

REV.	DATE	DESCRIPTION	ECO	BY	C'H'K.
C	0201-12-17 00:00:00 EST	UPDATED AS PER MARKUP	48032	MG	RM

FOR USE WITH 11 TON TOOLS ONLY, SUCH AS PAT644, PAT444S, AND Y644XT SERIES TOOLS

OPERATING INSTRUCTIONS:

- A. Prior to operating the tool, ensure the nest is fully closed and the gauge assembly is properly installed, including v-block and ram puck. Failure to follow these instructions may cause damage to the tool.
1. Ensure the force test gauge is calibrated (for calibration instructions refer to the safety operating instruction manual provided with the gauge) prior to use.

2. Remove the battery from the tool.

3. Prior to installing the force test gauge in the tool, the Indenter must be removed from the tool

a. Remove the two 1/4-28 set screws from the indenter and associated dowel pins.

4. Install the Ram Puck Assembly onto the piston ram.

5. Install the V-Block Assembly into the nest. Gently lock the pressure pad into the nest using the thumb screw

a. Close the tool nest and fully insert the nest locking pin (never operate the tool without the locking pin fully engaged or damage may result).

6. Insert the gauge assembly into the crimp tool.

a. The gauge body must rest flat on the v-block assembly.

b. The ram puck must be aligned with the gauge pressure pad.

c. Close the tool nest and ensure the nest locking pin is fully inserted.

7. Install the battery. Keep all body parts away from tool pinch points.

8. Jog the tool activation trigger to slowly engage the force test gauge.

9. Observe the pointer position on the force test gauge while advancing the tool when maximum output force is reached (at maximum force the relief valve will pop). Repeat this process several times.

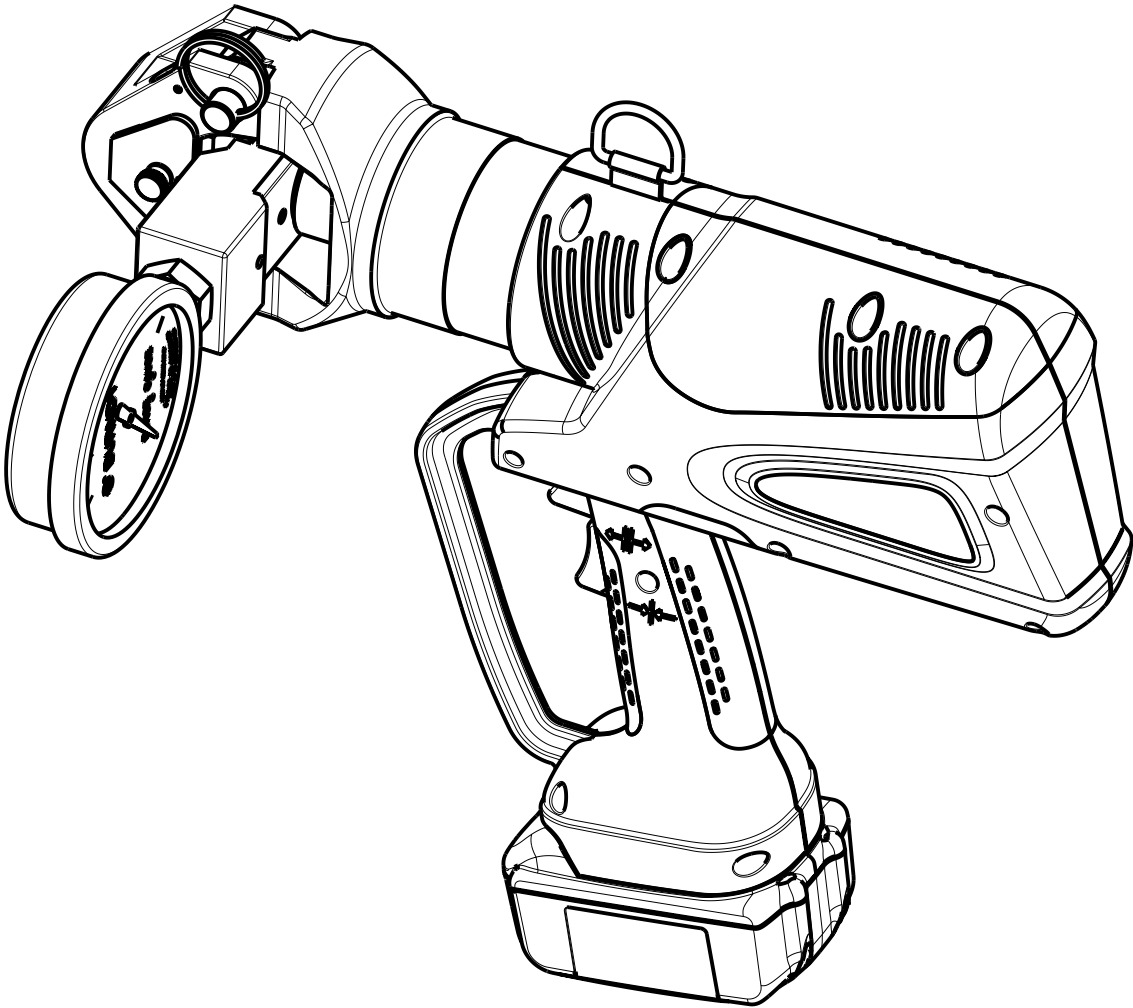
10. A pointer that reaches the solid green band verifies that the tool output force is within the recommended range.

