

1661

PNEUMATIC CRIMPING TOOL

OPERATING INSTRUCTIONS MANUAL



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1. CRIMPING TOOL APPLICATION

This tool is designed exclusively for crimping terminals. The manufacturer accepts no responsibility for damage or injury resulting from use for any other purpose.



WARNING!

Read all safety notes and instructions. Failure to follow the warnings and safety instructions may result in serious injury. Keep this manual for future reference. If the tool is transferred to another user, this manual must accompany it.

2. PACKAGE CONTENTS

No. 1 pneumatic crimping tool

No. 1 foot pedal

No. 1 die (534D) for insulated terminals from 0.25 to 6 mm² (AWG 22-10), mounted on the crimping tool

No. 1 operating instructions manual



If any part is missing or damaged, please contact your dealer.

When opening the package:

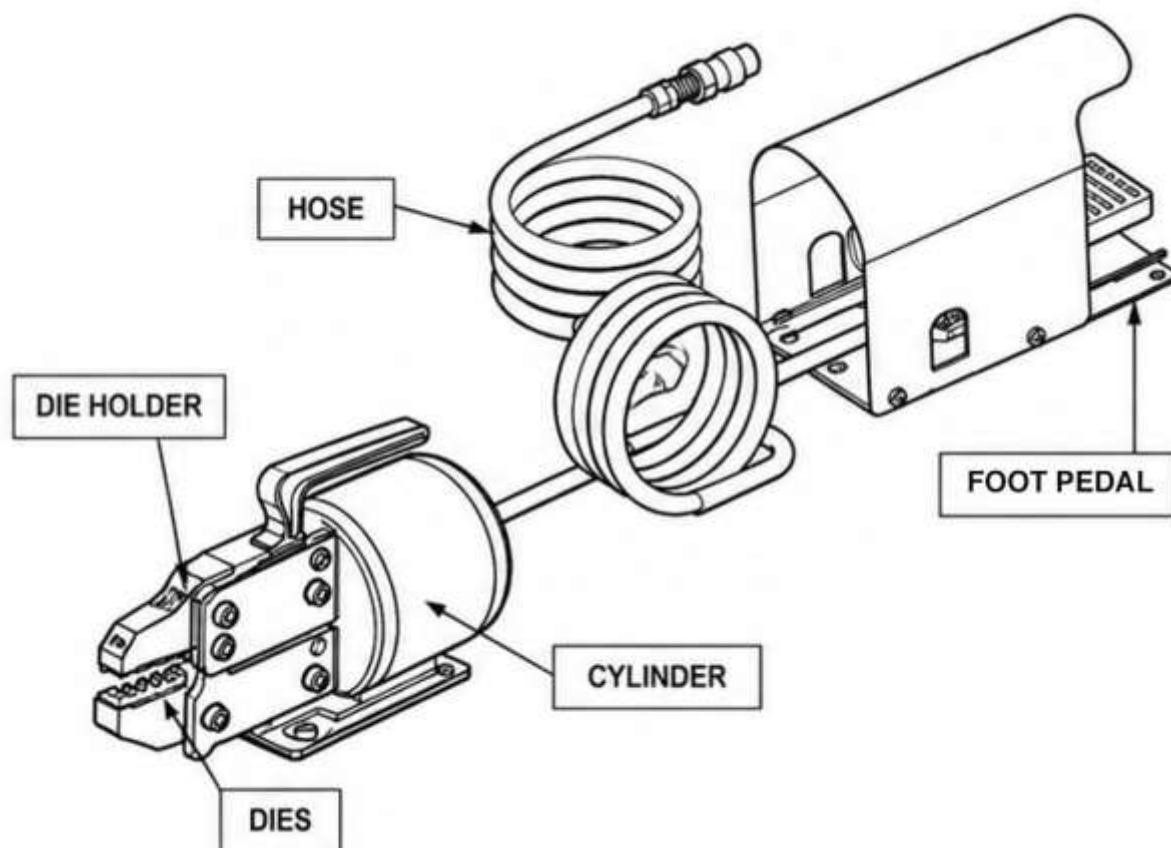
- Remove all packaging materials;
- Remove any remaining packaging and packing inserts (if supplied);
- Check that the package contents are complete;
- Check the tool and all accessories for damage caused during transport;
- Keep the packaging and all accompanying information for the entire service life of the tool. At the end of its useful life, dispose of or recycle the packaging at an authorized local waste collection facility.



