

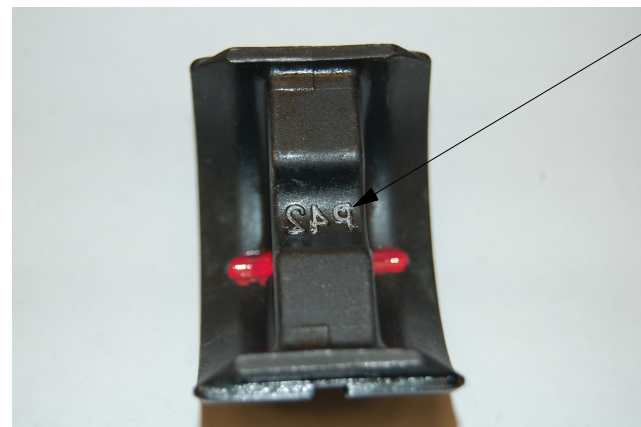
# INSTRUCTIONS FOR THE USE OF GO AND NO-GO PIN GAUGES FOR CD-920 AND CD-940 STYLE CRIMP DIES

Please follow the steps below for the use of pin gauges to check for wear of the Crimp Die set, also for an undersized Crimp Die set.

## STEP ONE

Please select the correct Crimp Die set and the correct gauge pins for the application that you will be checking. Wipe die set clean.

Your die set outside surfaces should look like this.



Your RAISED LETTER die set inside surfaces should look like this. The raised letters in this picture have been painted to show up more clearly. The diameter will be gauged across the surfaces of these letters. In die sets with recessed letters, the pockets will be gauged.

**(A) NOTES:**

- CD-920 CRIMP DIES WITH QC #'S AT OR HIGHER THAN 13287938L, WILL HAVE RAISED DIE INDEX NUMBERS IN DIE POCKET.
- CD-920 CRIMP DIES WITH QC #'S LOWER THAN 13287938L, WILL HAVE ENGRAVED DIE INDEX NUMBERS IN THE DIE POCKET.

SEE DRAWING 10J002BE-JC FOR GO/NO-GO DIE VALUES

For the purposes of this gauging, the upper pin tolerance (NO GO) is  $\pm .001^{vv}$  and the lower pin tolerance (GO) is  $\pm .001^{vv}$ .

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
05	11/9/22	JHNU	JHNU	JADE	REMOVED SHEET 7 FROM DRAWING, SEE DRAWING 10J002BE-JC FOR GO/NO-GO VALUES	127162
04	07/14/20	BJPU	JEH	JADE	ADDED TWO P/N'S, UPDATED NOTES AND DWG FORMAT, WAS CONTROL DRAWING (A)	084605
03	9/4/14	BJPU	BJPU	ABJ	REVISED AND REDRAWN ON TEAM CENTER, NO DIMENSIONS CHANGED	4763
02	8/6/14	BJPU	BJPU	ABJ	UPDATED WITH +/- .001" TOLERANCE ON PIN DIAMETER	4763
01	7/29/14	BJPU	BJPU	ABJ	UPDATED WITH CD-940-750 INFORMATION	4763
00	7/9/14	BJPU	BJPU	ABJ	RELEASE FOR KOREAN SALES	4763

TITLE <b>INSTRUCTIONS, GAGING CD-920 / CD-940 FMY'S</b>			
(A) CUSTOMER DRAWING			
ITEM REVISION NAME R27416AB/04		<b>PANDUIT</b>	
DATASET FILE NAME R27416AB_DC_TP27416B01/04			
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]			
.x ± .1 [ 2.54 ]		.xxx ± .005 [ .127 ]	
.xx ± .01 [ .25 ]		ANGLES ± 1°	
		THIRD ANGLE PROJECTION	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
DRAWING NUMBER: <b>TP27416B01</b>			SIZE B
SHT 1 OF 6			

