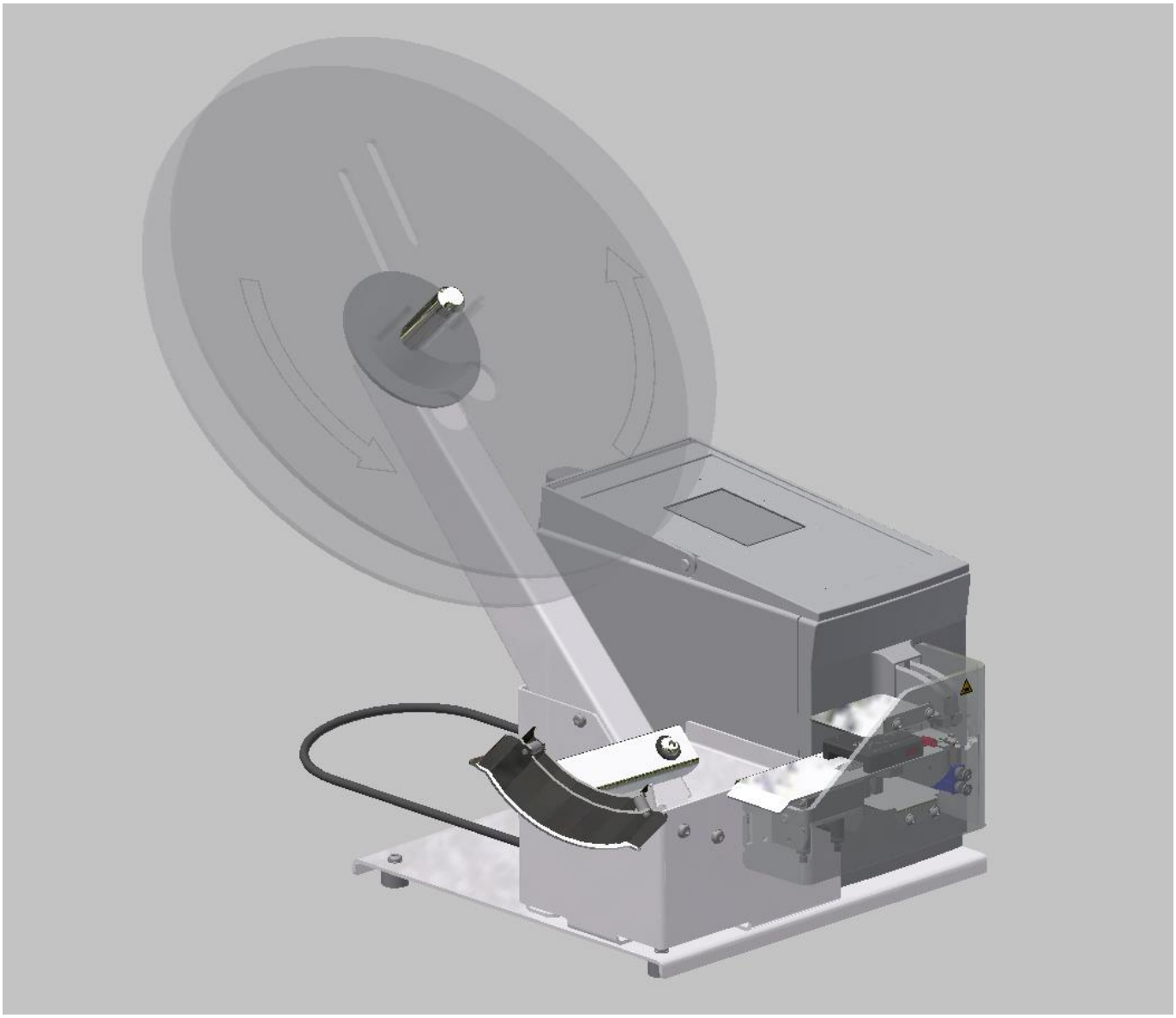
Operating instructions

TF 65

EN



GLW
CRIMPING TECHNOLOGY

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1 Product description

1.1 Scope of delivery

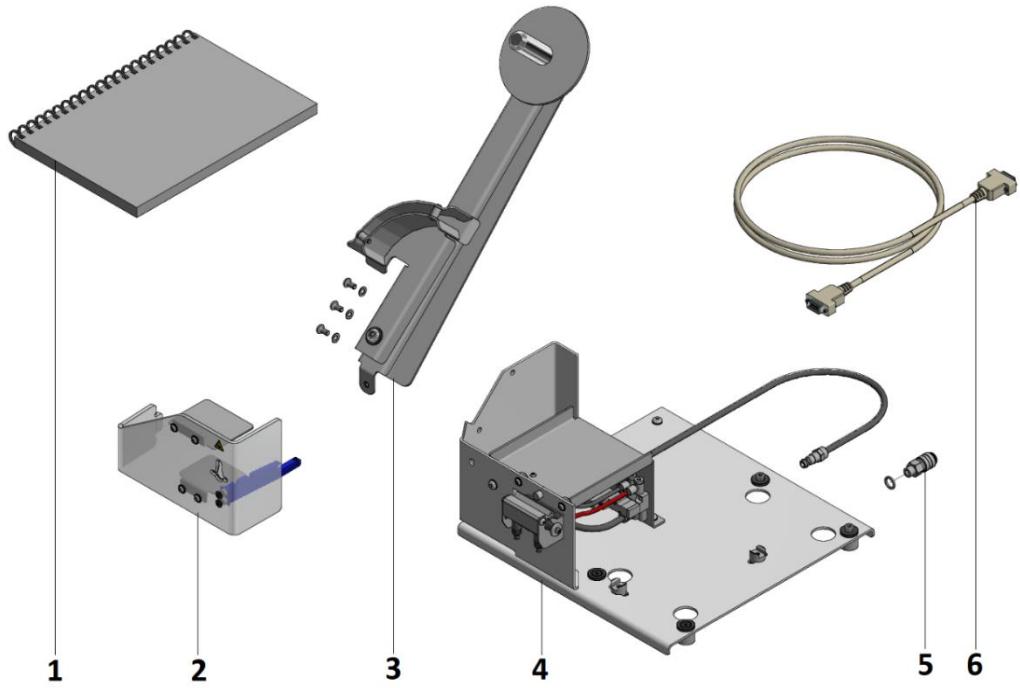


Fig. 1: Scope of delivery

Legend

Item	Description
1	Operating instructions
2	Protective cover
3	Spool holder

Item	Description
4	Base plate with feeder
5	Compressed air connection for PC 65
6	Connection cable

The TF 65 is used in combination with the PC 65 to process belted crimp contacts.

The PC 65 / TF 65 unit can only be operated with the protective cover (2) installed.