WARNING!

Packaging materials are not toys. Keep plastic bags away from children. Risk of suffocation.

3. CRIMPING TOOL PARTS



4. SYMBOLS

The following symbols are used in this manual and/or on the crimping tool:

	Warning. Read and follow the instructions carefully. Failure to follow the instructions may compromise safety.		Do not use on live conductors: risk of electric shock.
	Keep your fingers away from the die cavities.		Wear protective goggles.
	Read and carefully follow the instructions.		Note

5. SAFETY PRECAUTIONS

Pay particular attention to all safety precautions. Observing these precautions helps minimize the risk of accidents and injury.



WARNING!

Even when all safety precautions are followed, residual risks cannot be completely eliminated. The tool must be used only by qualified personnel.

- a) This tool is designed exclusively for crimping. Using it for any other operation may create hazards and cause personal injury;
- b) Use only the dies specified by the manufacturer for this crimping tool. Even if dies made by other manufacturers can be fitted, safe operation cannot be guaranteed. Safe use is ensured only when the specified dies are used and all safety instructions are followed;
- c) Use the dies only for their intended purpose. For example, never use them as levers to bend terminals;
- d) Do not use damaged dies. Inspect them carefully before each use and replace them if damaged;
- e) Wear suitable personal protective equipment when using the tool. Always wear safety goggles capable of protecting the eyes from flying fragments;
- f) Keep unauthorized persons away from the work area. Anyone entering the work area must wear suitable personal protective equipment, as flying fragments may cause injury;
- g) Do not use the crimping tool on live conductors: risk of electric shock.



WARNING!

- **Keep your fingers away from the die cavities;**
- **Do not place your fingers inside the crimping head while the dies are moving. Serious crushing injuries may result;**
- **Operate the locking lever carefully to avoid pinching;**
- **Do not use on live conductors: risk of electric shock.**

6. HOW TO USE THE CRIMPING TOOL

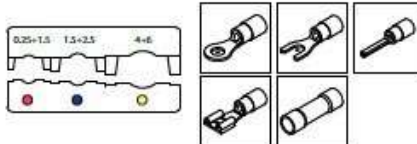
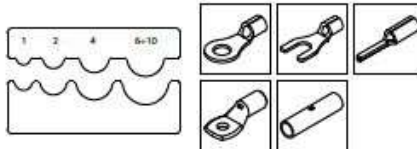
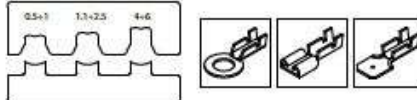
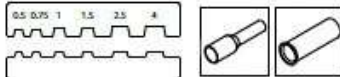
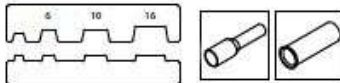
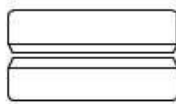
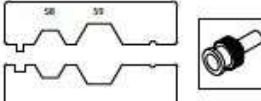


WARNING!

Check the crimping tool for damage before each use. Make sure that all parts operate correctly, moving parts move freely and no component is damaged. All components must be correctly assembled to ensure safe operation. Damaged or defective parts must be repaired or replaced by an authorized service center.

a) Select the dies

Select the appropriate BM die according to the terminal to be crimped. A cable-cutting die is also available for copper cables up to $\varnothing 7$ mm.

534D	<i>Die for insulated terminals from 0.25 to 6 mm² (AW 22-10)</i>	
535D	<i>Die for uninsulated copper terminals from 0.5 to 10 mm² (AWG 20-8)</i>	
531D	<i>Die for open barrel terminals from 0.5 to 6 mm² (AWG 20-10)</i>	
537D	<i>Die for end-sleeve terminals from 0.5 to 4 mm² (AWG 22-12)</i>	
539D	<i>Die for end-sleeve terminals from 6 to 16 mm² (AWG 10-6)</i>	
500D	<i>Cable cutter (Cu $\varnothing 7$ mm)</i>	
543D	<i>For coaxial connectors</i>	

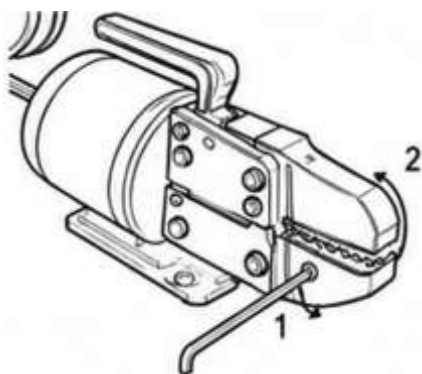


WARNING!