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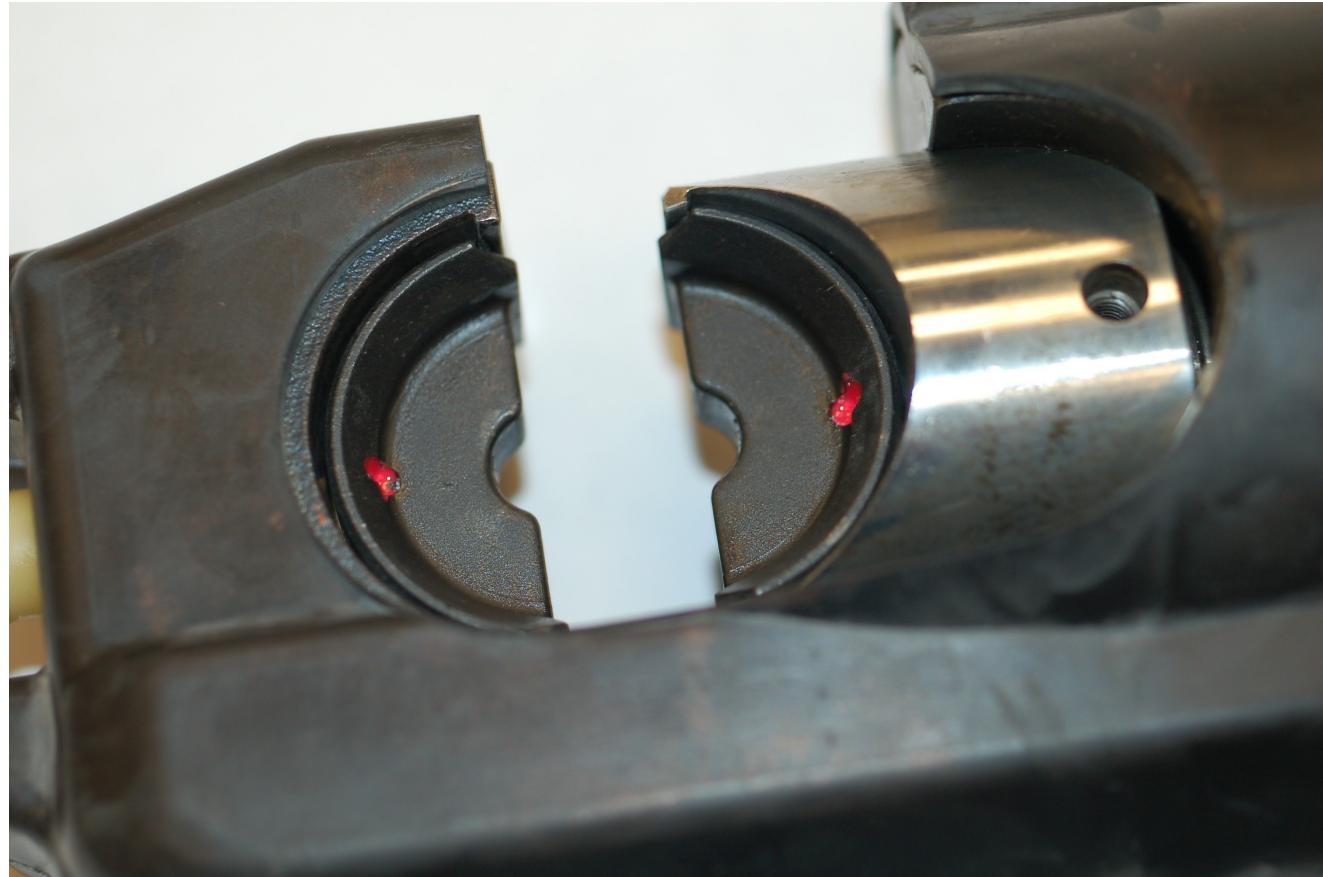


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# STEP TWO

Insert the correct Crimp Die in the correct tool as shown in the picture below.



