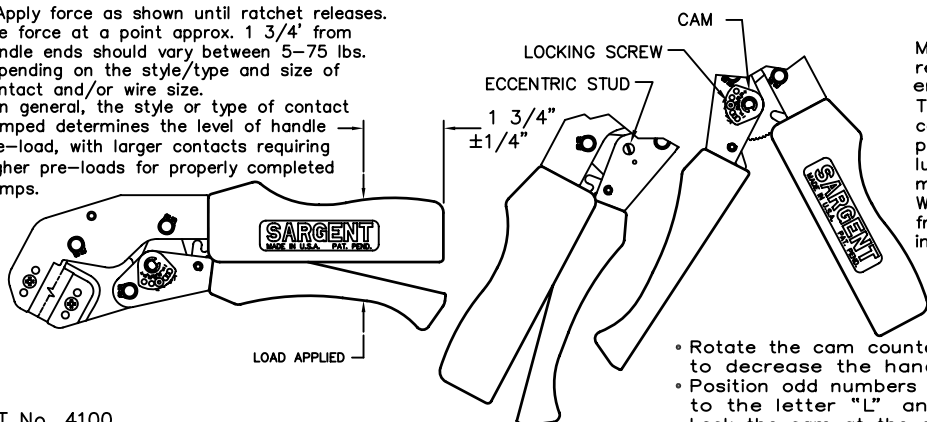


# SARGENT

## 4100 CRIMP TOOL OPERATING PROCEDURE

Apply force as shown until ratchet releases. The force at a point approx.  $1\frac{3}{4}$ " from handle ends should vary between 5-75 lbs. depending on the style/type and size of contact and/or wire size.

In general, the style or type of contact crimped determines the level of handle pre-load, with larger contacts requiring higher pre-loads for properly completed crimps.



PART No. 4100  
(TOOL FRAME)

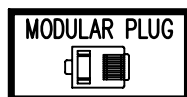
### TOOL MAINTENANCE

Maintenance and inspection should be performed regularly. Tool should be wiped clean with special emphasis on the crimping cavities.

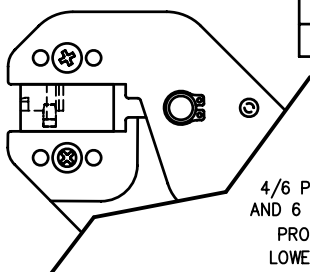
Tool may be cleaned by immersing in a suitable commercial solvent or cleaner which does not attack paints or plastic material. The tool should be re-lubricated after cleaning using a light film of a medium weight oil on bearing surfaces and pivot pins. When not in use, keep handles closed to prevent objects from becoming lodged in the crimping dies and store in a clean dry area.

### ECCENTRIC ADJUSTMENT

- To adjust the tool to obtain the proper force values, open the handles and remove the cam locking screw with a  $1/16$ " hex wrench.
- Rotate the cam counterclockwise to increase handle load or clockwise to decrease the handle load.
- Position odd numbers on the cam in the locking screw hole adjacent to the letter "L" and even numbers adjacent to the letter "T".
- Lock the cam at the desired handle load setting and remeasure force. Continue adjustment if necessary.



CAT No.	NUMBER POSITIONS	MOD. PLUGS ACCOMMODATED
4100-06	4/6 POSITION	RJ-11
4100-06LB	6 POSITION	RJ-11 LONGBODY
4100-08	8 POSITION	RJ-45
4100-10	10 POSITION	10 POSITION

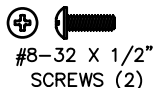


PART No. 4100-06 SHOWN



4/6 POSITION DIES  
AND 6 POSITION DIES  
PROVIDED WITH  
LOWER DIE ONLY

8 & 10 POSITION  
DIES PROVIDED WITH  
TOP SPACER, BOTTOM  
DIE, RIVETS & SCREW



#8-32 X  $1\frac{1}{2}$ "  
SCREWS (2)

5/32 X  $1\frac{1}{2}$ "  
FLAT HD. RIVETS (2)

Strip cable according to manufacturer's specifications. Insert cable fully into connector. Place connector in die, end of modular plug butting against back of die cavity, and close tool completing crimp cycle. Grasp cable near connector and lift and pull to remove cable/plug assembly. Inspect crimp to assure all contacts are crimped and strain relief portion is latched. Test by holding plug and pulling firmly on cable.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

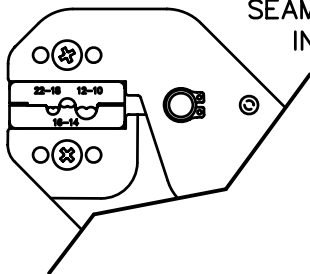
A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

ADJUST RATCHET RELEASE HANDLE FORCE TO **5-15 LBS.** FOR MODULAR PLUGS AS INSTRUCTED ABOVE IN ECCENTRIC ADJUSTMENT SECTION.

