

### COMPATIBLE WITH EXISTING CRIMP DIES

The HX23 accommodates all M22520/5-XX military and Daniels "Y" series crimp dies. This affords total utilization of existing dies and total interchangeability with M22520/5-01 (Daniels HX4) hand tool frames.

### FULL CYCLE CONTROL

Full die closure is assured on every crimp. The internal cycle control network will not allow the tool to open until complete closure is attained. A simple procedure is available to open the tool in cases where a complete cycle cannot be effected. A secure method is provided to prevent unauthorized personnel from defeating the cycle control system.

### HANDS FREE OPERATION

There are no awkward levers or mechanisms used to open or close the crimp dies. These operations waste time and distract the operator's attention. When the tool is in the normal condition, the crimp dies are fully open where contact assemblies

can easily be inserted. A touch of the foot valve releases the dies to a gripping position (spring pressure only). When the operator is satisfied that the contact assembly is positioned correctly, another actuation of the same foot valve completes the crimp and quickly returns the die to open position.

### OPERATOR SAFETY FEATURES

The HX23 is equipped with a transparent guard which affords the protection, but does not restrict vision. The Hands Free Operation system allows the operator to position the contact assembly while the die is

under spring pressure only. The operator is then free to let the tool hold the contact assembly during the crimp cycle while the operator's hands and fingers are a safe distance from the crimping die. The HX23 foot valve assembly is constructed with a protective shroud to prevent accidental actuation. For operation the operator places their foot under the shroud on the pedal and depress.

### FULL PNEUMATIC OPERATION

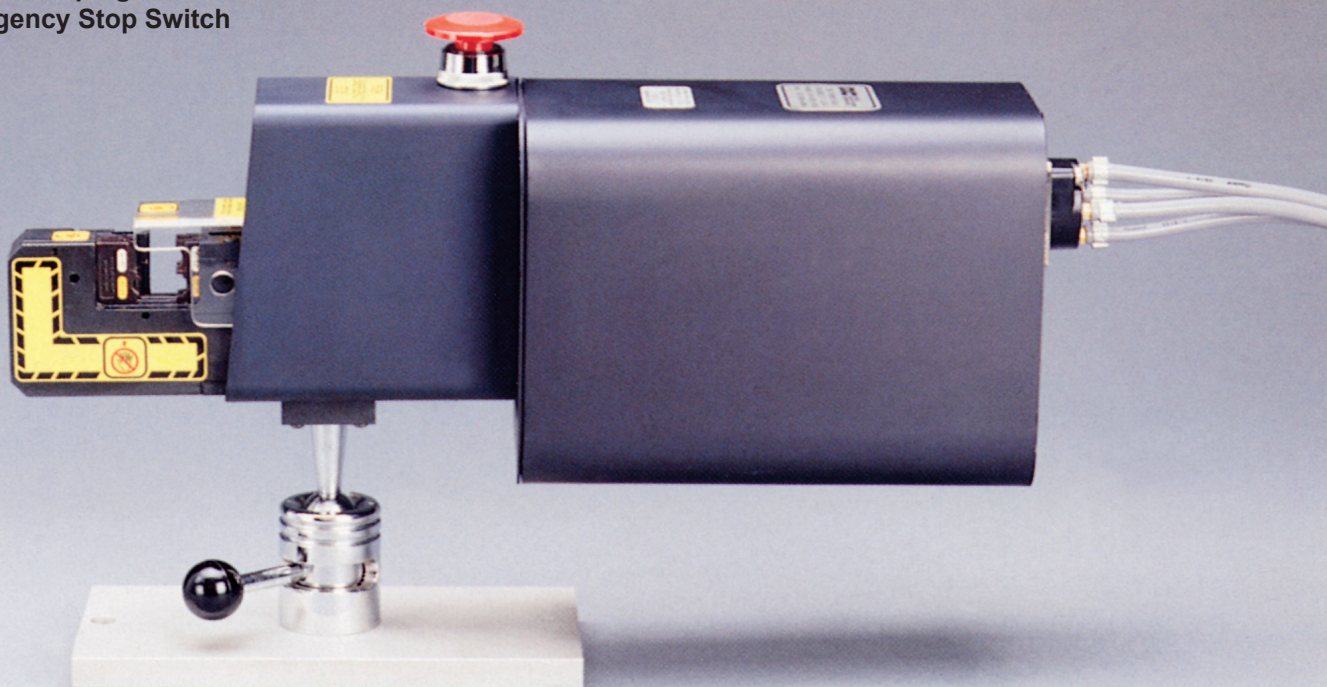
Standard clean, dry shop air at pressure is all that is required to operate the HX23 tool. There are no electrical or hydraulic requirements.

### SPECIFICATIONS

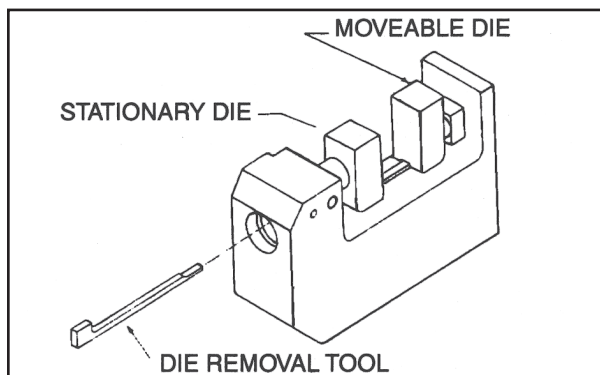
Components	Size	Weight
TOOL FRAME (less Bench Mount)	(in) 4½ x 6 x 16 (cm) 11.4 x 15.2 x 40.6	11½ LBS 5.2 KG
FOOT VALVE	(in) 4 x 5 x 13½ (cm) 10.2 x 12.7 x 34.3	6 LBS 2.7 KG
CABLE	9 Feet - 2.7 Meters	N/A
Air Requirements 80-95 PSI (5.5-6.5 BAR)		