Pull the top release die button to insert the die into the non-movable (upper) portion of the tool. Push in the release button to insert the die into the moving (lower) portion of the tool. Make sure the Crimp Dies are fully engaged and aligned with each other.

SEE DRAWING 10J002BE-JC FOR GO/NO-GO DIE VALUES

REV	DATE	BY	CHK	APR	DESCRIPTION	ECN
05	11/9/22	JHNU	JHNU	JADE	SEE SHEET ONE FOR DRAWING CHANGES	127162
04	07/14/20	BJPU	JEH	JADE	SEE SHEET ONE FOR DRAWING CHANGES	084605
03	9/4/14	BJPU	BJPU	ABJ	SEE SHEET ONE FOR DRAWING CHANGES	4763
02	8/6/14	BJPU	BJPU	ABJ	SEE SHEET ONE FOR DRAWING CHANGES	4763
01	7/29/14	BJPU	BJPU	ABJ	SEE SHEET ONE FOR DRAWING CHANGES	4763
00	7/9/14	BJPU	BJPU	ABJ	RELEASE FOR KOREAN SALES	4763

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UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]		MATERIAL: NONE	
.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]	DRAWING NUMBER: <b>TP27416B01</b>	
.xx ± .01 [ .25 ]	ANGLES ± 1°	THIRD ANGLE PROJECTION	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
SHT 2 OF 6			SIZE B

2



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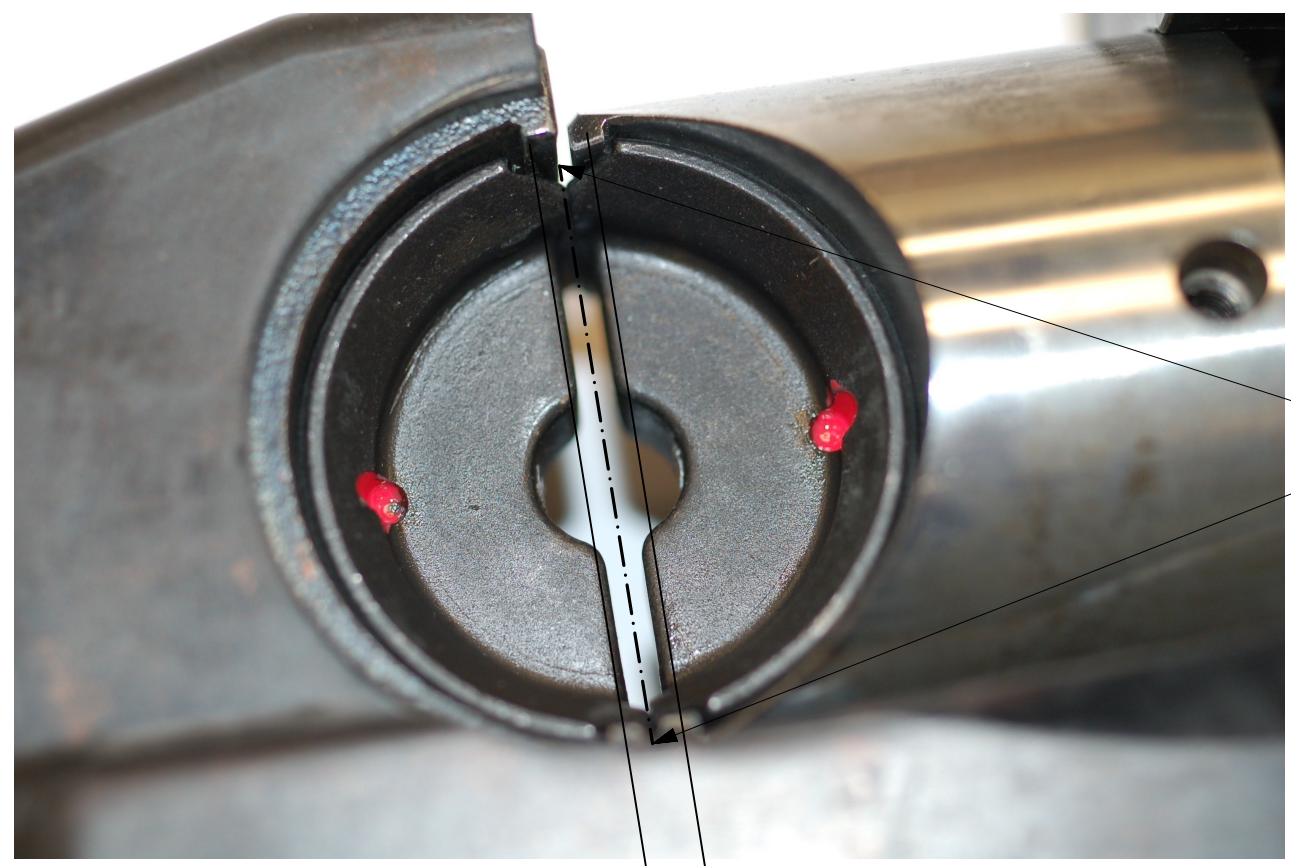


