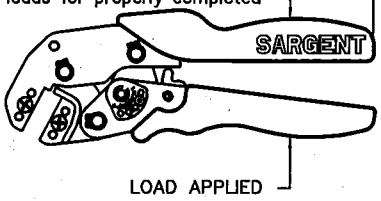
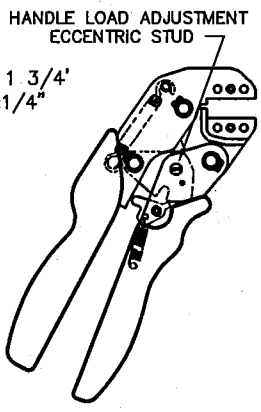
# SARGENT®

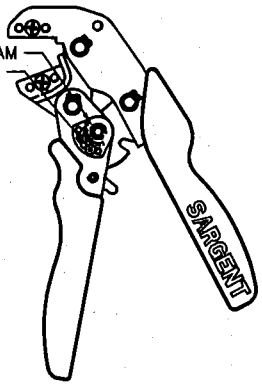
# 2100 CRIMP TOOL OPERATING PROCEDURE

Apply force as shown until ratchet releases. The force at a point approx. 1 3/4' from handle ends should vary between 5–35 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. 2100
(TOOL FRAME)

## TOOL MAINTENANCE

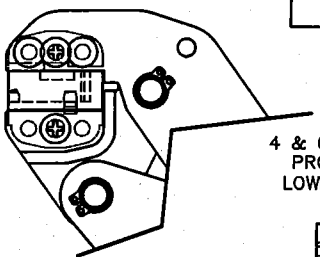
Maintenance and inspection should be performed regularly. Tool should be wiped clean with special emphasis on the crimping cavities
Tool may be cleaned by immersing in a suitable commercial solvent or cleaner which does not attack paints or plastic material. The tool should be re–lubricated after cleaning 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

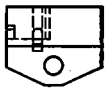
- To adjust the tool to obtain the proper force values, open the handles and remove the cam locking screw with a 1/16" hex wrench.
- Rotate the cam counterclockwise to increase handle load or clockwise to decrease the handle load.
- Position odd numbers on the cam in the locking screw hole adjacent to 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.

MODULAR PLUG

| CAT No. | NUMBER POSITIONS | MOD. PLUGS ACCOMODATED |
|---|---|---|
| 2100–06 | 4/6 POSITION | RJ–11 |
| 2100–08 | 8 POSITION | RJ–45 |
| 2100–10 | 10 POSITION | 10 POSITION |



PART No. 2100–08 SHOWN WITH TOP FRAME SPACER IN PLACE DO NOT USE WITH 6 POS. DIES



4 & 6 POSITION DIES PROVIDED WITH LOWER DIE ONLY

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

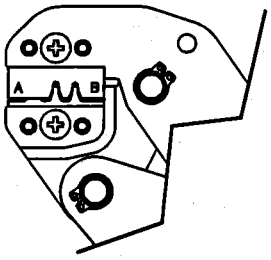
#8–32 X 1/2" SCREW

5/32 X 1/2" FLAT HD. RIVETS (2)

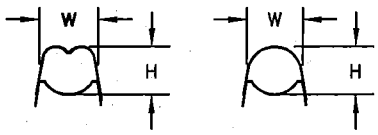
Strip cable according to manufacturer's specifications. Insert cable fully into connector. Place connector in die, end of modular plug butting against back of die cavity, and close tool completing crimp cycle. Grasp cable near connector and lift and pull to remove cable/plug assembly. Inspect crimp to 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.

HI–DENSITY




PART No. 2100–24

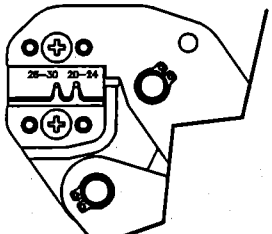



| NEST | CONDUCTOR | | INSULATION | |
|---|---|---|---|---|
| | HEIGHT | WIDTH | HEIGHT | WIDTH |
| A | .032 NOM. | .056 REF. | .057 NOM. | .057 REF. |
| B | .028 NOM. | .054 REF. | .044 NOM. | .054 REF. |

