

# Owner's Manual

4/8 Indent Crimping Tool MicroCrimp 8.78

P/N 8780 0004 61

Cross Section 0,14 – 6,0 mm<sup>2</sup> (AWG 26 – 10)



## Ten 47 Limited

Unit 2B Frances Industrial Park  
Kirkcaldy, Scotland, UK  
KY1 2XZ

Tel: +44 (0)1592 655725

Fax: +44 (0)1592 651049

Email: [sales@ten47.com](mailto:sales@ten47.com)

## Table of Contents

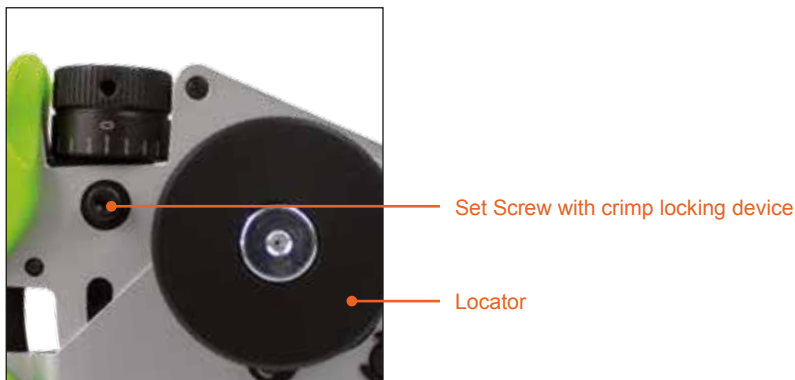
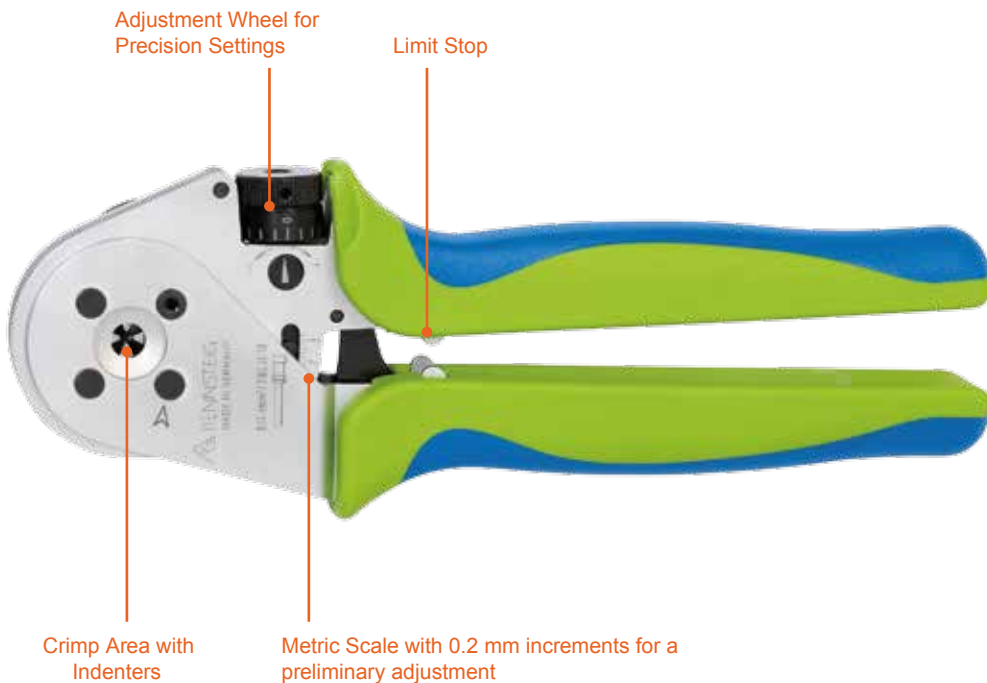
1	General Information	3
2	Operating Instructions	4
3	Exchanging Locators	5
4	Crimp Dimension Adjustment	5
5	Testing with Plug Gauge 2,0mm	6
6	Service and Maintenance	6
7	Crimp Settings for ST485 Contacts	7

---

## 1 General Information

The four indent crimping tool is a pair of handheld pliers, which is manufactured by using the latest technology and the general accepted safety regulations. The pliers may only be used in proper working condition. The four indent crimping tool is used to crimp male and female turned contacts with cross sections of 0,14 - 6,0 mm<sup>2</sup> (AWG 26 - 10) and should be used solely for the purpose, for which it is intended for as described in this manual.

