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1.0 INTRODUCTION

Thank you for selecting the CHECK•LINE WTTM Wire Terminal Pull Tester for your requirements. With correct use and proper care this product should provide many years of precise and accurate testing. Please read the entire operation manual thoroughly before using this instrument for the first time. The information contained herein will help users to achieve accurate and repeatable results as well as prevent damage through improper set-up or operation.

This instrument is designed for measuring tensile strength of soldered or solder-free cable joints with end sleeves, pins, solder pins or similar wire terminal components in the field of quality control or design validation.



Safety Precautions

Wear appropriate eye protection at all times.

The load cell can be damaged if the internal measuring system is overloaded. Do not exceed the maximum measuring limit of 50 Kg (110 lbs., 500N) or 100 Kg (220 lb., 1000N), respectively

Transport and store the instrument with care. This reduces the risk of damage to the load cell or other minor mechanical problems which can cause inaccurate measurement results.

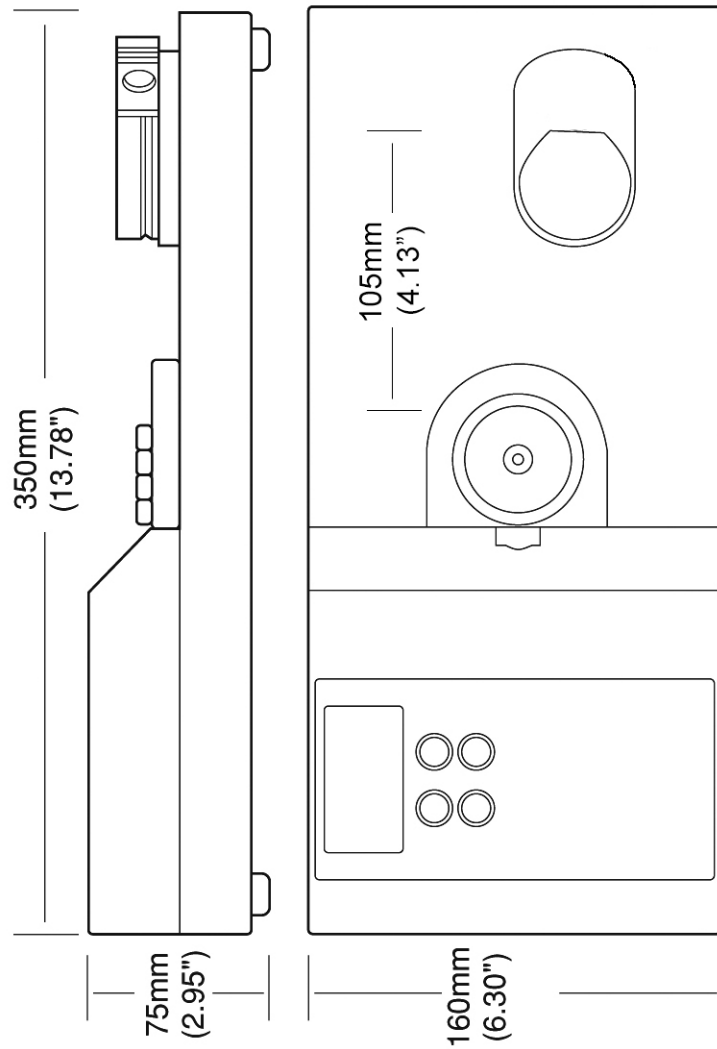
Operate the instrument in appropriate environments only. The instrument is equipped with a temperature compensation for a temperature range of 32 to 120 °F (0° to 40°C) and should be used in this temperature range only. Do not expose this device to liquid or operate in high-humidity environments.

