

## 1. INTRODUCTION

The purpose of this instruction sheet is to describe how to use an insertion tool to assist in inserting a terminal crimped to wire size 1.0 mm<sup>2</sup> or smaller into housing with the base number 154719.

Housing part number 927537-1 can be used in place of housing base number 154719 to avoid use of the insertion tool. See Figure 1.

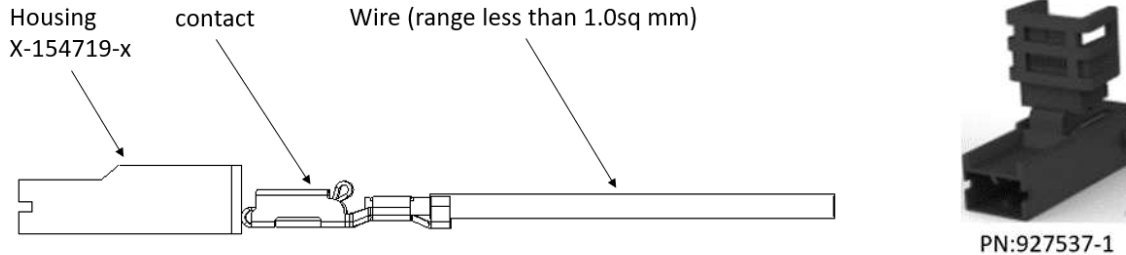


Figure 1

## 2. MANUAL ASSEMBLY OPERATION

If a housing with the base number 154719 is used with a contact crimped to wire size 1.0 mm<sup>2</sup> or smaller in a manual assembly operation, an insertion tool as featured in Figure 2 is required.

Figure 3 provides the reference dimensions for the insertion tool. Contact TE Connectivity Engineering for assistance or to request a 3D prototype model.

When inserting the contact into the housing using a manual process, the contact must be inserted straight into the housing. See Figure 4.

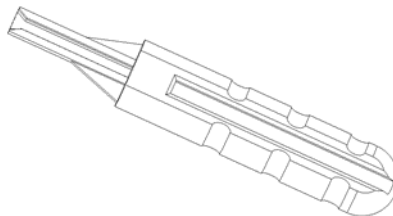


Figure 2

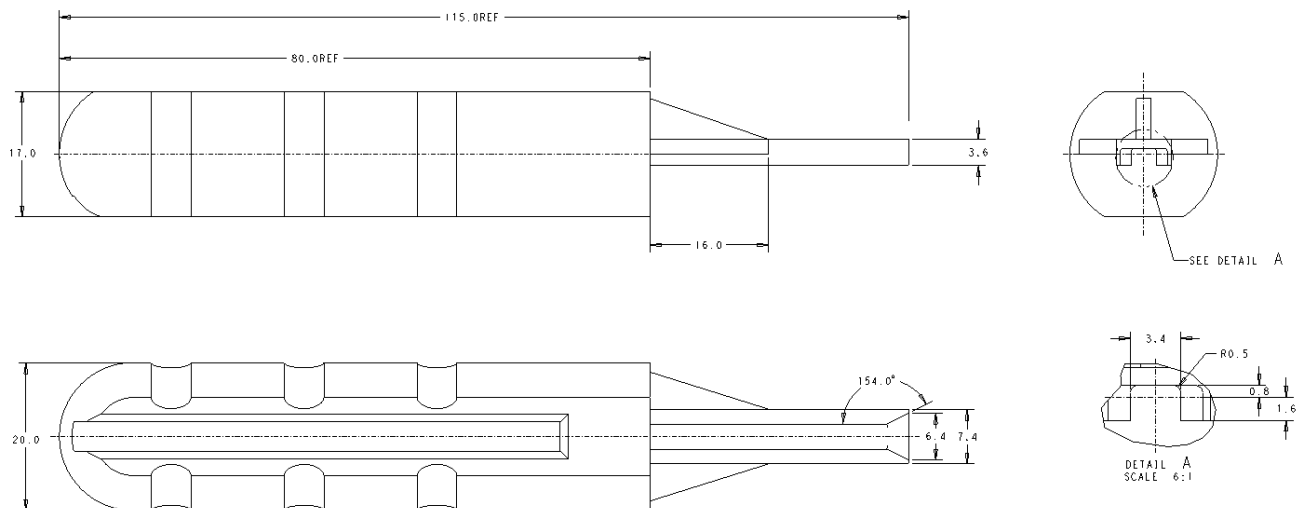


Figure 3

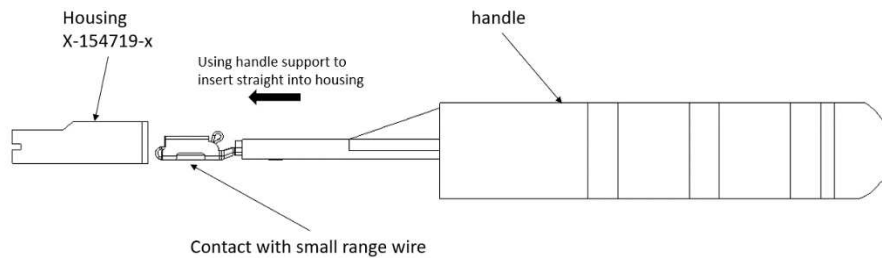


Figure 4

### 3. AUTOMATIC ASSEMBLY OPERATION

If a housing with the base number 154719 is used with a contact crimped to wire size 1.0 mm<sup>2</sup> or smaller in an automatic assembly operation, a clip as featured in Figure 5 may be used.

