

## 1 Introduction

These instructions describe the installation of the slider (part number 541868-1) with the adapter (part number 2234755-1) on the machines listed in Table 1. The slider allows die sets with locators to be used with module numbers x-528040-x and x-528041-x.

Table 1: Machines

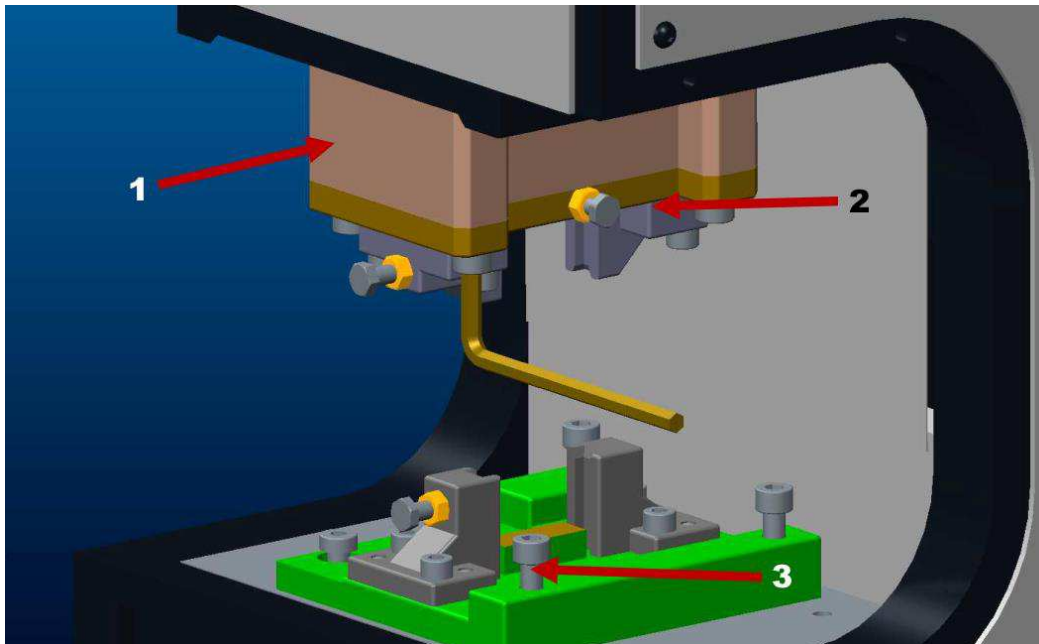
Part number	Machine
528008-4	HV crimping machine
2335500-X	HF-20 Terminator
2348822-X	HV-20 Terminator
2399816-X	HV-20 Terminator with Vision

## 2 HV crimping machine

This section describes how to install the slider on HV crimping machine 528008-4.

1. Install the guide plate with guides and latch block (Figure 1).

Figure 1: Installing the guide plate

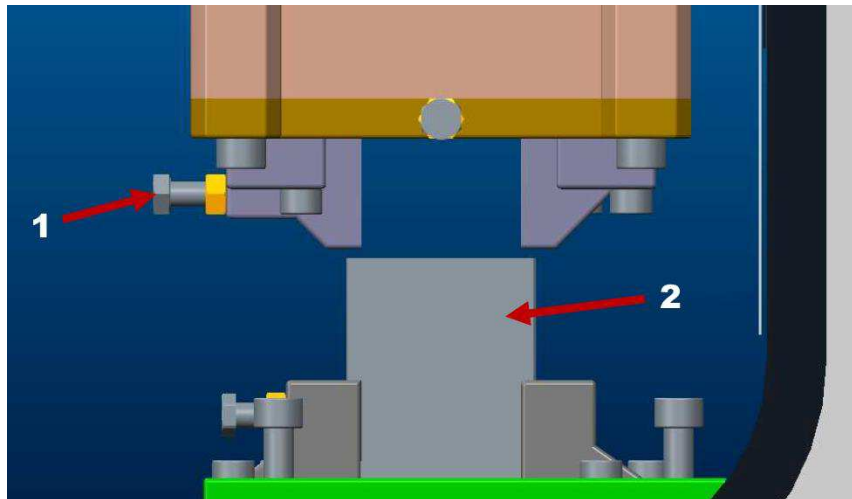


- 1** Latch block
- 2** Guides
- 3** Cylinder head bolt

2. Firmly tighten the corresponding cylinder head bolts.
3. Position the base with guides and loosely fasten the cylinder head bolts.