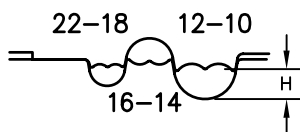


22-10 AWG

SEAM GOES DOWN  
INTO NEST



PART No. 4100-25



GAGING		
NEST	HEIGHT	UL (LBS)
22-18	.079-.075	8, 20
16-14	.095-.091	30, 50
12-10	.127/.123	70, 80

GAGING WITH WIRE SOLDER

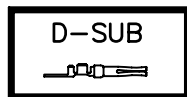
THE NON-INSULATED CRIMP DIE CRIMPS STANDARD NON-INSULATED RING, FORK AND SPADE BRAZED AND UNBRAZED CONNECTORS AS WELL AS MISCELLANEOUS OTHER TYPES OF NON-INSULATED CONNECTORS.

ALL CRIMPS SHOULD BE TESTED FOR ACCEPTABLE TENSILE VALUES FOR THE PARTICULAR TERMINAL AND WIRE BEING USED AND COMPARED AGAINST ACCEPTED STANDARDS (UL OR MIL). VALUES FOR THE INTENDED WIRE SIZES ARE LISTED AND SHOULD BE CHECKED WITH AN APPROPRIATE TENSILE TESTING MACHINE OR OTHER DEVICE.

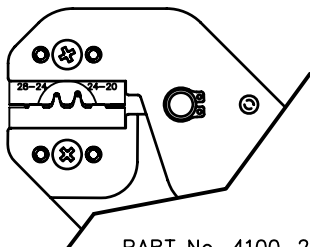
THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

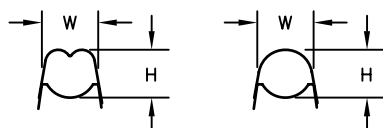
ADJUST RATCHET RELEASE HANDLE FORCE TO **15-30 LBS.** FOR OPEN BARREL TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.



28-20 AWG



PART No. 4100-27



NEST	CONDUCTOR	INSULATION
	HEIGHT	HEIGHT
28-24	.027/.025	.041 MAX.
24-20	.029/.027	.062 MAX.

GAGING WITH WIRE SOLDER

NOTE: SHOULD OVERCRIMPING OF CONTACT RESULT- ADJUST RATCHET RELEASE FORCE TO **30-50 LBS.**

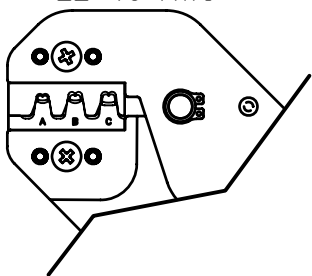
FOR D-SUB. STYLE CONTACTS. GAGE CRIMPS WITHIN SPECIFICATIONS- ADJUST HANDLE PRE-LOADS ACCORDINGLY.

REFER TO ECCENTRIC ADJUSTMENT PROCEDURE ABOVE.

## OPEN BARREL

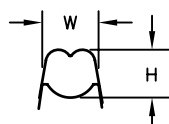


22-10 AWG



PART No. 4100-30 SHOWN

PART No. 4100-29 SIMILAR EXCEPT  
FOR WIRE SIZES



## 4100-30 GAGING INFORMATION

NEST	WIRE SIZE	COND. JAW	
		HEIGHT	WIDTH
A	22-18 AWG	.034 NOM.	.107 NOM.
B	16-14 AWG	.042 NOM.	.111 NOM.
C	12-10 AWG	.070 NOM.	.134 NOM.

## 4100-29 GAGING INFORMATION

NEST	WIRE SIZE	COND. JAW	
		HEIGHT	WIDTH
A	16-20 AWG	.054-.046	.075-.071
B	14-16 AWG	.062-.055	.087-.083
C	22-30 AWG	.030-.025	.067-.063

GAGING WITH WIRE SOLDER

EARLY DESIGN CRIMP DIES HAD TO BE PINNED  
IN PLACE FOR PROPER OPERATION USING THE FOUR  
DOWEL PINS PROVIDED.