Note	
	Please read the operating instructions for the PC 65 and TF 65 carefully. All general information in the operating instructions for the PC 65 must also be observed for the PC 65 / TF 65 combination!

2 Structure of the TF 65 / PC 65 combination

2.1 Assembling the spool holder

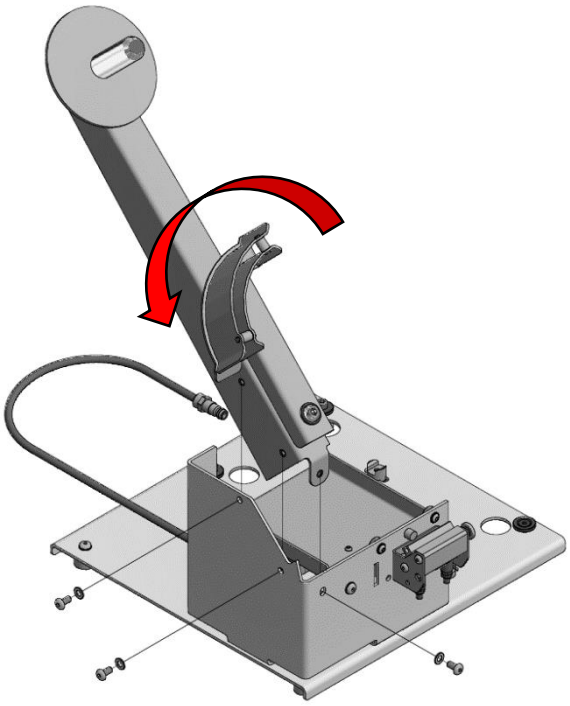


Fig. 2 Assembling the spool holder

2.2 Positioning the PC 65 on the TF 65 base plate

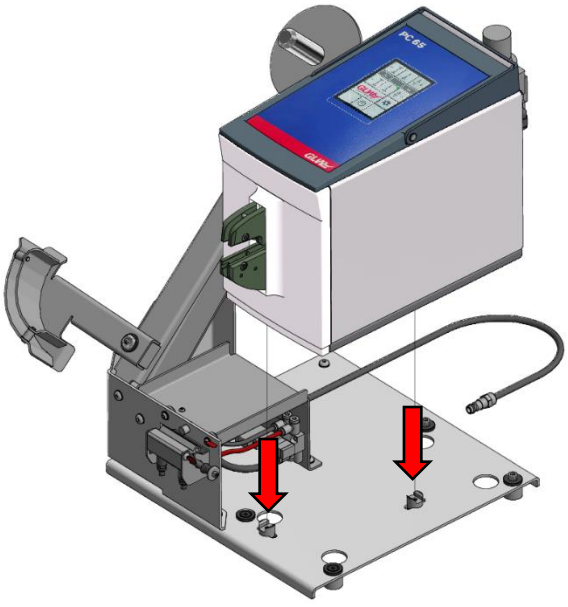


Fig. 3 Positioning the PC 65 on the TF 65 base plate

The screws on the underside of the PC 65 must slide into the guides on the TF 65 base plate (marked in Fig. 3)