4. Insert gauge (Item 3) in lower guide (see Figure 2).

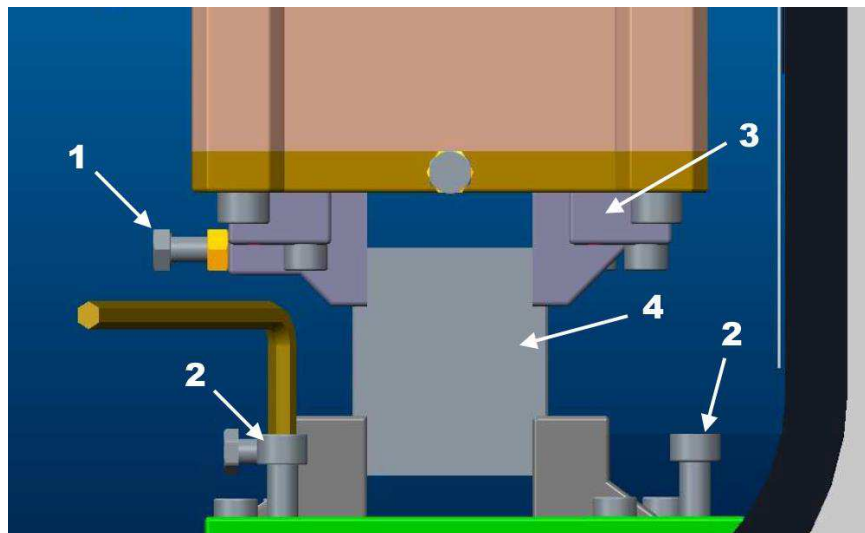
*Figure 2: Lowering the crimping machine*



- 1** Screw
- 2** Gauge

5. Gradually lower the crimping machine in setup mode (see operating instructions 412-94096) and stop it approximately 2-4 mm above the gauge.
6. Loosen the screw enough for the gauge to be freely moved into the upper guide mounting (Figure 3).

*Figure 3: Positioning the gauge*

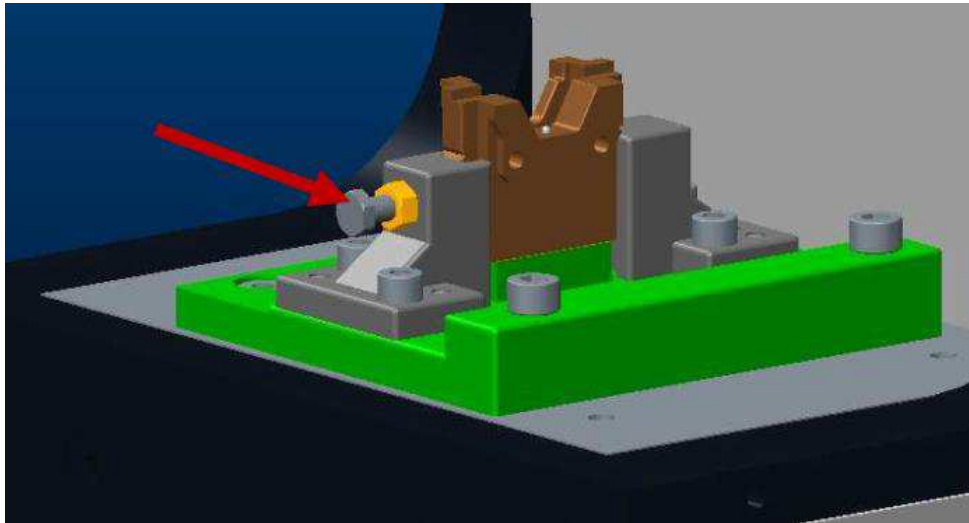


- 1** Screw
- 2** Cylinder head bolts
- 3** Guide
- 4** Gauge

7. Bring the gauge into position in the guide plate with guide.
8. While holding the gauge in position, firmly tighten the cylinder head bolts. The slider is now aligned.
9. Remove the gauge.
10. Insert the die and locator.

