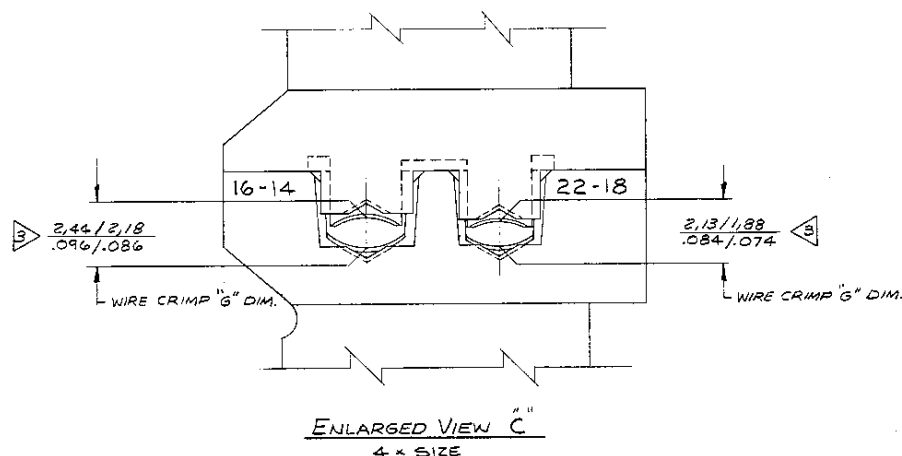
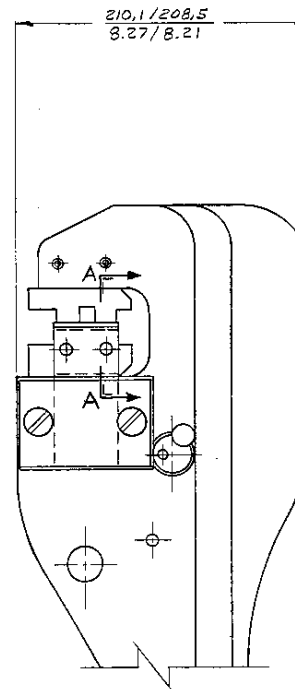
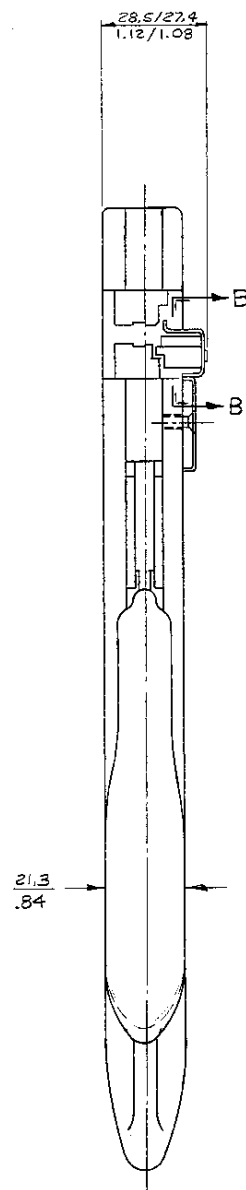
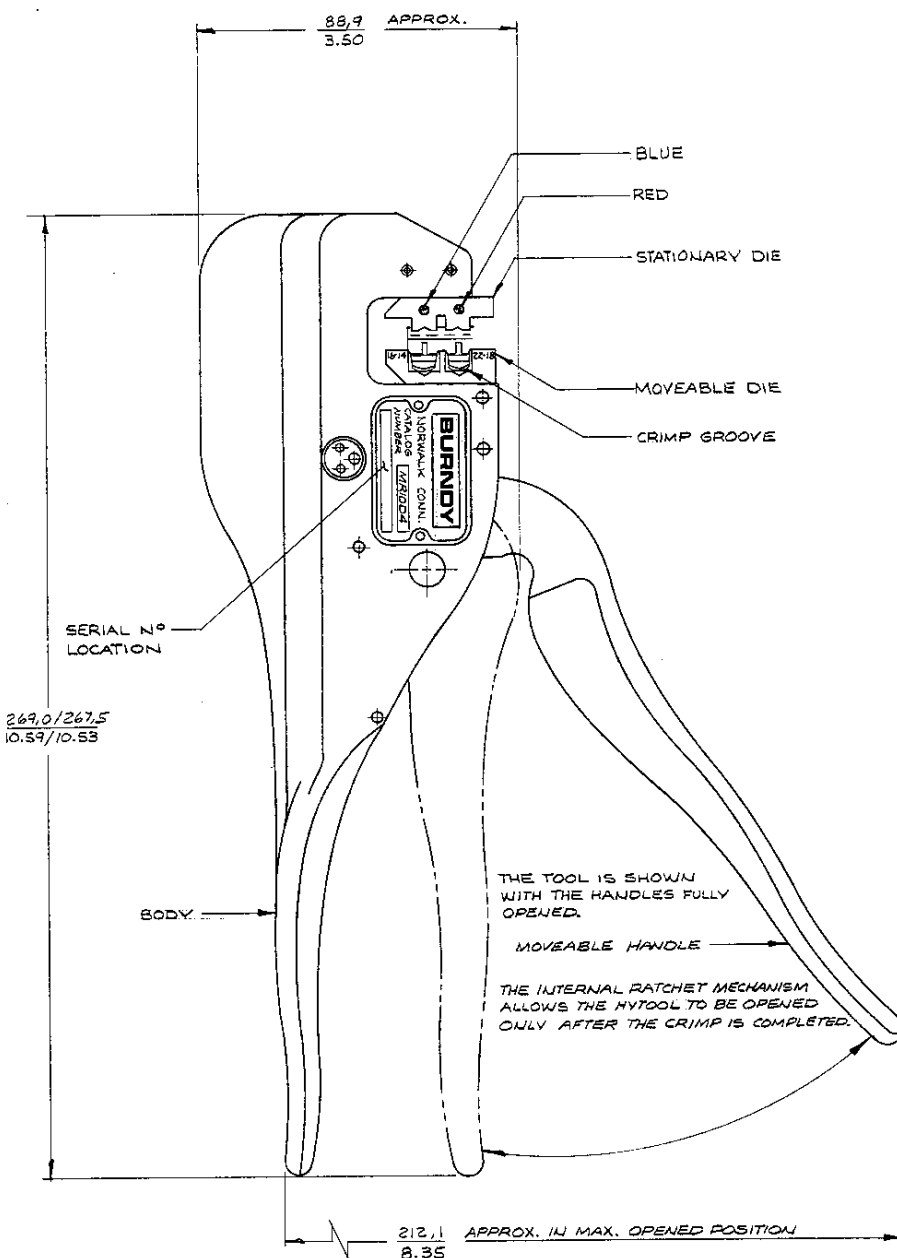