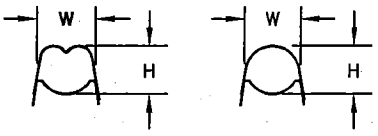
GAGING WITH WIRE SOLDER

D–SUB

30–20 AWG



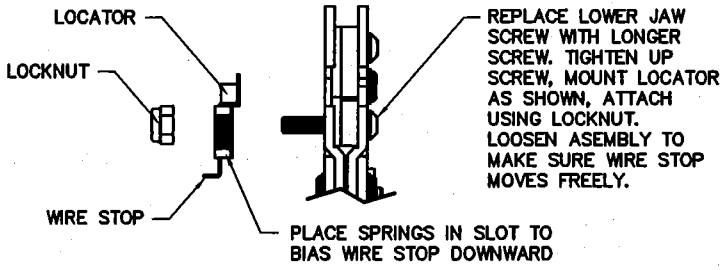

PART No. 2100–27




| NEST | CONDUCTOR | | INSULATION | |
|---|---|---|---|---|
| | HEIGHT | WIDTH | HEIGHT | WIDTH |
| 26–30 | .024 NOM. | .044 REF. | .042 NOM. | .053 REF. |
| 20–24 | .024 NOM. | .055 REF. | .060 NOM. | .057 REF. |

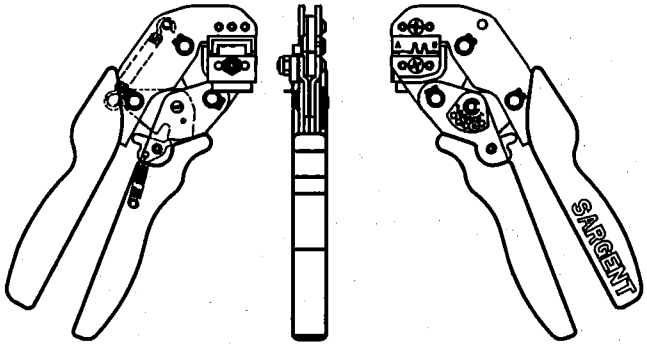
GAGING WITH WIRE SOLDER

## LOCATOR ASSEMBLY PROCEDURE



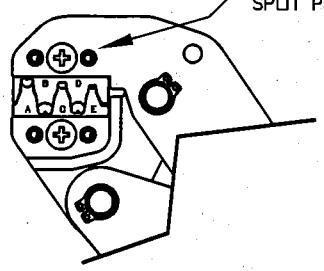

NOTE: SHOULD OVERCRIMPING OF CONTACT RESULT–ADJUST RATCHET RELEASE FORCE TO **15–30 LBS.** FOR D–SUB. AND HI–DENSITY STYLE CONTACTS.
GAGE CRIMPS WITHIN SPECIFICATIONS– ADJUST HANDLE PRE–LOADS ACCORDINGLY.
REFER TO ECCENTRIC ADJUSTMENT PROCEDURE ABOVE.

## LOCATOR/CRIMP TOOL ASSEMBLY

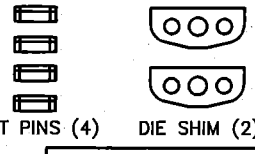


## OPEN BARREL

24–14 AWG



PART No. 2100–28




| GAGING | | |
|---|---|---|
| NEST | HEIGHT | WIDTH |
| A | .118 NOM. | .140 REF. |
| B | .119 NOM. | .134 REF. |
| C | .090 NOM. | .122 REF. |
| D | .068 NOM. | .086 REF. |
| E | .037 NOM. | .074 REF. |

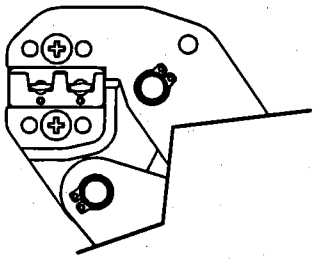
GAGING WITH WIRE SOLDER

THE OPEN BARREL CRIMP DIE HAS TO BE PINNED IN PLACE FOR PROPER OPERATION USING THE FOUR SPLIT PINS PROVIDED.
INSTALL THE UPPER DIE AS SHOWN WITH THE DIE SPACER PROVIDED TO THE REAR OF THE TOOL.
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.
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.