11. Loosely tighten the side machine screw (Figure 4).

*Figure 4: Side machine screw*



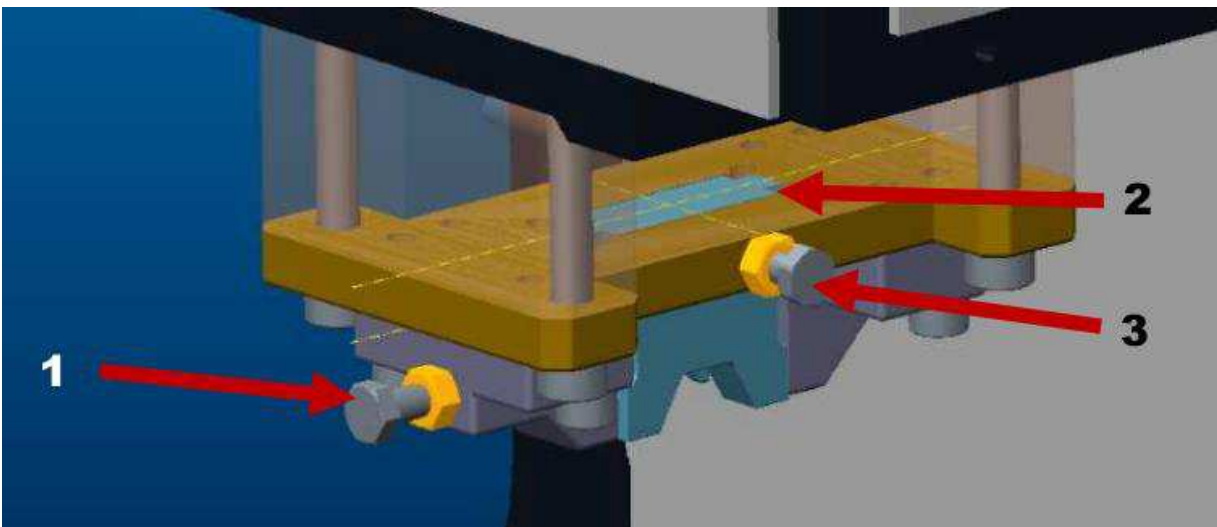
12. Insert the upper die. Ensure that:

- The side clamping screws do not block the die.
- The upper die rests on the contact surface of the latch block (Figure 5).

13. Loosely tighten the guide screw.

14. Firmly tighten the latch block screw.

*Figure 5: Tightening the screws*



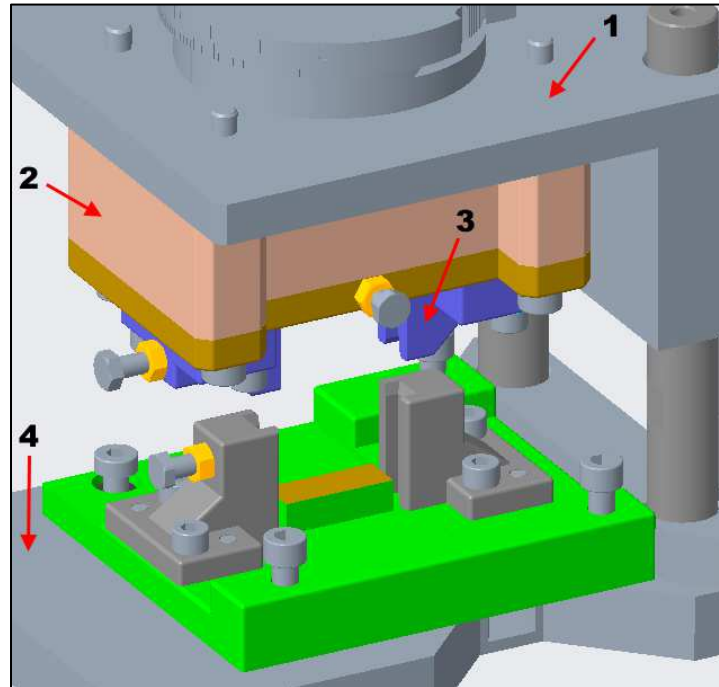
- 1** Guide screw
- 2** Contact surface
- 3** Latch block screw

### 3 HF-20 and HV-20 terminators

This section describes how to install the slider and adapter on the HF-20 and HV-20 Terminators.