2.3 Pneumatic connection for the TF 65 / PC 65

DANGER	
	Risk of injury from compressed air. Improper handling may result in severe personal injury and damage to property. ▶ Check the compressed air connections before starting the work. ▶ Make sure that the compressed air lines are shut off and depressurised

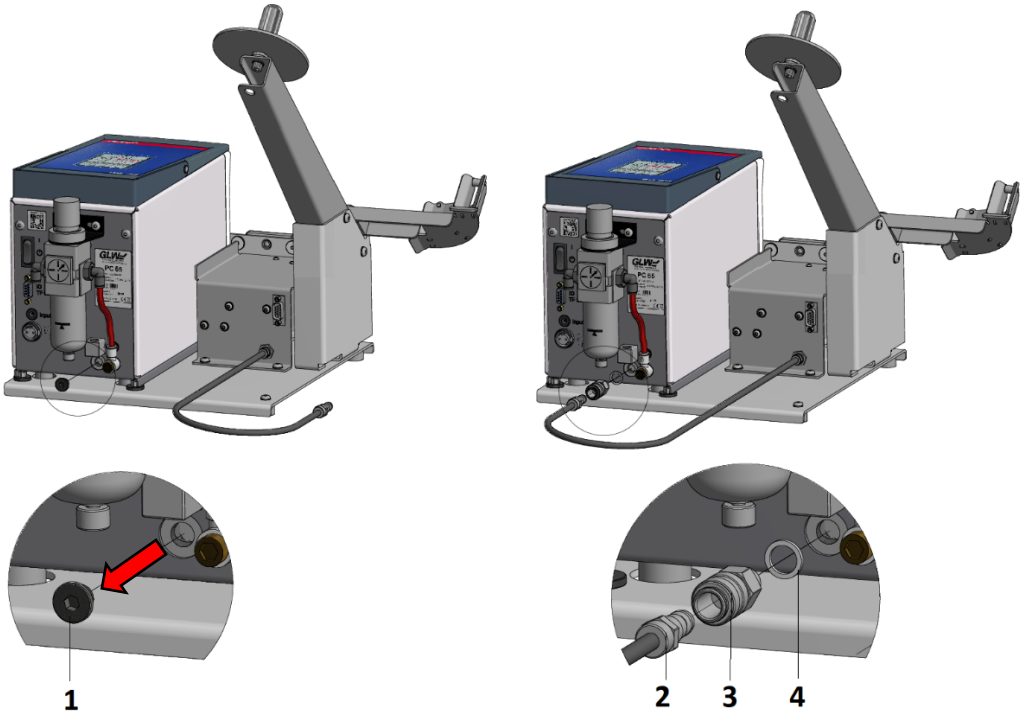


Fig. 4 Pneumatic hose connection

Legend

Item	Description	Item	Description
1	Sealing plugs (remove)	3	Pneumatic coupling (screw in)
2	Pneumatic connecting hose	4	Gasket

2.4 Electrical connection TF 65 – PC 65

DANGER	
	Risk of injury due to electric shock. There is a possibility of burns and even fatal injuries. ▶ Before you start working, make sure that all lines are disconnected. ▶ Secure the lines to ensure they remain de-energised.

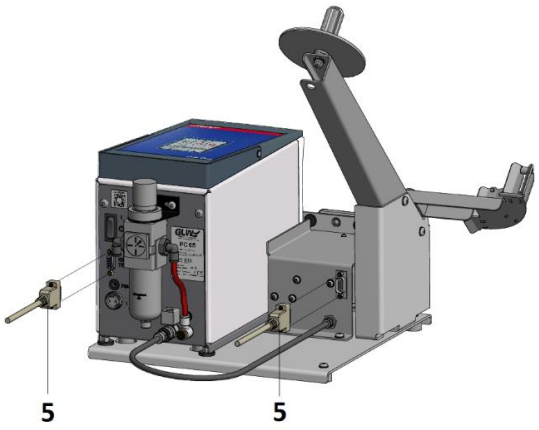


Fig. 5 Connector for connection cable (5)

Legend

Item	Description
5	Connection cable

2.5 Installing the contact feed, crimping die and spool

These parts are not included with the TF 65!

