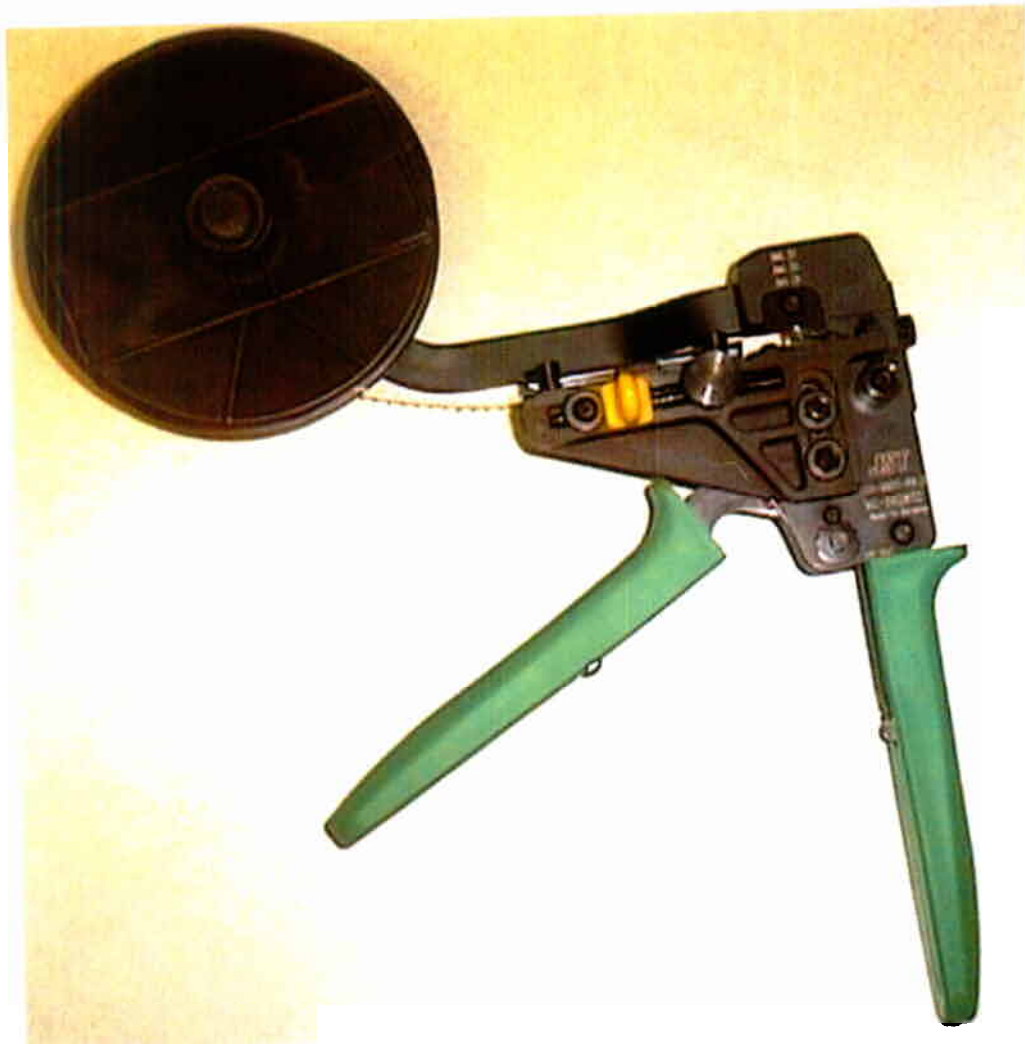




WC-SH2832 HAND TOOL OPERATION MANUAL



WC-SH2832 HAND TOOL FOR CRIMPING SH CONTACT

The WC-SH2832 has been developed as an inexpensive option to crimp prototype and pre-production samples of the SH contact and the crimp forms replicate those found in the semi-automatic crimping dies.

The tool is relatively easy to use but due to the small size of the contact and associated wire, care must be taken to ensure that the wire is correctly placed into the contact prior to crimping.

The tool is supplied with an empty reel to allow loading of strip contacts from a bulk reel.

It is also possible to purchase pre-loaded reels of SH contacts available in reels of 1,000 pieces, please contact JST for further information.

Technical Specification

Hand tool part number: WC-SH2832

Applicable contact part numbers: SSH-003T-P0.2, SSH-003GA-P0.2

Wire size: 28, 30 & 32 awg

Insulation outside diameter: 0.4 ~ 0.8 mm

Strip length: 1.5 mm

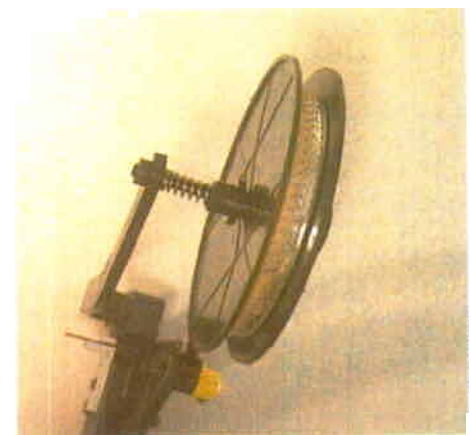
Wire Cross Section	Crimp Height	Crimp Width	Min Tensile (N)
AWG 32	0.38 ~ 0.42 mm	0.70 ± 0.05	3 N
AWG 30	0.40 ~ 0.44 mm	0.70 ± 0.05	5 N
AWG 28	0.43 ~ 0.47 mm	0.70 ± 0.05	10 N