1. Install the guide plate with guides and latch block on the upper plate of the adapter (Figure 6).

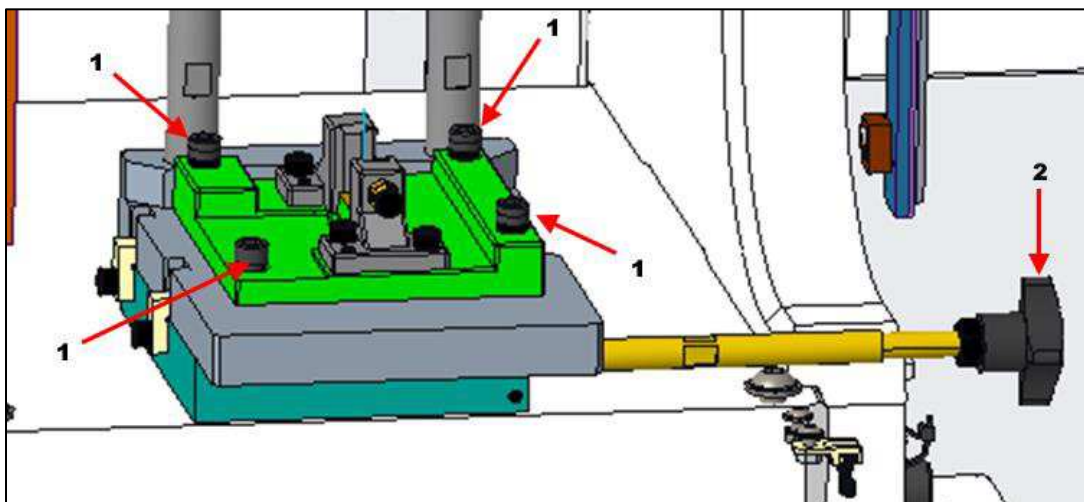
Figure 6: Installing the guide plate



- |                      |                      |
|----------------------|----------------------|
| <b>1</b> Upper plate | <b>3</b> Guides      |
| <b>2</b> Latch block | <b>4</b> Lower plate |

2. Position the base with guides on the lower plate of the adapter.
3. Loosely fasten the cylinder head bolts (Figure 7).

Figure 7: Cylinder head bolts and knob



- |                              |
|------------------------------|
| <b>1</b> Cylinder head bolts |
| <b>2</b> Knob                |

- Place the adapter on the base plate of the terminator (Figure 8) with the bolt head (Figure 9) positioned in the ram adapter slot (Figure 10).

