



# ASTRO TOOL CORP.

## CONNECTOR ASSEMBLY TOOLING CALIBRATION INSTRUCTIONS FOR ASTRO TOOL PART #620215 REF.: M22520/10-01 NSN 5120-00-117-4830

The following method is used to verify and if necessary, calibrate the Astro Tool 620215.

### VERIFICATION

Install Astro part # 631019 or a nominal set of crimp dies, .650"  $\pm$ .0005" stack height. Place the tool in the Astro Tool AT903 spring tester and compress handles together. With the gage block in place, the tool ratchet should release at between 30 and 50 pounds of force.

Install Astro part # 620288 die set (M22520/10-03). Cycle the tool, releasing the ratchet handle at the bottom of the crimp stroke. The tool should not bind and will release to the full open position.

Select a test ferrule, Astro part #7102735-01, and a cable size RG 62/U. Slide the test ferrule over the cable and position in the tool. Place tool in the AT903 spring tester and crimp. The force required to complete the crimp must not exceed 100 pounds.

### CALIBRATION

To adjust ratchet release force, locate the Movable Die Nest, see figure # 1. Holding the tool closed, use a punch pin or suitable object and rotate the Die Nest, and break the bonding agent used to secure the Movable Die Nest in position. Unscrew the drive shaft until several threads are visible along the bottom edge. **Do not remove the Die Nest completely.** Apply a small amount of Loctite™ #222, or equal to the exposed threads.

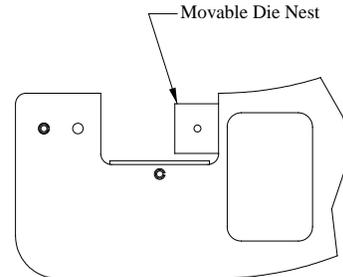


Figure # 1

Install Astro part # 631019 or a nominal set of crimp dies, .650"  $\pm$ .0005" stack height. Rotate the Movable Die Nest until the dies close completely at the bottom of the cycle.

Place the tool in the Astro Tool AT903 spring tester, compress handles together and observe the resulting ratchet pressure. The Ratchet should release between 30 and 50 pounds of force. Rotate the Movable Die Nest counter-clock-wise to increase, clock-wise to decrease ratchet pressure. Set Movable Die Nest to allow for movable die to be pinned in place.

After calibration is completed, the tool should not be cycled for 1 hour to allow the sealant to set.

## ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL, CRIMP TOOLS AND CONNECTOR SERVICE KITS

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