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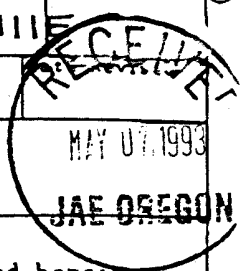
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Japan Aviation Electronics Industry, Ltd. Tokyo Japan	Type of Document Operation Manual	Page 1 of 5 No. T700111E	Rev. Date Issued
Issuing Organization	Title-Subject Hand Crimp Tool: CT150-1-AG5		



This hand tool crimps a contact to a pre-stripped wire specified herein. Satisfactory crimps requires the complete comprehension of this manual.

Model: CT150-1-AG5

1. Notes

- 1) Use applicable contacts and wire for crimp.
- 2) To maintain better condition for a long time, the tools should be free from contamination, dropping or rough handling.
- 3) The handles are already adjusted so that ratchets are released at the completion of crimping.
- 4) Lubrication is not required on the crimping positions (crimper, anvil).

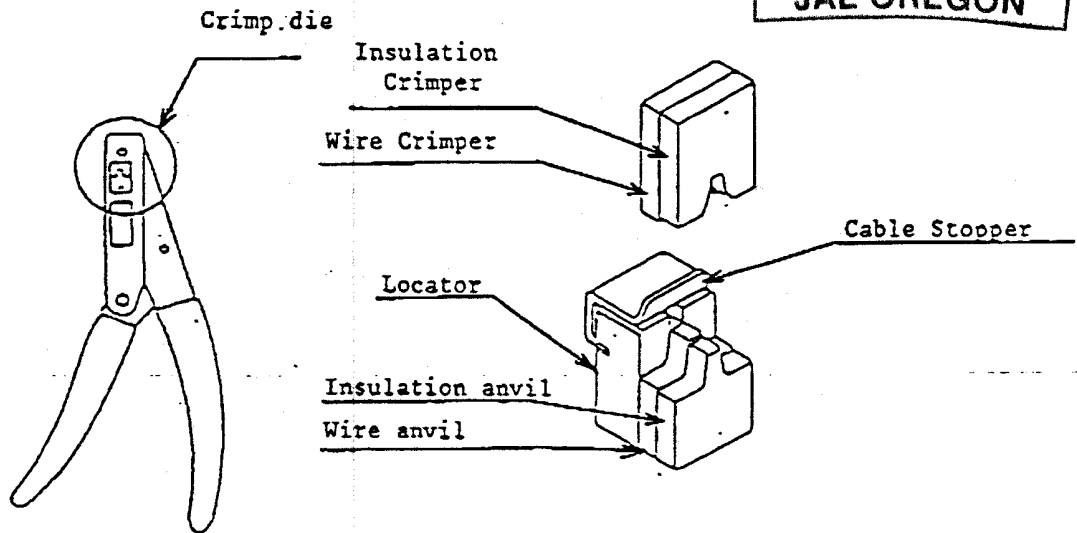
2. Description

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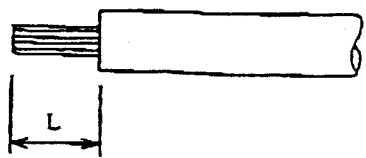
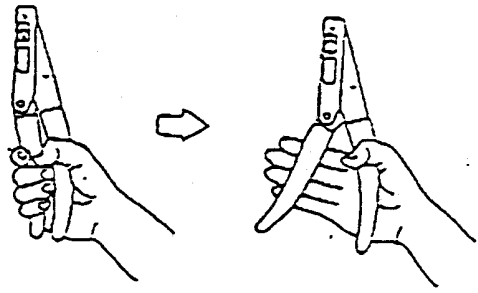
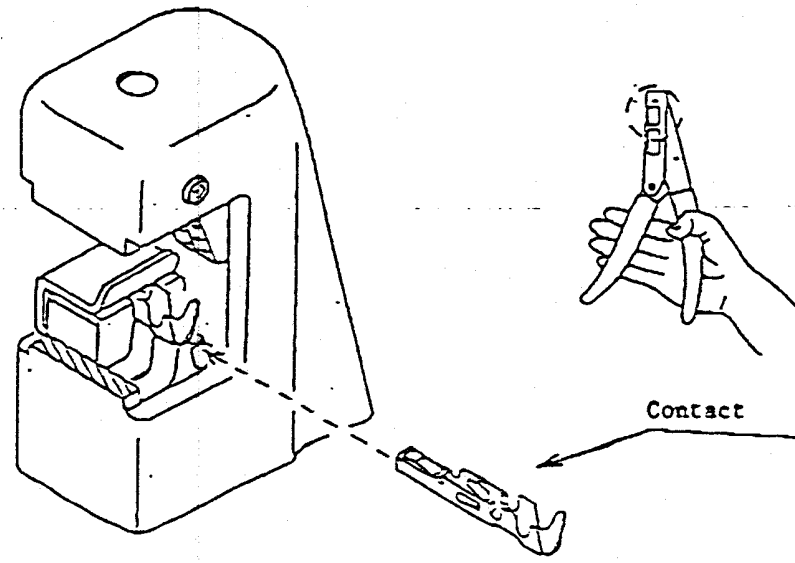