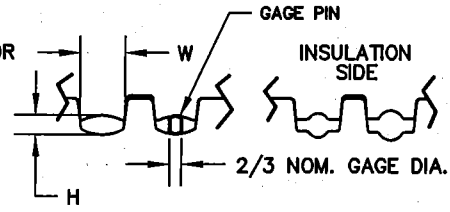
## SLIDE–ON

CONDUCTOR SIDE

RED 18–22 BLUE 14–16



PART No. 2100–42



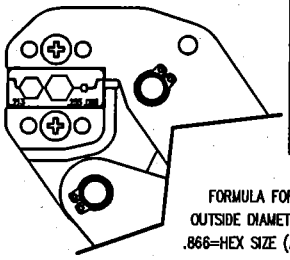

### GAGING INFORMATION

| 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

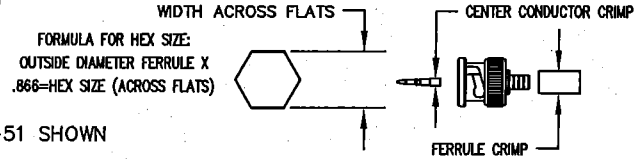
SELECT THE APPROPRIATE NEST FOR THE TERMINAL BEING CRIMPED.
POSITION THE TERMINAL WITH INSULATION SIDE TOWARDS THE FRONT OF THE TOOL.
CLOSE THE TOOL CAREFULLY UNTIL THE JAWS GRIP THE TERMINAL WITHOUT DISTORTION.
INSERT THE PROPERLY STRIPPED WIRE INTO THE TERMINAL.
HOLDING THE WIRE IN PLACE, CLOSE THE TOOL PAST THE RATCHET RELEASE POSITION AND ALLOW THE JAWS TO OPEN.
REMOVE AND INSPECT THE CRIMP.
ADJUST RATCHET RELEASE HANDLE FORCE TO **5–15 LBS.** FOR SLIDE–ON TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.

## COAX



PART No. 2100–51 SHOWN

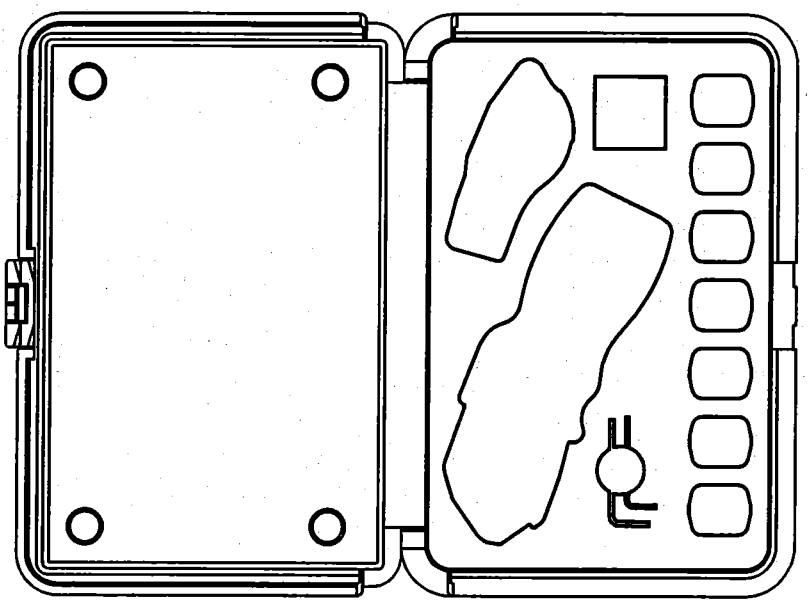
| CAT No. | CAVITY HEX. (EXCEPT WHERE NOTED) | CABLES ACCOMODATED |
|---|---|---|
| 2100–51 | .068,.213 & .255 | RG–58/59/62 (PVC) |
| 2100–52 | .068,.178 & .324 | RG–174 & 8281 |
| 2100–53 | .042(SQ.),.213 & .255 | RG–58/59/62 (PVC) |
| 2100–54 | .042(SQ.),.068,.190 & .213 | RG–58/59/62 (PLENUM) |
| 2100–64 | .068, .255 & .324 | RG–59/8281 |
| 2100–65 | .042(SQ.),.068,.100,.128 & .178 | RG–174/FIBER OPTIC |
| 2100–75 | .151,.178 & .213 | FIBER OPTIC |




Strip cable according to manufacturer's specifications. Select proper hex cavity for size of cable being used. Crimp center conductor in area shown. Assemble connector 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 **25–35 LBS.** FOR COAXIAL AS INSTRUCTED ABOVE IN THE ECCENTRIC ADJUSTMENT SECTION.
PROPER HANDLE FORCE IS BEING UTILIZED WHEN CRIMPS ARE GAGED AND FOUND TO BE WITHIN SPECIFIED TOLERANCE.

DURABLE BLACK PLASTIC CASE WITH BLACK POLYETHYLENE FOAM INSERT TO PROTECT AND STORE TOOL FRAME AND DIES. (12 X 8 X 2 15/16")



CARRYING CASE/FOAM INSERT
TK 2700 KIT BOX AND FOAM

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