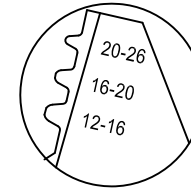


REVISIONS		
LTR	DESCRIPTION	DATE
G	REVISED PER ECO-11-006285	04/14/2011



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:

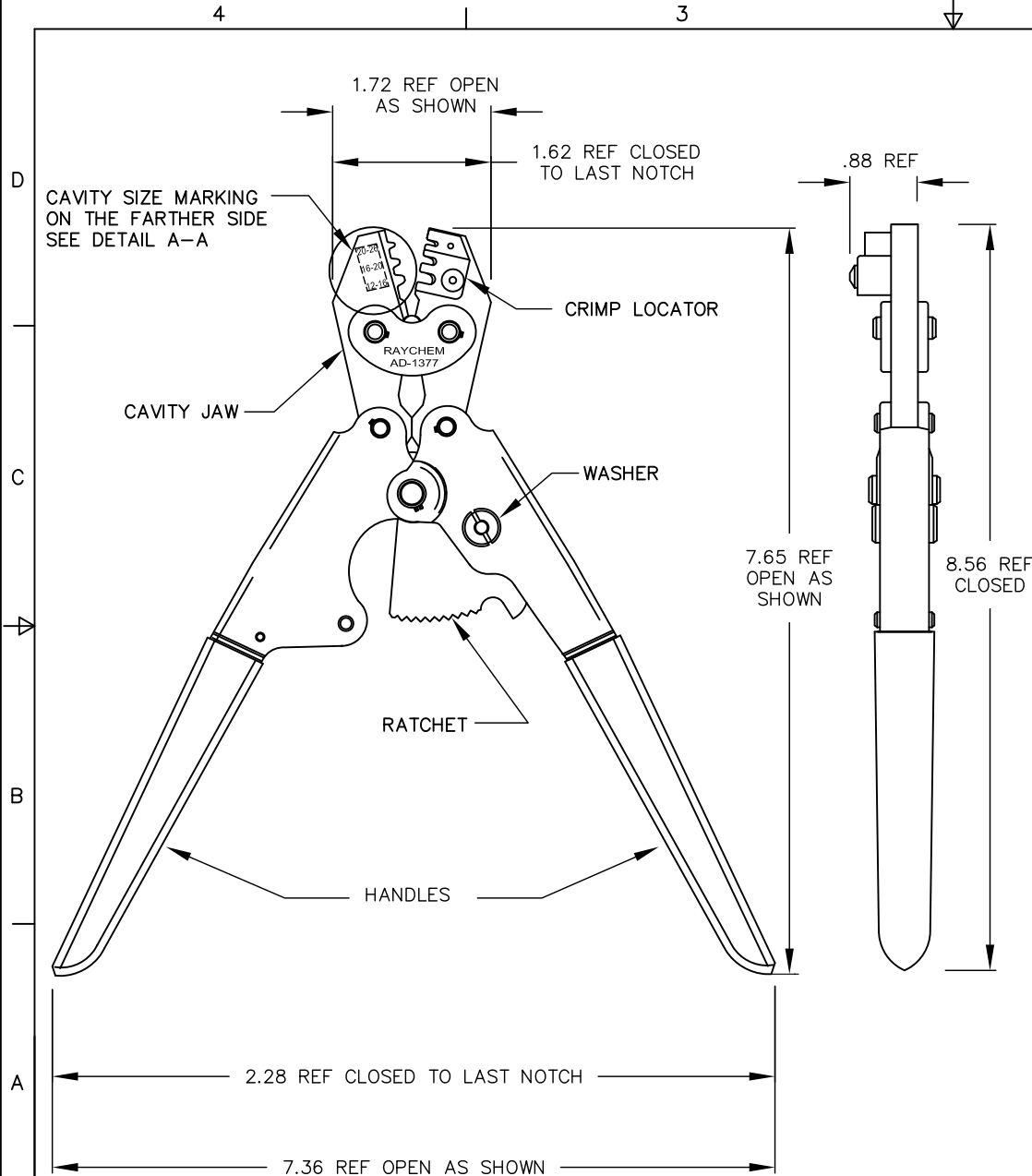
TOOL CAVITY	"GO"	"NO GO"
12 - 16	.062 DIA.	.072 DIA.
16 - 20	.042 DIA.	.052 DIA.
20 - 26	.025 DIA.	.035 DIA.

THE 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.	DRAWN UNGUYEN	TITLE AD-1377 CRIMP TOOL ASSEMBLY		
	PART NUMBER 992008-000			
THIRD ANGLE PROJECTION		SCALE: NTS		
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