

# Simonds

## OWNER & SAFETY MANUAL

### BC-004 BALL CRIMP TOOL



LENGTH	234.9 mm (9.25")
WEIGHT	652 gram (1 lb. 7 oz.)
DIAMETER	62.50 mm (2.46")
CFM@30 STROKES MIN.	0.0045 m <sup>3</sup> (0.20 cfm)
CLOSING FORCE @5.516 BAR (80 PSI)	Finish—(2400 lb)
CAM	BC-6—SPECIAL
MATERIAL	ALUMINUM



Made in the U.S.A.



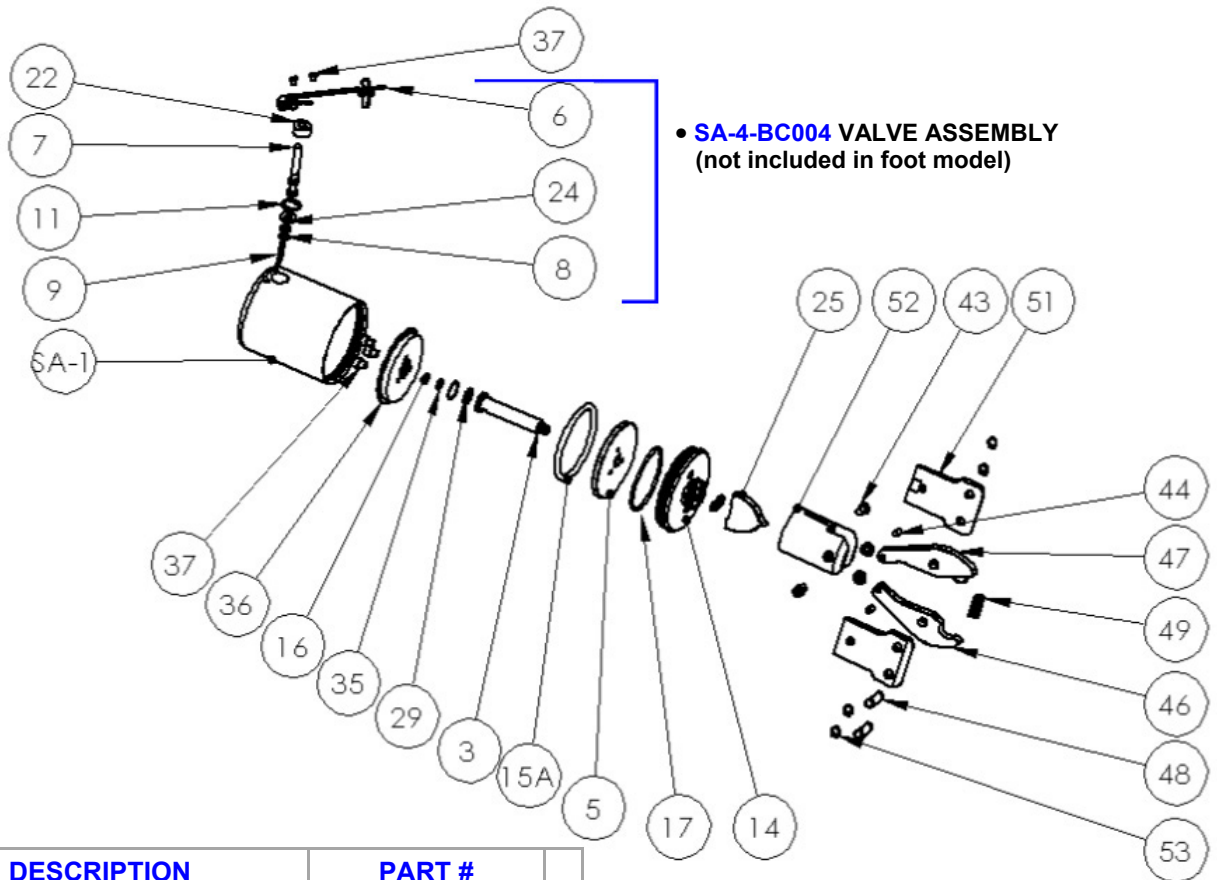
Read Carefully Before Operating



Wear Eye Protection

**SIMONDS INC.**  
248 ELM ST. | SOUTHBRIDGE, MA 01550  
508-764-3235 | [sales@simonds-inc.com](mailto:sales@simonds-inc.com) | [www.simonds-inc.com](http://www.simonds-inc.com)