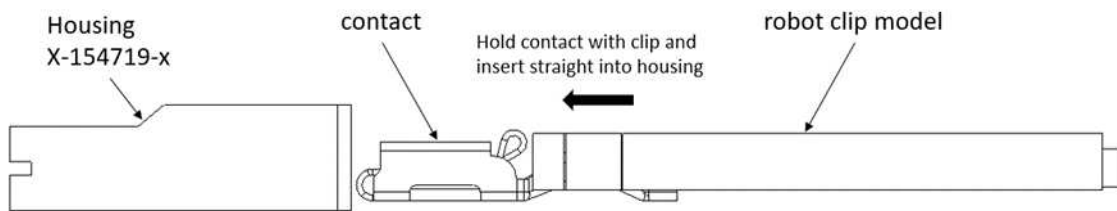


Figure 5

The clip must hold the wire barrel crimp but not the wire, as see in Figure 6.

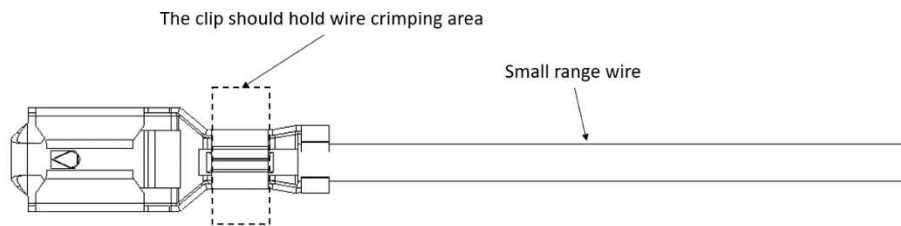


Figure 6

The clip must be controlled by an air cylinder. See Figure 7 for proper orientation to hold the contact.

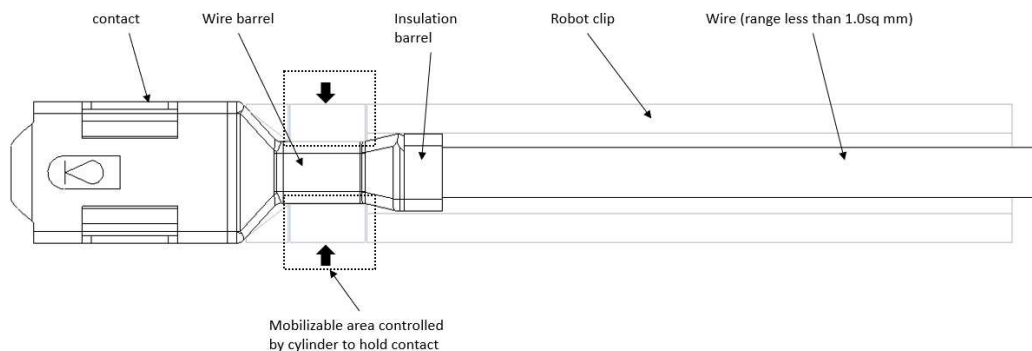


Figure 7

Figure 8 provides reference dimensions for the clip. These dimensions must be adjusted to ensure that the clip holds the wire barrel precisely, while maintaining the contact shoulder lower than the contact step. See Figure 9.

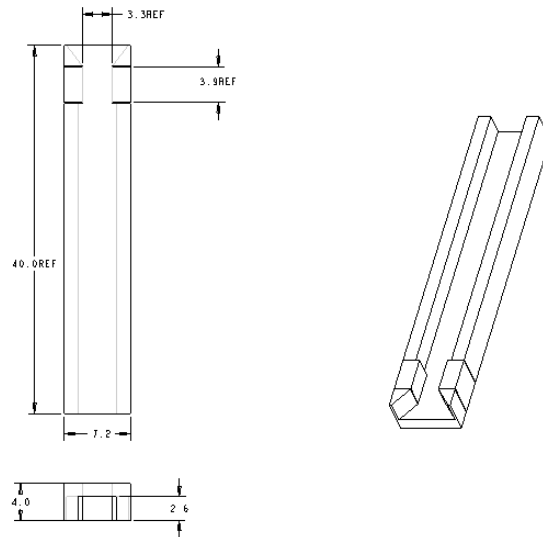


Figure 8

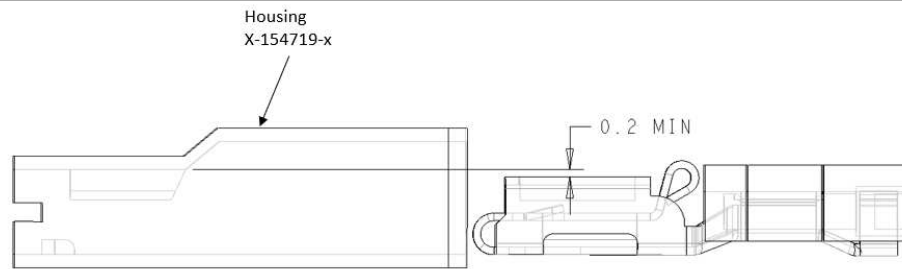


Figure 9