

NEW

Positronic Industries Series 9550 Automatic Feed, Strip and Crimp Machines

Advanced Design
State-of-the-Art

For Closed-Barrel
Crimp Contacts



Positronic Industries' models 9550-0 and 9550-1 cycle controlled Automatic Feed, Strip and Crimp Machines are pneumatically actuated, and employ double acting cylinders for both the crimp and strip mechanisms. Depending on operator skills, the machines are capable of 1200 per hour crimp cycles, or 600 per hour strip and crimp cycles.

Series 9550 machines are easy to set-up and are easy to operate. Crimp depth and wire insulation strip length settings are made with precision by micrometer handle adjustments, and then locked into place. The crimping mechanism is an eight-indenter device designed for consistent and reliable solderless crimp connections of either solid or stranded wires to closed barrel, crimp contacts.

The 9550-1 machine will crimp size 20 contacts with wire sizes ranging from 20 AWG (0,5mm²) to 28 AWG (0,08mm²). The 9550-2 machine will crimp size 22 contacts with wire sizes ranging from 22 AWG (0,3mm²) to 30 AWG (0,05mm²).

Series 9550 Automatic Feed, Strip and Crimp Machines are bench mounted units of compact size and light weight. The operator has unobstructed access to crimp barrels of contacts when inserting wires to be crimped. The non-glare, flat black finish of the machine permits ease of wire insertion into the crimp barrel. The crimping section of these machines may be tilted forward or away from the operator as desired for operator comfort.

The micrometer handles of the crimp and strip mechanisms are readily accessible when wire gage changes are made. A foot pedal controller activates the automatic feed mechanism, which allows for a "hands free" operation.

Contacts used with the Series 9550 Automatic Feed, Strip and Crimp Machines must be ordered in thermoplastic carriers containing 2000 contacts per carrier. The plastic carriers permit the contacts to be indexed to the crimping mechanism automatically. Should a contact be crimped without a wire inserted in the barrel, the contact need not be removed before automatic crimping can continue.

Series 9550 Automatic Feed, Strip and Crimp Machines may be leased by Positronic customers at a nominal charge.

SPECIFICATIONS:

External Air Supply:	80-100 psi., clean air, oil and moisture free.
Physical Dimensions:	19L x 11D x 21H
Weight:	27 lbs.
Cycle Time Study:	Crimp Only: 1200 cycles per hour. Strip and Crimp: 600 cycles per hour.

CRIMPING INFORMATION

USE INDICATED POSITRONIC TOOLS FOR BEST RESULTS

Step 1: Set up

Connect external air supply, 80-100 P.S.I., to air regulator. Adjust regulator to read 80 P.S.I. **CAUTION! DO NOT OPERATE MACHINE IF AIR SUPPLY CAN NOT BE REGULATED TO 80 P.S.I.!**

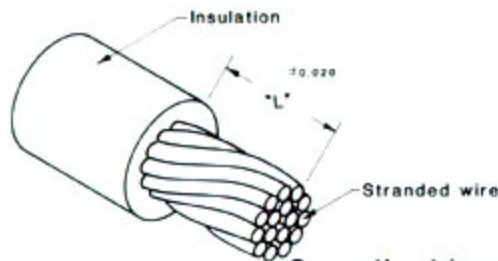
Install contact carrier to reel on arm. Feed contacts down into the slot until the contact carrier snaps into place.

Step 2: Strip wire to indicated length

To strip the wire of insulation, simply insert the wire into the hole in the stripper far enough to hit the trigger. The stripper blades will close and remove the insulation from the wire, and will then retract to open position. The stripped wire can be removed from the stripper. The adjustment to the right of the stripper is for the insulation gripper. The adjustment to the rear of the unit controls the strip length. The adjustment to the left of the stripper adjusts for the wire size.

