



Buchanan® Crimp Tool Products

Amerace Corporation
1065 Floral Avenue
Union, New Jersey 07083

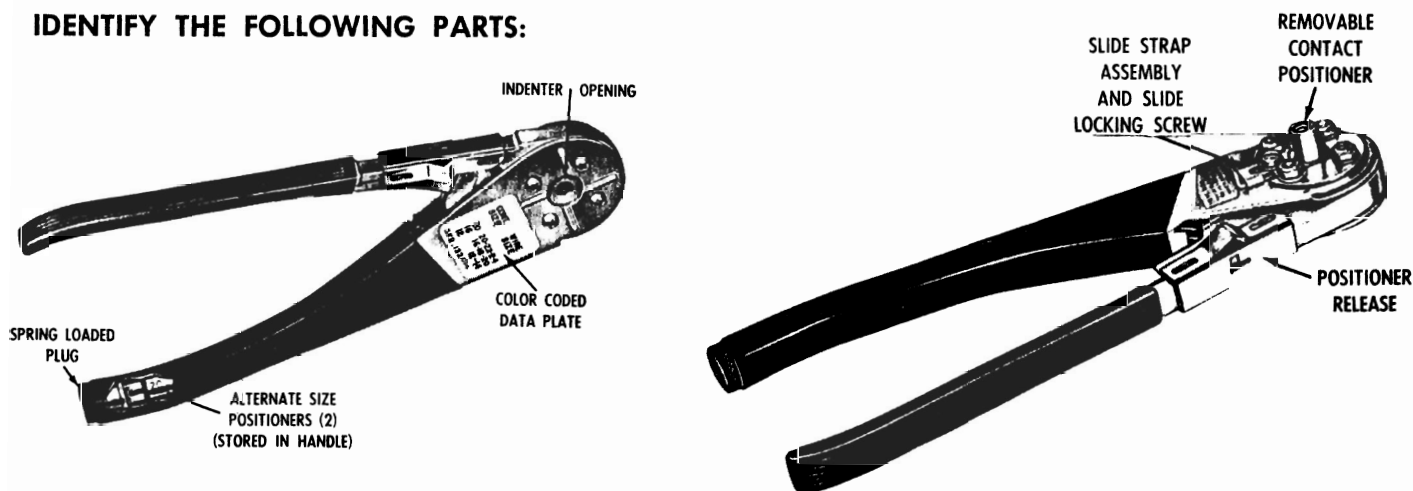
**How to Use the BUCHANAN®
MS 3191-1 HAND CRIMPING TOOL
NATIONAL STOCK NO. 5120-00-064-5631
and Associated Types
Buchanan Catalog #10692**

GENERAL INSTRUCTIONS

A POSITIONER MUST BE INSTALLED TO OPERATE TOOL.

Install positioner. Observe precision ratchet action by opening and closing tool fully several times. Note that tool cannot be opened without completing cycle.

IDENTIFY THE FOLLOWING PARTS:



CAUTION:

There are no adjustments to make. Never attempt to disassemble tool.
Never tighten or loosen ELASTIC STOP® nuts on back of tool.

SETTING UP TOOL FOR OPERATION

- 1** Tool must be in "open" position. Close handles to trip ratchet and then release pressure.
- 2** Loosen slide locking screw. Pull slide to "open" position.
- 3** Pull positioner release all the way down against spring pressure, and insert desired positioner.
- 4** Be sure flat on flange of positioner mates with the flat in handle. Notice that positioners are color coded and stamped for proper contact size identification. Flange of positioner must be flush with handle before positioner slide assembly can be fully closed.

- 5** After positioner is in place, push slide to closed position. (If slide does not close, positioner is not properly installed.) Tighten slide locking screw. Tool is now ready to crimp.

NOTE: Be sure to use the proper positioner for each contact size in the tool. Always store positioners in handle when not in use. Pull spring loaded plug for removal or storage of positioners.

CRIMPING

- 1** Insert prepared contact and wire through the indenter opening into positioner.
- 2** Squeeze handles together until the positive stop is reached. Tool will then release and return to fully "open" position. Remove crimped contact and wire.

IMPORTANT

Lubricate crimping head with Molykote† 505, Dow Corning Corp., Midland, Michigan 48640 or equivalent high quality grease when necessary. Do not use oil. As with any other precision instrument, this tool should be kept clean for long life and optimum performance. To lubricate assembled tool use Lubrication Fitting P/N 10804.

†Registered Trademark of Alpha-Molykote Corporation

INSTRUCTIONS FOR USE OF GAUGES

BY TOOL INSPECTION OR QUALITY CONTROL DEPARTMENTS

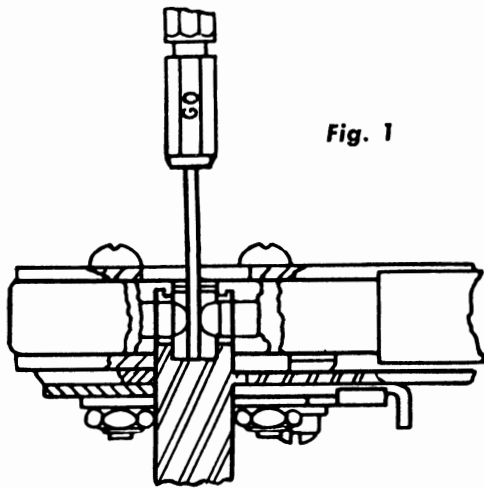


Fig. 1

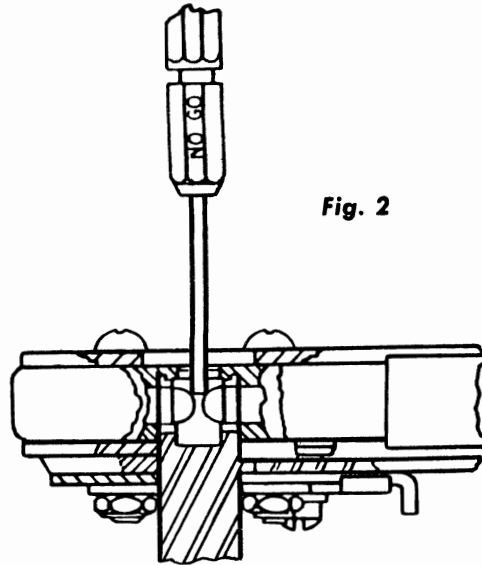


Fig. 2

1 GAUGING – The tool shall be gauged with gauge pin MS 3196-3 and the gauge positioner MS 3196-1 locked in place.

a. "GO" GAUGING – Close tool to fully closed (stop) condition using normal hand pressure (approximately 50 lbs.). Insert "GO" gauge pin into indenter opening. Gauge should pass through indenter opening (Fig. 1). Upon release, tool handles should return to fully open condition.

b. "NO-GO" GAUGING – Close tool to fully closed (stop) condition.

The "NO-GO" gauge pin shall not enter the indenter opening (Fig. 2).

2 RATCHET TEST – This is to determine satisfactory operation of the ratchet by use of the "NO-GO" gauge. Close tool on "NO-GO" gauge pin until a gentle pressure is exerted on the pin.

CAUTION: DO NOT CRIMP GAUGE. The tool shall not bottom and handles shall not automatically return to the fully open condition when the pressure is released.



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