TAP PINS IN PLACE WHILE ALIGNING DIE/SPACER HOLES  
WITH HOLES IN TOOL FRAME.

REPEAT PROCEDURE FOR LOWER DIE.

REPLACE THE #8-32 SCREWS AS SHOWN.

LATER DESIGNS HAVE DIE HALVES PINNED TOGETHER AND  
ARE HELD IN PLACE BY THE CENTER SCREW ONLY.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO  
ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR  
REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE  
CONNECTOR.

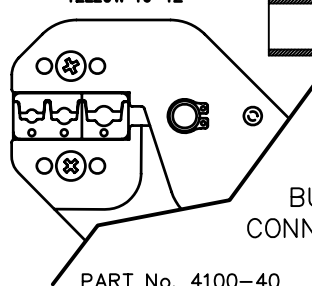
**15-30 LBS.**

ADJUST RATCHET RELEASE HANDLE FORCE TO  
FOR OPEN BARREL TERMINALS AS INSTRUCTED IN THE  
ECCENTRIC ADJUSTMENT SECTION.

## INSULATED

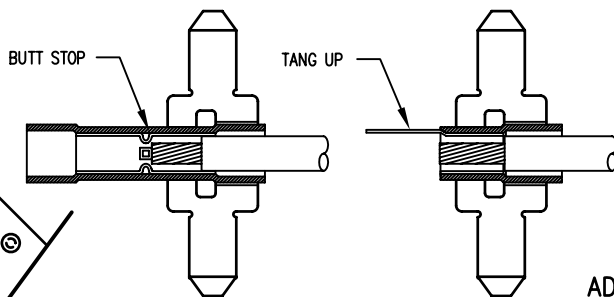


RED 18-22 BLUE 14-16  
YELLOW 10-12



PART No. 4100-40

## DIE FRONT VIEW



BUTT or SPLICE  
CONNECTOR LOCATION

INSULATED  
CONNECTOR LOCATION

NOTE: 4100-20 & -22 INSULATED TERMINAL DIES CRIMP CONDUCTOR PORTION ONLY!

Select the appropriate nest for the terminal or wire  
splice being crimped.

Position terminal or splice as shown in diagram.  
Close tool carefully until jaws grip the terminal  
without distortion.

Insert the properly stripped wire into the terminal.  
Holding the wire in place close the tool past the  
ratchet release position and allow the jaws to spring  
open.

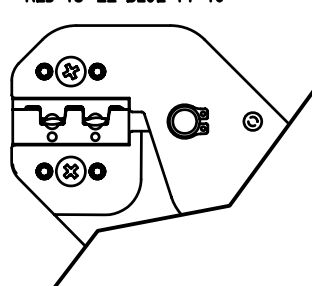
Remove and inspect the crimp.

ADJUST RATCHET RELEASE HANDLE FORCE TO **30-50 LBS.**  
FOR INSULATED TERMINALS AS INSTRUCTED IN THE ECCENTRIC  
ADJUSTMENT SECTION DEPENDING ON WIRE SIZE AND CONNECT-  
OR BRAND AND STYLE OR TYPE.

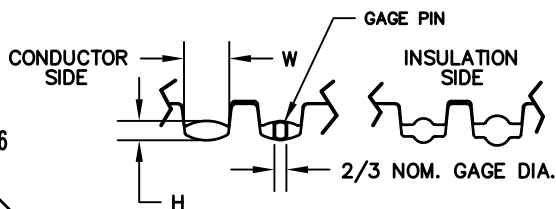
## SLIDE-ON



RED 18-22 BLUE 14-16



PART No. 4100-41



## GAGING INFORMATION

NEST	CONDUCTOR		INSULATION	
	H	W	H	W
22-18 RED	.100 NOM.	.220 REF.	.135 NOM.	.240 REF.
16-14 BLUE	.108 NOM.	.240 REF.	.165 NOM.	.260 REF.

\* GAGING USING FLATTED GO/NO GO PINS WITH  
TOOL CLOSED TO LAST TOOTH OF RATCHET

SELECT THE APPROPRIATE NEST FOR THE TERMINAL  
BEING CRIMPED.

POSITION THE TERMINAL WITH INSULATION SIDE TOWARDS  
THE FRONT OF THE TOOL.

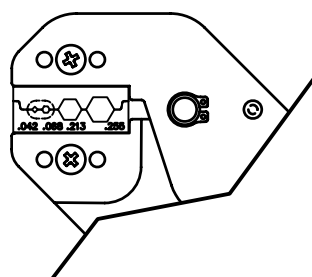
CLOSE THE TOOL CAREFULLY UNTIL THE JAWS GRIP THE  
TERMINAL WITHOUT DISTORTION.

