

1. INTRODUCTION

Refer to Figure 1 for contact crimp height and strip length. Refer to the instructions packaged with the tooling for tooling operating procedure.

Inspect crimped contacts for “ACCEPT” or “REJECT” conditions shown in Figure 2.

NOTE



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

CAUTION



To avoid connector failures, all connectors must be installed **ONLY** as shown in instruction material packaged with the connectors.

2. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated document to corporate requirements
- Corrected document reference for Machine 68296-1
- Changed name of contacts (II to 2)

APPLICATOR TOOLING

PART NUMBER (Instruction Sheet)	SETTING	FEED LENGTH	CRIMP HEIGHT		WIRE	
			DIMENSION	TOLERANCE	SIZE (AWG)	STRIP LENGTH
68296-1 (409-2661)	10	19.05 [.750]■	3.71 [.146]	±0.10 [.004]	10	7.94-9.52 [⁵ / ₁₆ - ³ / ₈]
	8		4.09 [.161]		8	
	6		4.72 [.186]		6	

■ Distance between centerlines of two contacts.

HAND TOOLING

PART NUMBER (Instruction Sheet)	CRIMP HEIGHT		WIRE	
	DIMENSION	TOLERANCE	SIZE (AWG)	STRIP LENGTH
68321-1 (408-2681)	3.71 [.146]	±0.10 [.004]	10	7.94-9.52 [⁵ / ₁₆ - ³ / ₈]
	4.09 [.161]		8	
	4.72 [.186]		6	

CONDITION OF CONTACT WIRE BARREL SEAM

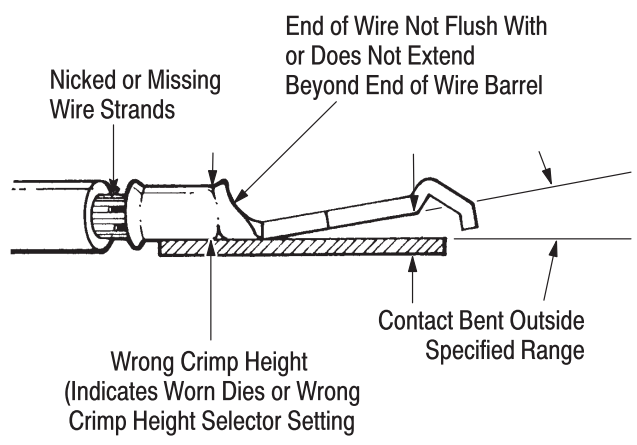
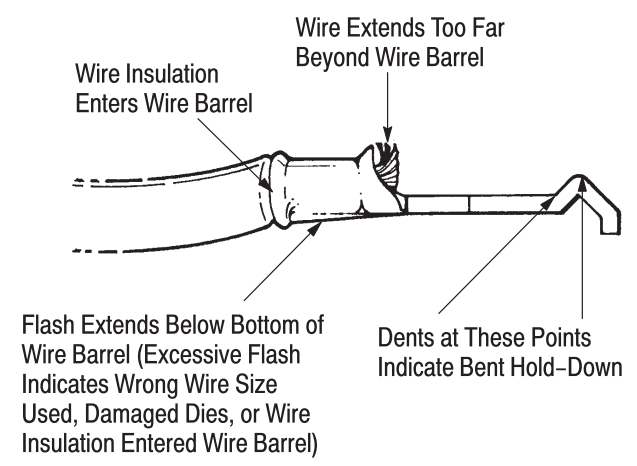
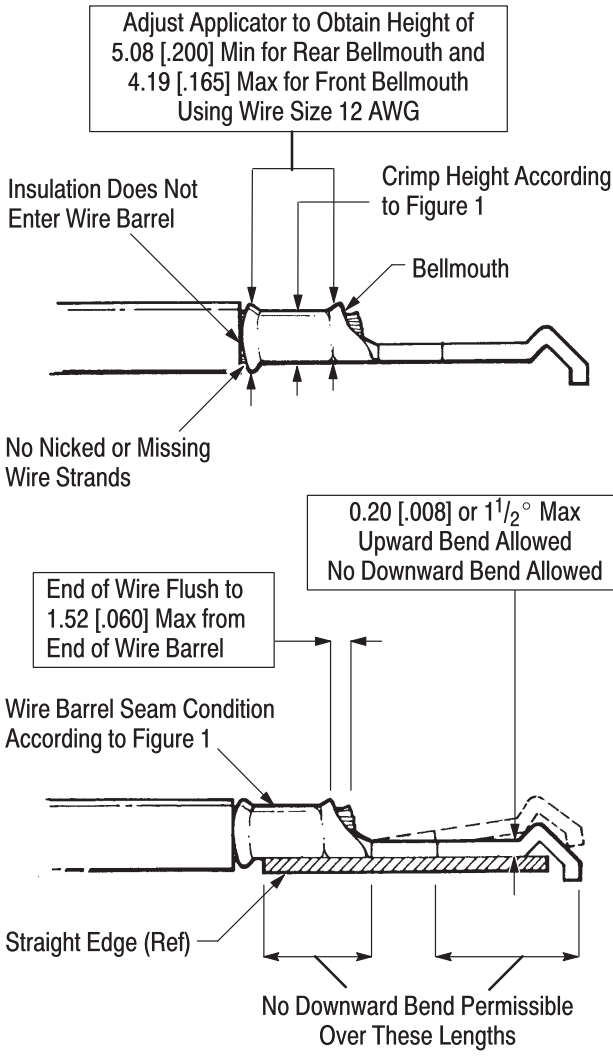
WIRE SIZE (AWG)


10	8	6
Closed	Closed	1.19 [.047] Max Gap

Figure 1

ACCEPT

REJECT



NOTE  Check contact straightness with a comparator. An alternate method, using a straight edge, is shown above. Contact bent upward excessively will not mate properly in connectors. Check for debris and for bent, misaligned, or worn tooling.

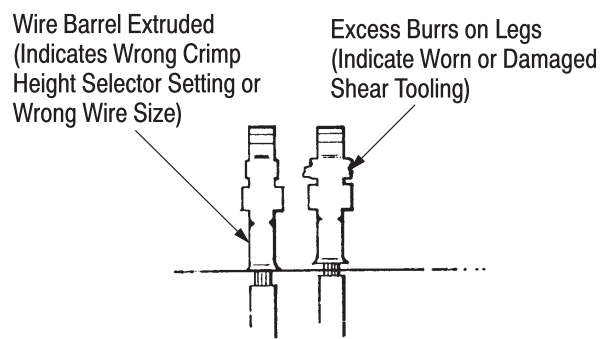
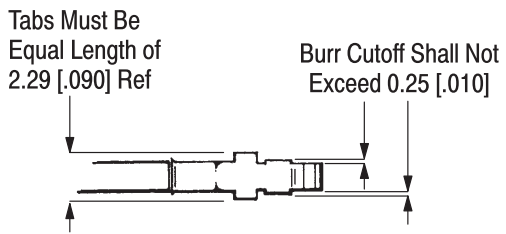


Figure 2