

WÜRTH ELEKTRONIK MORE THAN YOU EXPECT



OPERATION MANUAL RACK-AND-PINION PRESS BASE PLATE PRESS-ADAPTERS

Read these instructions carefully before using this tool

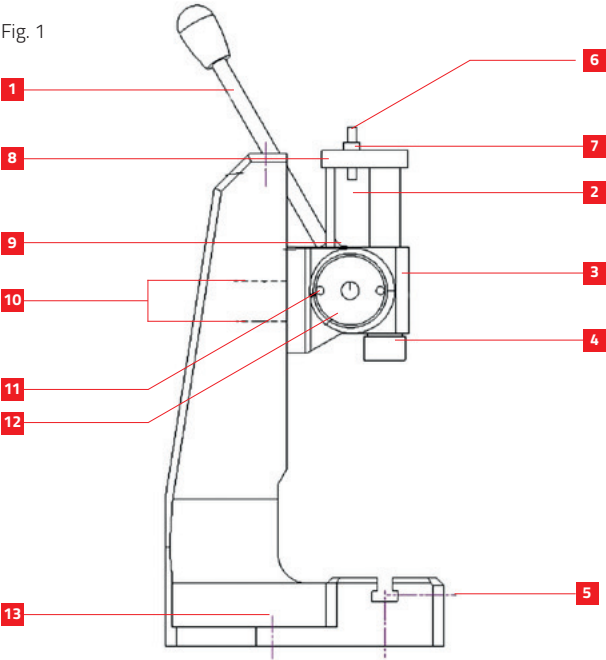
Art.-Nr./Order Code:

600 600 282 800 | 600 600 282 801 | 600 612 282 804 |
600 612 282 805 | 600 618 282 805 | 600 618 282 806 |
600 625 282 804 | 600 690 282 802 | 600 690 282 803 |
490 001 0

1. Mechanical Structure

1.1 Overview

Fig. 1



- | | | | |
|---|------------------------------|----|-------------------------------------|
| 1 | Handlever | 8 | Stroke reducer |
| 2 | Ram | 9 | UT Stroke stopper BDC |
| 3 | Head unit | 10 | Head locking screws |
| 4 | Tool locking screw | 11 | Screws for cover plate/bearing disc |
| 5 | Locking screw for workpiece | 12 | Cover plate for torsion spring |
| 6 | Working stroke adjustment | 13 | Frame bolt holes |
| 7 | Locking nut – working stroke | | |

2. Setup instructions

2.1 Handlever

- Mount handlever **(1)** to shaft and tighten it with a clamping screw. The fastening torque is from 6 Nm to max. 15 Nm.
Attention: The maximum operating force at the handlever is 200 N (it is not allowed to be exceeded)

2.2 Setting of working height

- Loosen head locking screws **(10)**
- Unfasten the adjustable stroke reducer **(8)**, move the tool upon the workpiece and retight
- Adjust the press depth by fine tuning of the ram **(6)** and retight the locking nut **(7)**

2.3 Adjustment of torsion spring return force

- Move the press head **(3)** to the upper position and remove the stroke reducer **(8)**
- Move the ram **(2)** downwards till toothing is out of contact
- Turning the handlever **(1)** forward will lead to a higher spring return force. Turning it backwards leads to a lower spring return force.
Attention: Don't overstrain the spring
- Assemble ram **(2)** and stroke reducer **(8)**

2.4 Exchange of the torsion spring

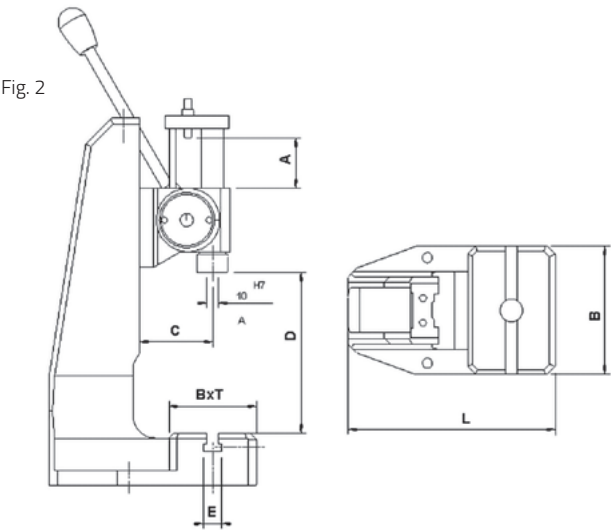
- Unfasten screws **(11)** and remove coverplate **(12)**
Attention: The torsion spring is under force
- Grease the new torsion spring at the inside, exchange the old spring with the new one and assemble the coverplate
Notice: The spring is self slinging

2.5 Cleaning of ram

- Clean the ram occasionally with a slightly oiled cleaning wipe
- In any case do not use any solvent based cleaners in order to avoid any dry running condition of the ram