INSERT THE PROPERLY STRIPPED WIRE INTO THE TERMINAL.  
HOLDING THE WIRE IN PLACE, CLOSE THE TOOL PAST  
THE RATCHET RELEASE POSITION AND ALLOW THE JAWS  
TO OPEN.

REMOVE AND INSPECT THE CRIMP.

ADJUST RATCHET RELEASE HANDLE FORCE TO **60-75 LBS.**  
FOR SLIDE-ON TERMINALS AS INSTRUCTED IN THE ECCENTRIC  
ADJUSTMENT SECTION.

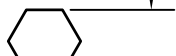
## COAX



PART No. 4100-66 SHOWN

CAT No.	CAVITY HEX. (EXCEPT WHERE NOTED)	CABLES ACCOMMODATED
4100-65	.042(SQ), .068, .128, .151 & .178	RG-174/FIBER OPTIC
4100-66	.042(SQ), .068, .213 & .255	RG58/59/62 (PVC)
4100-67	.042(SQ), .068, .255 & .324	RG58/59 & 8281
4100-68	.076(2) & .429	TWINAXIAL
4100-69	.068, .080, .100 & .429	RG8/11
4100-72	.324 & .360	CATV
4100-75	.151, .178 & .213	FIBER OPTIC
4100-76	.050(SQ), .044(SQ), .206(RO) & .239(RO)	RG58/59 (ROUND)
4100-78	.100, .128 & .429	RG8
4100-79	.128, .151, .178	SC & ST FIBER OPTIC

WIDTH ACROSS FLATS



CENTER CONDUCTOR CRIMP



FERRULE CRIMP

Strip cable according to manufacturer's specifications.  
Select proper hex cavity for size of cable being used.  
Crimp center conductor in area shown. Assemble conn-  
ector and crimp outer ferrule.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO  
ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR  
REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE  
CONNECTOR.

ADJUST RATCHET RELEASE HANDLE FORCE TO **30-50 LBS.**  
DEPENDING ON SIZE OF CONNECTOR & CABLE. LARGER  
CONNECTORS REQUIRE HIGHER HANDLE PRE-LOADS TO  
ASSURE A SECURE AND SYMMETRICAL CRIMP. MEASURE  
EACH CRIMP ACROSS THE FLATS AND ADJUST THE  
HANDLE PRE-LOAD TO OBTAIN SYMMETRY WITHIN .003.



Компания «ЭлектроПласт» предлагает заключение долгосрочных отношений при поставках импортных электронных компонентов на взаимовыгодных условиях!

Наши преимущества:

- Оперативные поставки широкого спектра электронных компонентов отечественного и импортного производства напрямую от производителей и с крупнейших мировых складов;
- Поставка более 17-ти миллионов наименований электронных компонентов;
- Поставка сложных, дефицитных, либо снятых с производства позиций;
- Оперативные сроки поставки под заказ (от 5 рабочих дней);
- Экспресс доставка в любую точку России;
- Техническая поддержка проекта, помощь в подборе аналогов, поставка прототипов;
- Система менеджмента качества сертифицирована по Международному стандарту ISO 9001;
- Лицензия ФСБ на осуществление работ с использованием сведений, составляющих государственную тайну;
- Поставка специализированных компонентов (Xilinx, Altera, Analog Devices, Intersil, Interpoint, Microsemi, Aeroflex, Peregrine, Syfer, Eurofarad, Texas Instrument, Miteq, Cobham, E2V, MA-COM, Hittite, Mini-Circuits, General Dynamics и др.);

Помимо этого, одним из направлений компании «ЭлектроПласт» является направление «Источники питания». Мы предлагаем Вам помощь Конструкторского отдела:

- Подбор оптимального решения, техническое обоснование при выборе компонента;
- Подбор аналогов;
- Консультации по применению компонента;
- Поставка образцов и прототипов;
- Техническая поддержка проекта;
- Защита от снятия компонента с производства.



#### Как с нами связаться

**Телефон:** 8 (812) 309 58 32 (многоканальный)

**Факс:** 8 (812) 320-02-42

**Электронная почта:** [org@eplast1.ru](mailto:org@eplast1.ru)

**Адрес:** 198099, г. Санкт-Петербург, ул. Калинина, дом 2, корпус 4, литера А.