

1200001438

9633

Issued November 1993



**Instruction Leaflet**

## Crimp Tool

RS stock no. 468-686

This tool is suited to crimping contacts for the QM Multipole connector range and the 9-way IP68 sealed connector range. Select the appropriate instructions below.

### QM Multipole, single and two piece contacts

1. Ensure you have the correct wire size for the contacts to be used.
  - i. Size 16 - wire size 0.5-1.5mm<sup>2</sup>
  - ii. Size 20 - wire size 0.3-0.75mm<sup>2</sup>
  - iii. Size 24 - wire size 0.08-0.41mm<sup>2</sup>
2. Remove the contact from the strip supplied.
3. Strip back the wire insulation 4mm.
4. Insert the contact and wire into the appropriate die nest, 16, 20 or 24. Ensure the small tongs on the contact face down into the U-shape of the die nest and the wire is inserted to enable the rear tongs to crimp over the insulation. Crimp the contact.
5. Move the contact to the INS position and crimp the rear tongs onto the wire insulation.
6. The contact may now be inserted through the rear of the connector body and pushed home.

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5. Move the contact to the INS position and crimp the rear tongs onto the wire insulation.
6. The contact may now be inserted through the rear of the connector body and pushed home.

### IP68 sealed connector range - 9-way

1. The contacts are suitable for wire sizes 24 to 28 awg ensure the wire selected is suitable.
2. Strip back the wire insulation 4mm.
3. Insert contact and wire into crimp position 24 with the small tongs facing down to into the U-shape of the die nest. Crimp the terminal.
4. Place the contact into the INS position of the tool. Crimp the tongs over the insulation.
5. The completed crimp termination may now be pushed home through the rear of the connector body.

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