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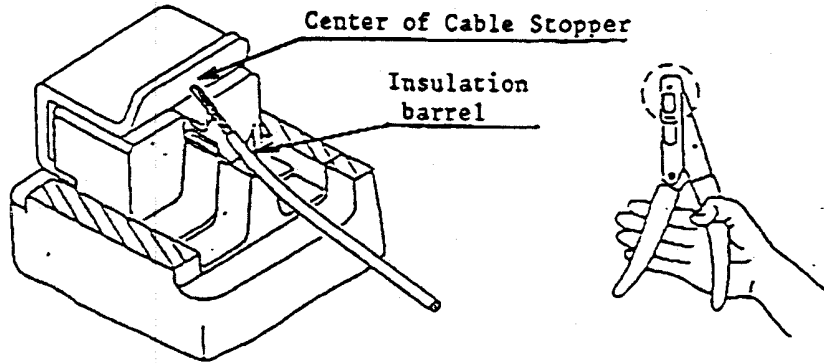
Details of crimp die

Japan Aviation Electronics Industry Ltd. Tokyo Japan	type of document Operation Manual	No.	Rev.
<p>3, Crimping</p> <p>1) Wire stripping</p> <p>Strip the insulation of a wire to the length of L on page 5. Check that conductors are not damaged, cut or disturbed.</p>  <p>2) Handles opening</p> <p>Open the handles before inserting a contact. A contact can be inserted only when they are open. Close them fully to crimp, and then release to automatically return them to the open position.</p>  <p>3) Contact insertion</p> <p>Insert a contact into the locator in the direction shown until its end touches the wire stopper.</p> 			

Japan Aviation Electronics Industry, Ltd. Tokyo Japan	Type of Document Operation Manual	No.	Rev.
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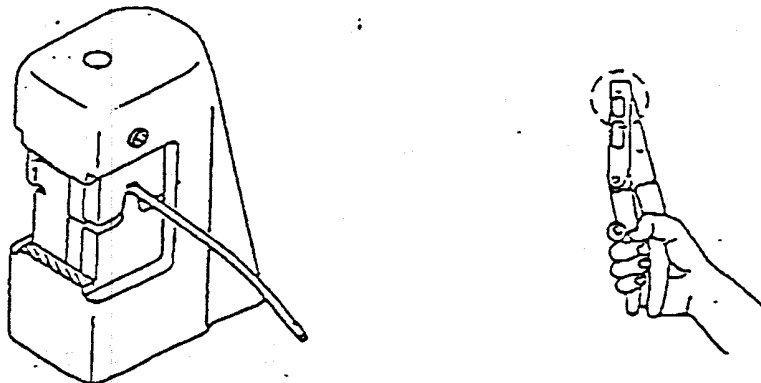
4) Wire insertion

Put the end of a pre-stripped wire to the wire stopper of the locator as shown. If a wire is pushed too much, it will be bent or twisted, which causes improper crimping. Correct disordered conductors in advance, if any.



