

CATALOG No. 13713 INSTALLING DIE INSTRUCTION SHEET FOR USE WITH TOOLS TBM15I, BPLT15BSCR INSTALLS MAGNET WIRE SPLICES AND TERMINALS 2200XX SERIES



PRIOR TO USING THIS TOOL, READ AND UNDERSTAND ALL THE INSTRUCTIONS PERTAINING TO THE TOOL AND CONNECTORS.



ANTES DE USAR ESTA HERRAMIENTA; LEA Y ESTE SEGURO DE ENTENDER TODAS LAS INSTRUCCIONES RELACIONADAS A LA HERRAMIENTA Y LOS CONECTORES.



AVANT D'UTILISER CET OUTIL, VEUILLEZ LIRE ET COMPRENDRE TOUTES LES INSTRUCTIONS SE RAPPORTANT A L'OUTIL ET AUX RACCORDS.

GENERAL SAFETY RULES:

1. **BE FAMILIAR WITH YOUR TOOL.** Read the instruction manual. Become aware of its proper usage as well as the potential hazards that could occur.
2. **KEEP WORK AREA CLEAN AND WELL LIT.** Poor lighting and cluttered areas invite accidents.
3. **USE SAFETY GLASSES.**
4. **DON'T ABUSE TOOL OR HOSE.** Never carry or yank tool by the hose. Protect hose from heat, oil, sharp edges and heavy weights. Avoid all bodily contact with hose while hydraulic pressure is being applied.
5. **MAINTAIN TOOL WITH CARE.** Keep tool in good condition at all times. Keep it clean for best and safest performance.
6. **DISCONNECT PUMP FROM POWER SUPPLY** when not operating tool or when performing any type of service or repairs.
7. **REMOVE WRENCHES** from tool before operating.
8. **AVOID ACCIDENTAL STARTING.** Remove hand or foot from control switch when not actually operating tool.
9. **DON'T OVER-REACH.** Keep proper footing and balance at all times.
10. **BENCH MOUNT OR HANG TOOL ON A TOOL BALANCER.** This frees the operator to better operate the tool.



NEVER ATTEMPT TO MAKE A CONNECTION TO A "HOT" LINE. Never assume the power is OFF! Determine before hand if any electrical hazard could exist before making a connection to a line or wire.

GENERAL DESCRIPTION:

This is an interchangeable die set for use in T&B 15 Ton tools (TBM15I and BPLT15BSCR), to install T&B insulation Piercing Splices and Terminals on Magnet Wire in the 50 to 238 MCM Range.

For certain wire combinations the dies will bottom (close), while for others, because of the wire fill factor, the dies will not bottom. In order to produce an acceptable connection, tools should be checked periodically to ensure they are operating at the proper pressure. See the tool operating manual for details.

Each die set consists of two halves, (**See Figure. 1**), and is designed to readily release the crimped connector. This is accomplished by the flexing of the die nest which necessitates the nest be located in the frame end of the tool as shown in **Figure. 2**.

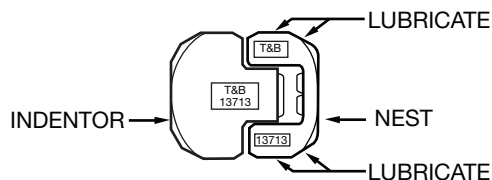


FIGURE 1

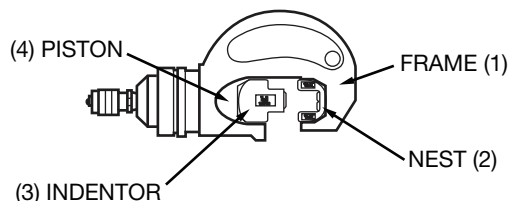


FIGURE 2

The die set is installed in the tool from either side, by laterally sliding each die half into its respective cavity until it locks in place.

- a. Mount the nest (2) in the frame die cavity (1).
- b. Mount the indenter (3) in the piston die cavity (4)

Refer to Instruction Sheets enclosed with the connectors for information on wire sizes, number of wires and proper connectors.

3. Crimp the connector by depressing the foot or hand control switch. Refer to the tool and pump manuals for instructions.

! WARNING !

FOLLOW INSTRUCTIONS CAREFULLY TO ENSURE THAT THE DIE SET IS PROPERLY INSTALLED IN TOOL. FAILURE TO FOLLOW INSTRUCTIONS MAY CAUSE INJURY OR DAMAGE.

! WARNING !

KEEP HANDS CLEAR OF DIES WHEN OPERATING TOOL.

CRIMPING PROCEDURE:

1. Install die set in tool.
2. Select connector to be installed on wire(s). Insert connector into die nest (2) with connector rib in the die nest side wall grooves, and with the open end of the connector facing outward as shown in **Figure 3**.

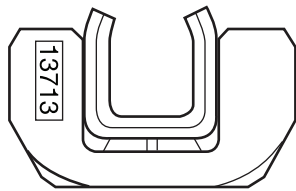


FIGURE 3

! CAUTION !

NEVER OPERATE TOOL WITHOUT A SET OF DIES. INSTALL ONLY T&B CONNECTORS WITH THIS DIE SET. DO NOT CRIMP HARDENED OBJECTS WITH THIS DIE SET. AVOID ALL BODILY CONTACT WITH HOSE WHILE HYDRAULIC PRESSURE IS BEING APPLIED.

PROPERLY MAINTAIN TOOLS AND DIES AT ALL TIMES. In particular keep chips and other foreign material out of the working areas of the tool and the mating surfaces of the dies. Inspect periodically for damage such as cracks, chips, excessive wear, broken or damaged parts, etc, and replace or repair as necessary.

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