

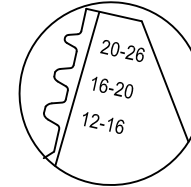
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REVISIONS		
LTR	DESCRIPTION	DATE
J	REVISED PER ECO-11-006285	04/14/2011



DETAIL A-A
CAVITY SIZE MARKING

NOTES:

- UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.
 - THE AD-1377 CRIMP TOOL IS DESIGNED TO MAKE WIRE SPLICES UTILIZING TYCO ELECTRONICS CRIMP SPLICES OF THE FOLLOWING SIZES:
- | TOOL CAVITY | 12 - 16 | | 16 - 20 | | 20 - 26 | |
|--------------------|---------|------|---------|------|---------|------|
| | I.D. | O.D. | I.D. | O.D. | I.D. | O.D. |
| CRIMP SPLICER SIZE | .102 | .153 | .069 | .106 | .050 | .080 |
| | .097 | .147 | .064 | .101 | .045 | .075 |
- WHEN MADE WITH A PROPERLY CALIBRATED AD-1377 CRIMP TOOL, THESE WIRE SPLICES WILL MEET THE VOLTAGE DROP AND TENSILE STRENGTH REQUIREMENTS OF THE APPLICABLE TYCO ELECTRONICS CUSTOMER DRAWING FOR CRIMP SPLICING SYSTEMS.
 - A PROPERLY CALIBRATED AD-1377 CRIMP TOOL HAS THE FOLLOWING CHARACTERISTICS:
 - RATCHET ADJUSTMENT (SET AT THE FACTORY): A COMPRESSIVE FORCE OF 40-50 LBS APPLIED 1.25 ± .12 INCHES FROM THE END OF THE HANDLES SHALL BE REQUIRED TO COMPLETELY CLOSE THE JAWS BEFORE THE RATCHET MECHANISM RELEASES THE HANDLES.
 - JAW CLOSING: WITH THE JAWS FULLY CLOSED (TIPS TOUCHING AND RATCHET IN LAST NOTCH), A "GO" GAUGE SHALL FIT IN THE SPACE BETWEEN THE INDENTER AND ITS CORRESPONDING CAVITY. A "NO GO" GAUGE SHALL NOT FIT IN THIS SPACE. GAUGE SIZES ARE AS FOLLOWS:

TOOL CAVITY	"GO"	"NO GO"
12 - 16	.062 DIA.	.072 DIA.
16 - 20	.042 DIA.	.052 DIA.
20 - 26	.025 DIA.	.035 DIA.

TYCO ELECTRONICS AD-1386 CRIMP TOOL GAUGE IS RECOMMENDED FOR THIS PURPOSE.

Raychem Application Equipment
CUSTOMER DRAWING



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE INCHES. METRIC DIMENSIONS ARE IN BRACKETS. DECIMAL TOLERANCES .XXX ± 0.005 [0.13 mm] .XX ± 0.01 [0.25 mm] .X ± 0.1 [0.50 mm] ANGLE TOLERANCE .X ± 1 DEG. TYCO ELECTRONICS CORPORATION RESERVES THE RIGHT TO AMEND THIS DRAWING AT ANY TIME. USERS SHOULD EVALUATE THE SUITABILITY OF THE PRODUCT FOR THEIR APPLICATION. © 1975-2011 Tyco Electronics Corporation. All rights reserved.	DRAWN UNGUYEN	STE TE Connectivity		
	PART NUMBER 959025-000	TITLE AD-1377 S CRIMP TOOL ASSEMBLY		
	THIRD ANGLE PROJECTION	SIZE B	CODE IDENT. NO. 06090	DWG. NO. AD-1377-6

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