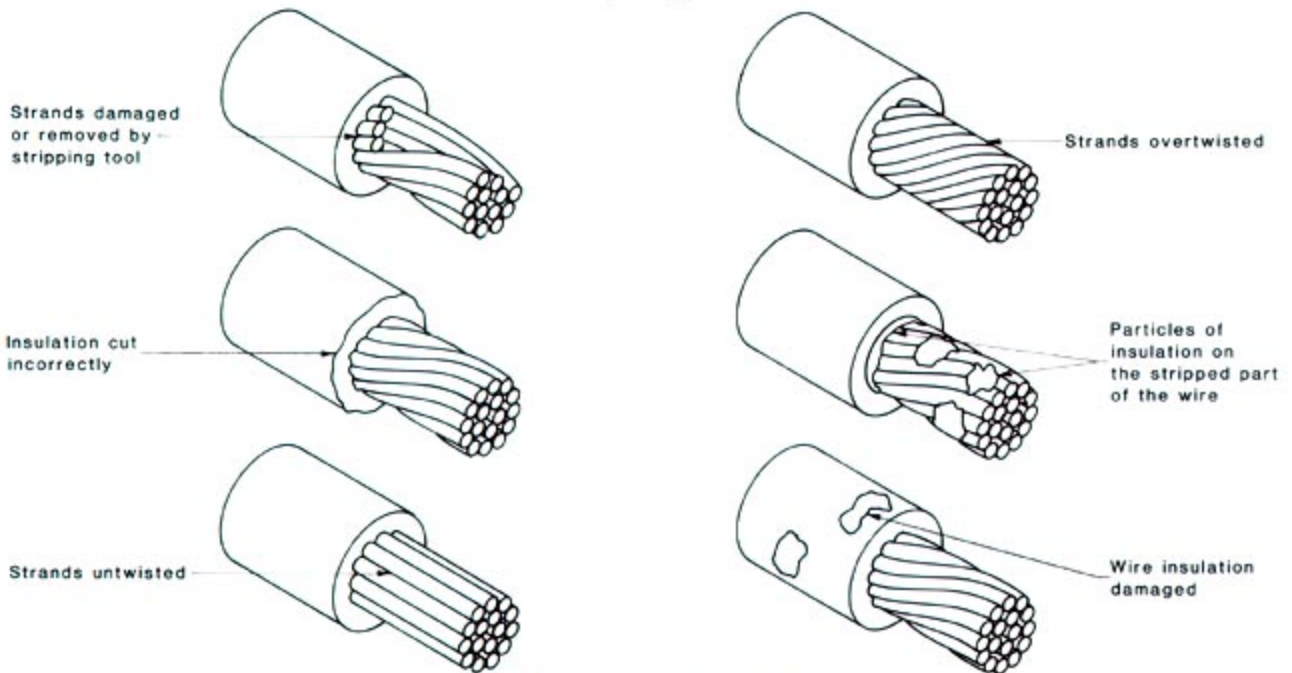
Take care not to:

- Damage or remove strands
- Untwist or overtighten strands
- Leave insulation particles on strands
- Damage insulation



Correctly stripped wire

SERIES	"L"
GMCT,POWR-LOK,VMCT	0.230 (5,84)
SGMC	0.125 (3,18)
ODD,DD	0.150 (3,81)
RD,SD	0.160 (4,06)



Examples of stripping faults

Step 3: Crimp wire to contact

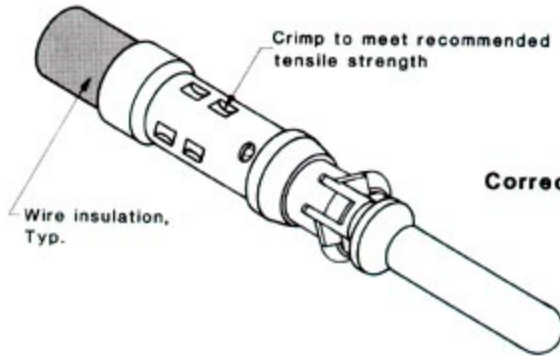
To crimp the contact onto the wire, simply insert the prepared end of the wire into the wire barrel. Depress the foot valve, allow the machine to crimp the contact, and pull firmly on the wire to remove the crimped assembly from the contact carrier. Crimp depth is adjusted using the micrometer at the end of the tool.