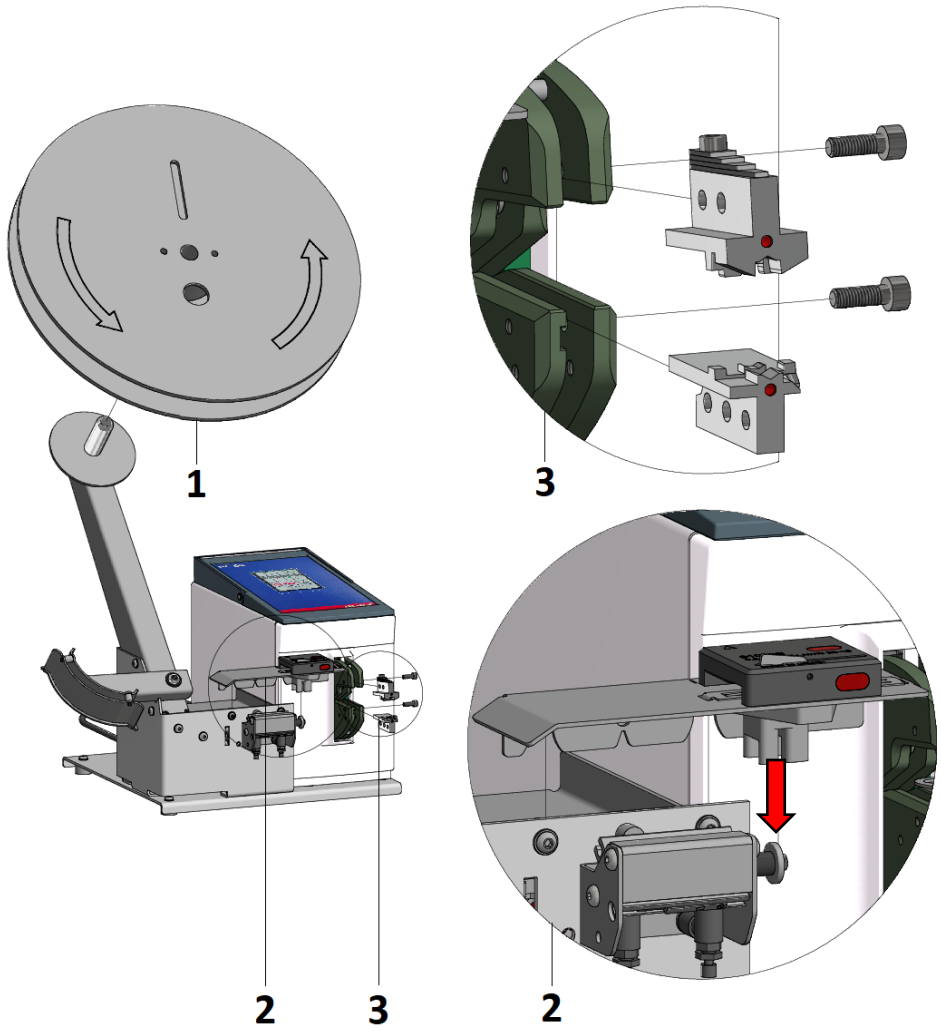


Fig. 6 Installation of spool (1), contact feed (2) and crimping tool (3).

Legend

Item	Description
1	Spool
2	Contact feed
3	Crimping die

Attention: when installing the crimping die, always follow the steps described in section 5.3 of the PC 65 operating instructions!