3. Technical Data

600 600 282 800 WR-TOOL IDC Press
600 600 282 801 WR-TOOL Base



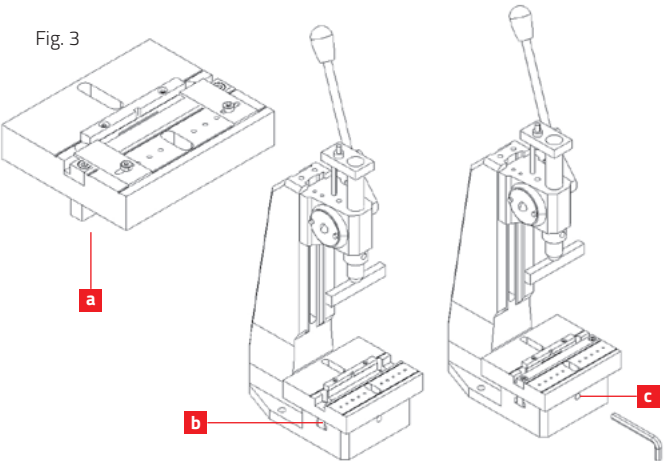
	Measure	Value
Force	–	1,6 kN (360 lbs.)
Stroke	A	0 – 40 mm (0 – 1.57 in.)
Base dim.	L x B	110 x 185 mm (4.33 x 7.28 in.)
Table dim.	B x T	110 x 80 mm (4.33 x 3.15 in.)
Overhang	C	65 mm (2.55 in.)
Working height	D	55 – 190 mm (2.16 – 7.48 in.)
Table bore	E Ø	20H7 mm (0.78 in.)
Weight appr.	–	11 kg (24 lbs.)

	Material
Screws (DIN 912-10.9)	Steel
Base of stator and slider	Cast iron EN-GJL-250 DIN EN 1561
Die	Aluminium EN-AW7075
Other functional parts	16MnCr5 or 9SM28K

4. Base plate & adapters

4.1 Mounting base plate

Fig. 3



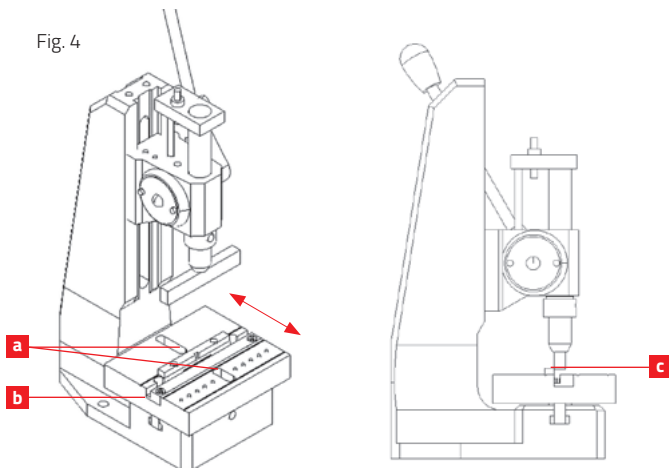
- Insert base plate **(a)** from above into the T-slot **(b)**
- Lock screw **(c)** with allen wrench until the first resistance

4.2 Available adapters

Adapter no.	WE-Series	Fits for p/n
600 690 282 802 600 690 282 803	WR-MM	690 157 00x x72 690 207 10x x72
600 618 282 805	WR-DSUB	618 0xx 221 823 618 0xx 221 923
600 618 282806	WR-DSUB Flange Type	618 0xx 226 221 618 0xx 227 221
600 661 282 802	WR-WTB 2,54 mm IDC	661 00x 15x x22
600 612 282 804	WR-BHD 2.54 mm	612 0xx 230 2 612 0xx 223 23
600 612 282 805	WR-BHD 2.54 mm, Flange	612 0xx 258 21 612 0xx 259 21
600 625 282 804	WR-BHD 2.00 mm	625 0xx 230 21 625 0xx 223 23
600 627 303 001	WR-BHD 1.27 mm	627 0xx 231 21
490 001 0	WR-WST	490 107 67x x12

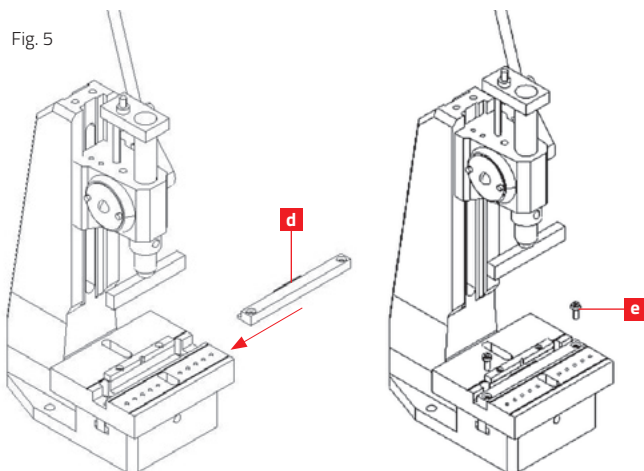
4.3 Preparatory work

Fig. 4



- Unlock the screws of the baseplate (a). After that the baseplate is movable lengthways.
- Move the head unit in the lowest position
- Align the fence of the baseplate (b) with the stamp (c)
- Adjust head unit to suitable working height

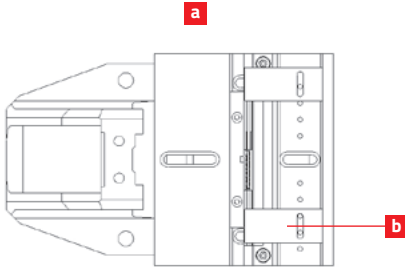
Fig. 5



- Insert the adapter (d) until it is flush mounted with the base plate
- Fix adapter with the screws (e)

4.4 Pressing process

Fig. 6



- Insert the connector sideways or from above into the adapter. Make sure that the connector is placed correctly in the adapter **(a)**
- Insert IDC connector from above into the adapter. Put the bigger plastic peg in one of the boreholes in the adapter. Make sure that the connector is placed planar in the adapter.
- Adjust the cable guidance **(b)** on cable width and fix it
- Start pressing process by operating the handlever

Advice:

For the final adjustment of working height please take care on sufficient stroke to ensure a entire pressing of the connector.

Notice:

The press dies have been developed specifically for Würth Elektronik products. In case of usage of non-specified third-party products, Würth Elektronik does not accept any warranty.

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