

CABLINE-UY SHELL A Crimping JIG

Part No. 91159-0**

Instruction Manual

5	S25452	November 19, 2025	R. Hatano	T. Tanigawa	H. Ikari
4	S25403	October 7, 2025	R. Hatano	T. Tanigawa	H. Ikari
3	S23375	October 20, 2023	W. Lau	Y. Shimizu	M. Takemoto
2	S22381	August 30, 2022	R. Hatano	T. Tanigawa	H. Ikari
Rev.	ECN	Date	Prepared by	Checked by	Approved by

1. Summary

This JIG is used to crimp the PLUG HSG ASS'Y and SHELL A of the I-PEX connector CABLINE-UY.

2. Specification

The detailed specifications are as follows.

Name	CABLINE-UY HAND TOOL 5/10/12/16 P
JIG Parts number	5P:91159-005 / 10P:91159-010 12P:91159-012 / 16P:91159-016
Conform PLUG CABLE ASS'Y P/N	CABLINE-UY PLUG CABLE ASS'Y P/N:20857-0**T-##-#
Conform PLUG HOUSING ASS'Y P/N	CABLINE-UY PLUG HOUSING ASS'Y P/N:20907-0**E-##-#
Conform SHELL A P/N	CABLINE-UY PLUG SHELL A P/N:3568-0**#-#
Crimp Height	0.68~0.74[mm]
Length	(W) 150[mm] × (D) 180[mm] × (H) 310[mm]
Weight	Approx.6.8[kg]
Productive capacity (Crimping process only)	120 plug / h (Reference value)
Recommended number of shots for part replacement	500,000 to 1,000,000 SHOT (Exchange parts : CRIMPER / WORK GUIDE / ANVIL)

※Each specification is subject to change without notice for quality reasons.

