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JRready ST2060-AS2G

JRready ST2060-AS2G M22520/2-01 Indent Crimper Kit

MODEL: ST2060-AS2G

Instruction Manual

1. INTRODUCTION

This manual provides comprehensive instructions for the safe and effective use of the JRready ST2060-AS2G M22520/2-01 Indent Crimper Kit. This professional tool is designed for precision crimping of miniature and sub-miniature connector contacts commonly found in electronic systems, including MIL standard, Harting, Wain, and TE connectors. It delivers a Mil-Standard 8-impression crimp, ensuring high tensile strength for wire sizes ranging from 20 to 32 AWG (0.52-0.032mm²).



Image 1.1: Overview of the JRready ST2060-AS2G Indent Crimper Kit, including the crimping tool, various positioners, and a G125 Go-NoGo gauge.

2. SAFETY INFORMATION

Always observe the following safety precautions when using the crimping tool:

- Wear appropriate personal protective equipment, such as safety glasses, to protect against flying debris.
- Ensure the work area is clean, well-lit, and free from obstructions.
- Do not use the tool for purposes other than its intended crimping function.
- Keep hands and fingers clear of the crimping jaws during operation to prevent injury.
- Inspect the tool and positioners for any damage before each use. Do not use damaged tools.
- Store the tool in a dry, secure place, out of reach of children.

3. PACKAGE CONTENTS

The JRready ST2060-AS2G M22520/2-01 Indent Crimper Kit includes the following items:

- 1 x NEW-AS2G Indent Crimper (M22520/2-01 equivalent)
- 7 x K-series Positioners: K1, M22520/2-06, M22520/2-07, M22520/2-08, M22520/2-09, M22520/2-10, M22520/2-37
- 1 x Universal Adjustment Positioner
- 1 x G125 Go-NoGo Gauge

4. PRODUCT OVERVIEW

The JRready ST2060-AS2G crimper is a precision tool designed for consistent and reliable crimps. Key features include:

- **4-Indent 8-Impression Crimp Style:** Ensures a secure and high-strength connection.
- **Ratchet Mechanism:** Provides a full crimp cycle, preventing partial crimps and ensuring consistent quality.
- **Adjustable Selector Knob:** Allows for precise adjustment of crimp depth for various wire and contact sizes.
- **Interchangeable Positioners:** Specific positioners guide the contact into the correct crimping position.
- **G125 Go-NoGo Gauge:** Used to verify the accuracy of the crimp tool's indenter settings.



Model :	NEW-AS2G
Crimp Range :	20-32AWG(0.52-0.032mm²)
Weight(g):	225/0.491b
Thru-hole Diameter:	φ3.60mm
Suitable for crimping:	Round contacts of MIL standard, Harting, Wain, TE connectors

Image 4.1: The JRready ST2060-AS2G crimper highlighting its 4-indent 8-impulsion style and key specifications.

5. SETUP

5.1. Selecting the Correct Positioner

Each contact type and size requires a specific positioner to ensure proper alignment during crimping. Refer to the contact manufacturer's specifications or the provided positioner chart to select the appropriate K-series positioner.