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### STEP THREE

Close the Crimp Dies in the tool so that they are completely against one another as shown below. The jaws should be brought together so they just meet and touch. The dies should NOT be able to be moved in this position. This will confirm that there is enough force to close them, but not enough force to compress them.



Die halves touch here

Parts are aligned and under slight pressure to meet and NOT move. NOT under full tool pressure!

SEE DRAWING 10J002BE-JC FOR GO/NO-GO DIE VALUES

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00	7/9/14	BJPU	BJPU	ABJ	RELEASE FOR KOREAN SALES	4763

TITLE <b>INSTRUCTIONS, GAGING CD-920 / CD-940 FMY'S</b>			
Ⓐ CUSTOMER DRAWING			
ITEM REVISION NAME R27416AB/04		<b>PANDUIT</b>	
DATASET FILE NAME R27416AB_DC_TP27416B01/04			
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]			
.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]	MATERIAL: NONE	
.xx ± .01 [ .25 ]	ANGLES ± 1°	DRAWING NUMBER: <b>TP27416B01</b>	
THIRD ANGLE PROJECTION		DRAWING NUMBER: SHT 3 OF 6	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
			SIZE B

2



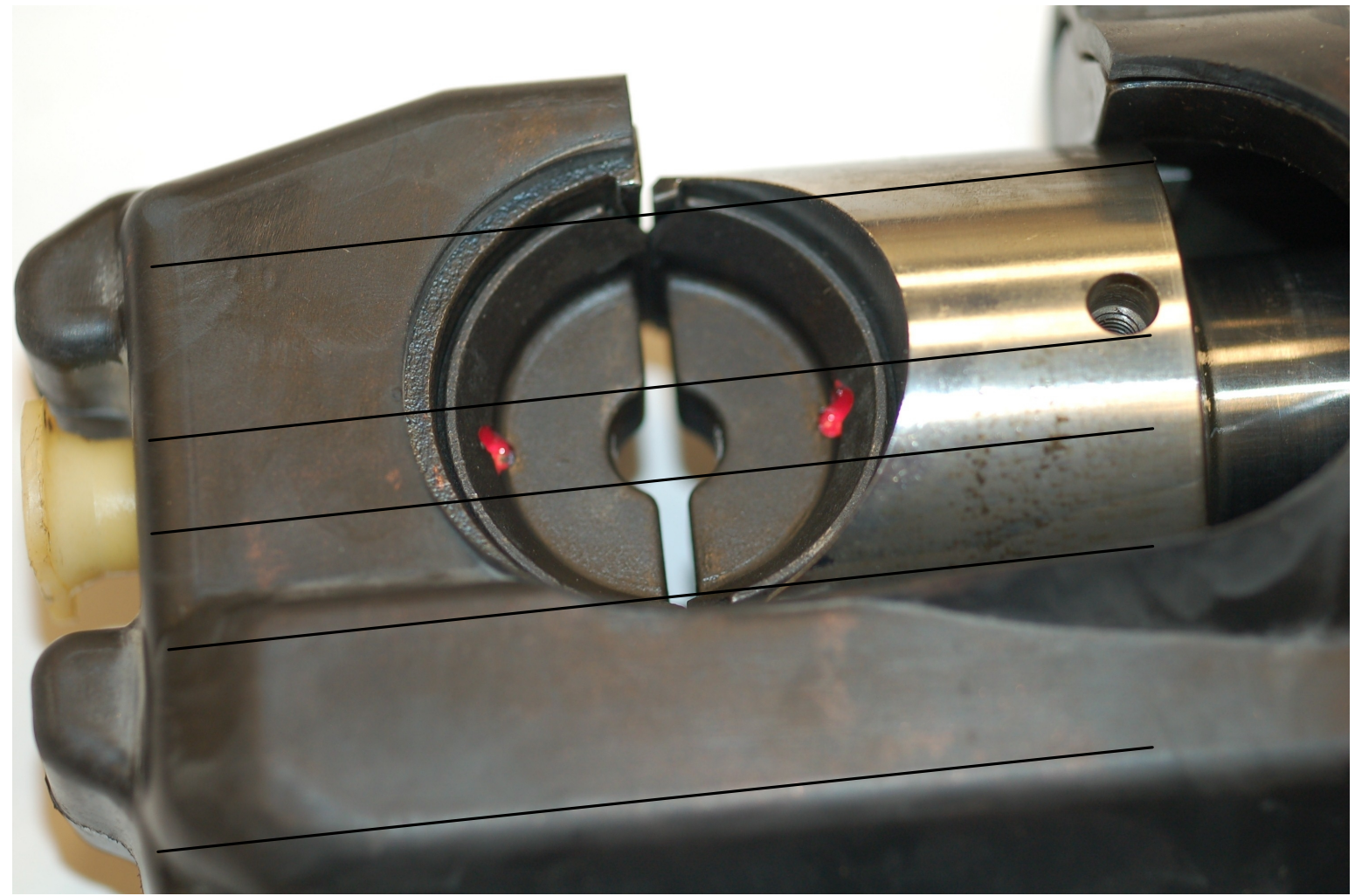
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# STEP FOUR

Check to see if both Crimp Dies are in-line with one another and centered in the tool.



The Crimp Dies should be aligned so that the maximum diameter pin can be inserted between the dies in the tool. If they are not aligned, a false GO or NO-GO could be seen.

SEE DRAWING 10J002BE-JC FOR GO/NO-GO DIE VALUES

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00	7/9/14	BJPU	BJPU	ABJ	RELEASE FOR KOREAN SALES	4763

TITLE <b>INSTRUCTIONS, GAGING CD-920 / CD-940 FMY'S</b>			
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ITEM REVISION NAME R27416AB/04		<b>PANDUIT</b>	
DATASET FILE NAME R27416AB_DC_TP27416B01/04			
UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [ mm ]			
.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]	MATERIAL: NONE	
.xx ± .01 [ .25 ]	ANGLES ± 1°	DRAWING NUMBER: <b>TP27416B01</b>	
THIRD ANGLE PROJECTION		SIZE B	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
SHT 4 OF 6			