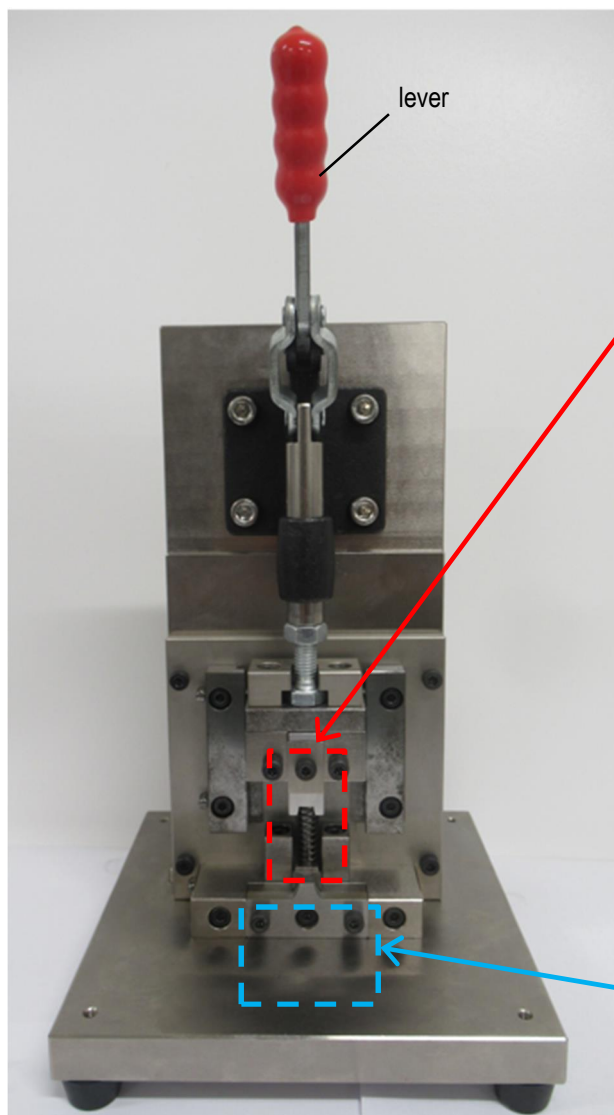
Parts number list

	名称	I-PEX P/N
5P	CABLINE-UY HAND TOOL 5P	セット型番 : 91159-005
	CABLINE-UY HAND TOOL CRIMPER 5P	3662-0051
	CABLINE-UY HAND TOOL WORK GUIDE 5P	3663-0051
	CABLINE-UY HAND TOOL ANVIL 5P	3661-0051
10P	CABLINE-UY HAND TOOL 10P	セット型番 : 91159-010
	CABLINE-UY HAND TOOL CRIMPER 10P	3662-0101
	CABLINE-UY HAND TOOL WORK GUIDE 10P	3663-0101
	CABLINE-UY HAND TOOL ANVIL 10P	3661-0101
12P	CABLINE-UY HAND TOOL 12P	セット型番 : 91159-012
	CABLINE-UY HAND TOOL CRIMPER 12P	3662-0121
	CABLINE-UY HAND TOOL WORK GUIDE 12P	3663-0121
	CABLINE-UY HAND TOOL ANVIL 12P	3661-0121
16P	CABLINE-UY HAND TOOL 16P	セット型番 : 91159-016
	CABLINE-UY HAND TOOL CRIMPER 16P	3662-0161
	CABLINE-UY HAND TOOL WORK GUIDE 16P	3663-0161
	CABLINE-UY HAND TOOL ANVIL 16P	3661-0161

※91159 includes the corresponding parts for 3661, 3662, and 3663.

See “CABLINE-UY Assembly Manual (ASM-18002)” for soldering method/process for CABLINE-UY PLUG and assembly method process for SHELL A.

3. Part Names and Configuration

Overall JIG Structure

HAND TOOL

Corresponding Pin	I-PEX P/N
5P	91159-005
10P	91159-010
12P	91159-012
16P	91159-016

Exchange parts

CRIMPER



Corresponding Pin	I-PEX P/N
5P	3662-0051
10P	3662-0101
12P	3662-0121
16P	3662-0161

WORK GUIDE



Corresponding Pin	I-PEX P/N
5P	3663-0051
10P	3663-0101
12P	3663-0121
16P	3663-0161

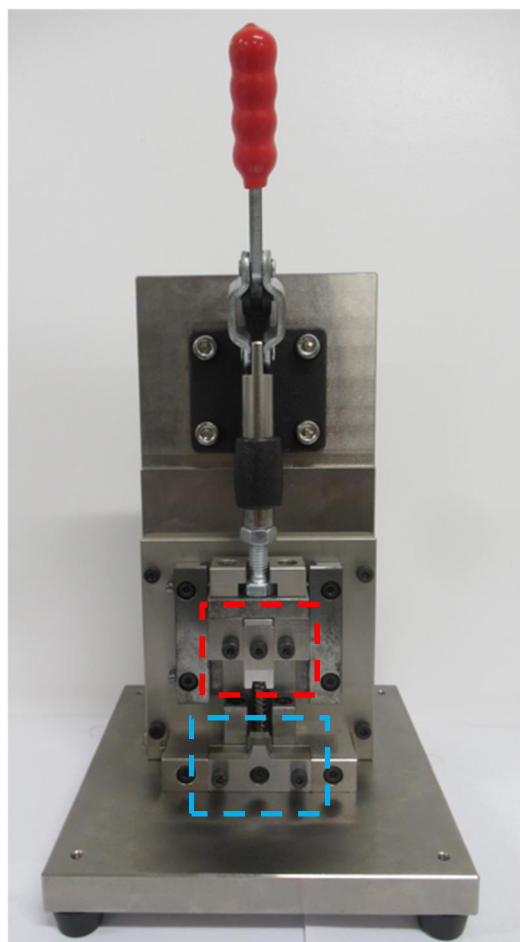
ANVIL



Corresponding Pin	I-PEX P/N
5P	3661-0051
10P	3661-0101
12P	3661-0121
16P	3661-0161

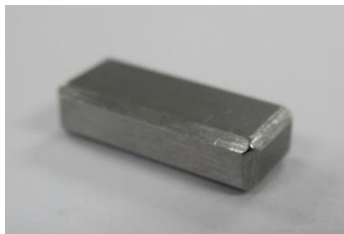
4. How to exchange parts (CRIMPER, WORK GUIDE, ANVIL)

Tool: Hexagonal wrench (3mm)