Figure 8: Base plate

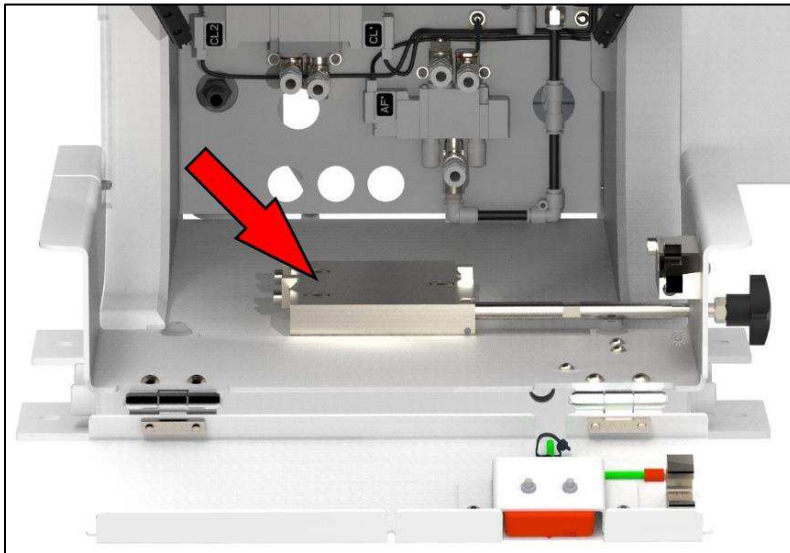


Figure 9: Bolt head

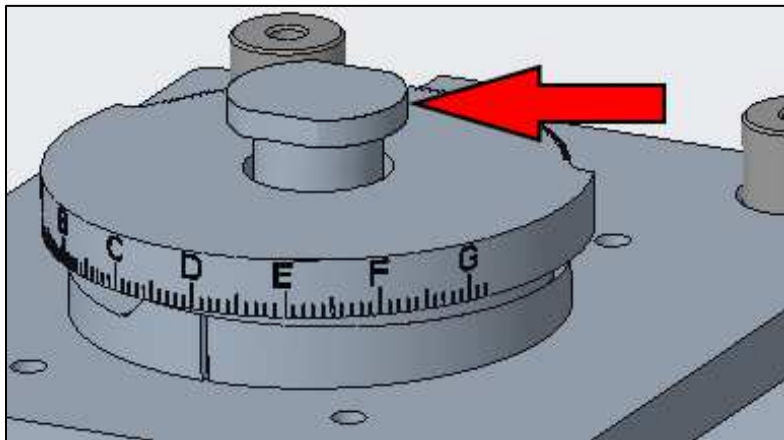
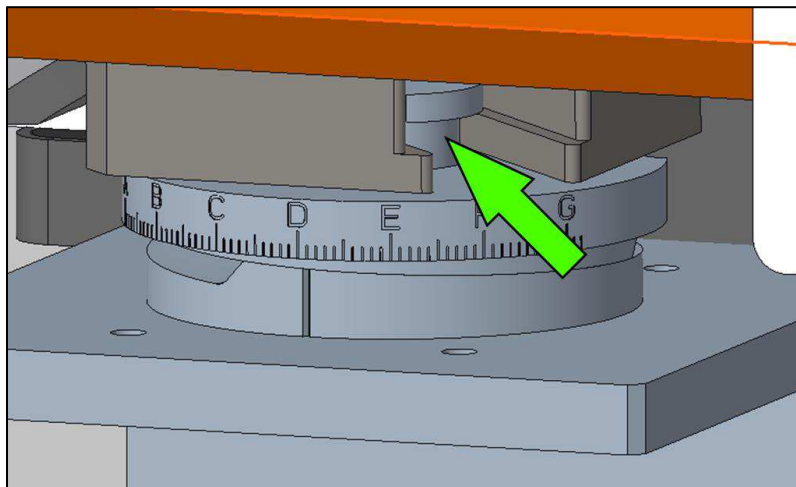
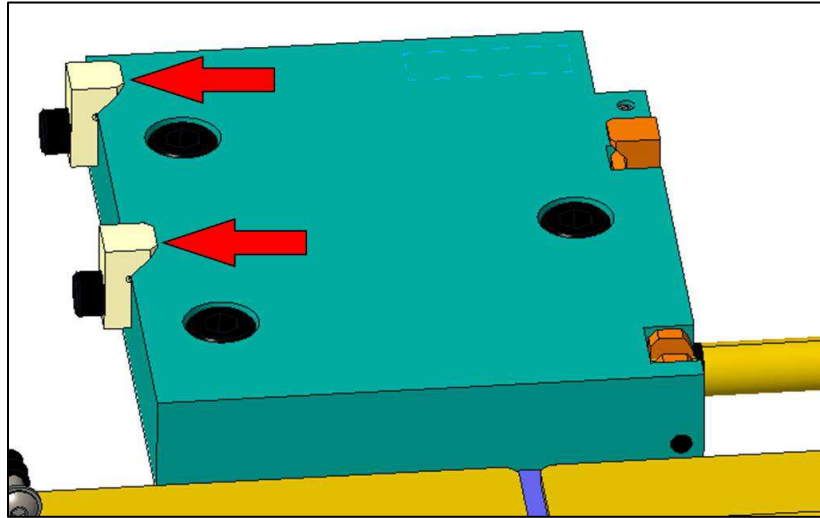