11. Holding the gauge assembly activate the retract trigger on the crimp tool.

12. Remove the battery.

13. Reinstall the indenter on the tool ram. Ensure two dowel pins and two set screws are installed.

14. Close the tool nest and fully insert the nest locking pin (never operate the tool without the locking pin fully engaged or damage may result).

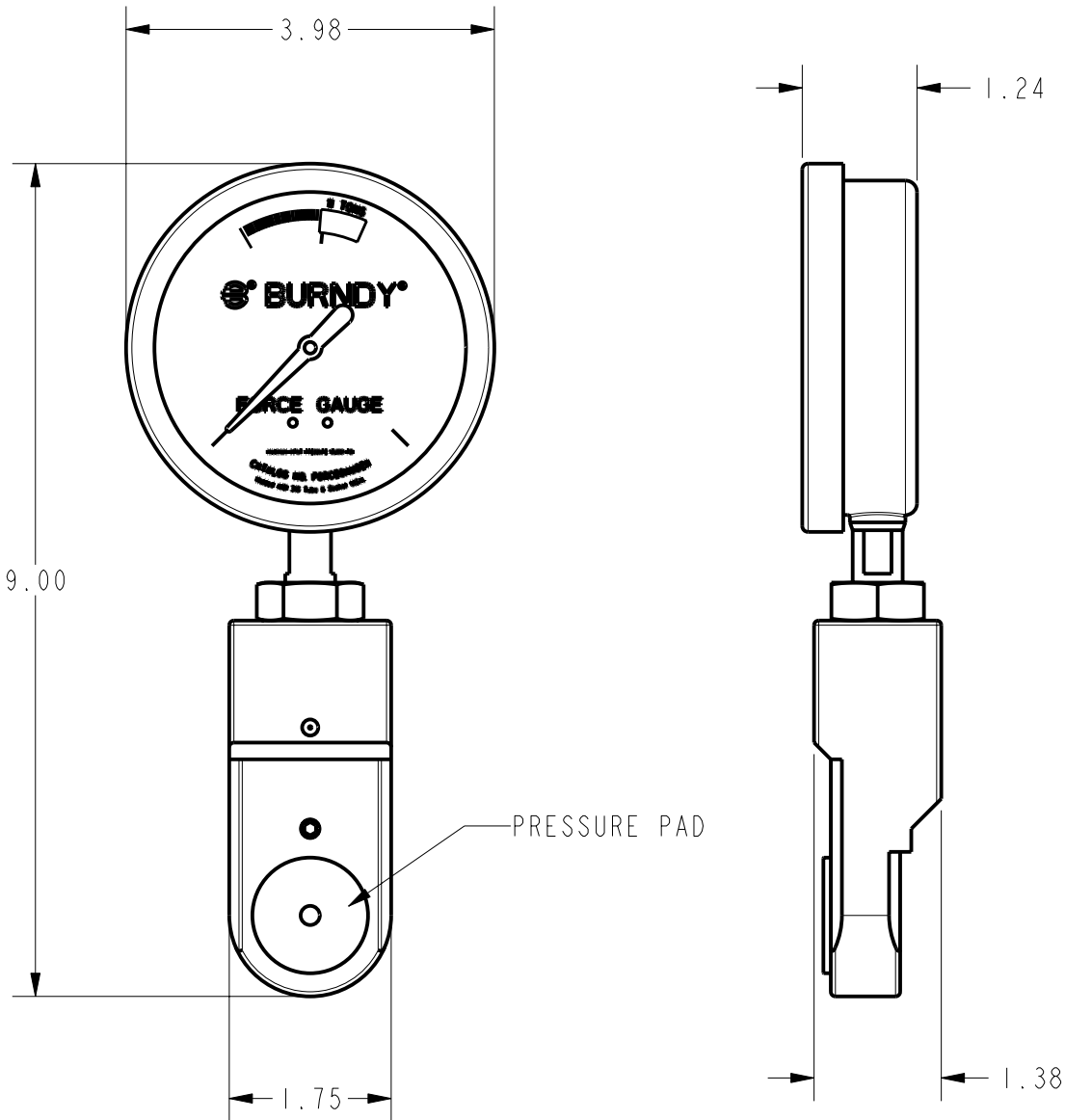
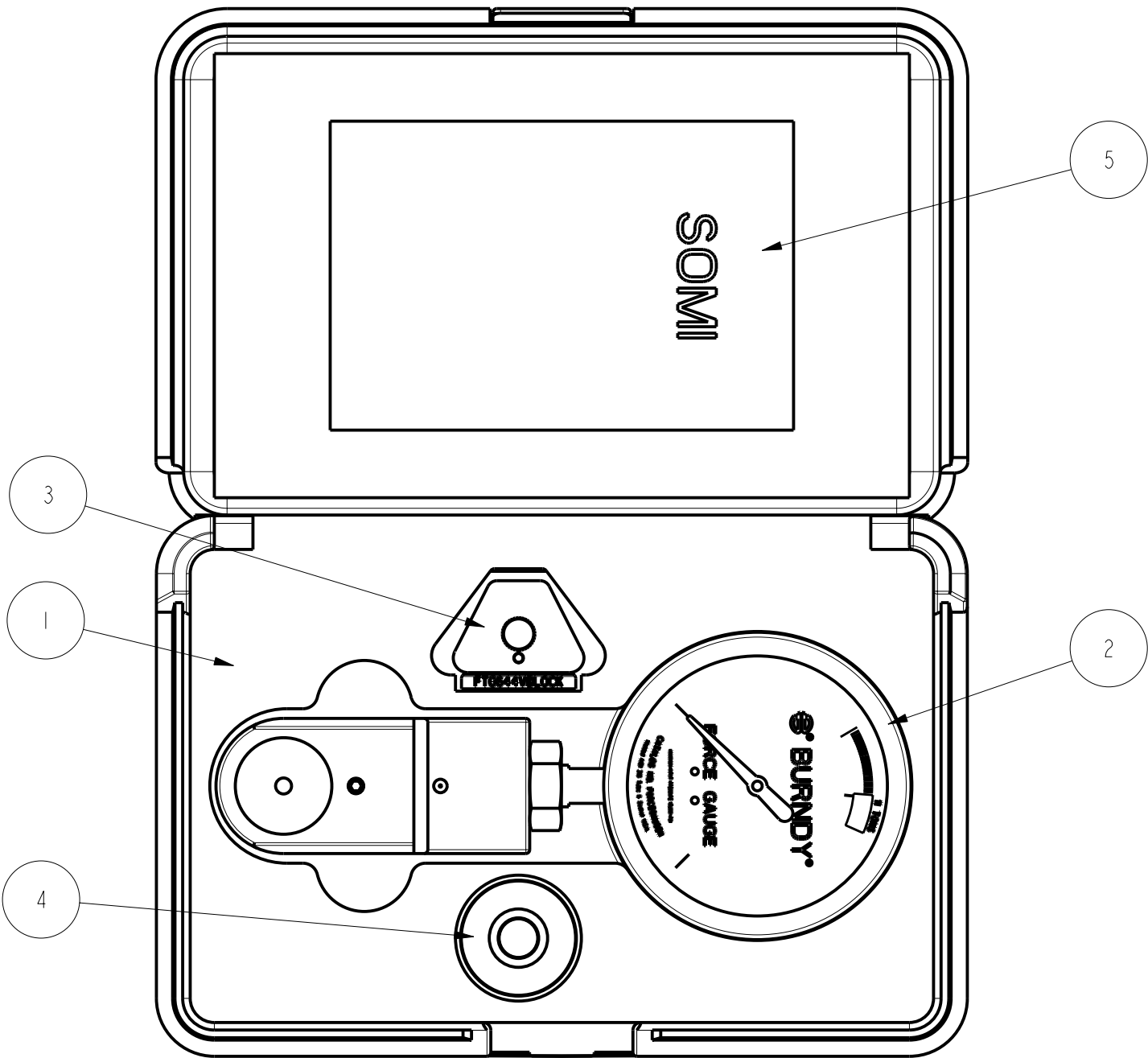