Common Parts

Common Parts①



Common Parts②



* Common for all Pin numbers

Exchange parts

CRIMPER



Corresponding Pin	X [mm]
5P	4.57
10P	6.33
12P	7.03
16P	8.43

WORK GUIDE



Corresponding Pin	Y [mm]
5P	4.00
10P	5.70
12P	6.40
16P	7.80

ANVIL



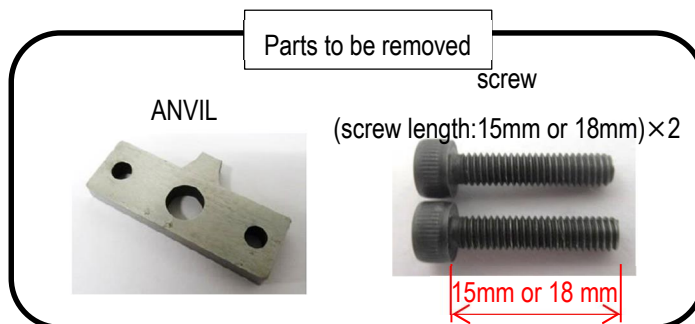
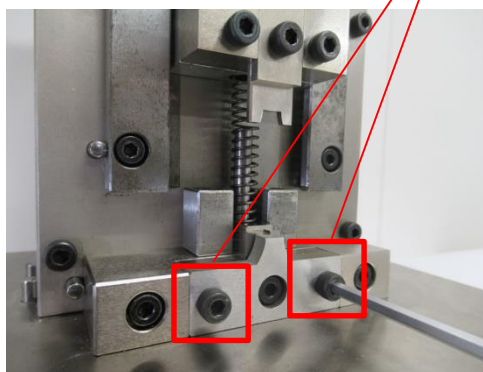
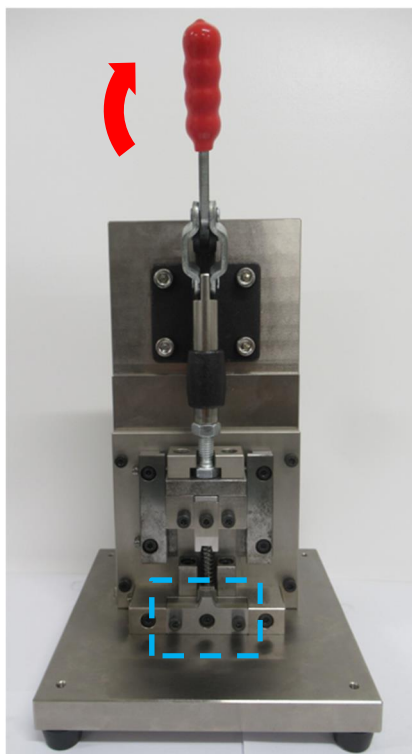
Corresponding Pin	Z [mm]
5P	3.31
10P	5.07
12P	5.77
16P	7.17

4. How to exchange parts

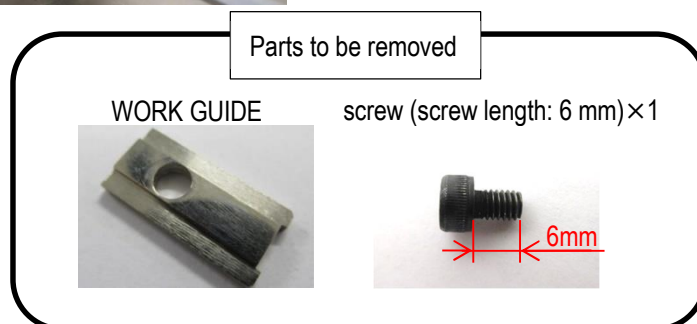
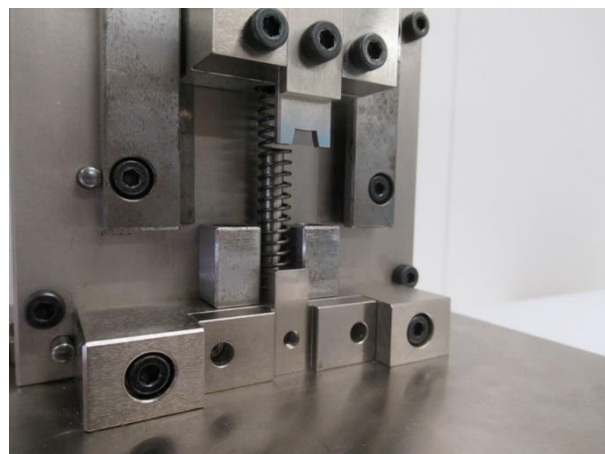
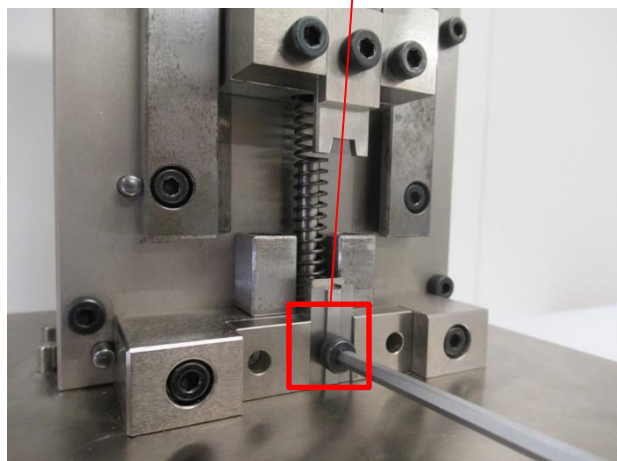
4.1 Removing parts (Remove the parts in the order of 1. Parts Receiving, 2. Caulked parts.)