Any unauthorized use or usage not according to the intended purpose is regarded as improper and may cause damage to the tool. Rennsteig will not assume responsibility for such damages.



Icons were used in order to highlight certain text passages. Please follow the instructions and act with greater caution in these particular cases. Please pass along all the safety information to all other users or technical personnel handling the tools

**WARNING!**

This section warns the reader about a potentially dangerous situation that can lead to death or serious physical injury.

**CAUTION!**

This section cautions the reader about a potentially dangerous situation that can lead to minor or moderate physical injury and/or damage to property.

**Please note!**

The information in this section is of particular relevance to the description of a function or an operating procedure.

## 2 Operating Instructions

- Loosen the set screw
- Look up the appropriate crimp dimension settings in the enclosed matrix
- Adjust the crimp dimensions (depth of indenters) by using the adjustment wheel
- Fixate the plier adjustment by using the set screw
- Lift and twist the locator into place to desired setting according to matrix
- Insert prepared cable into the contact to be crimped
- Place the contact with the cable into the crimp area up till the limit stop (the locator ensures the proper placement of the contact to be crimped)
- Close the handle bars of the pliers until you hear the last ratcheting sound
- Open the handle bars of the pliers and remove the crimped contact and cable

**ATTENTION!**

Do NOT crimp onto the plug gauge or other similar objects to avoid damage to the pliers. The crimping of massive materials, which have a hardness grade higher than 35 HRC, should be avoided under any circumstances.

### 3 Exchange of Locators

- Loosen the center hex head screw with an Allen wrench (SW 2.5 mm); you may want to use a second Allen wrench on the opposite side
- Remove the locator
- Fasten the other locator (optional) by using the Allen wrench

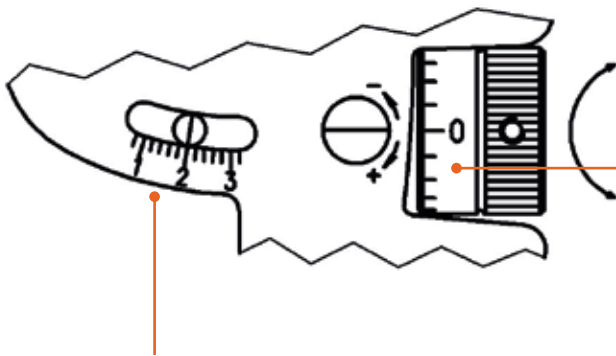
---

### 4 Crimping Dimension Adjustment

All precision settings are adjusted by using the adjustment wheel; the wheel is turned clockwise for crimp dimension decreases and counterclockwise for crimp dimension increases. The adjustment of the crimp dimensions (crimping depth of the indenters) can be changed through the adjustment wheel and may be modified by using the following steps:

#### Positioning accuracy

- 1 scale mark on adjustment wheel = 1/100 mm increment
- 1 360° turn of the adjustment wheel = 0.2 mm increment; indicated on the scale of the adjustment wheel
- 5 360° turns of the adjustment wheel = 1 mm increment; indicated on the scale of the adjustment wheel



Adjustment Wheel with 0.01 mm Increments

- Crimp dimensions decrease (-)
- Crimp dimensions increase (+)

Scale with 1 mm and 0.2 mm Increments

## 5 Testing with Plug Gauge 2.0 mm

Before starting any job, the basic setting of the pliers (crimp dimension of 2.0 mm) needs to be tested.

- Set the adjustment wheel to 2.0 (basic setting). Please note that the crimp dimension setting has to take place from a larger value down to a lower value (for example from 2.05 to 2.0)
- Close the plier handles and insert the plug gauge in between the indenters.