### SAFETY FEATURES:

- 2 Step Crimping Process
- Emergency Stop Switch

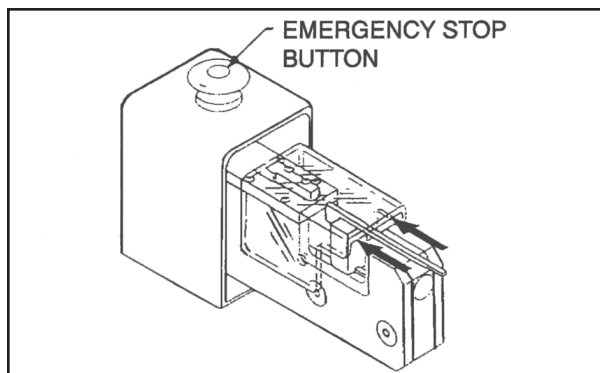


The HX23 crimp tool features a system of interchangeable dies which eliminate the need for separate fixed die crimp tools for each and every different application. Dies in various crimp patterns are available for MIL-C-39029 shielded contacts, MIL-C-39012 coaxial connectors, MIL-T-7928 terminals and splices, and other commercial and military terminating components.



The die sets snap in and out of the crimp tool for interchangeability. A die removal tool is included with the HX23 for operator convenience.

**CAUTION:** Always disconnect the air supply when changing the die sets.



Adjustable Dies for Terminals & Splices		
COLOR	SIZE	P/N
Red/Blue/Yellow	26-10	Y501
Yellow	12-10	Y670
Blue	16-14	Y671
Red	22-18	Y672
Yellow	26-24	Y678
Red/Blue	22-14	Y1060

Adjustable Crimping Dies accept terminations which conform to AS7928, AS25036 (class 1 and 2) and other military or commercial specifications.

DIE PART NUMBER			DIE DIMENSIONS			
DMC P/N	MILITARY P/N	NATIONAL STOCK NO. N.S.N.	"A" CRIMP HEIGHT	LENGTH	"B" CRIMP HEIGHT	LENGTH
HX4	M22520/5-01	5120-01-335-8575	N/A	N/A	N/A	N/A
HX23	N/A	N/A	N/A	N/A	N/A	N/A
Y200P	M22520/5-02	5120-01-335-8244	.091	.090	.068	.270
Y196	M22520/5-03	5120-01-335-8245	.128	.325	.105	.325
Y152	M22520/5-04	5120-01-335-8246	.138	.090	.118	.270
Y197	M22520/5-05	5120-01-335-8247	.213	.325	.178	.325
Y203	M22520/5-06	5120-01-335-8248	.128	.094		
Y195	M22520/5-07	5120-01-335-8249	.255	.325		
Y215	M22520/5-08	5120-01-335-8250	.128	.375		
Y204P	M22520/5-09	5120-01-335-8251	.178	.400	.068	.093
Y189	M22520/5-10	5120-01-335-8252	.160	.400		
Y205P	M22520/5-11	5120-01-335-8253	.213	.400	.068	.093
Y206P	M22520/5-13	5120-01-335-8254	.255	.400	.068	.093
Y207P	M22520/5-15	5120-01-335-8255	.263	.400	.068	.093
Y193	M22520/5-17	5120-01-335-8256	.118	.375		
Y142	M22520/5-19	5120-01-335-8257	.255	.400	.213	.400
Y149	M22520/5-21	5120-01-335-8258	.475	.400		
Y145	M22520/5-23	5120-01-335-8259	.384	.400		
Y110P	M22520/5-25	5120-01-335-8260	.429	.400	.100	.120
Y151	M22520/5-27	5120-01-335-8261	.532	.400		
Y109P	M22520/5-29	5120-01-335-8262	.324	.400	.100	.120
Y150	M22520/5-31	5120-01-335-8263	.501	.400		
Y136	M22520/5-33	5120-01-335-8264	.343	.400	.105	.400
Y137	M22520/5-35	5120-01-335-8265	.324	.400	.128	.400
Y138	M22520/5-37	5120-01-335-8266	.314	.400	.151	.400
Y139	M22520/5-39	5120-01-335-8267	.309	.400	.160	.400
Y140	M22520/5-41	5120-01-335-8268	.290	.400	.178	.400
Y141	M22520/5-43	5120-01-335-8269	.268	.400	.197	.400
Y143	M22520/5-45	5120-01-335-8270	.231	.400	.218	.400
Y144	M22520/5-47	5120-01-335-8271	.359	.400		
Y146	M22520/5-49	5120-01-335-8292	.401	.400		
Y147	M22520/5-51	5120-01-335-8293	.431	.400		
Y148	M22520/5-53	5120-01-335-8294	.454	.400		
Y102	M22520/5-55	5120-01-335-8295	.324	.400		
Y209P	M22520/5-57	5120-01-335-8296	.213	.400	.100	.120
Y208P	M22520/5-59	5120-01-335-8297	.255	.400	.100	.120
Y178	M22520/5-61	5120-01-335-8298	.429	.400		
Y314P	M22520/5-63	5120-01-335-8299	.263	.400	.091	.090
Y501	M22520/5-100	5120-01-335-8300	Pre-Insulated Terminal Crimp 26-10 AWG			
Y527	M22520/5-101	5120-01-335-8301	Pre-Insulated Splice Crimp 26-20 AWG			
Y539	M22520/5-102	5120-01-335-8302	Splice Crimp 12-16 AWG			
Y540	M22520/5-103	5120-01-335-8303	Splice Crimp 16-26 AWG			

Other Dies available, consult DMC.