

Contact Assembly Instructions — Section 9

Signal Terminal Assembly  
P/N 610 110 167 (Receiver)

**Crimp Tool Setup**

Tool PN 910 101 103 (Fig A)

1. Set up crimp tool PN 910 101 103 (Fig A) by loosening contact retainer latch assembly using the locking screw (turn counter-clockwise to loosen)
2. Insert open end of crimp contact locator PN 910 104 127 into contact retainer assembly

NOTE: Contact locator is "D" shaped with a flat at one side to allow only one possible contact locator insertion position

NOTE: Crimp contact locator PN 910 104 107 may also be used, but VPC recommends use of 910 104 127, as it contains an integrated wire stop feature for ease of contact crimping.

3. Slide crimp tool retaining latch to contact locator until contact locator is securely held in place and tighten latch locking screw

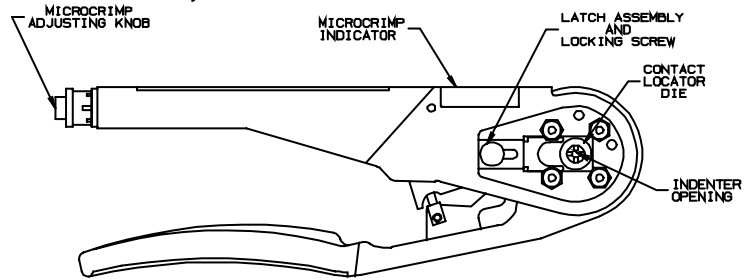


Fig. A

**Crimp Tool Adjustment and Wire Preparation**

1. Using Table 1 below, determine appropriate crimp tool setting and wire strip length according to the wire gauge being used
2. Pull and turn the microcrimp adjusting knob (clockwise to increase, counter-clockwise to decrease settings) to adjust the crimp tool until the appropriate setting is achieved
3. Strip wire to the appropriate length

Table 1

Wire Gauge	Strip Length +.05 -0.0	Crimp Max.	Crimp Min.	Pullout Force (lb.)
26	.19	.028	.026	4
28	.19	.024	.023	4

**Contact Setup and Crimping**

1. Align contact retaining tab (Fig B) with positioning slot in contact crimp locator and insert contact into crimp tool  
 NOTE: Contact will drop completely into the crimp tool if properly positioned;  
 NOTE: Do not force contact into the crimp tool, as contact damage will occur;  
 NOTE: If contact does not drop completely into the crimp tool, remove the contact, ensure that the contact retaining tab is properly aligned with the contact crimp locator, and re-insert contact into crimp tool
2. Once contact is properly inserted into the crimp tool, squeeze crimp tool handle slightly to hold the contact in position for wire insertion
3. Insert stripped wire fully into the contact and squeeze the crimp tool handle fully until reaching a positive stop
  - a. NOTE: Crimp tool will automatically release and return to open position when crimp is complete
4. Remove the crimped contact wire

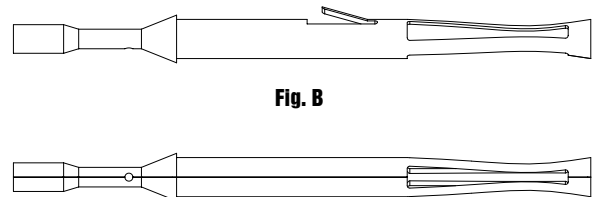


Fig. B

**NOTE: Observe precision ratchet action by opening and closing crimp tool fully several times. Note that tool cannot be opened without completing cycle. Never attempt to disassemble tool. Never tighten or loosen stop nuts on back of tool.**