HOLE DIMENSIONS

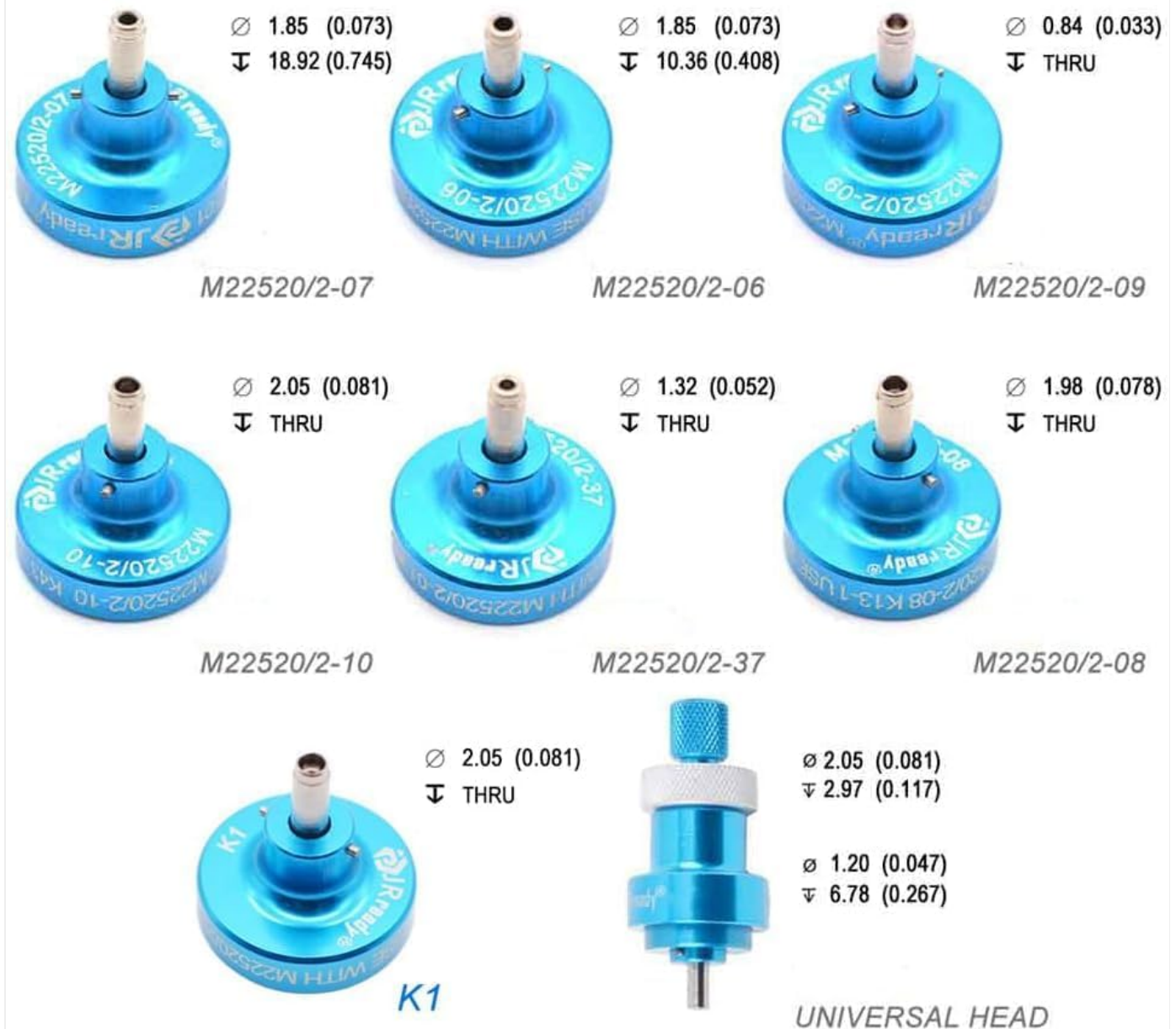


Image 5.1: Detailed hole dimensions for various M22520/2-XX positioners and the K1 positioner, aiding in selection.

5.2. Installing a Positioner

1. Ensure the crimper handles are fully open.
2. Align the selected positioner with the mounting hole on the crimper head.
3. Push the positioner firmly into place until it clicks or is securely seated.
4. Verify that the positioner is stable and does not wobble.

5.3. Adjusting the Selector Knob

The selector knob on the crimper adjusts the depth of the indenter, which corresponds to different wire gauges.

1. Locate the selector knob on the side of the crimper.
2. Push the knob inwards and rotate it to the desired setting (1-8). The appropriate setting for your wire gauge and contact type should be specified by the contact manufacturer or in relevant technical documentation.
3. Release the knob to lock it into position.