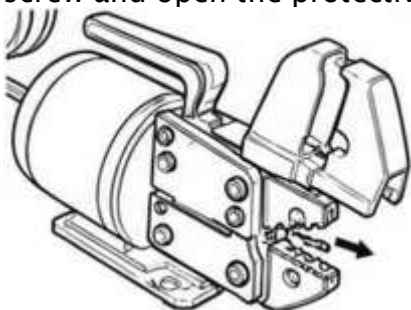
BM cannot guarantee the safety of a crimped connection if dies and/or terminals from other manufacturers are used. A safe crimped connection is ensured only when the complete BM crimping system (tool, die and terminal) is used correctly and in accordance with good engineering practice.

BEFORE REPLACING THE DIES, MAKE SURE THAT THE TOOL IS DISCONNECTED FROM THE COMPRESSED-AIR SUPPLY.

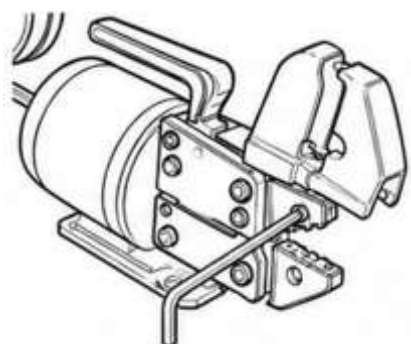
b) Mount the selected dies



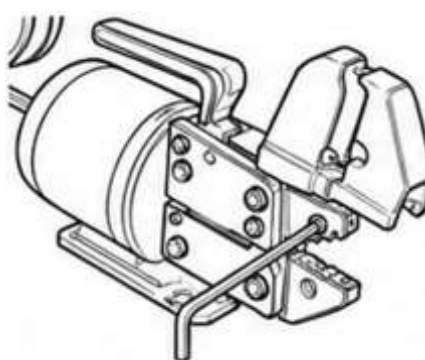
Use a 2.5 mm Allen key to remove the screw and open the protective guard



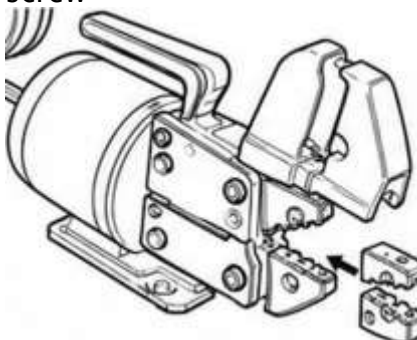
Remove the dies



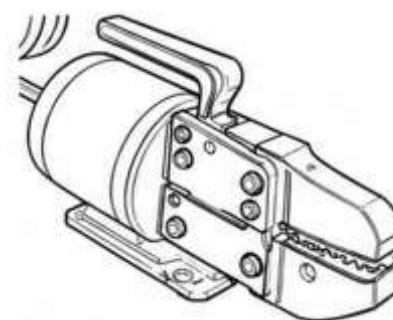
Use a 2.5 mm Allen key to tighten the screws



Use a 2.5 mm Allen key to remove the screw



Insert the dies into the die holder



Close the protective guard and tighten the screw using a 2.5 mm Allen key

c) Pneumatic connection

1. Connect the crimping head to the foot-operated air valve
2. Connect the threaded hose of the foot pedal to a compressed-air supply set to 5-6 bar.

d) Crimp



WARNING!

The dies close with considerable force. Keep your fingers away from the die cavities.



WARNING!

Do not use on live conductors: risk of electric shock.