APPENDIX: PULL TEST SPECIFICATIONS FOR UL, MIL AND SAE

Pull Test Specifications for UL, MIL and SAE

Size of Conductor		UL 486A Table 12.1		SAE AS7928 Table II	
AWG	(mm ²)	Pounds	(N)	Pounds	(N)
30	0.050	1-1.5	6.7	N/A	N/A
28	0.080	2	8.9	N/A	N/A
26	0.130	3	13.4	7	3.12
24	0.200	5	22.3	10	44.5
22	0.324	8	35.6	15	66.8
20	0.519	13	57.9	19	84.6
18	0.823	20	89.0	38	169.1
16	1.310	30	133.5	50	222.5
14	2.080	50	222.5	70	311.5
12	3.310	70	311.5	110	489.5
10	5.261	80	356.0	N/A	N/A

12.0 Dimensions



2.0 UNPACKING & CONTENTS

Remove the unit carefully and check that it appears undamaged. Check that all of the supplied items are contained in the box (see below). Retain packaging materials in the case that the unit needs to be returned to the manufacturer or distributor.

- Main instrument with integrated electronics.
- 12 VDC power supply: 100–240 VDC (50 – 60Hz) with U. S. cord (Part No.: 20133-US)
- Software CD Fmi-Connect (Part No.: FMI-972)
- Operating instruction manual
- Connection cable for RS232C (Part No.: 20073)



3.0 SETUP

Place the WTTM Wire Terminal Tester on a level and stable work area where the user can perform the testing in a comfortable manner. The surface should be clean and grease-free, so that the instrument does not slip.

Make sure that there is no residue from the pack-aging materials stuck under and around any of the operating components especially in the recessed area around the rotating terminal fixture (see photo). Use of compressed air to clear any debris from these areas is recommended.



Please note that the instrument weighs approximately 42 pounds (19 kg), so take care when lifting and moving. We suggest that the instrument be located in close proximity to an AC-Power outlet.

4.0 AC-OPERATION

The WTTM must be operated using the AC-Adapter.

11.0 SPECIFICATIONS

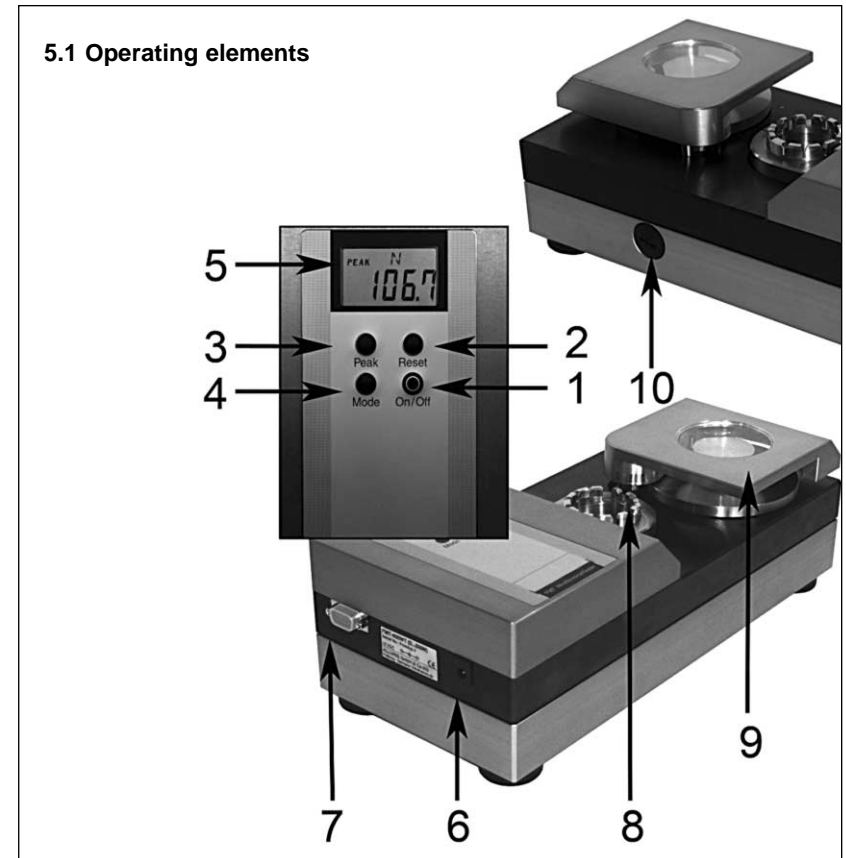
Measuring Range*	0–50 Kg / 0–110 lbs / 0–500N or 0–100 Kg (0–220 lbs / 0–1000N) (units selected via keypad)
Resolution	0.01Kg / 0.1 lbs / 0.1 N
Terminal adapter slot width (mm)	0.5, 0.8, 1.0, 1.4, 1.5, 2.0, 2.5, 3.0, 3.5, 4.0, 5.0, 6.0
Accuracy	±0.5% F.S. or better
Operating Mode	Continuous Displays actual value in Kg, lbs. or N Peak-Hold Displays peak value in Kg, lbs. or N
Wire Diameter	SAE AS7928 II AWG 8. . .30 IEC 60352-2 Cross section 0.05. . .10mm ² Maximum 0.236" (6mm)
Overload	120%
Display	LCD, 4–1/2 digit, 12mm high
Update Time (msec)	Standard 1000, 500, 333, 200, 100, 50 (selectable) Peak 1
Memory	Peak Value
Power Supply	AC adapter (100-240V/50-60 Hz)
Interface (RS232C)	Baud rate: 2.4, 4.8, 9.6, 19.2 Kb (selectable)
Temp. Range	Operating 32 to104 °F (0 to 40 °C) Storage –4 to 140 °F (–20 to 60 °C)
Weight, approx.	42lbs. (19 Kg)
Dimensions	14.2" x 6.3" x 3.33" (360 x 160 x 110 mm)
Protection Code	IP40
Material	Anodized aluminum, steel and stainless steel