Positronic Industries believes the data contained herein to be reliable. Since the technical information is given free of charge, the user employs such information at his own discretion and risk. Positronic Industries assumes no responsibility for results obtained or damages incurred from use of such information in whole or in part.

CRIMPING INFORMATION

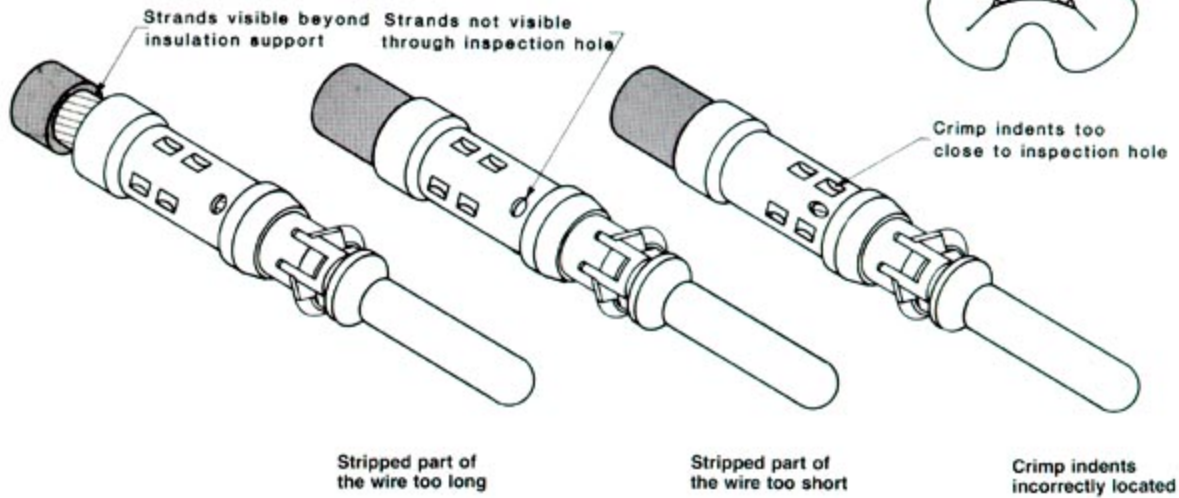
Step 4: Inspect crimp

- For all tools:
- Strands to be visible through the inspection hole
 - Strands not to be visible beyond the insulation support
 - Crimped contact to meet recommended conductor tensile force shown in chart
 - Check for peeled gold and bent contact



Correctly crimped contact

Cross section of correctly crimped contact



Examples of crimping faults

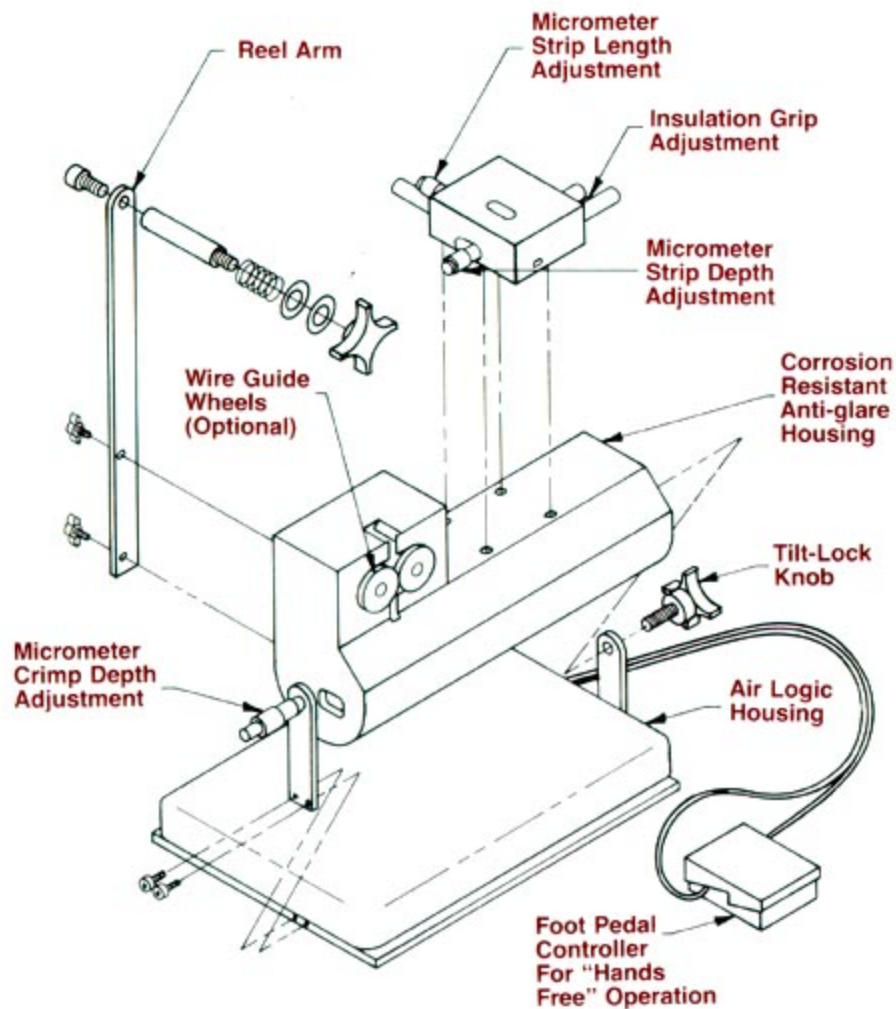
Positronic recommended conductor tensile strength

