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MINI COAXIAL ITA CONTACT ASSEMBLY

PART # 610 103 161 FOR 24 & 26 AWG TWISTED PAIR



Dimensions shown: [millimeters]
inches

TOOLS REQUIRED

Crimp Tool, Part # 910 101 118
Crimp Tool, Part # 910 101 115
Crimp Locator, Part # 910 104 128

CRIMP TOOL SETUP

1. Set up the Crimp Tool, Part # 910 101 118 (**Figure A**), by loosening the latch locking screw (counter-clockwise, until turning stops). Remove any previously used locator.
2. Insert the open end of the Crimp Contact Locator, Part # 910 104 128 (**Figure B**) into the locator retainer. Slide the retaining latch toward the locator until it is securely locked into place. The locator may have to be twisted to allow the latch to retain it. Tighten the latch locking screw.

ASSEMBLY INSTRUCTIONS

1. Select correct crimp setting for gauge wire to be used. See Table below. While in closed position, check diameter of the crimp tool with gauge pins to be sure setting is correct. This should be done periodically during use to compensate for wear. For more information about gauge pins, visit vpc.com/gaugepins. See calibration instructions for Part # 910 101 102/103 for pin gauge verification instructions.
2. Untwist 2" [50.8 mm] of twisted wire. Cut 0.5" [12.7 mm] off the white wire and strip white wire 0.160" [4.06 mm] (**Figure C**).
3. Slide $^{1}/_{16}$ [1.58 mm] shrink tubing 0.25" [6.35 mm] long over white wire. Slide crimp ring over both wires (smaller end first) (**Figure D**).
4. Insert wire with center conductor in place at depth allowed by die into Crimp Tool, Part # 910 101 118 (**Figure B**) and close crimp tool handles completely until handles release. Remove crimped center conductor and wire. Gently pull on wire to ensure proper crimp.
5. Slide shield conductor over center conductor until it stops (**Figure E**).
6. Slide shrink tubing over crimped area so that it covers all exposed areas of center conductor and touches dielectric. Heat to shrink (**Figure F**).
7. Re-twist black wire around white conductor and shield. Trim excess wire that extends beyond the shoulder of the shield conductor. Strip black wire such that insulation still covers shrink tubing but not crimp area on shield. Unravel and flare strands around shield (**Figure G**).
8. To ensure proper crimp position, slide shield conductor over the locator pin. Crimp using the Hex Crimp Tool, Part # 910 101 115 (**Figure H**) in hex position "A" for the larger side and hex position "B" for the smaller end (**Figure J**). Wire must not be allowed to pull on the center conductor during crimping (for example, long wire hanging down to floor).

CRIMP SETTINGS

WIRE GAUGE	MAX. (in [mm])	MIN. (in [mm])	PULLOUT FORCE (lbs [N])
26	0.032 [8.12]	0.028 [7.11]	2 [8.89]
24	0.039 [9.91]	0.035 [8.89]	2 [8.89]
22*	0.044 [11.17]	0.039 [9.91]	2 [8.89]
*Acceptable Stranding: 1 x 22; 7 x 30			

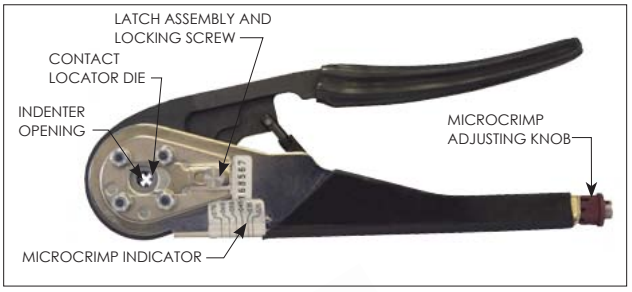


Figure A. Crimp Tool, Part # 910 101 118.

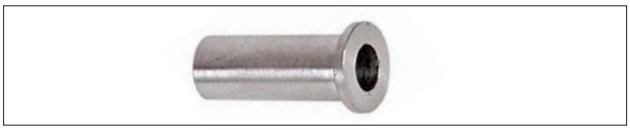


Figure B. Locator, Part # 910 104 128.

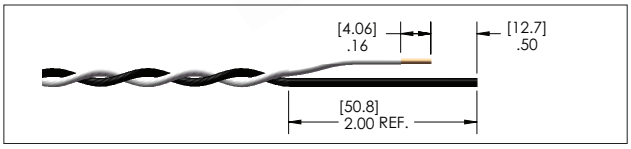


Figure C. Cut and strip wire.

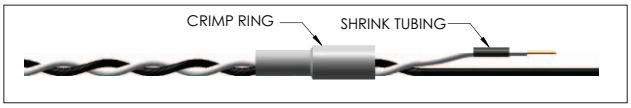


Figure D. Crimp ring and shrink tubing.

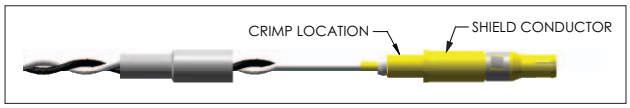


Figure E. Install shield conductor.

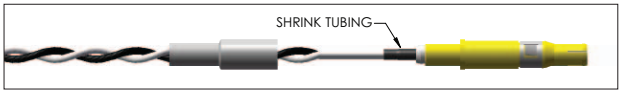


Figure F. Shrink tubing.

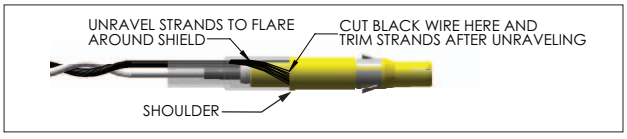


Figure G. Apply crimp ring.



Figure H. Crimp tool, Part # 910 101 115.

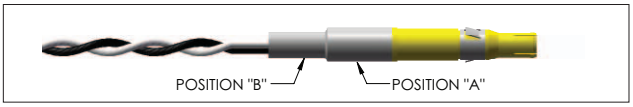


Figure J. Crimp locations.

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