* Low-range model available on special order basis.

10.0 TROUBLESHOOTING

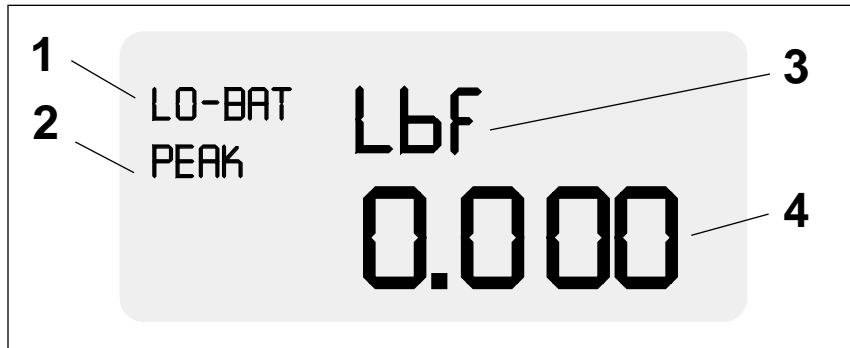
No indication on display	Plug in the AC-adapter and check the electrical connections.
RS-232C communication is disturbed	Check the wiring of the connection cable and the compliance of wiring within the input terminals of the PC-card.
Error Code Indications:	
OV+	Overload of +120%. Reduce the load until the instrument indicates a value within the admissible measuring range.
OV-	Overload of -120%. Reduce the load until the instrument indicates a value within the admissible measuring range.
OVP	Overload +!! The load cell can be damaged. Remove the excessive load immediately and check the instrument. If the indicated measuring values are obviously incorrect, the load cell must be replaced by the manufacturer.
OVM	Overload -!! The load cell can be damaged. Remove the excessive load immediately and check the instrument. If the indicated measuring values are obviously incorrect, the load cell must be replaced by the manufacturer.
ERR -3-	Reading error of the E_proms. Switch off the instrument and turn it on again. Should the error still exist, the microprocessor may need to be replaced by the manufacturer.
ERR -4-	Reading error of the E_proms. Switch off the instrument and turn it on again. Should the error still exist, the microprocessor may need to be replaced by the manufacturer.
Pull force fixture does not work	Remove the AC-adapter/charger, close the protection cover and wait for approx. 5 minutes. Plug in the AC-adapter again and switch on the instrument. If the display does not show any of the error codes above and still does not work, please send the instrument back for inspection to your dealer or directly to the manufacturer.