WIRE SIZE	AXIAL LOAD
12 AWG (4,0mm ²)	110 lbs. (489 N)
14 AWG (2,5mm ²)	70 lbs. (311 N)
16 AWG (1,5mm ²)	50 lbs. (222 N)
18 AWG (1,0mm ²)	28 lbs. (125 N)
20 AWG (0,5mm ²)	20 lbs. (89 N)
22 AWG (0,3mm ²)	12 lbs. (53 N)
24 AWG (0,25mm ²)	8 lbs. (36 N)
26 AWG (0,12mm ²)	5 lbs. (22 N)
28 AWG (0,08mm ²)	3 lbs. (13 N)
30 AWG (0,05mm ²)	1.5 lbs. (6,7 N)
32 AWG (0,03mm ²)	1.0 lbs. (4,4 N)

MODEL	SERIES	CONTACT SIZE
9550-0	GMCT,POWR-LOK,VMCT	16
9550-1	RD,SD	20
9550-2	SGMC,ODD,DD	22

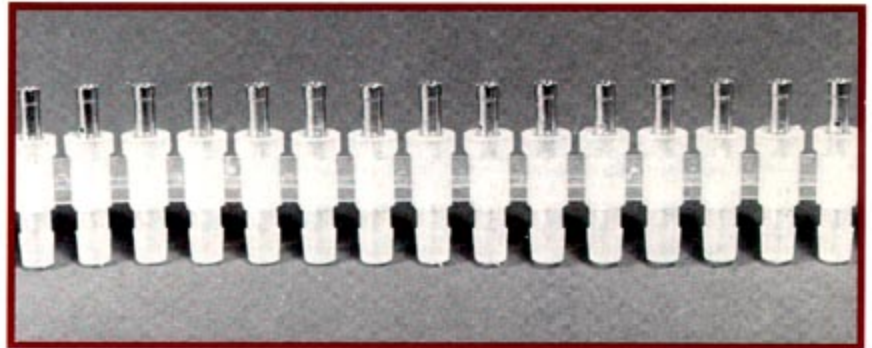
Conductor tensile strength values are derived using silver-tin plated copper wires. Values may change depending upon what type of wire is used.

EXPLODED VIEW OF 9550 SERIES CRIMP MACHINE WITH "EASY SET-UP" ADJUSTMENTS



CONTACT CARRIERS FOR AUTOMATIC FEED TOOL

Molded thermoplastic carriers in a continuous belt feed contacts to the crimp station of the automatic feed tool. They also locate the contacts in respect to the tool's indentors. The carriers are color coded red, blue, yellow, green, orange or natural for contact identification.



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