- Strip the conductor to the length specified for the terminal
- Take care not to damage the conductor strands
- Place the terminal in the correct crimping cavity
- Insert the stripped conductor fully into the terminal
- Press the foot pedal to perform the crimping operation
- At the end of the crimping cycle, the head releases automatically
- Remove the crimped terminal.

e) Check

- Visually check that the terminal has been correctly crimped
- Check the mechanical strength of the crimped connection

7. MAINTENANCE

- Lubricate the pneumatic crimping tool every 5,000 cycles via the dedicated hole located on top of the safety guard (recommended oil: SAE 10W-40).
- Clean and lubricate all moving parts of the pneumatic crimping tool daily.
- Clean and lubricate the die used at the end of each production run.
- Use only accessories and spare parts recommended by the manufacturer;
- In the event of a malfunction, do not attempt to repair the tool yourself. Contact authorized personnel. If repair is required, return the tool to your usual supplier together with the warranty certificate, duly completed and stamped by the dealer.



WARNING!

All repairs must be carried out by qualified personnel using original spare parts. Failure to comply may make the tool unsafe and will invalidate the warranty.

8. STORAGE

Store the crimping tool in its original packaging, in a clean, dry and frost-free place out of the reach of children. Before long-term storage, disconnect the tool from the compressed-air supply, then clean and lubricate all moving parts.

9. TROUBLESHOOTING

FAULT	POSSIBLE CAUSE	SOLUTION
The dies do not close completely.	1. Pneumatic system malfunction; 2. Foot pedal malfunction	1. Check the hoses and supply pressure. If the fault persists, contact an authorized service center. 2. Check foot pedal operation.

10. DISPOSAL

At the end of its service life, do not dispose of the crimping tool with household waste. Take it to an authorized collection facility in accordance with applicable local regulations.

11. SPECIFICATIONS

Tool weight:	2.7 kg
Tool dimensions (L x W x H):	225 x 135 x 90 mm
Operating pressure:	5–6 bar
Output force:	1.3 kN at 5 bar

12. WARRANTY



The tools are fitted with tamper-evident seals. The warranty is valid only if these seals have not been removed. Repairs carried out by BM on tools with removed seals will be charged to the customer, even during the warranty period.

Use of the product implies acceptance of the following warranty conditions:

Warranty conditions:

1. Subject to the exclusions stated below, BM pneumatic tools are warranted against defects in materials and/or workmanship for one year from the date of sale to the end user. At its discretion, BM will repair or replace any tool or component found to be defective following inspection by an authorized BM service center;
2. Repairs may be carried out only by personnel authorized by BM. Contact BM for further information;
3. To make a warranty claim, the customer must notify BM of the alleged defect in materials and/or workmanship and provide the end-user purchase invoice together with the tool serial number;
4. Acceptance of a warranty claim does not extend or restart the warranty period, even if the tool is replaced;
5. A warranty claim does not entitle the customer to defer payment for the equipment, either in whole or in part;
6. Parts and components replaced under warranty become the property of BM;
7. Pneumatic tools must be returned clean, fully assembled and without dies, in their original packaging and accompanied by a copy of the purchase invoice;
8. Shipping costs to BM for warranty service are borne by the customer. Return shipping costs after approved warranty service are borne by BM.

Warranty exclusions:

1. DOCUMENT

Documentation proving the sale and purchase of the tool must be retained as evidence of the purchase date. BM reserves the right to reject a warranty claim if the purchase details cannot be verified;

2. FREIGHT COSTS

Shipping costs for parts not accepted under warranty will be charged to the customer;

3. REPAIRS, ALTERATIONS, MODIFICATIONS

The warranty is void if alterations, modifications or repairs are carried out by personnel not authorized by BM;

4. NORMAL WEAR

The warranty does not cover failures or reduced performance caused by normal wear and tear, including wear of bushings, retaining pins, wear plates, bumpers, retaining rings, plugs, rubber bushings, return springs, seals and guide rings;

5. DIES

Dies are subject to normal wear and are not covered by the warranty;

6. FREIGHT DAMAGE

Damage caused by improper storage or handling during transport is not covered by the warranty;

7. TIME OF INACTIVITY

Loss of operating time while the tool is out of service is not covered by the warranty;

8. IMPROPER OPERATION

The warranty does not cover failures or reduced performance resulting from failure to follow the instructions and procedures in this operating instructions manual;

9. MAINTENANCE

The warranty does not cover failures or reduced performance resulting from failure to maintain the tool as specified in this manual;

10. MIS-APPLICATION

Failures or reduced performance resulting from use of the tool for purposes for which it was not designed are not covered by the warranty.

Serial number	Date of sale to the end-user	End-user receipt/invoice



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