

QUADRAPADDLE™ SIGNAL RECEIVER CONTACT ASSEMBLY

PART # 610 138 116 / 610 138 216

TOOLS REQUIRED

Crimp Tool, Part # 910 101 125

Dimensions shown: [millimeters]
inches

CRIMP TOOL SETUP

- Using the Crimp Tool, Part # 910 101 125 (**Figure A**), with the wire gauge numbers facing you, squeeze the tool handles together until the ratchet releases; this will open the tool.
- Place the contact into the correct crimp locator/die cavity (**Figure B**) from the front side of the tool. The contact crimp areas will be facing you.



Figure A. Crimp Tool, Part # 910 101 125.

CONTACT SETUP AND CRIMPING

- Determine the strip length according to wire gauge (**Table 1**). Strip wire (**Figure C**).
- Insert the wire into correct locator/die cavity until it stops against the insulation stop.
- Holding the wire in place, squeeze the handles together until the tool is completely closed. Continue squeezing, until the last click, to allow the handle to release fully. Remove the contact from the cavity (**Figure D**). The conductor shall be visible on both ends of the conductor crimp. The insulation crimp should grip securely around the wire insulation without deforming the insulation.
- Check to make sure the wire meets the minimum pullout force shown in **Table 1** and the wire and insulation barrel are within the height and width specifications. Measure the crimp height with an anvil and point micrometer.

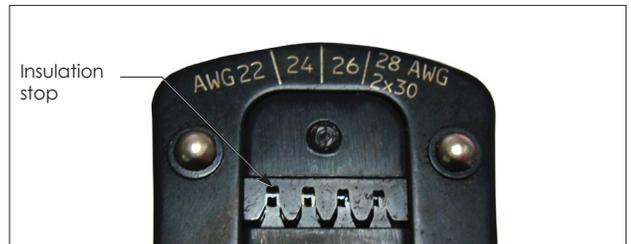


Figure B. Insulation stop on crimp tool.



Figure C. Correctly stripped wire.

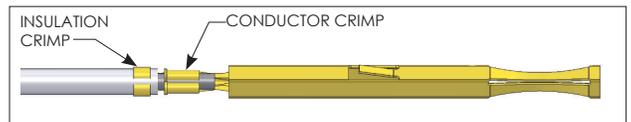


Figure D. Correctly crimped contact.

Table 1.

WIRE SIZE, AWG	CRIMP TOOL	LOCATOR DIE	STRIP LENGTH IN [MM]	INSULATION DIAMETER MAX (IN [MM])	WIRE BARREL CRIMP MAX (IN [MM])	PULLOUT FORCE (LBS [N])	EXTRACTION TOOL
22	910 101 125	N/A	0.125 [3.18]	0.048 [1.22]	0.032 - 0.038 [0.81 - 0.96]	10 [44.5]	910110112
24					0.027 - 0.036 [0.68 - 0.91]	8 [35.6]	
26				0.025 - 0.032 [0.63 - 0.81]	4 [17.8]		
28				0.024 - 0.030 [0.60 - 0.76]	2 [8.9]		
2-30*				1 [4.4]*			

*Pullout force is for individual wires.

NOTE: If using yellow-handled crimp tool, refer to this instruction sheet.