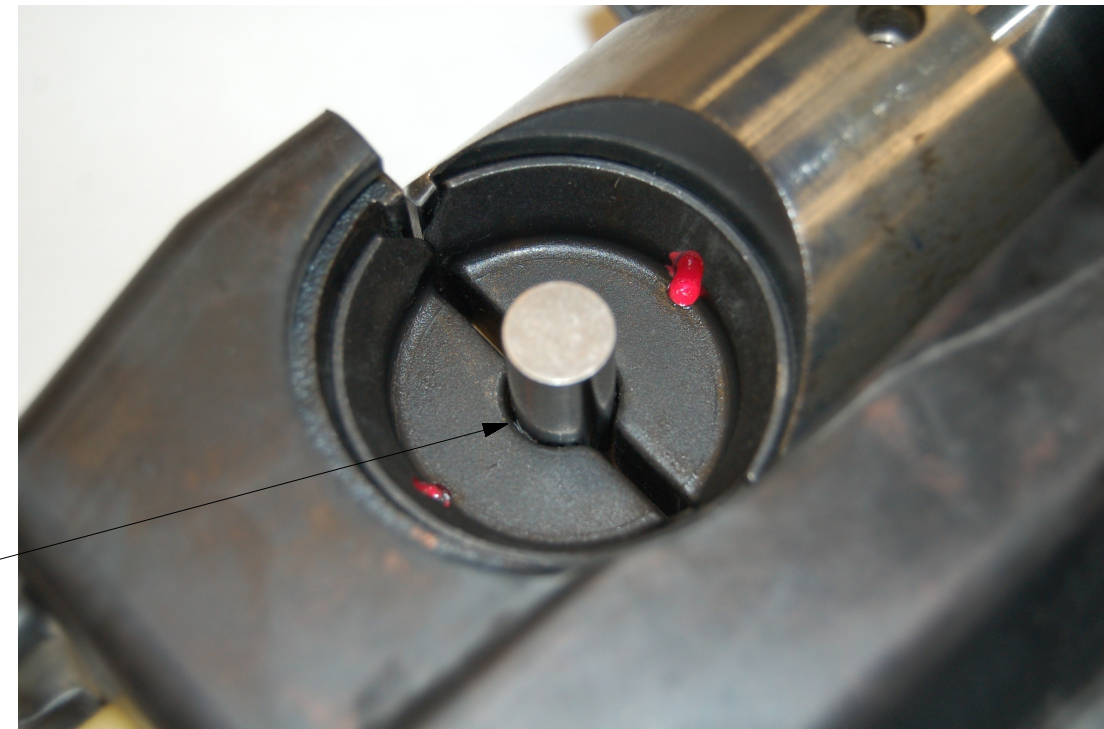


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# STEP FIVE

Using the correct GO & NOGO Pin Gauges:

- a. Insert the pin gauge in the center of the Crimp Die. If checking for wear, and the correct GO pin gauge is able to pass through the center of the two Crimp Dies, then the dies are within specification.
- b. If checking to see if the Crimp Dies are over size (worn), then use the correct NO-GO pin gauge and insert it in the center of the two Crimp Dies. If the pin gauge is able to completely pass through the center of the two Crimp Dies, the Crimp Dies are out of specification and should not be used.



PIN MUST PASS THROUGH DIE SET

GO Pin gauge must pass through the center of the two dies for a PASS.  
 NO-GO pin gauge must NOT pass through the center of the two dies for a PASS.

SEE DRAWING 10J002BE-JC FOR GO/NO-GO DIE VALUES

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GO PIN GAUGES ARE SHOWN IN BOTH PICTURES

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.xx ± .01 [ .25 ]	ANGLES ± 1°	DRAWING NUMBER: <b>TP27416B01</b>	
THIRD ANGLE PROJECTION		SIZE B	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
SHT 5 OF 6			