Operation procedure

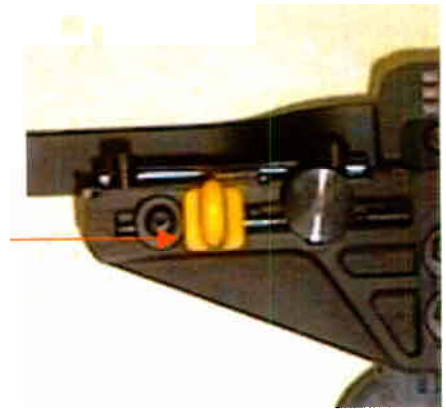
1/ Remove the tool from its protective case and mount the reel of contacts on the reel holder.
(The tool is supplied with one empty reel for self-loading of the SH contacts, or alternatively pre-loaded reels containing 1,000 contacts are available from your JST Sales Office).



2/ Ensure that the reel is central on the spindle and the contacts have unhindered access into the guide track. The axial position can be adjusted by loosening the nut on the spindle and turning the shaft in or out until the desired position is achieved.



3/ Take the end of the contact strip and feed it into the guide track. Ensure that the position of the contact is correct and that minimum force is used to locate the contact, or damage will occur to the contacts. If it is difficult to insert the contact strip, remove from the tool and try again.

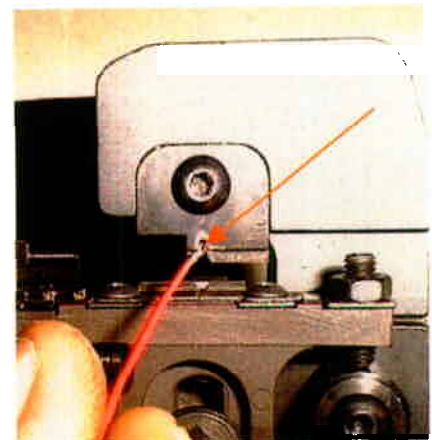


When the contact strip is approximately 50mm into the feed track, the yellow feed lever should be pushed in a right-hand direction until the feed finger engages with the feed holes in the contact strip. It may take a few attempts to engage the contact strip on the feed finger. The lever can then be pushed repeatedly until the first contact is positioned over the crimping anvils.

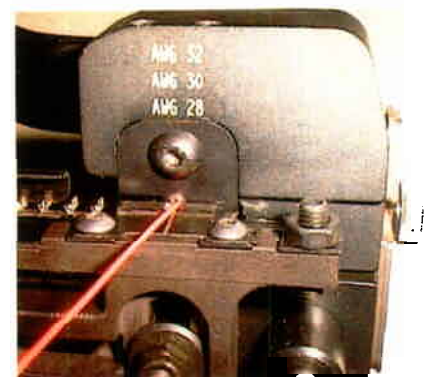
4/ The crimp height of the contact is controlled by the insertion of the appropriate shim into the rear face of the hand tool. The shims are marked for the applicable wire size and are stored on the side of the hand tool. Remove the applicable shim from the side of the hand tool by unscrewing the knurled retaining screw and insert into the rear of the tool by pushing firmly in a forward direction until the shim is firmly located.



5/ Strip the insulation from the end of the wire to be crimped (strip length = 1.5mm). Insert the stripped wire into the upper die of the hand tool and locate the end of the stripped insulation against the wire locator between the two crimping punches. Due to the extremely small size of the wire, it may take several attempts to locate the insulation in the correct position. Once the correct position is established, it will become easier to repeat the correct insertion position on subsequent occasions.



6/ Gently squeeze the handles together whilst ensuring that the wire remains in the correct position relative to the punches. Continue to squeeze the handles together until the handles are fully closed and the ratchet releases the handles to enable them to fully open. Remove the crimped wire from the tool and with the aid of a magnifying lens, inspect the resultant crimp.

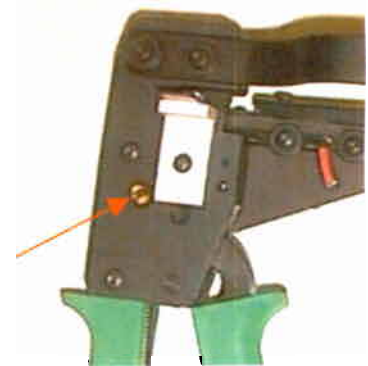


7/ Advance the next contact over the crimping anvils by pushing the yellow feed lever in a right hand direction towards the side of the tool.



If it is desired to remove the strip of contacts from the tool at any time, it is possible to do so by pushing the red lever on the back face of the hand tool in an upward, counter-clockwise direction. This action disengages the feed finger from the contact strip and allows the withdrawal of the strip from the tool in a reversal of the insertion procedure.

8/ If it is necessary to stop the crimping process at any time during the cycle, the handles can be released and the jaws opened by turning the knurled shaft in a counter-clockwise direction with the aid of a small flat head screwdriver.



Rotate counter-clockwise

Maintenance & storage

To ensure the long life of the hand tool, please ensure that any debris is removed from the tool after use and that a thin film of oil is applied to all metal parts to prevent corrosion during storage. Please keep the tool in the storage case to protect it from damage.

Further technical information on the SH contact can be found in the JST technical publication "SH HANDLING MANUAL" (reference: HM-0060 R3)