1. Parts Receiving

- ① With the lever raised, use an Allen wrench to remove the screws in the red frame section, and remove the ANVIL and two screws (screw length: 15 mm or 18 mm).



- ② Remove the screws in the red frame using a hexagonal wrench, and remove the WORK GUIDE and one screw (screw length: 6 mm).

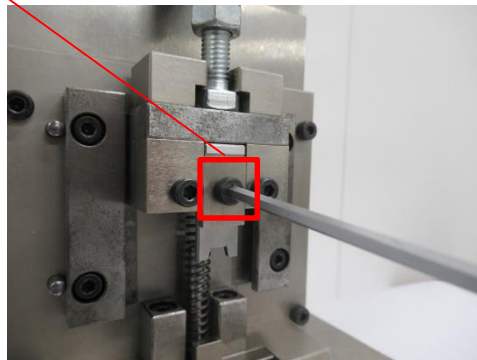
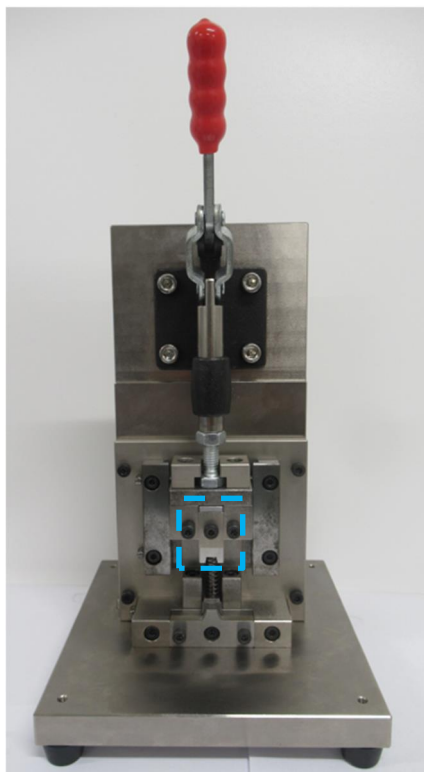


4. How to exchange parts

4.1 Removing parts (Remove the parts in the order of 1. Parts Receiving, 2. Caulked parts.)

2. Caulked parts

- ① Remove the screw (screw length 10mm) in the red frame part using a hexagonal wrench, and remove CRIMPER and Common parts① and ②.