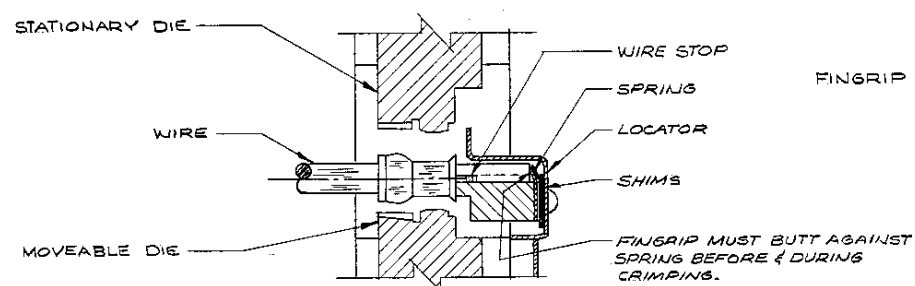
SE76749

SE76749

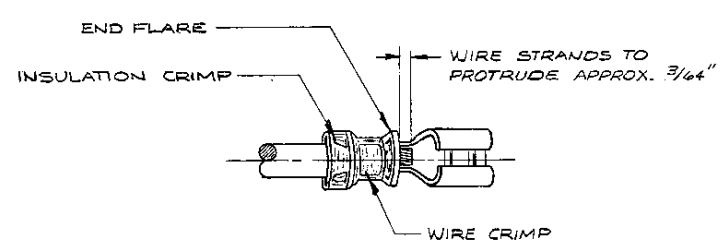
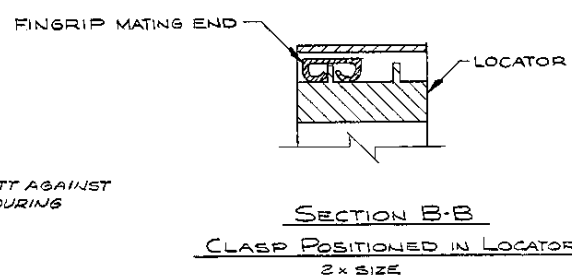
REV.	DATE	REVISION DESCRIPTION	BY	CHK'D.
4	11-12-75	REDRAWN & REVISED PER ECM 2352	MV	MV
5	12-1-75	.84 WAS .845/1.835 DC 8742	MV	MV
6	1/12/76	IN NOTE 3 PG 353 WAS 339 & PG 354 WAS PG 340 DC 10819	MV	MV
7	7/21/84	IN NOTE 3 PG 353 WAS PG 339 AND PG 354 WAS PG 340 (DC 11249)	CAR	OK



NOTE: DIES ARE TO BE FULLY BUTTED BEFORE CHECKING WIRE CRIMP "G" DIMS. THEY ARE TO BE CHECKED WITH APPROPRIATE PG GAGE FROM FRONT SIDE OF DIES AS SHOWN. LOCATOR IS NOT TO BE REMOVED



SECTION A-A
TYPICAL FINGRIP IN POSITION FOR CRIMPING
2x SIZE



TYPICAL COMPLETED CRIMP

NOTES:

1. THIS TOOL IS FACTORY ADJUSTED SO THAT WITH NO TERMINAL IN TOOL, A FORCE OF 25 TO 35 LBS APPLIED ONE INCH FROM THE END OF THE HANDLES IS NECESSARY TO RELEASE THE INTERNAL RATCHET. THIS ASSURES FULL CRIMPING.