Figure 10: Bolt head in ram adapter slot



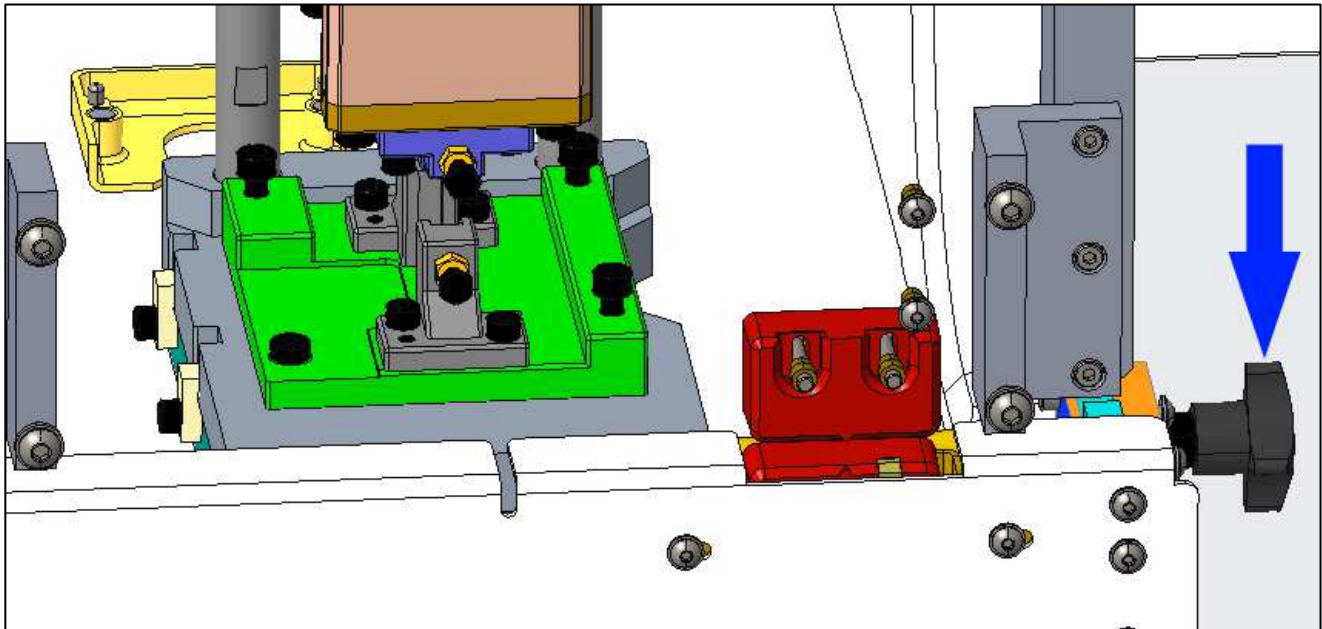
- Slide the adapter with the two inclined planes covered by the rear stop (Figure 11) onto the base plate of the terminator.

Figure 11: Inclined planes



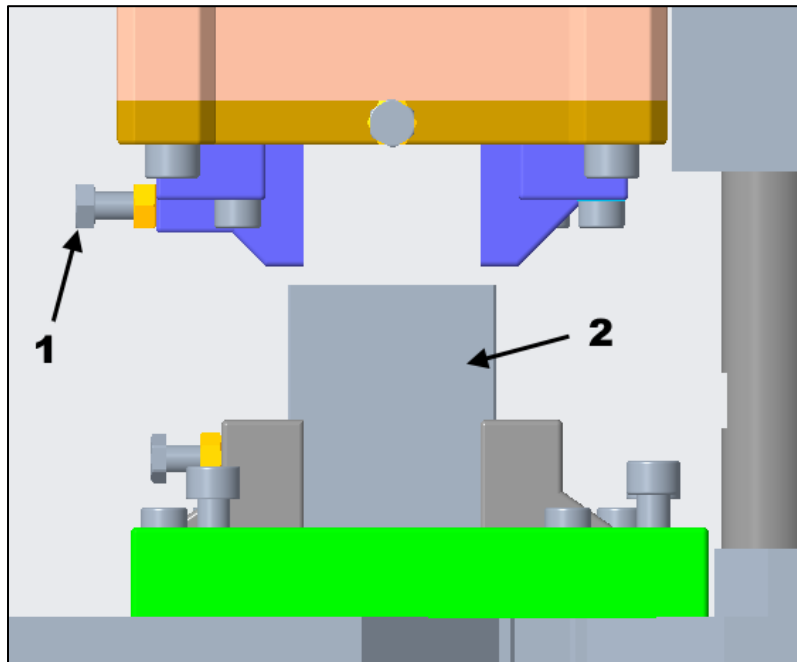
- Release the knob (Figure 12) to position the adapter in the terminator. Figure 12 shows the final position of the adapter and slider.