# BC-004 PARTS BREAKDOWN



#	DESCRIPTION	PART #	
SA-1	PISTON HOUSING	SA-1-004-RV	
3	PISTON SHAFT	3-003-BC	
5	PISTON LOCK PLATE	5-004	
6	SAFETY LEVER ASSEMBLY	DA-1	1
7	SPOOL	7-004	1
8	SPOOL O'RING (2 required)	16-003-K10	1
9	SPOOL SPRING	9A-01	1
11	SNAP RING	11-01	1
14	END CAP	BC-14-004	
15A	O-RING PISTON SEAL	15A-004	
16	O-RING (2 required)	16-003-K10	
17	O-RING	17-004-K10	
18	O-RING	18-01	
22	VALVE SPACER	22-004	1
24	VALVE WASHER	24-01	1
25	CAM	BC-6	
29	VALVE WASHER	24-01	
33	SCREW (2 required)	28-01-K10	
35	O'RING	35-003-K10	
36	PISTON SEAL HOLDER	36-004	
37	MOUNT SCREW (3 required)	37-003-K10	
43	SIDE PLATE MOUNT SCREW	4-24A	
44	ROLL PIN (2 required)	3-20-K2	
45	ROLLER (2 required)	3-19-470-K2	
46	BOTTOM JAW (with pocket, curve)	RBC-3L	
47	TO JAW (with crimp ball)	RBC-3R	
48	PIVOT PIN (2 required)	BC-23A-1	
49	INTERNAL JAW SPRING	4-8A	
51	SIDE PLATES (2 required)	BC-30-K2	
52	JAW HOUSING	BC-2	
53	SNAP RINGS (4 required)	BC-7A	
	VALVE REPAIR KIT	SA-4-BC004	

(1) Included in the valve repair kit.

- Two hoses included with FOOT models, one with HAND models.

## ASSEMBLY

- Upon receipt inspect box for all parts.
- Crimping head should come assembled on BC-004. **To replace or remove head**, the piston/cam must be in the forward position. Attach air hose, activate lever, let jaws close. Then unscrew jaw and housing. The piston/cam must still be forward when you reassemble the jaws. Put cam in to slot inside of housing. Push down on housing to connect to threads on power pack. Keep hands and fingers away from jaws. This should go on hand tight and should line up with air lever.
- Air hose to air inlet of power pack using proper wrench size. Check that all threads are free of debris.
- Attach air hose to Air filter/Regulator using a quick disconnect device. Be sure that air hose is secure. There should be no air leaks. If there is, remove hose and check threads for damage. Reattach air hose, tighten.

- **ISOLATE AIR WHILE ATTACHING HOSE AND JAW HEAD!**

- Test unit to assure free movement of jaws. Be sure to follow all safety instructions when testing.
- Once unit has been tested and safety issues addressed the unit is ready for production line use.

## OPERATING INSTRUCTIONS:

- Maximum inlet pressure is **90 PSI** (5.516 BAR). The power pack needs to have an inline locking regulator so that maximum inlet pressure is not exceeded. Minimum air pressure is 40 PSI (2.758BAR).  
*For longer tool life it is recommend to use only enough air to complete the job, never exceeding the recommended pressure.*
- Tools should have an in line air filter to remove debris, water and particulates. Inline air filter and regulator should be not more than 6 feet (1.83 m) from the tool.
- An inline lubricator will help to extend the life of the tool. Only use pneumatic oil recommended by Simonds in the lubricator. If no lubricator is available place a few drops of pneumatic oil in to the air inlet of tool each week.
- To activate unit, slide safety latch over with thumb and squeeze lever. Be sure to release start and stop device in case of a failure of energy supply.
- Air hose must be securely fastened to the air inlet prior to using. Be sure hose is tightened using the proper tool. The air hose needs a 1/8" (.25 mm NPT) thread attached that will screw in to the tool end.
- Air hose should be attached to air supply (air filtration system) securely. It is recommended that a quick disconnect devise be used to attach air hose to air supply.

## **SAFETY INSTRUCTIONS**

- Inspect tools and hoses each day prior to operation. Air hose that is frayed, cut or abraded should be replaced. Be sure that threads are clean and not worn.
- If the tool is not in use and not positively disconnected from the energy supply, the energy supply system must facilitate isolation and dissipation of pressure by a suitable and lockable shutoff device in order to prevent unexpected start-up.
- Beware of hair, fingers, ties, loose clothing etc. when operating the tool. Keep away from moving parts.
- Always wear eye protection when operating the tool. Beware of ejection of cuttings or chips. Turn head to avoid being exposed to this operation.
- Beware that working on brittle material may cause harmful splinters.
- Always disconnect from air supply when changing tool, during repair, adjusting and inserting tools, maintenance and cleaning operations.
- Simonds tools are not designed for use in explosive atmospheres.
- Simonds tools are not insulated for coming in to contact with electric power sources.
- Do not use tools near personnel where risk of flying debris may hit them.
- Do not point or aim tool at another person.
- Unsecured or cut air hose may cause a whipping action which may result in injury.
- Do not use any attachments not manufactured by Simonds for this tool. Injury may result.
- If the tool is used on a bench stand or a work station be sure that the tool is fastened properly.
- Dispose of tool and material as recommended by local disposal regulations.
- Simonds tools are not for use other than on production line. Tool should not be used as a hammer or pry bar. A “two hand control” may be required depending on the attached tool.
- **DO NOT EXCEED RECOMMENDED WIRE SIZE OR AIR PRESSURE.** Exceeding the recommended wire size for the jaws may cause damage to tool or injury to user.

## **WARRANTY**

Simonds Inc. power packs and jaws are warrantied to be free from defects in materials and workmanship for a period of one year, barring alterations, abuse or misuse. All products returned for warranty repair must be sent to Simonds Inc., Southbridge, MA at end users expense. Simonds will either repair or replace the tool if it is found defective due to material defect or workmanship at Simonds discretion.

Warranty repairs accepted only through distributors with proper RMA's.