5.0 OVERVIEW



- 1. ON/OFF Button** Switches the instrument on/off
- 2. RESET Button** For zero-setting after inserting the test sample
- 3. PEAK Button** For selecting the display function, current measurement result or peak value of the tractive force (drag indicator function), and for calling up the peak value of the measurement
- 4. MODE Button** For selecting the desired measurement unit
- 5. Display**
- 6. Outlet** For AC Adapter
- 7. Outlet** For data transfer
- 8. Terminal adapter** with 12 slots for inserting the cable joint
- 9. Tractive force fixture** for inserting the free cable end (with protection cap)
- 10. Selector switch for pull speed** (access protected by screw connection)

5.2 Display



- 1 **Low Battery Indicator.** Flashes when batteries need charging, turns off when fully charged. Remains on while charging.
- 2 **Peak Mode Indicator.** Shown on display when configured for peak mode (stores highest peak force until it is reset by pressing zero key)
- 3 **Units Indicator.** Displays currently selected units of measure (pounds, newtons or kilograms). Changed by pressing UNITS key.
- 4 **Force Value.** Displays current or peak force value in user-selected units of measure.

5.3 Operating modes

The WTTM can be set to operate in one of two distinct operating modes: Peak Capture or Average. In **Peak Capture Mode**, the system measures the force at a frequency of 1000 Hz (1000 times per second) and displays the highest force measurement. The peak value remains on the display until a higher force value is measured or until the user presses the ZERO key.

In **Average Measurement Mode**, the system measures the force at a frequency of 1000 Hz (1000 times per second) and displays the average each time the display is updated. The factory default display update rate is 3 times per second (1 time every 1/3 second).

Note: Refer to section 7.3, page 8, for additional information and to change the update rate.

Recalibration Procedure

For recalibration, you would need a solid and vibration-free rack and a test weight (50kg or 100kg), preferably Class M1, which complies with the international standard.

Before calibrating the load cells, the pull force fixture must be brought back to the zero-position. In order to do this, adjust the selector switch for the pull speed to "0" and switch on the instrument.

1. Switch off the instrument using **ON/OFF** button.
2. Press and hold **MODE**, **PEAK** and **RESET** buttons simultaneously.
3. While keeping the above buttons pressed, press the **ON/OFF** button until **CAL** is indicated in the display and the calibration weight code (??) is shown. Then release all buttons. The WTTM is now in calibration mode

CAL
-00-

4. Press the **MODE** button. The signs **SNC** and **-00-** flash for approx. 10 seconds followed by the indication **ZER 88888**.

"SCN"
-00- → ZER
88888

5. To confirm the calibration of the zero point press the **RESET** button. The indication **SCN 88888** flashes on the display for approx. 15 seconds, followed by **PEK 88888**. The first step of the calibration is now complete.

"SCN"
88888 → PEK
88888

6. Hang the calibration weight on the terminal adapter. When the weight hangs perpendicular and still, you may save the full-scale value.
7. Press the **PEAK** button. The display flashes for approx. 15 sec. with the sign **SCN 88888** followed by the sign **END 88888**. After a further period of approx. 5 sec., the sign **OK 88888** indicates that the calibration was successful. The instrument switches off automatically.

"SCN"
88888 → "End"
88888 → "oK"
88888

8. Should the calibration fail, the display will show **ERR 88888** instead. The original calibration data are still saved in the memory. You may remove the weight and repeat the recalibration procedure

10.0 CALIBRATION

The WTTM Pull Tester has been calibrated in accordance with factory procedures and is certified to perform within the stated accuracy specifications shown in the Specifications section found on page 18. Assuming the unit is handled with care and operated as detailed in this manual it should remain accurate for an extended time period. If however, it is subjected to forces that exceed its maximum range or if it is not properly cared for, it might need to be recalibrated.

It is recommended that the calibration is verified at least on an annual basis and more frequently if feasible. Normally, instruments of this type go out of tolerance from one day to the next and rarely on a regular periodic basis.

A calibration procedure is provided in this manual, however it should only be performed by individuals properly trained for this type of service and with the appropriate certified standards (known weights or secondary force measuring system such as a load cell, etc.).

