## 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.



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



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 [ <sup>5</sup> / <sub>16</sub> – <sup>3</sup> / <sub>8</sub> ]		
	8		4.09 [.161]		8			
	6		4.72 [.186]		6			

Distance between centerlines of two contacts.

HAND TOOLING								
PART NUMBER	CRIMP HEIGHT	WIRE						
(Instruction Sheet)	DIMENSION	TOLERANCE	SIZE (AWG)	STRIP LENGTH				
68321-1 (408-2681)	3.71 [.146]		10	7.94–9.52 [ <sup>5</sup> / <sub>16</sub> – <sup>3</sup> / <sub>8</sub> ]				
	4.09 [.161]	<u>+</u> 0.10 [.004]	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 Adjust Applicator to Obtain Height of Wire Extends Too Far 5.08 [.200] Min for Rear Bellmouth and **Beyond Wire Barrel** Wire Insulation 4.19 [.165] Max for Front Bellmouth **Enters Wire Barrel** Using Wire Size 12 AWG Crimp Height According Insulation Does Not to Figure 1 **Enter Wire Barrel** Bellmouth Flash Extends Below Bottom of **Dents at These Points** Wire Barrel (Excessive Flash Indicate Bent Hold-Down Indicates Wrong Wire Size Used, Damaged Dies, or Wire Insulation Entered Wire Barrel) No Nicked or Missing Wire Strands 0.20 [.008] or 1<sup>1</sup>/<sub>2</sub>° Max Upward Bend Allowed End of Wire Not Flush With No Downward Bend Allowed or Does Not Extend End of Wire Flush to Nicked or Missing Beyond End of Wire Barrel 1.52 [.060] Max from Wire Strands End of Wire Barrel Wire Barrel Seam Condition According to Figure 1 **Contact Bent Outside** Specified Range Wrong Crimp Height (Indicates Worn Dies or Wrong Straight Edge (Ref) Crimp Height Selector Setting No Downward Bend Permissible Over These Lengths Check contact straightness with a comparator. An alternate **NOTE** 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. Wire Barrel Extruded Excess Burrs on Legs Tabs Must Be (Indicates Wrong Crimp (Indicate Worn or Damaged Equal Length of Height Selector Setting or **Burr Cutoff Shall Not** Shear Tooling) 2.29 [.090] Ref Wrong Wire Size) Exceed 0.25 [.010]

Figure 2