

1. INTRODUCTION

Inspect crimped contacts for "ACCEPT" or "REJECT" conditions shown below. Refer to the chart for crimp heights and strip lengths. Refer to the instructions packaged with the tooling for tooling adjustments or parts replacement information.

CAUTION

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

NOTE

All dimensions are in millimeters [with inches in brackets].

2. REVISION SUMMARY

Revisions to this document include:

Per EC 0210-0866-93:

- Change name in title from 30 Series to Series I.
- Change part number in title to 53892.
- Change applicator tooling part number to 466516-6 or -7.
- Change hand tooling part number to 68347-1.

Per EC 0990-0252-93:

- Updated format
- Added metric dimensions
- Added revision summary

APPLICATOR TOOLING INFORMATION

PART NUMBER (Instruction Sheet)	CRIMP HEIGHT			WIRE		FEED LENGTH
	SET	DIMENSION	TOLERANCE	SIZE (AWG)	STRIP LENGTH	
466516-6 or -7 (408-8074)	A	2.82 [.111]	± 0.05 [.002]	12	5.56 to 6.35 [7/32 to 1/4]	12.45 ■ [.490]
	B	2.59 [.102]		14		
	C	2.36 [.093]		16-18		
	D	2.29 [.090]		20		

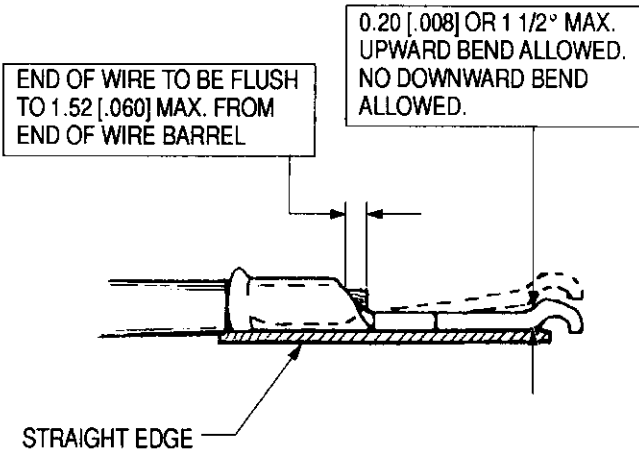
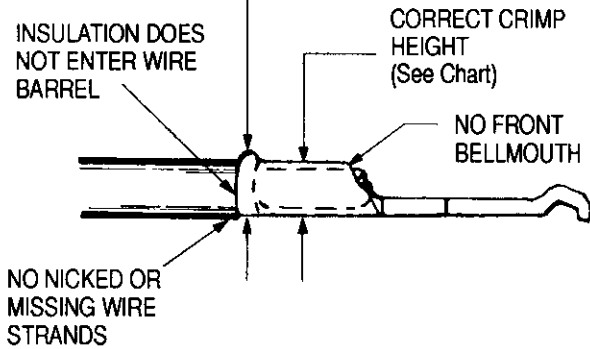
■ Distance between centerlines of two contacts.

HAND TOOLING INFORMATION

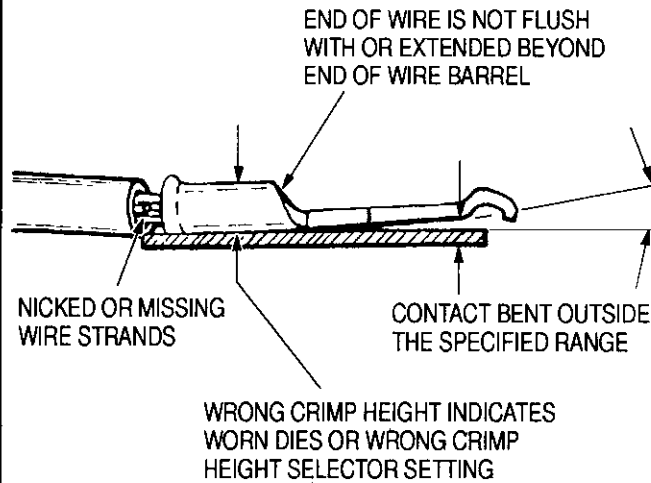
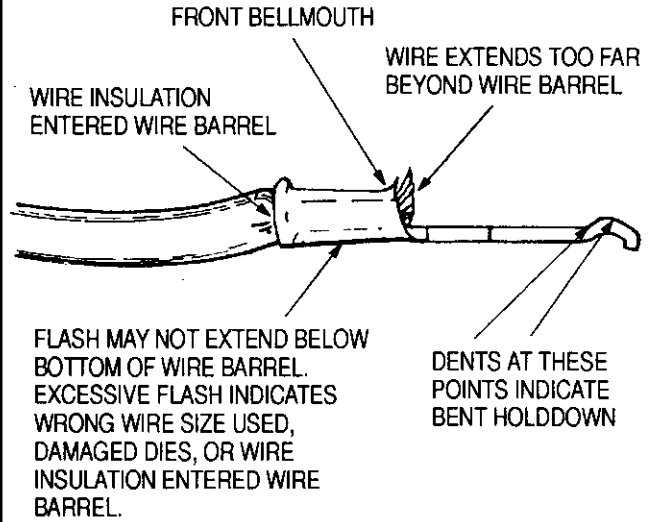
PART NUMBER (Instruction Sheet)	CRIMP HEIGHT		WIRE	
	DIMENSION	TOLERANCE		
68347-1 (408-2734)	2.82 [.111]	+ 0.08 [.003] - 0.05 [.002]	SIZE (AWG)	
	2.44 [.096]		12	5.56 to 6.35 [7/32 to 1/4]
	2.44 [.096]		14	
	16			

ACCEPT

ADJUST APPLICATOR TO OBTAIN BELLMOUTH HEIGHT OF 3.30 TO 3.68 [.130 TO .145] FOR 12 AWG WIRE



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.