Figure 12: Knob



7. Insert gauge in the lower guide (Figure 13).

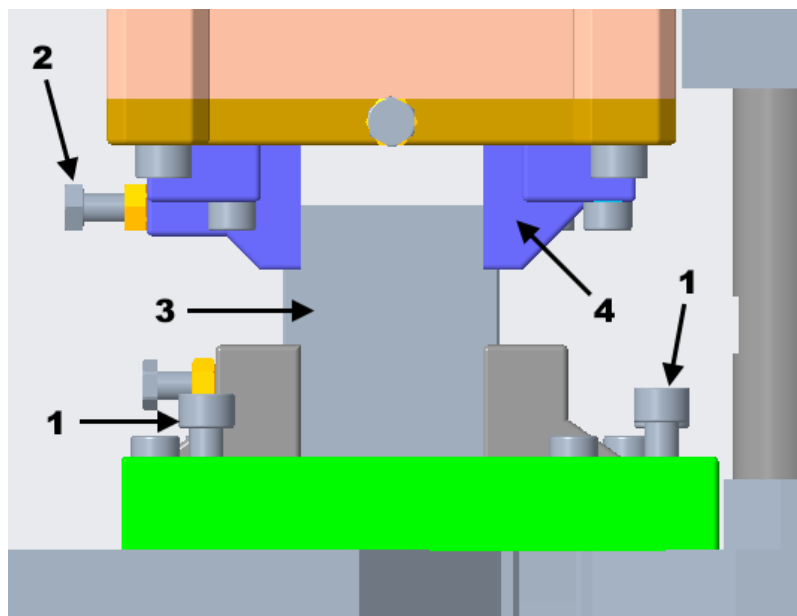
Figure 13: Inserting the gauge



- 1 Screw
- 2 Gauge

8. In setup mode (see manual [409-35009](#)), gradually lower the terminator until it is approximately 2-4 mm above the gauge (Figure 14).

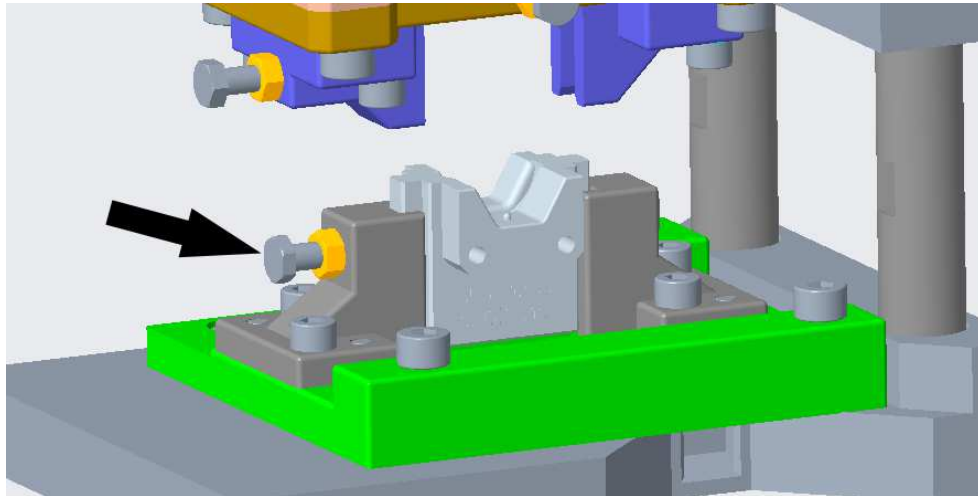
Figure 14: Positioning the gauge



- 1 Cylinder head bolts
- 2 Screw
- 3 Gauge
- 4 Guide

9. Loosen the screw far enough for the gauge to be freely moved into the upper guide mounting (Figure 14).
10. Bring the gauge into position in the guide plate with the guide.
11. While holding the gauge in position, firmly tighten the four cylinder head bolts on the lower plate of the adapter (Figure 7). The slider is now aligned.
12. Remove the gauge.
13. Insert the die and locator.
14. Loosely tighten the side machine screw (Figure 15).