Parts to be removed

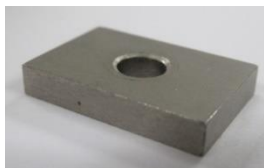
CRIMPER



Common Parts①



Common Parts②



screw (screw length: 10 mm)×1

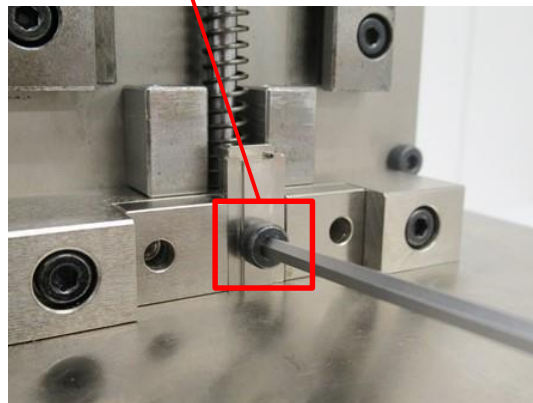
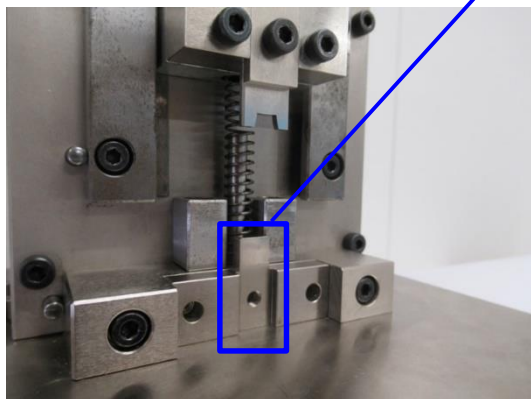


4. How to exchange parts

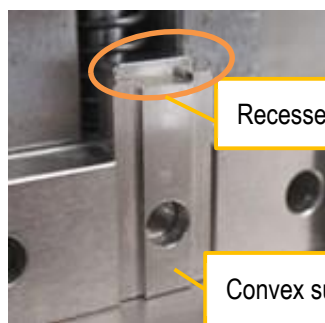
4.2 Parts Installation (Install in the order of 1. receiving part, 2. caulked part. Check if the number of pins of the part to be used is correct.)

1. receiving part

- ① With the lever raised, fit the WORK GUIDE into the blue frame part* and fix it to the red frame part with a screw (screw length: 6 mm) x 1 using a hexagonal wrench.



*Turn the recess upward. Place the convex side facing forward.

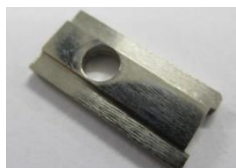


Recessed portion faces up

Convex surface faces forward

Parts to be used

WORK GUIDE

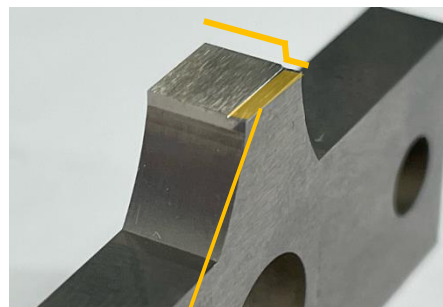
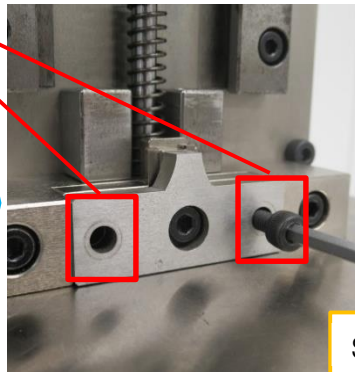
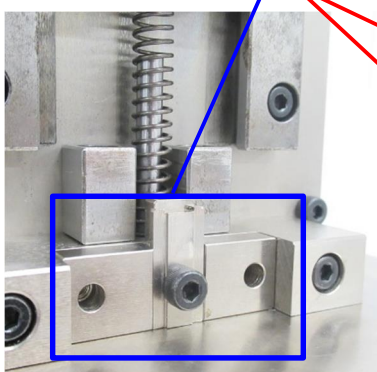


screw (screw length: 6 mm) x 1



- ② Fit ANVIL into the blue frame with the concave part facing the WORK GUIDE.

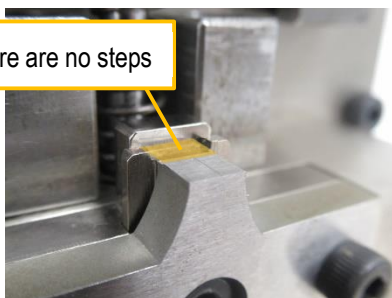
Fix ANVIL to the red frame with two screws (screw length: 15 mm or 18mm) using a hexagonal wrench.



Set it so that the concave part is on the side of the WORK GUIDE.

After fixing, check that there is no gap between the ANVIL and WORK GUIDE, and that the ANVIL is level with the foundation.