2.6 Aligning the PC 65 on the TF 65 base plate

Insert the contact belt into the transport feed

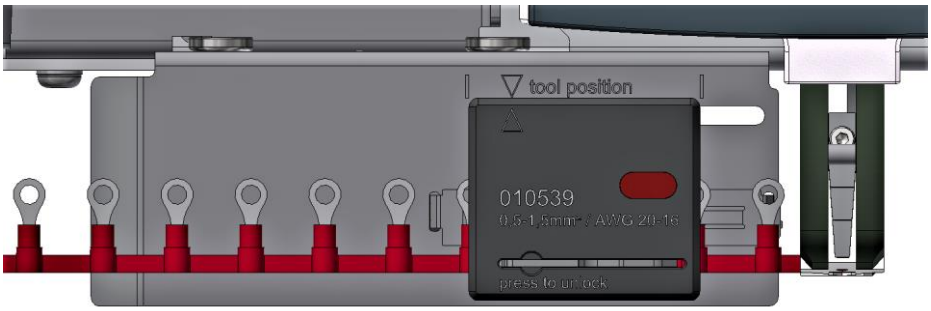


Fig. 7 Contact feed with contact belt

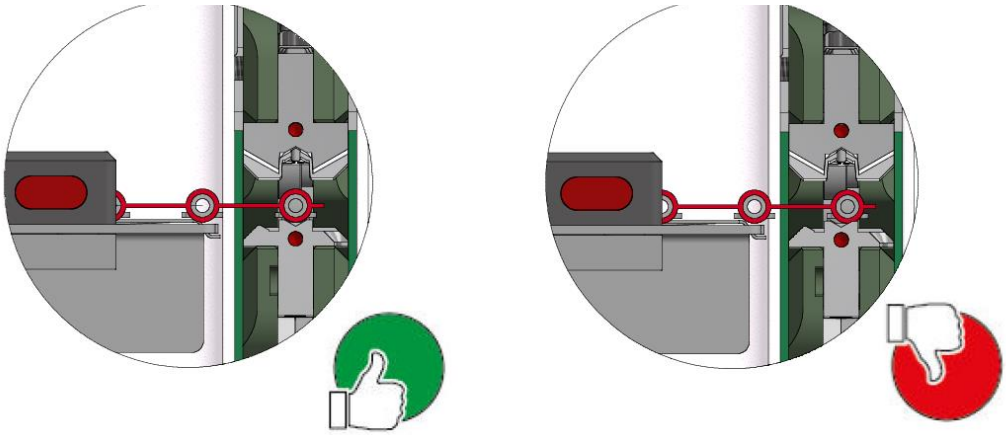


Fig. 8 Check the position of the contact belt

Push the end of the contact belt up to the middle of the die and snap it into place
When correctly aligned, the contact is centred or slightly offset to the left in the die.

If the contact is not in the centre of the die, the device holder (A) on the TF 65 base plate can be readjusted.

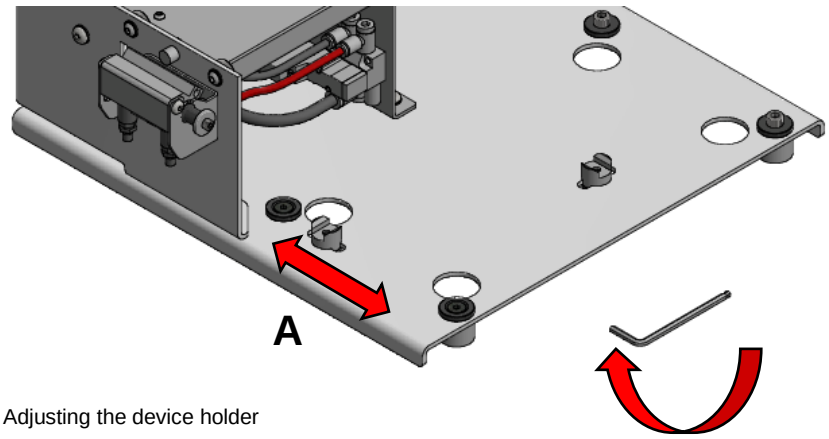


Fig. 9 Adjusting the device holder

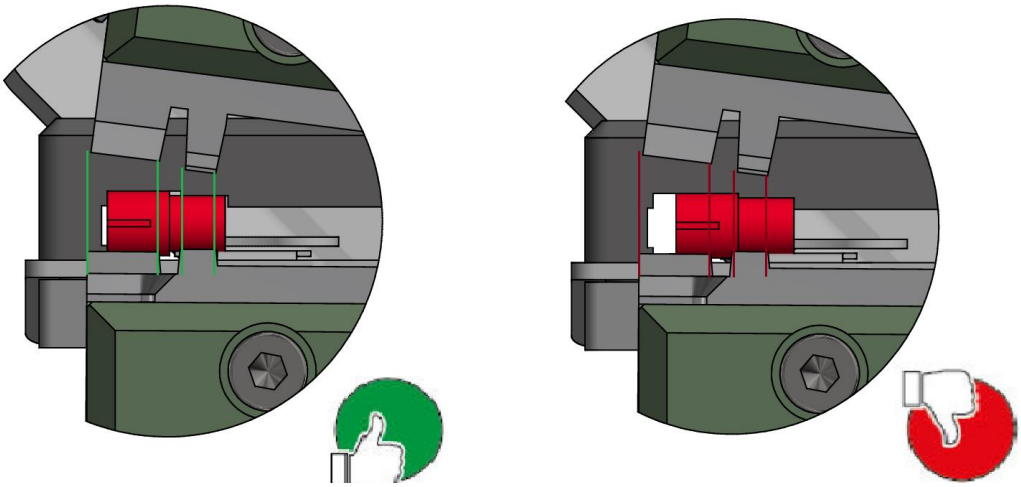


Fig. 10 Check the position of the contact belts

Check the longitudinal alignment.

If the contact is outside the crimping or cutting area, the device holder (B) on the TF 65 base plate can be readjusted

