

CD-940 CRIMP DIE WEAR MEASUREMENT
CD-940-750, CD-940-1000

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


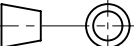


MEASUREMENT METHOD:

1. SET UP CRIMP DIES AS SHOWN ABOVE.
2. UPPER SIZE 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.

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

CRIMP DIE PART NUMBER	DIE COLOR CODE	DIE INDEX NUMBER	GAUGING - MAX/MIN FOR RECESSED LETTER CRIMP DIES IN INCHES	
			(GO)	(NO-GO)
CD-940-750	BLACK	P106	.835" - .896"	
CD-940-1000	WHITE	P125	.978" - 1.039"	

							INSTRUCTIONS, GAGING CD-920 / CD-940 FMY'S									
06	4/18/23	JHNU	JHNU	MRWA	C. MOVED CD-920 DIES TO 03249NBF-DC B. REMOVED SHEETS 2-6	130488	CUSTOMER DRAWING									
05	11/9/22	JHNU	JHNU	JADE	REMOVED SHEET 7 FROM DRAWING, SEE DRAWING 10J002BE-JC FOR GO/NO-GO VALUES	127162	ITEM REVISION NAME		R27416AB/06							
04	07/14/20	BJPU	JEH	JADE	A. ADDED TWO P/N'S, UPDATED NOTES AND DWG FORMAT, WAS CONTROL DRAWING	084605	DATASET FILE NAME		R27416AB_DC_TP27416B01/06							
03	9/4/14	BJPU	BJPU	ABJ	REVISED AND REDRAWN ON TEAM CENTER, NO DIMENSIONS CHANGED	4763	<div>UNLESS OTHERWISE SPECIFIED, DIMENSIONAL TOLERANCES ARE: IN [mm]</div> <div><div>.x ± .1 [2.54]</div><div>.xxx ± .005 [.127]</div><div>.xx ± .01 [.25]</div><div>ANGLES ± 1°</div></div> <div>THIRD ANGLE PROJECTION</div>					MATERIAL :		NONE		
02	8/6/14	BJPU	BJPU	ABJ	UPDATED WITH +/- .001" TOLERANCE ON PIN DIAMETER	4763						DRAWING NUMBER:		TP27416B01		
01	7/29/14	BJPU	BJPU	ABJ	UPDATED WITH CD-940-750 INFORMATION	4763						DRAWN BY		DATE	CHK	SCALE
00	7/9/14	BJPU	BJPU	ABJ	RELEASE FOR KOREAN SALES	4763	BJPU		9-4-14	ABJ	NONE			B		
REV	DATE	BY	CHK	APR	DESCRIPTION	ECN										