Make sure there are no steps



Parts to be used

ANVIL



screw

(screw length: 15 mm or 18mm) x 2

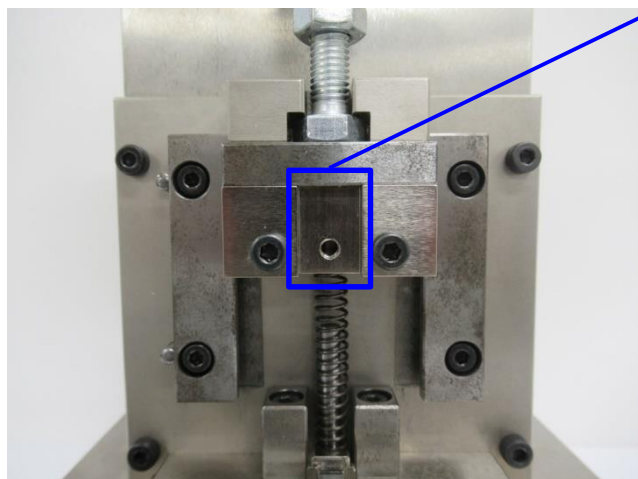


4. How to exchange parts

4.2 Parts Installation (Install in the order of 1. receiving part, 2. caulked part. Check if the number of pins of the part to be used is correct.)

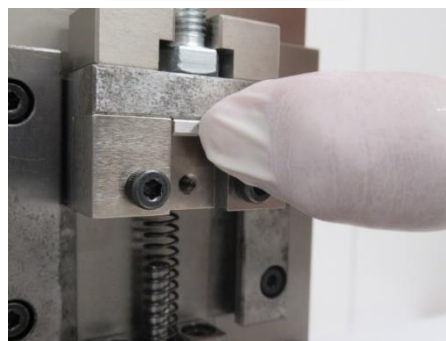
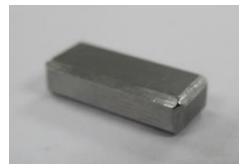
2. Caulked parts

- ① With the lever raised, place the “Common part①” against the upper surface of the blue frame part.



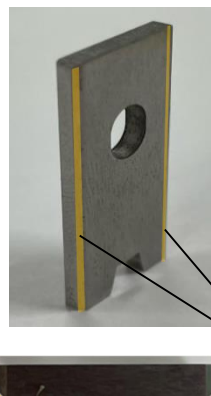
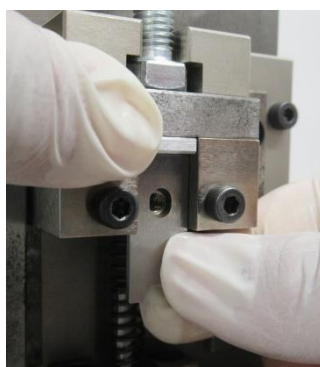
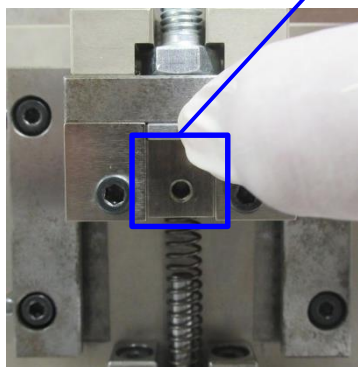
Parts to be used

Common Parts①



- ② With the “Common part①” left as it is, align the screw holes of CRIMPER with those of the main body.

Place CRIMPER on the blue frame so that the caulking part of CRIMPER is facing down and the chamfered part is on the front side.



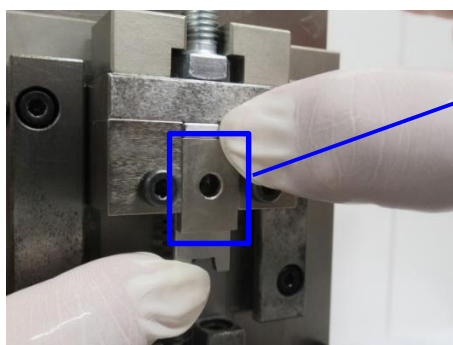
Parts to be used

CRIMPER



Chamfered part

- ③ While leaving the “Common parts①” and CRIMPER as they are, fit the “Common parts②” into the blue frame section so that the screw positions of the main unit, CRIMPER, and “Common parts②” are aligned.