*Figure 15: Side machine screw*

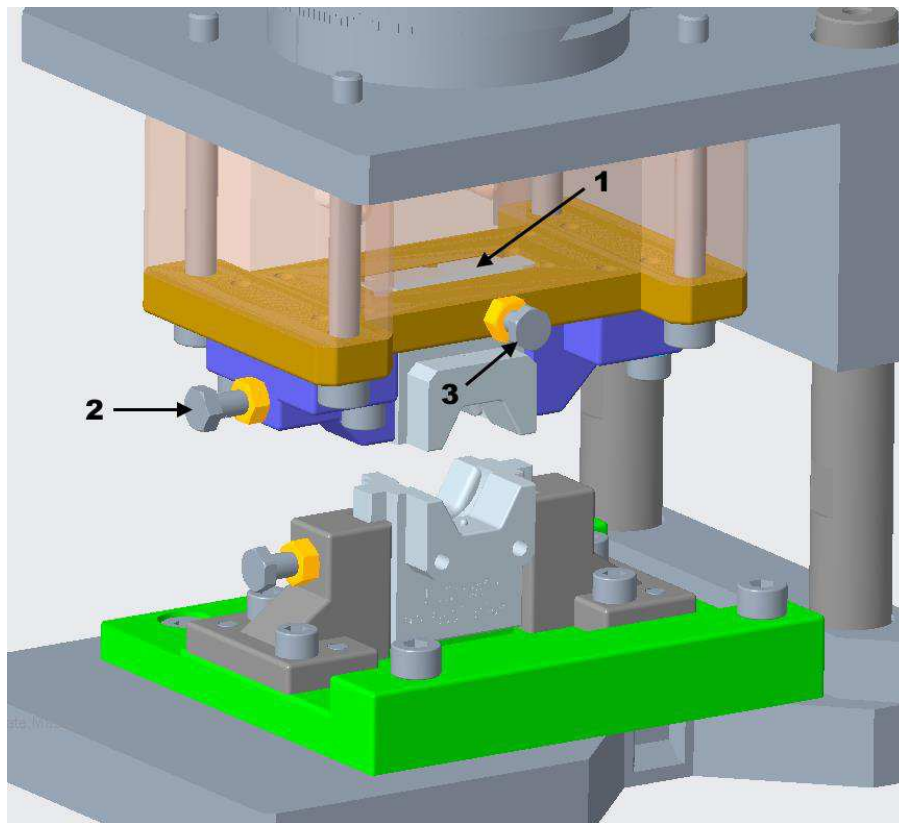


15. Insert the upper die. Ensure that:
  - The side clamping screws do not block the die.
  - The upper die rests on the contact surface of the latch block (Figure 16).
16. Loosely tighten the latch block screw.



17. Firmly tighten the guide screw.

Figure 16: Tightening the screws



- 1 Contact surface
- 2 Guide screw
- 3 Latch block screw

## 4 Replacement and repair

Order replacement parts through your TE representative, or go to [TE.com](http://TE.com) and click the **Shop TE Store** link at the top of the page.

For field service, go to the [Service and Repair](#) page on the TE website, or send an e-mail to the address for your region in Table 2.

Figure 17: Service and repair



Table 2: Field service e-mail addresses

Region	Address
Asia	<a href="mailto:Tefe1ap@te.com">Tefe1ap@te.com</a>
EMEA (including India)	<a href="mailto:Tefe1@te.com">Tefe1@te.com</a>
North America	<a href="mailto:Fieldservicesnorthamerica@te.com">Fieldservicesnorthamerica@te.com</a>
South America	<a href="mailto:FSE@te.com">FSE@te.com</a>

## 5 Revision summary

Since the last revision of this document, the following changes were made:

- Added section 3, **HF-20 and HV-20 terminators**.
- Reformatted and edited.