Please note:

- The plug gauge needs to fit snug through the indenters. If this is the case, no deviation exists; the pliers are ready to be used.
- If the plug gauge moves in between the indenters with much clearance or it the plug gauge cannot be inserted at all, the deviation lies outside of the allowable value. The exact value can be determined by the precise setting of the adjustment wheel (+/-). If the value lies outside of the allowance, the manufacturer needs to be informed.



### **ATTENTION!**

The adjustment of the crimp tool should only be executed by authorized and qualified personnel, because improper alignment settings may lead to faulty crimping connections.

---

## 6 Service and Maintenance

The pliers must be in clean and proper working condition before starting any job. Please remove any remains from the crimping procedure from the indenters and locators of the pliers. Please note that all bolts are secured by locking rings.

All repairs need to be performed by the manufacturer or an authorized dealer.

---

## 7 Crimp Settings for ST485 Contacts



### ATTENTION!

Please note the settings shown below are for reference only and contact to wire fit should be checked prior to production use!

Contact P/N	Wire Size	Positioner Location	Setting Value
ST485-18P / GMC 18P	AWG 26	1	0,70
	AWG 24		0,75
	AWG 22		0,80
	AWG 20		0,90
ST485-18S / GFC 18S	AWG 26	2	0,70
	AWG 24		0,75
	AWG 22		0,80
	AWG 20		0,90
ST485-16-13P / GMC-16P-13	AWG 26	3	0,70
	AWG 24		0,75
	AWG 22		0,80
	AWG 20		0,90
ST485-16-13S / GFC-16S-13	AWG 26	4	0,70
	AWG 24		0,75
	AWG 22		0,80
	AWG 20		0,90
ST485-16-26S	AWG 12	4	1,80
ST485-16-26P	AWG 12	5	1,80
ST485-12P	AWG 12	6	1,80
ST485-12S	AWG 12	7	1,80
SHL-PC	1,50	8	1,50
	2,50		1,70
SHL-SC	1,50	9	1,50
	2,50		1,70
ST485-16-15P	AWG 18	3	1,20
ST485-16-15S	AWG 18	4	1,20
ST485-16-20P	AWG 14	3	1,50
ST485-16-20S	AWG 14	3	1,50
ST485-16P / GMC-16P	1,00	3	1,30
	1,50		1,40
	AWG 18		1,20
	AWG 16		1,30
ST485-16S / GFC - 16S	1,00	4	1,30
	1,50		1,40
	AWG 18		1,20
	AWG 16		1,30
ST485-12-30P	4,00	6	2,10
ST485-12-30S	4,00	7	2,10

Contact P/N	Wire Size	Positioner Location	Setting Value
ST485-12-15P	1,00	6	1,60
	AWG 18		1,50
ST485-12-15S	1,00	7	1,60
	AWG 18		1,50
ST485-12-22P	2,50	6	1,80
ST485-12-22S	2,50	7	1,80
ST485-16S-P	1,00	10	1,30
	1,50		1,40
	AWG 18		1,20
	AWG 16		1,35
ST485-16S-S	1,00	11	1,30
	1,50		1,40
	AWG 18		1,20
	AWG 16		1,35
ST485-16S-13P	0,14	10	0,90
	0,25		0,95
	0,35		1,00
	0,50		1,10
	AWG 26		0,90
	AWG 24		0,95
	AWG 22		1,00
	AWG 20		1,10
ST485-16S-13S	0,14	11	0,90
	0,25		0,95
	0,35		1,00
	0,50		1,10
	AWG 26		0,90
	AWG 24		0,95
	AWG 22		1,00
	AWG 20		1,10
ST485-12-20S	1,00	9	1,70
	1,50		1,80
	AWG 18		1,70
	AWG 16		1,90
	AWG 14		2,00
ST485-12-20P	1,00	7	1,70
	1,50		1,80
	AWG 18		1,70
	AWG 16		1,90
	AWG 14		2,10