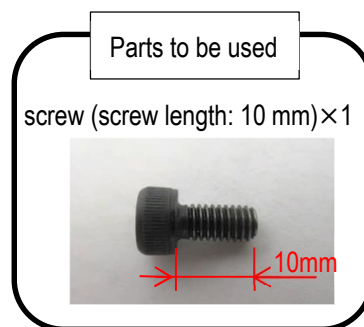
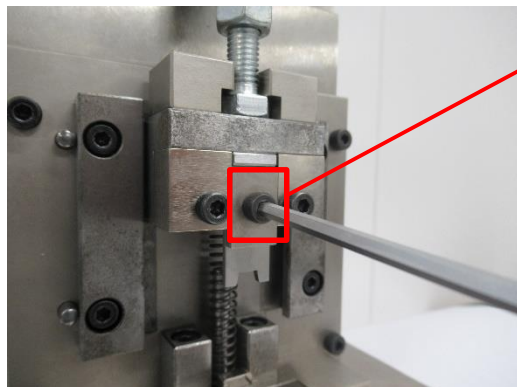
Parts to be used

Common Parts②

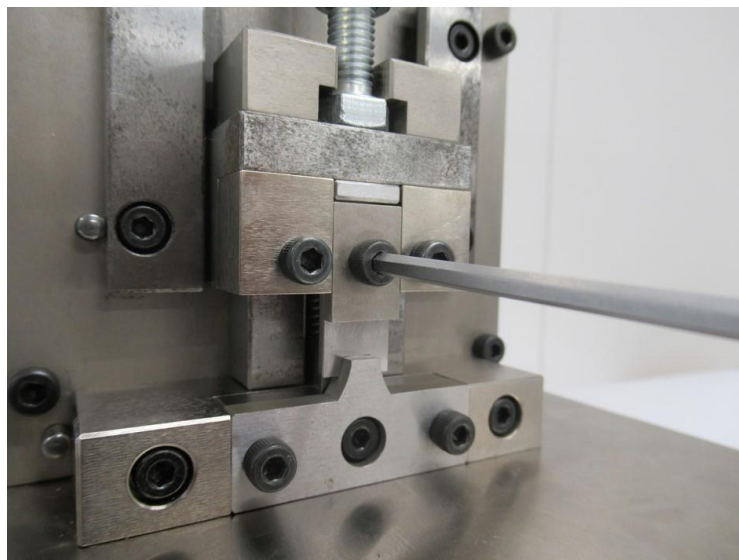
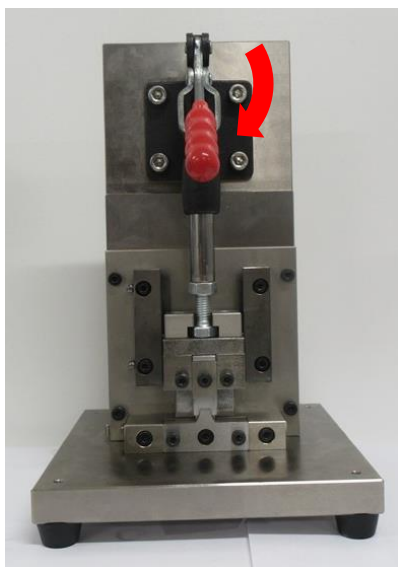


2. Caulked parts

- ④ Using a hexagonal wrench, temporarily tighten a screw (screw length: 10 mm) × 1 in the red frame section.



- ⑤ With the lever down and the CRIMPER and ANVIL in close contact, tighten the screws that were temporarily tightened in the previous step ④.



- ⑥ Raise the lever.

5. handling precautions and maintenance

- This jig is used to crimp the PLUG HSG ASS'Y and SHELL A of the I-PEX connector CABLINE-UY. Therefore, the use of a product other than the specified one (incompatible) may cause damage to the jig if a crimp is performed on it. Therefore, please do not use other than the specified products, as crimping with other products may cause damage to the jig.
- Do not unnecessarily loosen or remove screws or bolts other than the replacement part. Also, do not replace parts other than those specified, as this may cause deviations in jig settings and affect product quality.
- Please clean the jig regularly with a brush, air, etc., to remove any cable chips, etc. adhering to the parts related to the product.