



Zhejiang VASUNG Tools Co.,Ltd.

FEK- 50L

Terminal Crimping Machine



Pneumatic Type

In order to ensure the safe use, please read this operation instruction carefully before operation

Product parameters

| | |
|--------------------------|---|
| Name | Pneumatic Type Terminal Crimping Machine |
| Model | FEK-50L |
| Crimping range | 6-50mm ² for non-insulated terminals |
| Air pressure range | 0.6-1MPa |
| Output | 2.5T |
| Weight | 6Kg |
| Overall dimension | 275 × 128 × 145mm |

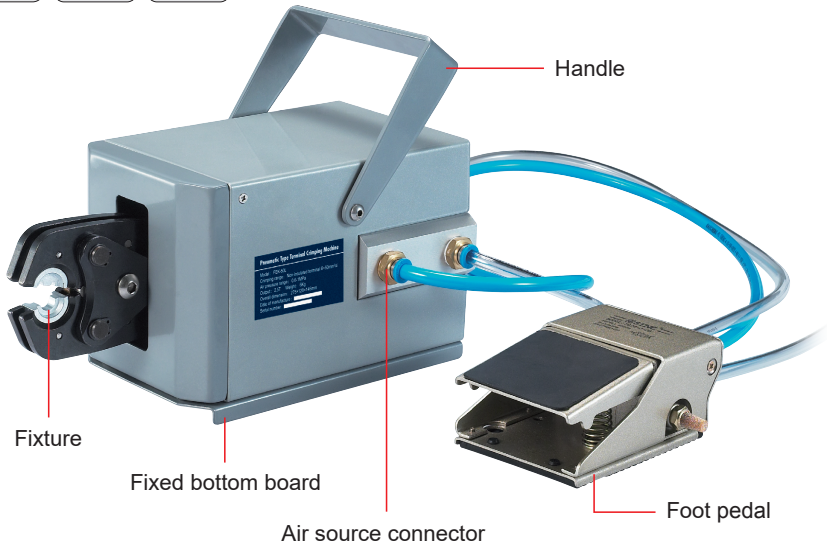
Accessories included

| Name | Quantity |
|-----------------------|----------|
| Air tube | 2 |
| Foot air valve | 1 |
| Screw driver | 1 |
| Operation instruction | 1 |
| Crimping die set | 1 |

Operation Instruction for FEK- 50L

Production description

FEK-50L can replace the manual crimping tool. You can work free from the boredom, repeated manual crimping mode with the pneumatic crimping machine, the crimping speed is 10 times of the manual crimping tools, it has a greater cost advantage, and it is applicable for the international standard welding or tubular electrical connection termination crimping, the materials of the precision die sets is made of high quality alloy steel by the special heat treatment process, it is with the advantages of fast replacement, quick crimping, reliable firmness after crimping.



Crimping die sets



The crimping dies used for FEK-50L shall be interchangeable with the fixture of the manual crimping tools produced by the company. There are many types of terminal crimping die sets for selection. Crimping shape it is Hexagonal or Indent depends of the die set in use.

FEK-50L is the first crimping machine in the world for crimping the non-insulated terminal of 6~50mm² with the air source. The machine can provide extremely convenient and quick service for the user to greatly promote the practical value and convenient use of the tools. The parts of the crimping machine are made of the special alloy steels by many precision stamping after heat treatment, the sections are smooth and flattened. The crimping die sets are made of super hard tool steel with the advantages of long life, accurate aperture size and good crimping effect. The crimping mode can be hexagonal or indent type. Each crimping machine as standard it is equipped with 1 set of crimping dies, the customers can select a different crimping die from our list from page 6.

Product introduction

This product uses the double-acting standard cylinder driving, has the high efficiency and high quality advantages on the crimping force and crimping speed. It is applicable for crimping large quantities of terminals. If the diversified forms of crimping terminals are used, this product shall be chosen because the crimping die sets is interchangeable with the crimping die sets of the hand crimping tools produced by the company. Our company have many kinds of crimping die sets for selection.

Operating instructions

It is recommended for the user to read this instruction manual carefully before using this equipment, to be familiar with the use method and technology performance indexes of the equipment.

■ Using method

Please connect to the air tube in accordance with the corresponding markings of the equipment and accessories,

- Open the air source, the crimping can be conducted only after the clamp head of the equipment in open state.
- After the fixture is installed, slowly step on the foot air valve so that the machine can operate at low speed, to check the installation situation of the fixture.
- Place the crimping terminal in the corresponding fixture position, step on the foot air valve, release the air valve after the completion of the crimping.
- The crimping speed can be manually controlled according to the speed when stepping on the air valve, or adjusted by selecting the matched pipe joint with the throttling valve.

