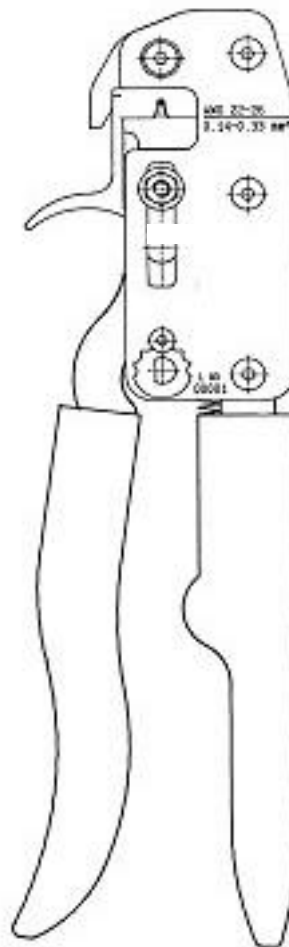


HT270
**Handpistol for Clincher Male and
Female connector**
User's Guide



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1. DESCRIPTION

The Clincher connector handtool HT 270 is designed to terminate Clincher Male and Female connectors from 2 through 34 positions.

2. SPECIFICATIONS

- ?? FCI Clincher Male and Female connector
- ?? Number of positions: 2 through 34
- ?? Product part number:
 - Male clincher 66226-series
 - Female clincher 65801-series
- ?? Cable: flat conductor, flat cable or flexible circuitry
- ?? Conductor width: 1.57 mm

3. OPERATING INSTRUCTIONS

1. Place the handtool in your hand, so that the movable handle (item 2) may be actuated by your thumb.
2. Place Clincher connector on the anvil (item 23a).
3. Place cable well positioned in the connector.
4. Close handtool by moving the handle (item 2) and hold Clincher connector with cable in place.
5. When the handtool is completely closed, the movable handle (item 2) may be returned to its standing position.
6. Repeat procedure 1-4 when a Clincher connector is used with more than 4 positions.
7. Close the connector.

Note:

The handtool has stops, which prevents opening the tool before the clinch action is complete. Should it be necessary, the stop can be released by turning the ratchet wheel at the back of the tool in the direction indicated by the two yellow arrows. Keep the movable handle under light pressure during this operation.

4. ADJUSTMENTS

Adjusting clinch height

1. Use enclosed hollow-head screw wrench number 2 and special wrench with the blue grip. (Hollow-head screw wrench number 2.5 is used for replacing clinch tooling only).
2. After removing the two button cap screws (item 10) it is possible to turn the stop ring (item 9 and 9a)
3. Place the handtool so that the FCI name plate side is up.
4. Turn the eccentric pin (item 8) with special wrench one position in clockwise direction.
5. Check the height of the clinch.
6. If the clinch is still too high, then the eccentric pin should be turned one position further.
7. If the height of the clinch is correct, remount the two button head cap screws (item 10).