TESTING THE INDENTER WORKING DIAMETER OF CRIMPING TOOLS

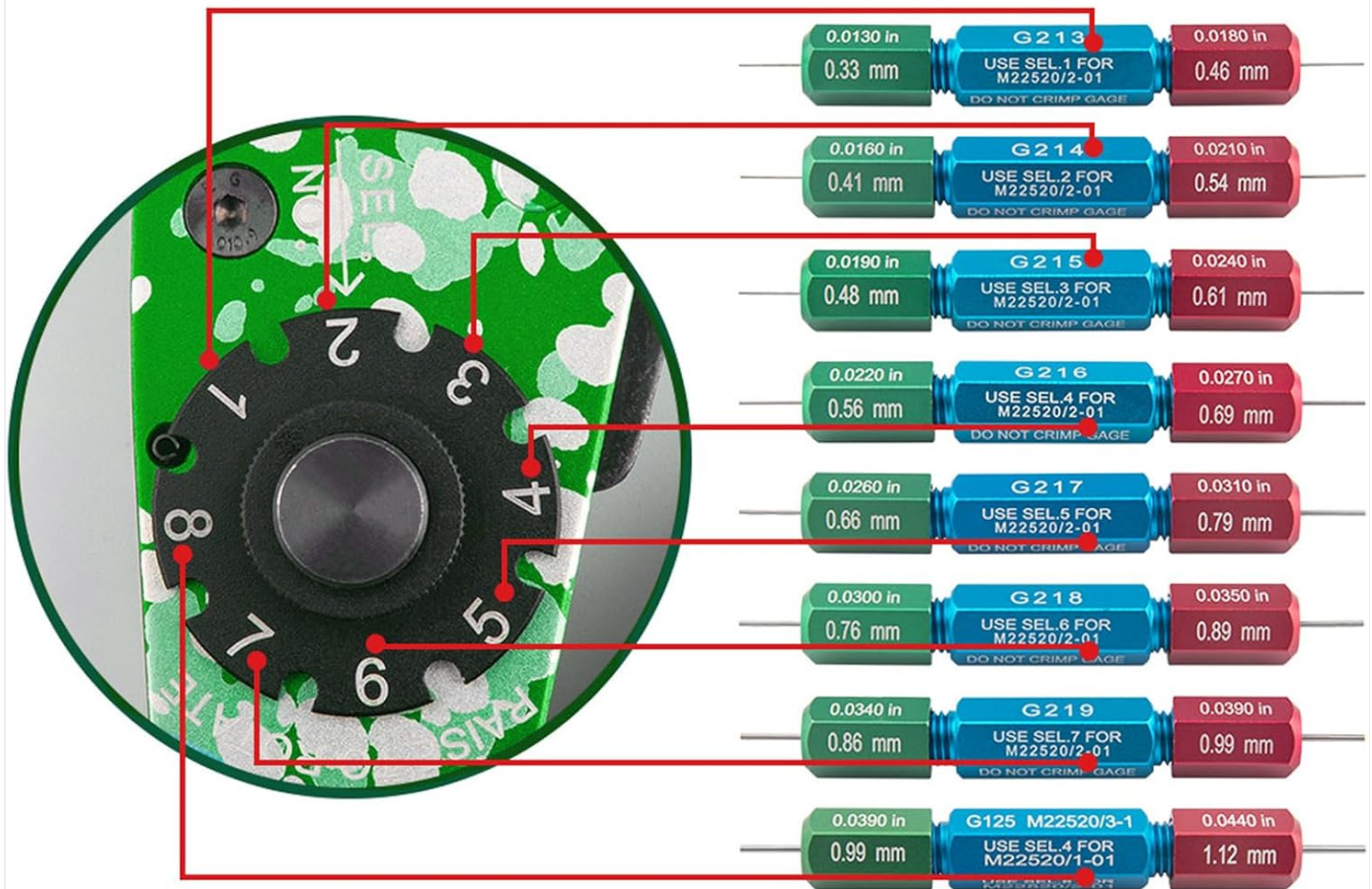


Image 5.2: Illustration of the crimper's selector knob and its corresponding indenter working diameters for various settings (1-8).

6. OPERATING INSTRUCTIONS

6.1. Preparing the Wire and Contact

- Strip the insulation from the wire to the length specified by the contact manufacturer. Ensure the stripped wire is clean and free of frayed strands.
- Ensure the contact is clean and undamaged.

6.2. Crimping Procedure

1. With the correct positioner installed and the selector knob set, fully open the crimper handles.
2. Insert the contact into the positioner. Ensure the contact is fully seated and properly oriented.
3. Insert the stripped wire into the contact's wire barrel. Ensure the wire insulation is flush with the back of the contact barrel and no bare wire is exposed beyond the crimp area.
4. Slowly close the crimper handles until the ratchet mechanism completes its cycle and automatically releases. Do not force the handles open before the cycle is complete.

5. Remove the crimped contact from the positioner.
6. Inspect the crimp for proper formation, ensuring the wire is securely held and the crimp is uniform.

7. TESTING AND CALIBRATION WITH G125 GO-NOGO GAUGE

The G125 Go-NoGo gauge is essential for verifying the accuracy of the crimper's indenter settings. This ensures that the tool consistently produces crimps within specified tolerances.

