

# Crown Ring Contact Termination, Installation, and Removal

CONTACTS

## HOW TO TERMINATE, INSTALL AND REMOVE CROWN RING CONTACTS

**1 Set Up Crimp Tool.** Install proper die assembly and locator into the pneumatic crimper. See 979-013 for proper tools needed for each contact size.

**2 Strip Wire.** Remove wire insulation, taking care to avoid nicking or cutting wire strands. Strip wire to length shown on table.

**3 Insert Wire** into contact. The wire should be visible in the inspection hole.

**4 Insert contact into crimp tool.** Make sure the contact is fully inserted into the locator.

**5 Crimp contact.** While keeping contact seated, press the actuation button and hold the crimp die closed for a minimum of 8 seconds, to allow adequate dwell time for wire strand deformation.

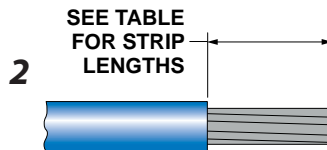
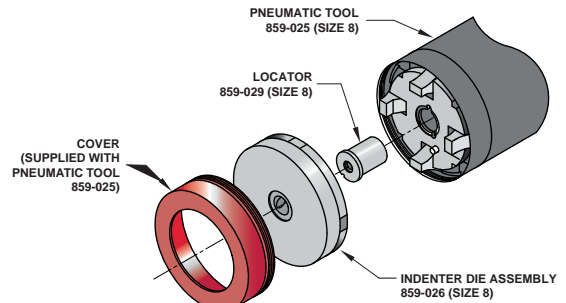
**6 Inspect crimped contact.** Wire should be fully inserted and visible through the inspection hole. The crimp should be uniform in appearance.

**7 Install contact into connector.** Brush Isopropyl Alcohol (IPA) onto the contact and approximately 1" of the wire. Before IPA dries, push the contact through the rear grommet until the contact locks into place. This can be done by hand without the need for a tool. **USE CARE TO AVOID DAMAGING THE CONNECTOR/GROMMET.**

**8 Contact Extraction.** Use the correct extraction tools per 979-013. Install the tool over the wire for the contact to be removed. Brush a generous amount of Isopropyl Alcohol (IPA) onto the grommet, where the wire is exiting. Before IPA dries, slide the tip of the tool into the connector/grommet. Push the tool into the connector cavity until the tip bottoms in the connector. Avoid wiggling or rocking the tip. This may damage the cavity. A straight push is best. Holding both the wire and the tool, pull the tool and contact out of the connector. **Ensure the wire insulation is within the acceptable limits listed on the connector datasheet.**

### PNEUMATIC CRIMP TOOL

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| Wire Size (AWG) | Strip Length in. (mm)   |
|-----------------|-------------------------|
| 10              | .495-.545 (12.57-13.84) |
| 8               |                         |
| 6               |                         |
| 4               | .550-.600 (13.97-15.24) |
| 2               |                         |
| 1/0             | .575-.625 (14.60-15.88) |