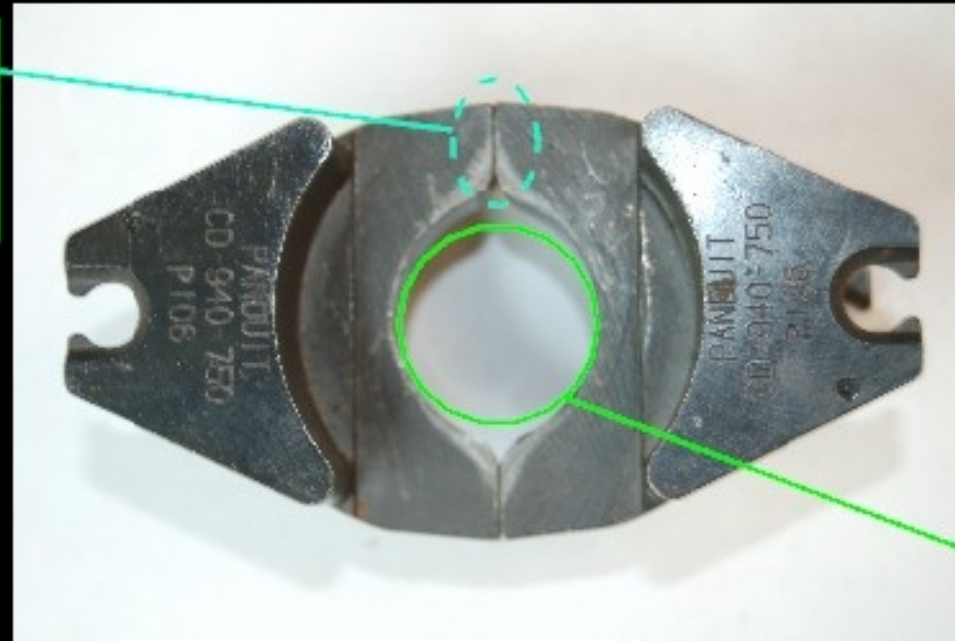
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# INSTRUCTIONS FOR THE USE OF GO AND NO-GO PIN GAUGES FOR THE CD-940 STYLE CRIMP DIES

## HOW TO MEASURE CRIMP DIE WEAR

**CRIMP DIES  
CD-940-750 and CD-940-1000**

IN THIS PICTURE, PLEASE OBSERVE THAT THE CRIMP DIE HALVES ARE ALIGNED TOP TO BOTTOM AND FRONT TO BACK. THE DIES SHOULD BE CLAMPED IN A VISE IN THIS POSITION TO MEASURE WITH GAUGE PINS. THIS CLAMPED POSITION IS RECOMMENDED WHEN CHECKING WITH NO/NOGO GAUGES.



**NOTE:**  
\*NO SPECIAL CUSTOM GAUGES ARE CURRENTLY OFFERED. USE COMMERCIALY AVAILABLE STANDARD ROUND GAUGE PINS.\*

USE STANDARD ROUND PIN GAUGES (FOR DIAMETER - SEE DIAMETER RANGE BELOW)

### MEASUREMENT METHOD:

1. SET UP CRIMP DIES AS SHOWN ABOVE.
2. SPECIFICATION RANGE:
  - A. FOR THE CD-940-750, THE GO/NOGO GAUGE PINS ARE .835"/.896".
  - B. FOR THE CD-940-1000, THE GO/NOGO GAUGE PINS ARE .978"/1.039".
3. THE UPPER SIZED GAUGE PIN MUST NOT PASS THROUGH THE DIE POCKET FORMED WHEN THE TWO HALVES ARE HELD TOGETHER. THE LOWER SIZED GAUGE PIN MUST ENTER THE DIE POCKET FORMED WHEN THE TWO HALVES ARE HELD TOGETHER.

SEE DRAWING 10J002BE-JC FOR GO/NO-GO DIE VALUES

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.x ± .1 [ 2.54 ]	.xxx ± .005 [ .127 ]	DRAWING NUMBER: <b>TP27416B01</b>	
.xx ± .01 [ .25 ]	ANGLES ± 1°	THIRD ANGLE PROJECTION	
DRAWN BY BJPU	DATE 9-4-14	CHK ABJ	SCALE NONE
SHT 6 OF 6			SIZE B

B

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