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		ITEM NO: 50044501	
		CAT. NO: FORCEGAUGE11	
		DRAWN BY: T. FAUCHER 12/15/2015	
		CHECKER: J. LEFAVOUR 12/15/2015	
		DSN APPVL: J. LEFAVOUR 01/29/2016	
		MFG APPVL: S. GONYAW 01/29/2016	
		QA APPVL: C. LINDQUIST 01/29/2016	
		MKT APPVL: P. SILVA 01/28/2016	SCALE: 1:5
		PROD FAM: TOOLS, SERVICE	DRAWING NO
		PROJECT #: --	50044503
		DOCUMENT TYPE: Sales	REV
		REL LEVEL: Released	C
		SIZE	
		B	
		SHEET 1 OF 2	

REV: PE0200

*** BILL OF MATERIAL ***

PT NO.	CATALOG NO.	QTY	DESCRIPTION
1	FTG644CASE	1	CASE, FORCE GAUGE PAT644
2	--	1	GAUGE, PRESSURE TEST PAT644
3	FTG644VBLOCKASSY	1	V-BLOCK ASSEMBLY, FORCE TEST GAUGE 644
4	FTG644PUCKASSY	1	PUCK ASSEMBLY, RAM PAT644
5	FORCEGAUGE11OMI	1	SOMI, FORCE GAUGE 11 TON
6	CSELBLGAUGE11	1	LABEL, FORCE GAUGE 11 TON



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SHEET 2 OF 2	