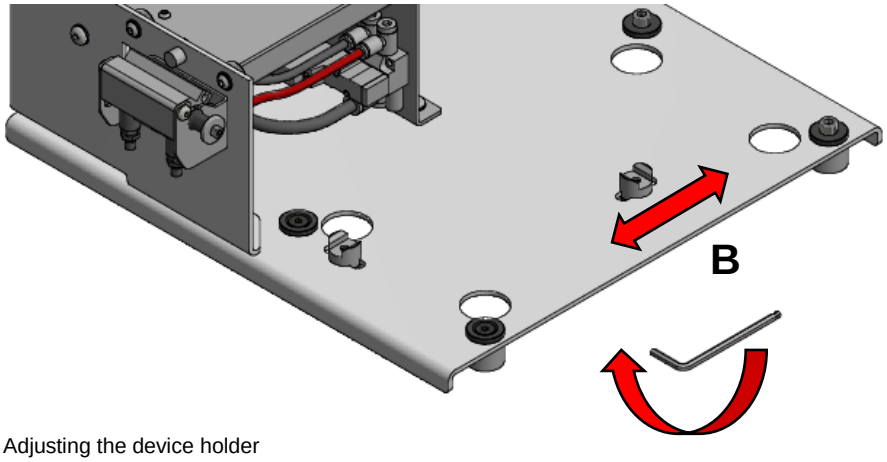
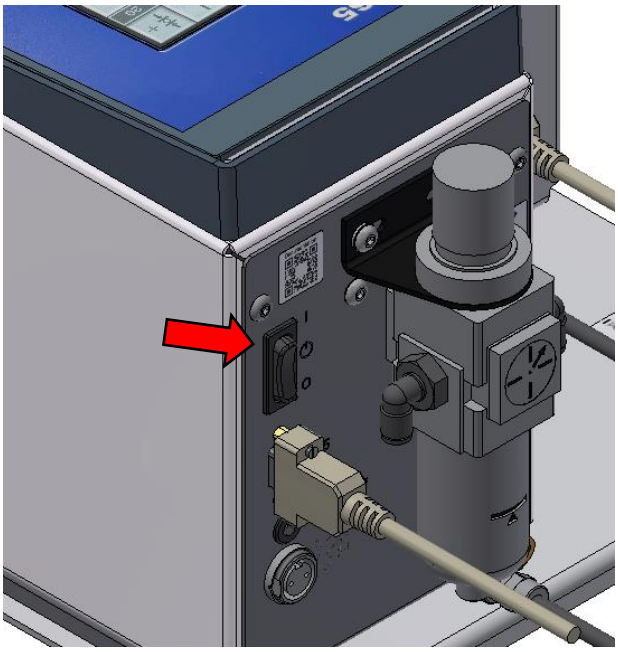
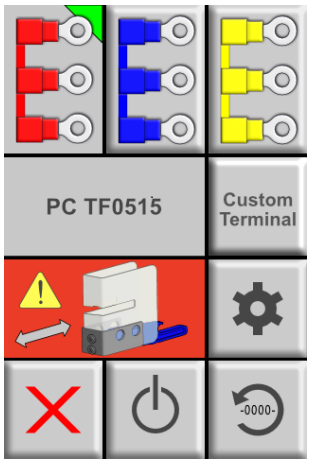


Fig. 11 Adjusting the device holder

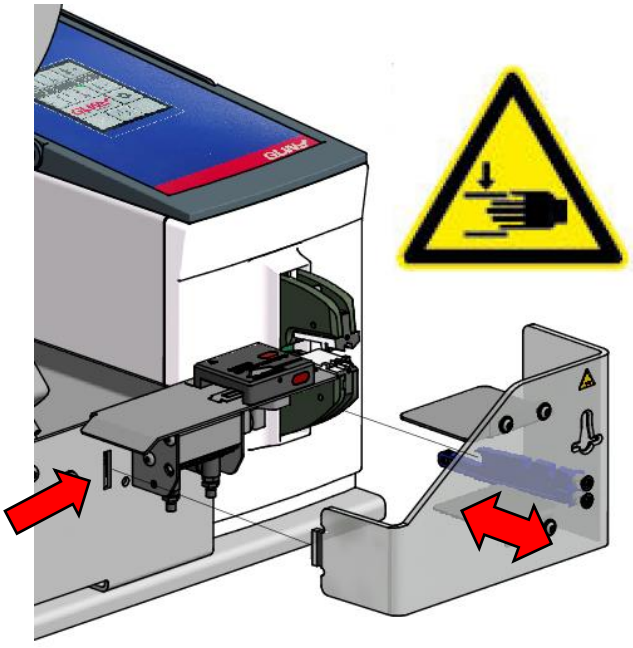
2.7 Commissioning the PC 65 and TF 65



Switch on the PC 65 and TF 65



Display



Remove the protective cover and slide it on again

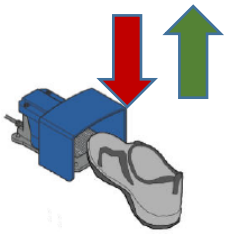


Select the desired contact cross section

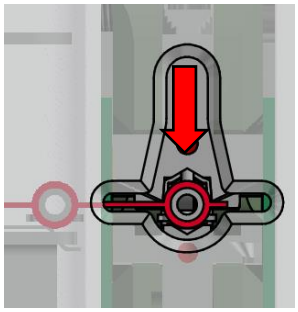
More detailed information can also be found in the operating manual for the PC 65.

