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MINI COAXIAL ITA CONTACT ASSEMBLY

PART # 610 103 136 FOR 24 AWG, PART # 610 103 166 FOR 24 AWG
PART # 610 103 172 FOR 22 AWG



TOOLS REQUIRED
Crimp Tool, Part # 910 101 118
Crimp Locator, Part # 910 104 128

Dimensions shown: [millimeters]
inches

CRIMP TOOL SETUP

1. Set up 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 Locator, Part # 910 104 128 (**Figure B**), into the crimp tool contact locator retainer. Slide the retaining latch toward the locator until the locator 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 of wire and contact to be used. See Table below. While in closed position, check diameter of 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. Strip wire (**Figure C**).

3. Slide tubing onto wire (**Figure C**).

4. Insert contact with wire in place to the depth allowed by die (**Figure D**).

5. Close crimp tool completely until it automatically releases.

6. Contact should be crimped in correct position with no fractures or loose crimp.

7. Gently pull wire to check crimp.

8. Slide tubing into position and shrink (**Figure E**).

CRIMP SETTINGS

WIRE GAUGE	STRIP LENGTH (IN [MM])	MAX. (IN [MM])	MIN. (IN [MM])	PULLOUT FORCE (LBS [N])
24	0.160 [4.06]	0.039 [9.91]	0.035 [8.89]	2 [8.89]
22	0.160 [4.06]	0.037 [9.39]	0.033 [8.38]	2 [8.89]

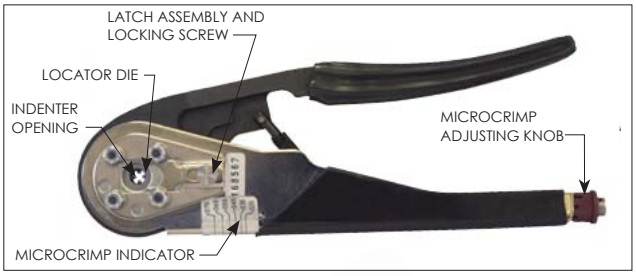


Figure A. Crimp Tool, Part # 910 101 118.

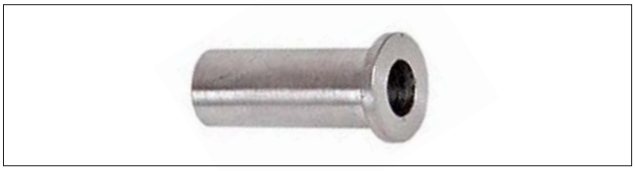


Figure B. Locator, Part # 910 104 128.

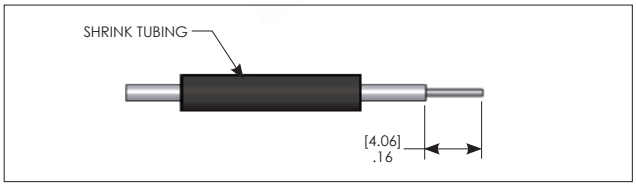


Figure C. Stripped wire with tubing.

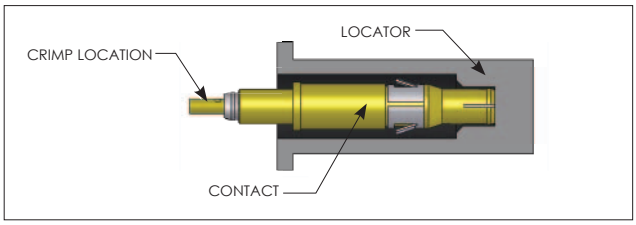


Figure D. Contact in locator.

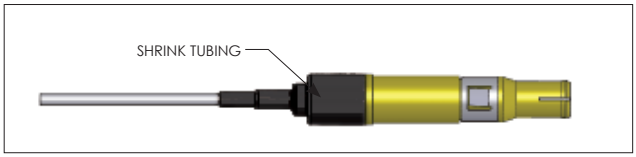


Figure E. Shrink tubing must cover crimp.

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