Operation Instruction for FEK- 50L

■ Service conditions and notes

- The fluid used for the equipment: compressed air.
- Use environment and fluid temperature: 5 ~ 60°C .
- The medium used for the equipment cylinder can be used only after it is filtered by filter element of 40 um and above (i.e., the air source used for the cylinder shall be used after it is filtered by air filter
- The corresponding air tube and joint shall be chosen for the pipeline connecting to the equipment and internal dirty objects must be removed, in order to prevent the sundry into the cylinder from damage to the cylinder.
- When crimping big square terminals, please ensure the air source and air pressure is sufficient.
- If it is used in low temperature environment, the antifreeze measures shall be taken to prevent the water in the system from freezing.
- Suggestion: The medium used for the cylinder can be used after the lubricant is filled (i.e. the oil sprayer is installed in the air supply pipeline; It is proposed to use the turbine oil No. 1 ISOVG32).

■ Maintenance and Storage Notes

- Before using, the connection positions of the sliding shafts of the machine should be filled with a little lubricating oil to extend the service life of the machine.
- The product is the pneumatic product, it shall not be placed in the high temperature and low temperature, high humidity environments no matter when use or store.
- In no use, it shall be kept clean and dry to avoid rust, the removed intake and exhaust ports shall be blocked with the dust cap or taken the other dust prevention measures

■ Crimping die sets replacement method

- Shut off the air source to avoid the risk caused by the improper operation.
- Remove the screws which fixed the crimping die sets with the screwdriver supplied together with the machine.
- Replace it with the required crimping die sets, and then fasten the screws again.

■ Notes when loading and unloading the crimping die sets

- The crimping die sets are used in pairs, when installing, please confirm that the upper and lower die sets are in the centered positions.
- After installing the die sets, slowly step on the foot air valve, so that the machine can operate at low speed, to check the installation situation of the crimping die sets.

Quality assurance

Our guarantees that all products are strictly performed the quality inspection before leaving the factory, the company will provide you with the perfect after-sale security services in accordance with the regulations of three guarantees for products. The company will provide you with the quality assurance of 12 months under normal service conditions from the date of purchase, the followings do not belong to the warranty scope:

- Application of the non-provisions of FEK-50L.
- Inappropriate workplace
- Inappropriate application and application beyond the provisions of the operating instructions.
- Reformation of FEK- 50L without authorization
- Continuous use of FEK-50L under the failure situation
- Continuous use after crimping more than 500,000 times. It shall be maintained by the manufacturer after crimping more than 500,000 times.
- Inappropriate die installation/repair
- No use of original crimping die sets and original spare parts.










The large metal parts or materials cannot be fed into the crimping die sets for avoiding to damaging the crimping die sets.

-Based on security reasons, FEK-50L is prohibited to transform and the part is prohibited to replace and change without authorization.



- (1) Put the stripped wire into the corresponding terminal.
- (2) Put the terminal into the corresponding crimping die sets, then step down the foot air valve, release the air valve after the completion of the crimping.
- (3) When replacing the crimping die sets, shut off the air source firstly for avoiding the risk caused by improper operation. Unscrew the screw which fixed the crimping die sets.
- (4) Replace the required crimping dies on the fixture.

Die sets for selection

| Item No. of Die Sets | For Terminals | Crimping Diameter (mm) | mm ² | AWG | Crimped Shape | Terminal Type | | |
|----------------------|---------------|------------------------|-----------------|-------|--|---|--|--|
| RN-5.5W | RNB5.5 | 5.6 | 4~6 | 12-10 |  Hexagonal (TO) |  (TO) | | |
| RN-8W | RNB8 | 7.2 | 6~10 | 8 | | | | |
| RN-14W | RNB14 | 9 | 10~16 | 6 | | | | |
| RN-22W | RNB22 | 11.5 | 16~25 | 4 | | | | |
| RN-38W | RNB38 | 13.3 | 35~50 | 2 | | | | |
| RN-60W | RNB60 | 15.4 | 50~70 | 1/0 | | | | |
| SC-6W | SC6 | 5.3 | 6 | 12 |  Hexagonal (DTGA) |  (DTGA) | | |
| SC-10W | SC10 | 6.3 | 10 | 10 | | | | |
| SC-16W | SC16 | 7.5 | 15 | 8 | | | | |
| SC-25W | SC25 | 9 | 25 | 6 | | | | |
| SC-35W | SC35 | 10.8 | 35 | 4 | | | | |
| SC-50W | SC50 | 12.5 | 50 | 2 | | | | |
| SC-70W | SC70 | 14.5 | 70 | 1/0 | | | | |
| RN-5.5D | RNB5.5/SC10 | 5~6 | 4~6 | 12-10 | | |  Indent Type A  Type B |  (TO) and (DTGA) |
| RN-8D | RNB8/SC16 | 7~8 | 6~10 | 8 | | | | |
| RN-14D | RNB14/SC25 | 9~10 | 10~16 | 6 | | | | |
| RN-22D | RNB22/SC35 | 11~12 | 16~25 | 4 | | | | |
| RN-38D | RNB38/SC50 | 13~13.5 | 35~50 | 2 | | | | |



Distributor in EU (Denmark and Nordic)

TEK+ Electronic ApS
www.tek-tools.dk
info@tek-tools.dk