For the first crimping operation follow steps 1–3, for all subsequent ones follow steps 2–3

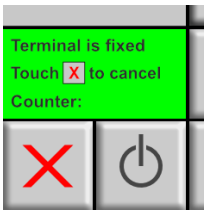
Step 1:



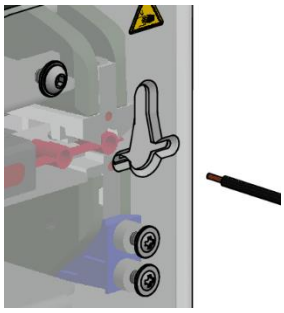
Operate foot pedal



The contact is fixed in the die

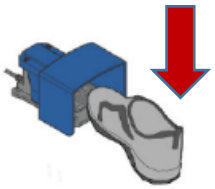


Display

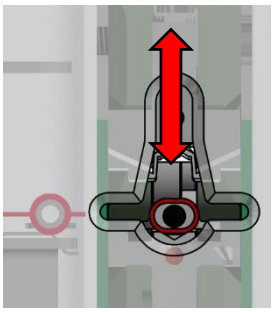


Insert the stripped cable

Step 2:



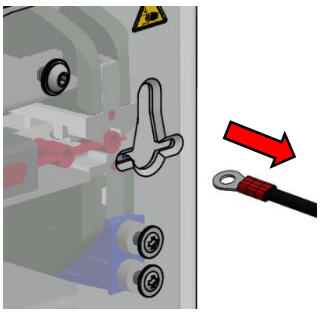
Operate the foot pedal again **and keep it depressed!**



The contact is crimped

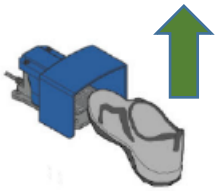


Display after successful crimp

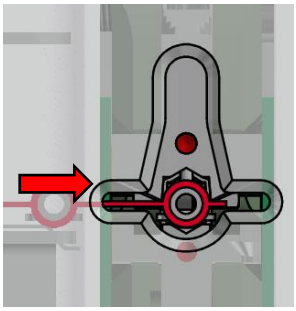


Remove the cable with contact

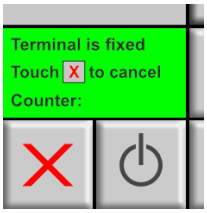
Step 3:



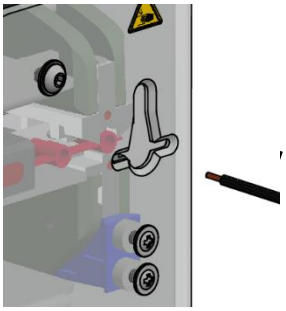
Release the foot pedal



A new contact is transported into the die and fixed in the die

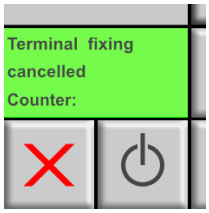


Display



Insert the next stripped cable -> Repeat Step 2

Press the  button to cancel the crimping process after Step 1 or Step 3.



Display

The crimping process must be repeated starting with Step 1.

3 TF 65 / PC 65 error messages

A detailed description of the possible errors can be found in the operating manual for the PC 65.

3.1 Foot switch released too early during crimping process





Display

If the foot switch is released prematurely, the crimping die immediately opens to its initial position

Acknowledge the error message with 

The crimping process must be repeated starting with Step 1.

3.2 Contact feed not properly attached or no compressed air available to the TF 65

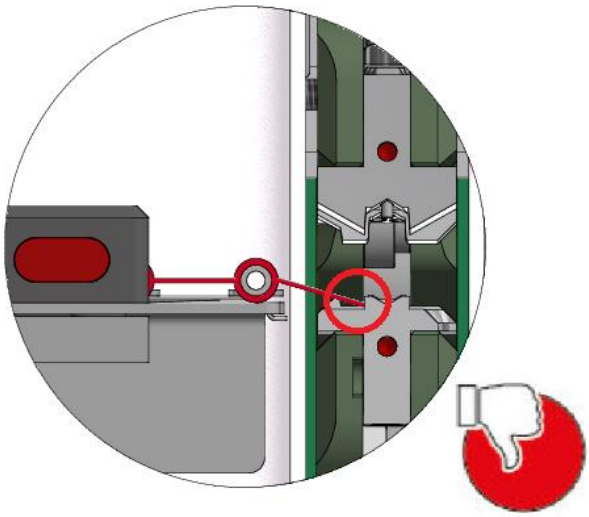


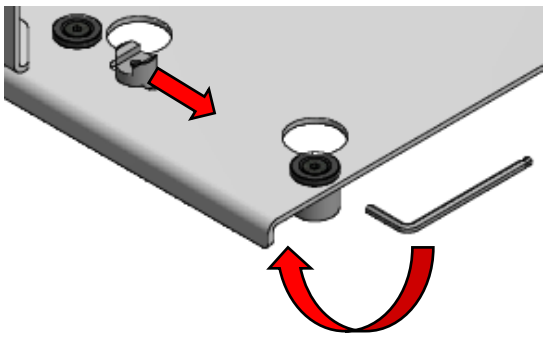
Display

Acknowledge the error message with 

Attach contact feed correctly (see section 2.5) or check compressed air connection to the TF 65.