2. CRIMPING PROCEDURE:

2.1 SELECT THE PROPER TERMINAL & CRIMP GROOVE (SEE TABLE)

TERMINAL		CRIMP GROOVE		WIRE STRIP LENGTH IN INCHES ± 1/64	
COLOR	WIRE SIZE & MARKING	COLOR DOT	WIRE SIZE & MARKING	WIRE SIZE	LENGTH
BLUE	16-14	BLUE	16-14	16-14	.28
RED	22-18	RED	22-18	22-18	.28

2.2 CLOSE THE HANDLES OF THE TOOL UNTIL THE RATCHET RELEASES. RELEASE THE MOVEABLE HANDLE AND ALLOW THE TOOL TO OPEN.

2.3 PUSH THE LOCATOR DOWN TO ITS LOWER POSITION.

2.4 INSERT THE PROPER TERMINAL (SEE TABLE I) INTO ITS PROPER DIE GROOVE AND PUSH THE "MATING END" INTO THE LOCATOR SO THAT IT IS HELD WITHIN THE LOCATOR AS SHOWN IN SECT. B-B. PUSH THE TERMINAL ALL THE WAY IN SO THAT THE FRONT FACE OF THE TERMINAL BUTTS AGAINST THE SPRING AS SHOWN IN SECT. A-A.

2.5 INSERT THE PROPER WIRE, WHICH HAS BEEN STRIPPED OF INSULATION, INTO THE CRIMP BARREL. PUSH WITH A SMALL FORCE ON THE WIRE SO THAT IT IS HELD FIRMLY AGAINST THE WIRE STOP.

NOTE: THE TOOL USER MAY SOON DEVELOP OTHER TECHNIQUES FOR LOCATING THE FINGRIP & WIRE IN THE PROPER POSITION FOR CRIMPING. SUCH AS: LIGHTLY CLOSING THE TOOL TO HOLD THE FINGRIP IN PLACE AFTER INSERTING IT AGAINST THE LOCATOR, OR PLACING THE FINGRIP ON THE WIRE FIRST AND THEN PLACING IT INTO THE CRIMP GROOVE. THE QUICKEST, EASIEST METHOD SHOULD BE EMPLOYED PROVIDED THAT: THE FINGRIP BUTTS AGAINST THE LOCATOR, AND THE WIRE BUTTS AGAINST THE WIRE STOP.

2.6 CLOSE THE TOOL HANDLE BY SQUEEZING IT UNTIL THE END OF THE STROKE IS REACHED AND THE INTERNAL RATCHET RELEASES. THEN ALLOW THE HANDLE TO OPEN.

2.7 REMOVE THE CRIMPED FINGRIP. SEE VIEW "TYPICAL COMPLETED CRIMP" FOR PROPER APPEARANCE OF COMPLETED CRIMP.

3. "G" DIMS. - WIRE CRIMP GROOVES TO BE CHECKED WITH FOLLOWING GAGES: (SEE ENLARGED VIEW "C") 16-14 GROOVE - PG 353, 22-18 GROOVE - PG 354

4. MATERIAL: BODY - FORGED ALUMINUM. OTHER PARTS - CARBON & ALLOY STEELS. WEIGHT: APPROX. 1 LB. 9 OZ.

TABLE I, TERMINALS INSTALLED BY THIS TOOL.

CATALOG NO.	WIRE SIZE & TERMINAL COLOR	TERMINAL TYPE
PG18R255B/6B	22-18 - RED	FINGRIP
PG14R255B/6B	16-14 - BLUE	FINGRIP

REFERENCES:

FE75392 - MRODA FACTORY ASSY.
PD45138 - INSPECTION GAGES - PG...

SUPERSEDES SE76749-3 - MRODA

HYTOOL		SCALE: FULL	
CAT. NO. MRODA		REV. 11-11-75	
DRAWN: MV		CHECKED: MV	
DES. APPROV. 11-11-75		PRES. APPROV. 11-11-75	
BURNBY		REV. 7	

THIS DRAWING AND/OR SPECIFICATION IS THE PROPERTY OF THE BURNBY CORPORATION. IT IS ISSUED IN STRICT CONFIDENCE, AND SHALL NOT BE REPRODUCED, COPIED, OR DISCLOSED TO OTHERS, OR USED AS THE BASIS FOR THE MANUFACTURE OR SALE OF APPARATUS WITHOUT THE PERMISSION OF THE OWNER.