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## Daniels Crimp Tool M22520/2-01 Maintenance and Lubrication Guide

This manual provides the information required for basic maintenance of the Daniels Crimp Tool M22520/2-01 as modified by C. Davis Systems & Software, LLC's (CDSS) for use in our GWT and LC lines of Crimping Machines.

NOTE: the Daniels Crimp Tool M22520/2-01 is a hand tool modified by CDSS for use in our our various automated Crimping Machines. Although the tool was designed by Daniels to be 'maintenance free,' we have found that the extremely high cycle counts and throughput of automated crimping in our customer's various wire processing applications necessitate periodic maintenance, especially cleaning and lubrication.

After extensive testing, we recommend Krytox GPL 206 Grease for all Crimp Tool lubrication. Krytox is stable at high temperatures, chemically inert, insoluble in most common solvents, non-flammable, and compatible with plastics, metal, rubber and ceramics.



### Step 1: Disassembly of the Daniels M22520/2-01



To disassemble the Daniels M22520/2-01, start with the front face of the the tool (pictured above) remove the two flathead hex screws which attach the faceplate of the crimp tool to the positioner body. The faceplate may still be attached the the indenter body by two pins --if so carefully pry off the faceplate off of the indenter body.

Continue disassembly of the Daniels M22520/2-01 by removing both flathead hex screws from the back side of the crimp tool (the side with the selector knob). At this point the tool should come apart into components as depicted below:



When the indenter body / handle is removed from the front side of the tool, the indenters, indenter springs and the cams of the indenter body will be exposed:



At this point you can remove the thin shims from either side of the indenter body and fully expose the indenters, cams, springs etc. This is the heart of the crimp tool.

Step 2: CLEANING the Daniels M22520/2-01

**Take this opportunity to clean the tool by removing old grease, and any debris or particulate which might exist. You should also examine all components for wear -- any excessive wear to the indentors or cams will result in out-of-spec crimps. These parts cannot be repaired -- if excessively worn the crimp tool must be replaced. However, regular cleaning and lubrication will greatly extend the life of the crimp tool.**

### Step 3: Lubricating the Daniels M22520/2-01

After cleaning the innards of the Crimp Tool, apply fresh Krytox Grease to the indenter cams, the indenter springs, and the mating faces of the shims:



At this point the key moving parts have been cleaned and freshly lubricated:



### Step 4: Reassembly of the Daniels M22520/2-01

After completing cleaning and lubrication, reassemble the tool by reversing the steps described above. Take special care when reattaching the faceplate, and if necessary gently press into place

with an appropriate sized wood dowel, or compress with soft-jaw pliers.

After reassembly, cycle the crimp tool manually to confirm function. The tool should articulate freely, the ratchets should engage and disengage smoothly, and the the crimp depth selector should function as before.

**NOTE:** if the crimp tool is sticky, articulates poorly, requires excessive pressure to close or sticks in position a piece of debris may have gotten caught om the cams or springs -- disassemble and clean tool again with careful attention to debris which may be caught in the indenters, the cams or the indenter springs.

After confirming good function, re-install tool into your CDSS Automated wire termination machine and resume crimping.