5) Crimping

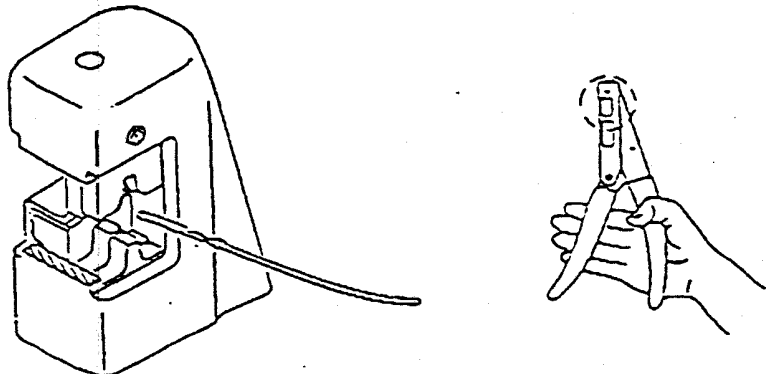
While holding a wire in position, close the handles gradually until ratchets are released. In this stage, crimping is completed.



6) Contact removal

Loosen the handles after the completion of crimping and they will automatically return to the open position.

Pull the wire with a crimped contact slightly to remove from the tool. (Care should be taken, so as not to deform the latch when pulling out the wire.)



Japan Aviation Electronics Industry, Ltd. Tokyo Japan	Type of document Operation Manual	No.	Rev.
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4. Check of crimping

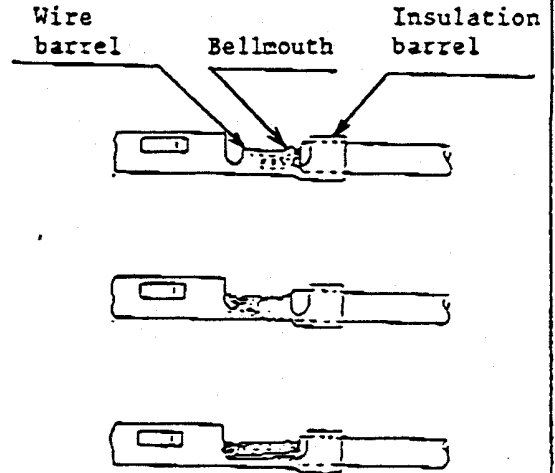
The following are the general standard of judgement on crimping quality.
 Other standard shall be as in each contact specification.

<Accepted>

- The end of a conductor is out of wire barrel.
- Insulation is held inside insulation barrel.
- Insulation is not inserted up to wire barrel.
- Conductor is held inside barrel.
- Crimping does not have excessively rough surface.
- Bellmouth remains uncrimped.

<Rejected>

- Insufficient insertion
(Conductor is not sufficiently inserted up to wire barrel).
- Insufficient stripping
(Insulation extends to wire barrel due to shorter stripping than specified).
- Disordered conductor
(Conductor is out of contact crimp barrel).

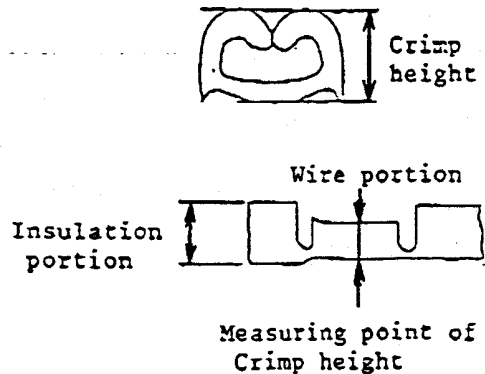


5. Check of tool crimp height

The crimp height is already adjusted.
 Before crimping, however, check by the following methods that crimp height stands within the specified value, to prevent improper crimping.

To crimp a contact without a wire and compare the crimp height with the specified.

As for the specified values of contact, each see page 5 for the details of each contact specification.



Japan Aviation Electronics Industry, Ltd. Tokyo Japan	Type of Document Operation Manual	No.	Rev.
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6. Description of tools, applicable contact and specification

Hand tool	Applicable contact	Applicable wire (AVS)		Strip length L(mm)	Standard crimp height for check	
		conductor (mm ²)	Insulation outer dia.		Conductor	Insulation
CT150-1-AG5	AG5-C1	0.3~0.85	φ1.7~2.4	4.0~5.0	1.05±0.02	2.50±0.1

7. Crimping tensile strength

Pulling strength is called crimping strength only when conductor is crimped but not insulation.

When the hand tool are used in normal conditions, contacts meet the requirements for crimping tensile strength in the following table.

Contact	wire size conductor (mm ²)	requirements (Kg) min.
AG5-C1	0.85	13.0
	0.5	9.0
	0.3	5.4