Re-Calibration Set-up

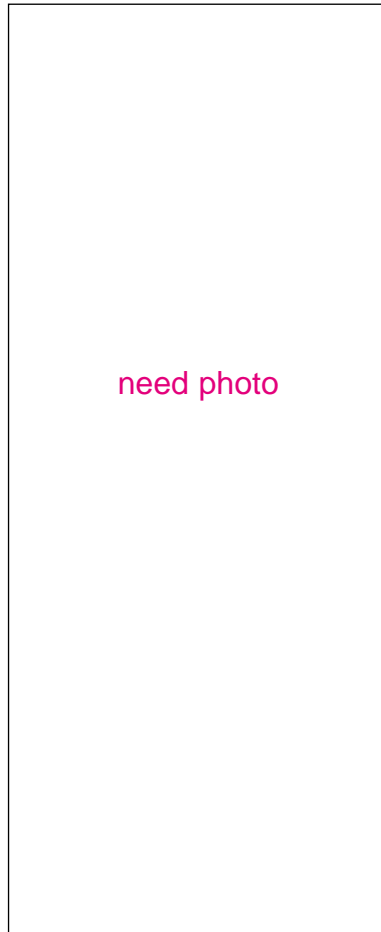
1. Remove the lever by unscrewing it in a counter-clockwise direction and move the Wire Clamp assembly out from the path of the hanging sample.
2. Position the WTTM in a vertical position so that the keypad & display are at the top (refer to photo). Be sure to secure it so it can not topple over when the weight is attached.
3. Using a heavy-duty monofilament (fishing line), wire or similar, suspend a 50 Kg weight from one of the teeth on the wire terminal fixture by hooking a loop of the material over the selected tooth.
4. Temporarily, remove the weight and follow the Re-Calibration Procedures shown on page 16.



- Make sure that the WTTM is well secured in the vertical position.

Caution

- Select a material that is strong enough to support 50 Kg of weight.



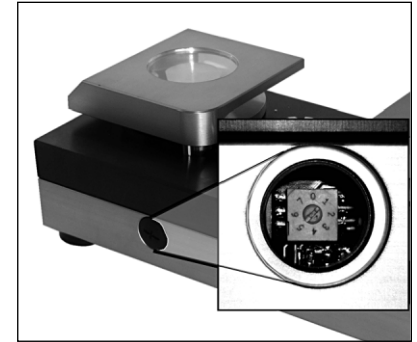
6.0 BASIC PROCEDURES

6.1 Changing the pull speed (default: 50mm/min)

The pull speed can be adjusted according to the testing standards. You need a small and a large screw driver to do this. The selector switch is protected by a screw thread cap, in order to avoid an unintentional manipulation of the pull speed.

To adjust the pull speed:

1. Switch off the instrument and unplug the power supply.
2. Loosen the protection cap with the large screw driver (flat or phillips head?).
3. Adjust the selector switch to the desired pull speed (How? Using the small screw driver?).
4. Replace and tighten the protective cap.



Standard	Speed	Switch Position
DIN IEC 60352 Part 2* UL 486 C	25 mm/min	1
DIN IEC 60352 Part 2 UL 486 C	37.5 mm/min	2
DIN IEC 60352 Part 2 UL 486 C SAE AS7928 Table II	50 mm/min	3
SAE AS7928 Table II** SAE/USCAR-21	100 mm/min	4
SAE/USCAR-21	150 mm/min	5
SAE/USCAR-21	200 mm/min	6
SAE/USCAR-21	250 mm/min	7

* DIN IEC 60352 Part 2 replaces DIN 4161/3 BS5B178 corresponds to IEC 60352 Part 2 ** SAE AS7928 Table II replaces MIL-T-7928 UL486A corresponds to IEC 60352 Part 2

6.2. Selecting the baud rate of the RS232C interface (Default: 19200)

The speed of the data transfer for the RS232C interface can be adjusted to match your data acquisition rate by changing the baud rate as follows. This is possible by changing the baud rate:

1. Switch off the instrument.
2. Press and hold **RESET** button.
3. Press the **ON/OFF** button.
4. Wait until **f01** is displayed, then release **RESET** button.
5. Select function **f04** by repeating to press the **PEAK** button until **f04** is shown on the display.
6. Press the **MODE** button repeatedly until the appropriate baud rate (2400 / 4800 / 9600 / 19200) shows on the display.
7. Press the **RESET** button to save your settings.