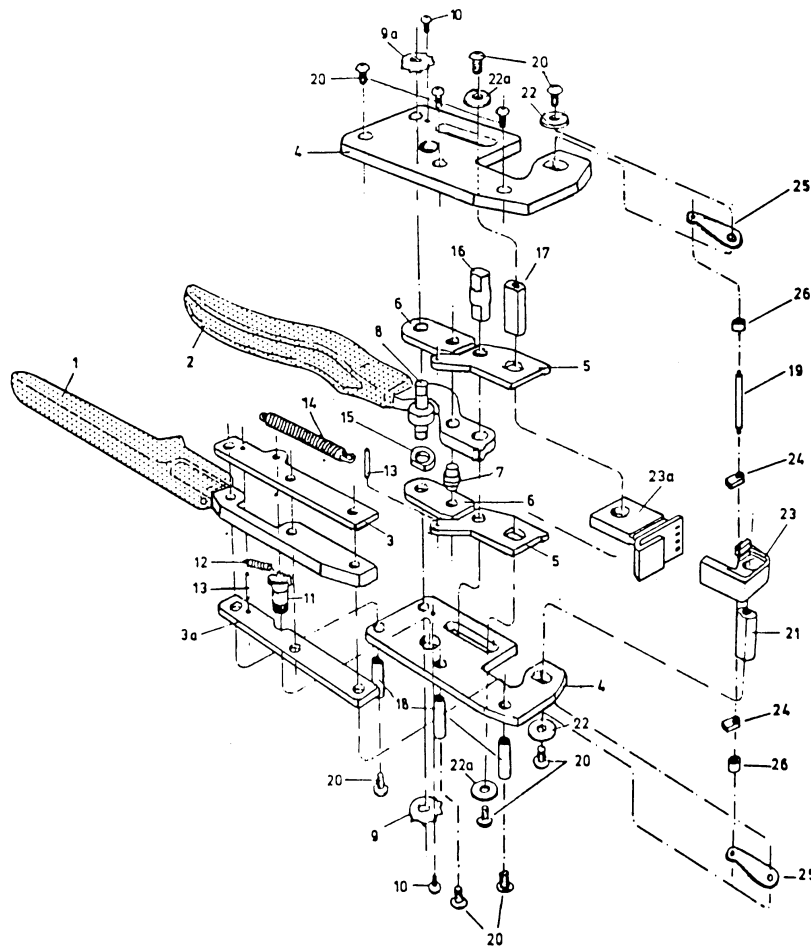
5. MAINTENANCE

- ?? Regular checks must be made on pressplate and anvil.
 - ?? If necessary, these parts may be cleaned.
 - ?? Damaged parts must be replaced immediately. For part numbers see parts list (6.)
 - ?? Movable parts should be lightly oiled. For this purpose use the oil that is enclosed in the case.
- ?? For 20z copper, 0.0711/.0028 thick, laminated between two layers of polyester insulating material - total nominal thickness 0.260/.011:

clinch height should be $0.91/.0360 + 0.076/.0030 - 0.025/.0010$.

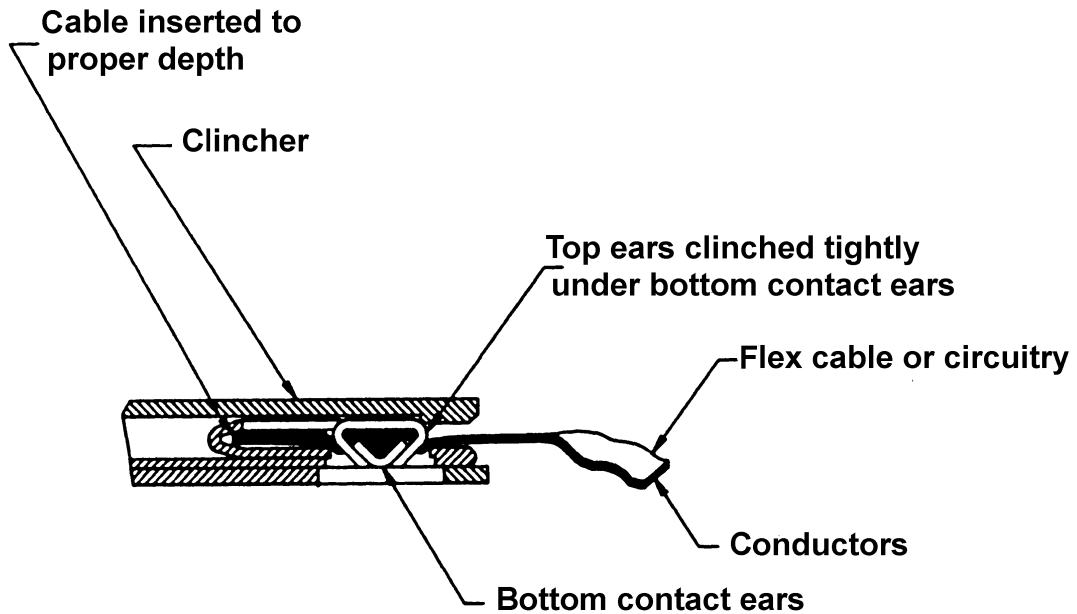
?? For 30z copper, 0.1067/.0042 thick, laminated between two layers of polyester insulating material - total nominal thickness 0.330/.013:
clinch height should be $0.965/.038 ? 0.025/.0010$.

?? For flex circuitry not conforming to IPC FC-2208 cable specification, a clinch height guide of 0.64/.025 added to the circuitry thickness should be used. Clinch height tolerance should be $? 0.025/.0010$.
Because of the variety of circuitry and types of conductive links, consult with a FCI technical representative for specific applications.



exploded view HT 270

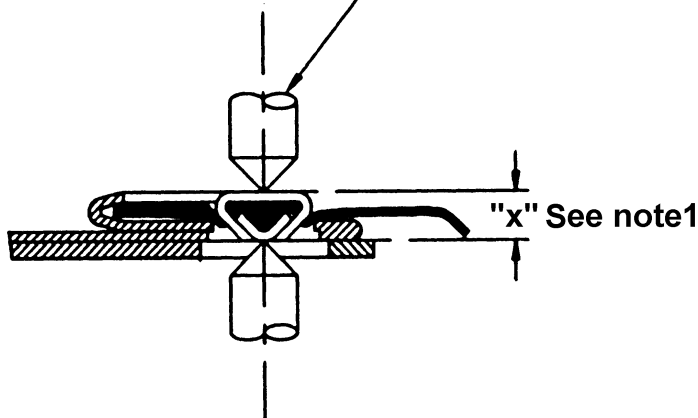
6. TECHNICAL APPLICATION (TA-372)