7.1. Go-NoGo Gauge Procedure

1. Set the crimper to the desired selector knob setting (e.g., SEL #8 for G125 gauge).
2. Close the crimper handles completely until the ratchet releases.
3. Insert the "GO" end (green) of the G125 gauge into the crimper's indenter opening. The "GO" end should pass freely through the indenter.
4. Insert the "NO-GO" end (red) of the G125 gauge into the crimper's indenter opening. The "NO-GO" end should **not** pass completely through the indenter.



NECESSARY TOOLS FOR TESTING THE QUALIFICATION OF CRIMPING TOOLS



GO



NO-GO

Each gear of crimping tool shall comply with the principle of **GO** passing and **NO-GO** failing. Only accurate detection of each gear can meet the requirements of accuracy, safety and qualification of each tool.

Image 7.1: Demonstrates the correct use of the G125 Go-NoGo gauge to verify crimpers calibration. The 'GO' end should pass, and the 'NO-GO' end should not.

7.2. Interpretation of Results

- If the "GO" end passes freely and the "NO-GO" end does not pass, the tool is properly calibrated for that setting.
- If the "GO" end does not pass, or the "NO-GO" end passes completely, the tool is not qualified for that setting and should not be used until recalibrated or replaced.



GAGING LIMITS OF INDENTERS		
SEL. NO.	INSPECTION GAGE (mm/in)	
	GO	NO GO
1	0.33/0.013	0.46/0.018
2	0.41/0.016	0.54/0.021
3	0.48/0.019	0.61/0.024
4	0.56/0.022	0.69/0.027
5	0.66/0.026	0.79/0.031
6	0.76/0.030	0.89/0.035
7	0.86/0.034	0.99/0.039
8	0.99/0.039	1.12/0.044

CHECK WITH GAGE: G125 SEL #8



Gage G125

Image 7.2: Table detailing the "GO" and "NO-GO" inspection gauge limits (in mm/in) for each selector setting (1-8).

8. MAINTENANCE

- **Cleaning:** Regularly clean the crimper jaws and positioners with a soft, lint-free cloth to remove any debris or residue. Avoid using harsh chemicals that could damage the tool's finish or components.
- **Lubrication:** Apply a small amount of light machine oil to the pivot points and ratchet mechanism periodically to ensure smooth operation.
- **Storage:** Store the crimper and its accessories in the provided case or a clean, dry environment to prevent

corrosion and damage.

- **Inspection:** Before each use, inspect the tool for any signs of wear, damage, or misalignment. Pay close attention to the crimping jaws, positioner, and ratchet mechanism.

9. TROUBLESHOOTING

Problem	Possible Cause	Solution
Poor crimp quality (loose wire, deformed contact)	Incorrect selector setting; wrong positioner; damaged contact/wire; incomplete crimp cycle.	Verify selector setting and positioner match contact/wire. Ensure wire is properly stripped. Allow ratchet to complete full cycle. Inspect contact/wire for damage.
Crimper handles stick or do not release	Debris in ratchet mechanism; lack of lubrication; damaged ratchet.	Clean the ratchet mechanism. Apply light machine oil. If problem persists, tool may require professional service.
Positioner does not fit or is loose	Incorrect positioner for the tool; debris in mounting hole; damaged positioner.	Ensure correct positioner is selected. Clean mounting hole. Replace damaged positioner.
G125 gauge fails "GO" or "NO-GO" test	Incorrect selector setting; tool misalignment or wear.	Re-check selector setting. If still failing, the tool may be out of calibration or worn. Contact JRready support.

10. SPECIFICATIONS

Feature	Detail
Model	ST2060-AS2G (YJQ-W1A equivalent)
Crimp Style	4-indent 8-impression
Wire Range	20-32 AWG (0.52-0.032mm ²)
Applicable Connectors	MIL standard, Harting, Wain, TE connectors (round contacts)
Design Standard	MIL-C-22520/2-01
Item Weight	225 Grams (7.9 ounces)
Material	Alloy
Handle Material	Multicolor
Grip Type	Textured
UPC	743829092640

11. WARRANTY AND SUPPORT

For warranty information, technical support, or service inquiries regarding your JRready ST2060-AS2G M22520/2-01 Indent Crimper Kit, please contact JRready customer service. Refer to the product packaging or the official JRready website for the most current contact details.

Manufacturer: JRREADY



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