

QUADRAPADDLE™ SIGNAL ITA CONTACT ASSEMBLY

PART # 610 138 109 / 610 138 112



TOOLS REQUIRED

- Crimp Tool, Part # 910 101 103
- Locator, Part # 910 104 140

CRIMP TOOL SETUP

- Set up the Crimp Tool, Part # 910 101 103 (**Figure A**), by loosening the latch locking screw (counter-clockwise, until turning stops). Remove any previously used locator.
- Insert the open end of the Locator, Part # 910 104 140 (**Figure B**), into the crimp tool 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.

CRIMP TOOL ADJUSTMENT AND WIRE PREPARATION

- Adjust the crimp tool setting by pulling the microcrimp adjusting knob and turning it at the same time (clockwise increases, counter-clockwise decreases setting) until the desired setting is achieved on the microcrimp indicator (**Table 1**). Verify with gauge pin. For more information about gauge pins, visit vpc.com/gaugepins. See calibration instructions for Part # 910 101 102/103 for gauge pin verification instructions.
- Determine the strip length according to wire gauge (**Table 1**). Strip wire.

CONTACT SETUP AND CRIMPING

- Insert the contact into the crimp tool and squeeze the handle slightly to hold the contact in position for wire insertion.
- Insert the stripped wire fully into the contact and squeeze the crimp tool handle until a positive stop is reached. The tool will release and return to a fully "open" position. Remove the crimped contact wire (**Figure C**).

NOTE: This contact can also be used to solder wire.

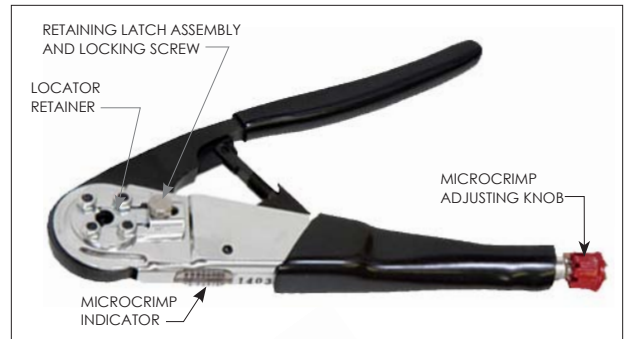


Figure A. Crimp Tool, Part # 910 101 103.



Figure B. Locator, Part # 910 104 140.



Figure C. Correctly crimped contact.

! OBSERVE PRECISION RATCHET ACTION BY OPENING AND CLOSING TOOL FULLY SEVERAL TIMES. NOTE THAT THE TOOL CANNOT BE OPENED WITHOUT COMPLETING A CYCLE. NEVER ATTEMPT TO DISASSEMBLE TOOL. NEVER TIGHTEN OR LOOSEN STOP NUTS ON THE BACK OF THE TOOL.

Table 1.

CONTACT	CRIMP TOOL	LOCATOR DIE	STRIP LENGTH (IN [MM])	INSULATION DIAMETER MAX (IN [MM])	WIRE GAUGE	CRIMP SETTING (IN [MM])		PULLOUT FORCE (LBS [N])	EXTRACTION TOOL
						MAX	MIN		
610138109	910101103	910104140	0.200 [5.08]	0.050 [1.27]	22	0.030 [0.76]	0.026 [0.66]	10 [44.5]	910110111
					24	0.026 [0.66]	0.022 [0.56]	8 [35.6]	
			2-24*		0.030 [0.76]	0.026 [0.66]	8 [35.6]		
			2-26*		0.029 [0.74]	0.026 [0.66]	4 [17.8]		
610138112	910101103	910104140	0.200 [5.08]	0.040 [1.02]	26	0.032 [0.81]	0.031 [0.79]	4 [17.8]	
					28	0.027 [0.68]	0.026 [0.66]	2 [8.9]	
					30	0.023 [0.58]	0.022 [0.56]	1 [4.4]	

* Pullout force is for individual wires