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Instruction Sheet

IS-51

Kontrol IDC Termination Tool Z55-020



CRIMP CONTACT INFORMATION

This IDC Termination Hand Tool is intended for use with the following Kontrol 1.27mm pitch cable connectors:

- M55-820XX42 Female IDC Cable Connector for 30 AWG ribbon cable
(XX = total number of contacts, up to 80)

GENERAL INFORMATION

The Z55-020 IDC Termination Hand Tool ensures the complete and secure assembly of Kontrol IDC connectors. The tool uses a ratchet mechanism and press plate to assemble the connector onto the ribbon cable. The tool is also supplied with a desk clamp, for secure fastening during operation.

The connector is fully assembled once the tool is free to open fully to its original position, i.e., when the ratchet releases. The ratchet will release once the handles have been compressed to the fully closed position and should not be forced open before reaching fully closed.

TOOL PART IDENTIFICATION



ASSEMBLY PROCEDURE

1. Ensure that the crimp tool is on the correct tool setting at number 5 (see figure A). The settings start from 1 and go round the dial clockwise.



Figure A - Tool set at 5

2. Decide whether you will clamp the tool to the desk or use the tool freehand. If clamping the tool to a desk, make sure the tool is securely fastened before use (see figures B and C).



Figure B - Locate clamp into tool undercarriage



Figure C - Tighten the clamp to the work surface

3. Make certain that the hand tool is in the fully open position, and that the jaws are free from dirt and debris.
4. Select a suitable ribbon cable for the connector. Harwin recommends:
 - Wire Type UL2678
 - Wire Pitch 0.635mm
 - Wire Thickness 30AWG

5. Make sure the ribbon is the correct width for the applicable connector, and that the ends are cut clean and straight at the desired length.
6. Feed the cable into the connector, with the Contact 1 wire (normally marked red) positioned correctly to the Contact 1 ident on the connector.
7. Securely place the connector in the tool recess and align it approximately in the center, using the center mark on the tool as a guide (see figures D & E). Exact positioning is not critical.

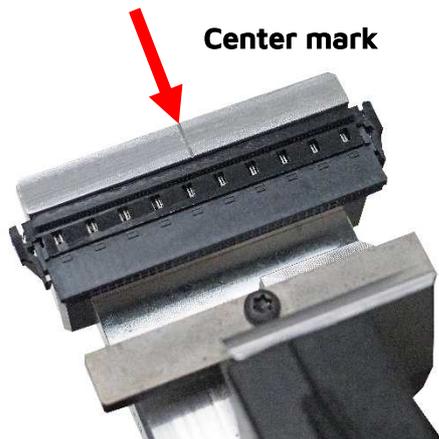


Figure D - Align connector central to tool

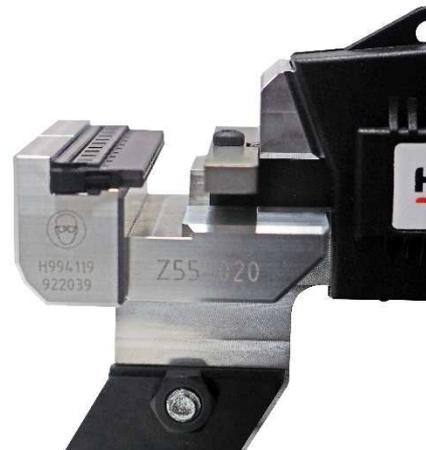


Figure E - Rest connector on outer ledge (ribbon not shown in both images for clarity)

8. Once the connector is secure in the correct position, slowly compress the handle (see figures F and G) until the tool and the connector are fully shut and the ratchet within the tool has released.



Figure F - Tool jaw in contact with connector



Figure G - Mid-compression of handles

9. If assembling a second connector to the cable, take care to ensure the Contact 1 wire is positioned correctly to the Contact 1 ident on this second connector, and the required orientation is used – see figure H for the two orientations. Repeat steps 5 to 8 to assemble the second connector.

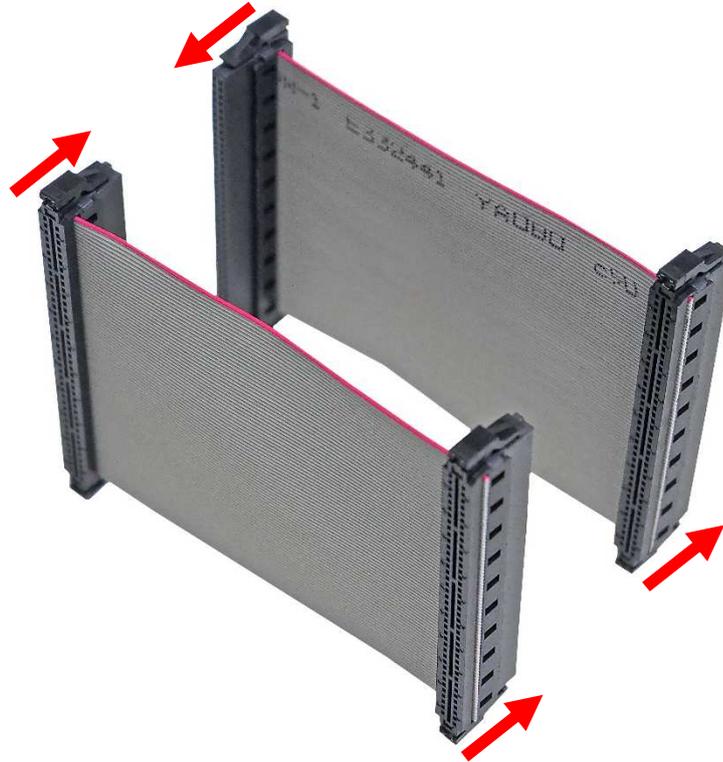


Figure H: Choice of orientation for second connector assembly

TOOL MAINTENANCE

1. Keep the tool clean and free from dirt and foreign matter. Ensure that all pins and clips are in place before use, and that signs of wear are not visible. If the pivots are worn, the tool must be replaced, or integrity of assembly will be compromised.
2. Oil at all pivots and bearings using light cycle oil.
3. At regular intervals, check the assembly tool jaws for wear or damage, and inspect sample connector assemblies for form and function.

If you have any questions about this instruction sheet, or the Kontrol range of connectors, please contact technical@harwin.com.