3.3 Contact belt is stuck to the lower part of the die after crimping





Move the front device holder slightly to the right (see also point 2.6).

4 Technical data

4.1 Technical data

TF 65 Feed Unit	Description	Value
Weight		2.5 kg
Dimensions	length x height x width	387 x 418 x 422 (with spool arm extended)
Compressed air	dry	0.45 to 0.65 MPa
Control voltage		12 V DC
Power consumption		100 mA
Power rating		1.2 W max.
Temperature		+10 to +40°C
Relative humidity		30 to 90%
Ground inclination		Max. 3°

Table 1, Technical data

4.2 Name plate

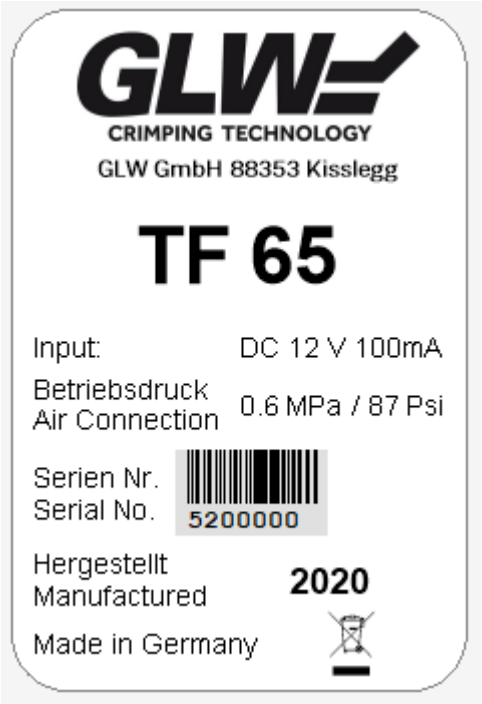


Fig. 12 Name plate

5 Service, spare parts and accessories

A service department is available to assist customers.

5.1 Customer service

GLW GmbH

Steinbeisstr. 2
88353 Kisslegg
Germany

Phone +49 (0)7563 / 9123-0
E-mail service@glw.de

5.2 Spare parts

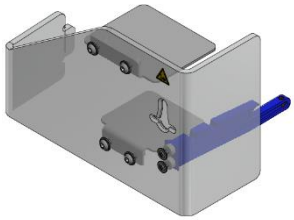
	Illustration	Designation	Order number
1		Protective cover	see www.glw.de

Table 2, Spare parts

5.3 **Accessories** (not included in scope of delivery)

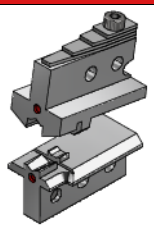
	Illustration	Designation	Order number
1		Crimping die	see www.glw.de
2		Contact feed	see www.glw.de

Table 3, Accessories

6 Declaration of incorporation

Declaration of incorporation in accordance with the EC Machinery Directive 2006/42/EC, Annex II B

Manufacturer:
GLW GmbH
Steinbeisstr. 2
88353 Kisslegg / GERMANY

Contact:
Phone +49-9123 0
info@glw.de
www.glw.de

We hereby declare that the incomplete machine

Product: Feed Unit

Type: TF 65

Serial number: as per delivery documents

complies with the following essential requirements of the Machinery Directive 2006/42/EC Annex I, subchapters 1.1.2, 1.1.3, 1.1.5, 1.3.1, 1.3.2, 1.3.3, 1.3.4, 1.3.9, 1.4.1, 1.5.3 and 1.5.4 – as far as possible based on the scope of delivery.
Furthermore, we declare that the special technical documentation for this incomplete machine has been prepared in accordance with Annex VII Part B, and undertake to provide this documentation to the market surveillance authorities on request via our “Documentation” department.

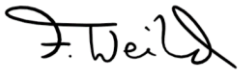
Commissioning of the incomplete machine is prohibited until the incomplete machine has been incorporated into a machine that complies with the provisions of the EC Machinery Directive, and the corresponding EC Declaration of Conformity has been made available in accordance with Annex II A. This declaration shall lose its validity in the event of any modifications to the delivered parts.

Person authorised to compile the relevant technical documentation:

Felix Weiland
Steinbeisstr. 2
88353 Kisslegg / GERMANY
Phone +49-(0)7563 9123 0

This declaration of incorporation was issued:

in Kisslegg, on 30 November 2020



Felix Weiland
(Technical Management)

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We reserve the right to make changes to the technical data and design without prior notice in the interests of continuous product improvement.

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