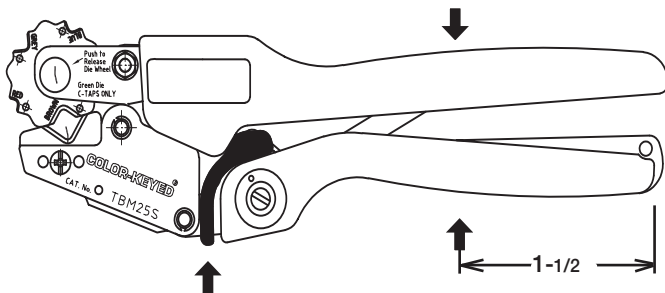
1.0

INSTRUCTIONS FOR USE

1.1 SHURE STAKE® Mechanism



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



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

Figure 2

1.2

Maintenance

1. Remove dust, moisture, and other contaminants with a clean brush or a soft, lint-free cloth.
2. DO NOT use on objects that could damage the tool.
3. 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.
4. Keep handles closed when not in use to prevent objects from becoming lodged in the crimping dies.
5. Store tool in a cool, dry area.

1.3 SHURE STAKE® Mechanism Check

1. Squeeze handles until jaws are fully closed but before SHURE STAKE® mechanism releases.
2. Apply a force gradually at 1 1/2" from end of handles until SHURE STAKE® mechanism releases, see Figure 2.
3. The force required to release the SHURE STAKE® mechanism should be 25 lbs. minimum, 43 lbs. maximum.

2.0

GAGING VERIFICATION

NOTE: Calibration verification procedure should be performed whenever damage or suspected damage has occurred or as often as operation conditions warrant.

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 "A"

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

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 as specified in TABLE "A" (SEE BELOW).

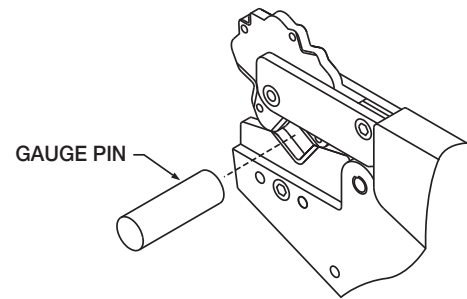


Figure 3

NOTICE: If tool fails any of the above tests, do not attempt repair or adjustment. Call nearest T&B sales office 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 cause by said changed, modified or altered tool or improper usage of such tool.

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

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