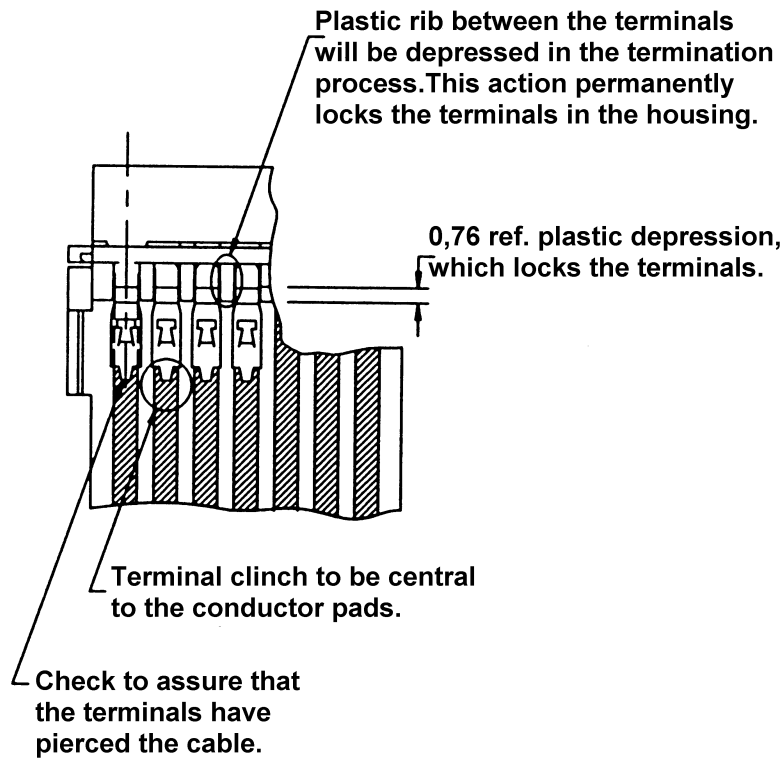
Cross-section of correct terminal crimp

Note 1

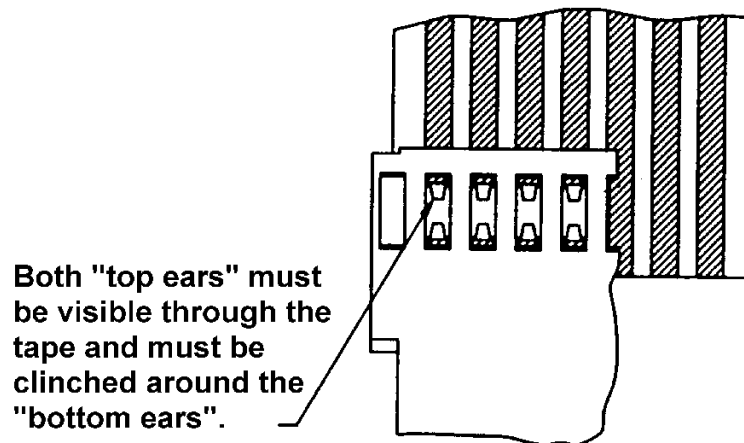
Crimp height micrometer is similar to the Starrett micrometer no.210-a this micrometer may be used to measure "x"



Cross-section of means for measuring crimp heights



TOP VIEW

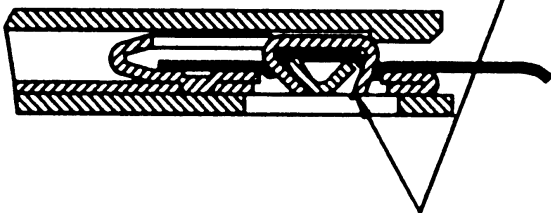


BOTTOM VIEW

Cable is not inserted to the proper depth.
The end of the cable must be cut square and inserted deeper into the connector.



"Top ears" are not clinched under the "bottom ears"
Cause: Possible mis-alignments of connector on tooling anvils in Handtool



"Top ears" are not piercing the cable. Possible cause: Conductors too thick.



Note: Clinch height "x"

7. PARTS see table

1	172380 a	Handle permanent	1
2	190589	Handle mobile	1
3	172382	Upper spacer plate	1
3a	172383	Lower spacer plate	1
4	192650	Cover plate	2
5	172386	Holding plate	2
6	172387 a	Connecting plate	2
7	172388	Hinge pin	1
8	172389	Eccentric pin	1
9	172390	Stop ring, lower side	1
9a	190582	Stop ring, upper side	1
10	5305-003-050	Button head cap screw M3x4	2
11	172391	Pawl	1
* 12	172392	Extension spring No 19	1
13	172393	Pin \varnothing 2x7.8	2
14	172394 a	Extension spring No 35	1
15	190583	Stop roll	1
16	172395	Guide pin	1
17	190591	Stud	1
18	172397	Connecting pin	3
* 19	192651	Shaft	1
20	5305-003-051	Button head cap screw M4x6	10
21	172399	Thread bush crimper	1
22	173584	Washer \varnothing 4.3 DIN 125-ST	2
* 23	190592	Washer \varnothing 12/4.2x1.5	2
* 23a	192788	Press plate and anvil	1 set
* 24	192654	Press plate rotating	2
* 25	192655	Holder plate	2
26	192656	Spacer	2

?? = recommended spare part(s)

 8. CONTACT

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