6.3. Changing the up-date (refresh) rate of the display (Default: 3/sec)

The force applied to the load cell of the instrument is internally processed at a rate of 1000Hz, which allows the precise capturing of the peak values. The readings on the display, however, are refreshed at a default rate of 3 times/sec. You may increase or decrease the factory settings to match your personal demands as follows:

1. Switch off the instrument.
2. Press and hold the **RESET** button.
3. Press the **ON/OFF** button.
4. Wait until **f01** is displayed, then release the **RESET** button.
5. Select function **f02** by repeatedly pressing the **PEAK** button until **f02** is shown on the display.
6. Press the **MODE** button repeatedly until the desired refresh rate (1 / 2 / 3 / 5 / 10 / 20 times/sec) appears on the display
7. Press the **RESET** button to save your settings.

6.4 Temperature Compensation (default: SET = on)

In general, it is recommended to have this function turned on as long as it does not effect your measuring results. Only when measuring very minute forces over a longer period of time at a slow rate and under stable environmental conditions might it be useful to switch this off.

1. Switch off the instrument.
2. Press and hold **PEAK** and **MODE** buttons.
3. Press **ON/OFF** button.
4. Wait until **TRK oFF** is displayed.
5. Release **PEAK** and **MODE** buttons.

**TRK
oFF**

PROTOCOL CODE		
Extern >>	Average data output 3. digit: + /or - 4.-6. digit. Value incl. floating decimal point	NA@@@@@cr
	Peak data output 3. digit: + /or - 4.-6. digit. Value incl. floating decimal point	NB@@@@@cr
	Unit: 3 digit 0 = N 1 = kg (g) 3= lb (oz)	NH@cr
	Unit: 3 digit 0 = N 1 = kg (g) 3= lb (oz)	NH@cr
Error	OBcr	Command Error
	OEcr	Parity Error
	OFcr	Format Error
	OGcr	Summing Error
	OHcr	Overflow

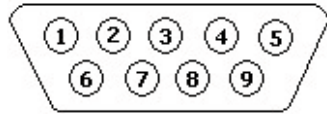
8.2 Analog Output

The analog output (-1...0...1 VDC) can be used for any data acquisition or data recording device. Pull Force data will be expressed as a negative voltage. The signal can be set to zero (reset) by performing a ZERO (tare) function. +1 VDC and - 1VDC refers to the maximum and minimum full scale (end of nominal measuring range).

SPECIFICATION	
Amplitude	-1VDC / +1VDC
Signal generator	12-bit D/A-Converter
Signal update	100 Hz

8.0 DATA TRANSFER

Model WTTM testers can transfer measuring data by means of an RS-232C interface. A 9-pin D-Sub connector is provided for this purpose, which can be found at the left side of the instrument. A connector cable for the serial port is included. If a custom serial cable must be used or if the user wishes to access the analog output, the pin designations are as follows:



Pin	Description
1	0...1 VDC (analog out)
2	Serial : TXD (RS-232C)
3	Serial : RXD (RS-232C)
5	Serial : CD (RS-232C)
9	Analog: Gnd (analog out)

8.1 RS-232C Interface

The RS-232C interface can be used for the direct communication between an appropriate serial I/O-card of a computer and the instrument. The minimum requirement for the data transfer up to 19200 baud is the connection of the RXD, TXD and GND communication terminal.

SPECIFICATION	
Baud rate	2400, 4800; 9600 or 19200 (selectable, see general settings)
Data length	8 bits
Stop bit	1
Parity	None

PROTOCOL CODE		
Extern >>	AAcr	Tare
	ABcr	Stop Output
	ACcr	Change to Peak Mode
	ADcr	Change to Average Mode
	AEcr	Reset Peak
	AFcr	Change Units to kg (g)
	AGcr	Change Units to N
	AHcr	Change Units to lb (oz)
	BAcr	Data output request (single reading)
	BBcr	Data output request (10/sec)
	BB1cr	Data output request (20/sec)
	BB2cr	Data output request (50/sec)
	BB3cr	Data output request (100/sec)
	BDcr	Units confirmation request
	BEcr	Peak data output request
	BFcr	Minus peak data output request
	cr	(carriage return)

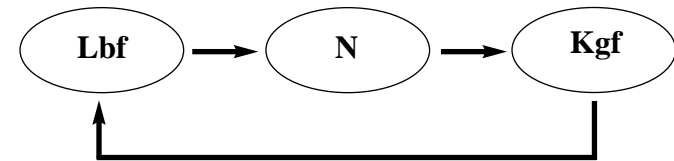
Chart continues on next page

6.6 Changing Units of Measurement

The WTTM can display force measurements in any of the following three engineering units:

- lbf (pounds)
- N (Newtons)
- Kgf (kilograms)

To change the selected engineering units for display press UNITS key. Each time the key is pressed, the units will change from one to the other as follows:



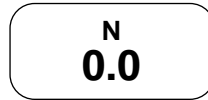
7.0 OPERATING PROCEDURES

7.1. Switching on the instrument, selecting the measurement unit and operational mode

1. Switch on the instrument by pressing the **ON/OFF** button.
After a power-up self test and calibration (approx. 20 sec.), the display will indicate the last selected measuring unit, function and the value 0.00.
2. Select the desired operation mode (indication of the current measurement value or the peak value) and the measuring unit by pressing the **PEAK** and **MODE** buttons simultaneously. The current settings will be indicated on the display. When you choose the **PEAK** mode, the peak value will be always indicated on the display (drag indicator function).

7.2. Resetting to zero before each measurement

It is necessary to zero-set the instrument before starting each pull force measurement. Press the **RESET** button for this purpose. The **RESET** button can also be used for deleting the peak value updated in the memory.



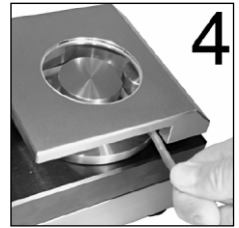
7.3 Taking Measurements

NOTE: Select the smallest suitable slot for the test sample diameter.

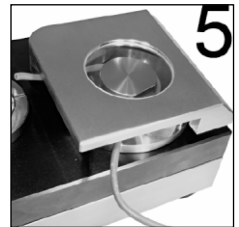
1. Place the cable connection into the adapter, so that the sleeve of the cable connector stays securely inside the ring and cannot be pulled out through the slot.
2. Insert the free cable end with slight tension into the **clamping fixture**. The nut in the pull force **fixture** will help you to find the right position for the cable.
3. Holding the cable tight and securely, close the protection cover.



4. The motor starts and closes the pull force fixture. Hold the cable end securely until the pull force develops.



5. The rotational motion of the pull force fixture tears off the cable from the terminal joint. The motor stops when the maximal pull length has been reached.



6. When you open the protection cover, the pull force fixture returns back to the original position and releases the cable.
7. During the measurement, the force progression can be read off the display.



The peak value, which mostly appears before the connection breaks, is captured at 1000Hz and is indicated when the **PEAK** button is pressed (so long as the drag indicator function was not active).

Depending on the wire strength and the related standard, the following tensile strength should at least be achieved.

AWG	Cross-Section	Cable Diameter	SAE AS7928 Table II	IEC 60352 Part2	UL 486 C
30	0.06 mm ₂	0.36 mm		6 N	6 N
28	0.09 mm ₂	0.38 mm		11 N	11 N
26	0.14 mm ₂	0.48 mm	32 N	18 N	18 N
24	0.22 mm ₂	0.61 mm	45 N	28 N	28 N
22	0.34 mm ₂	0.76 mm	67 N	40 N	40 N
20	0.56 mm ₂	0.97 mm	85 N	60 N	45 N
18	0.93 mm ₂	1.27 mm	170 N	90 N	45 N
16	1.25 mm ₂	1.44 mm	223 N	135 N	68 N
14	1.93 mm ₂	1.80 mm	312 N	200 N	100 N
12	3.16 mm ₂	2.29 mm	490 N	275 N	138 N
10	4.65 mm ₂	3.10 mm		355 N	

* DIN IEC 60352 Part 2 replaces DIN 4161/3
BS5B178 corresponds to IEC 60352 Part 2

** SAE AS7928 Table II replaces MIL-T-7928
UL486A corresponds to IEC 60352 Part 2

XXXXX

CHECK·LINE®
BY ELECTROMATIC

WTTM

WIRE TERMINAL PULL TESTER



CHECK·LINE®
INSTRUMENTS

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Operating Instructions