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**1.25mm**

**CRIMP-TO-WIRE**

**HAND TOOL P/N: 10118041-1000**

**FCI MANUAL P/N 10118041-9090**



*Figure 1*

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## **Operation**

### ***Wire Stripping***

Make sure stripped length of the wire is in the range of 1.4 to 1.90 mm.

Be careful not to make cuts or nicks in the strands during the stripping operation.

The use of improperly prepared wire may cause insufficient crimp performance.

### ***Terminal Loading***

- (1) First verifying that the carrier strip is cut off from the left side of the first terminal being inserted, slide the pre-cut terminal strip beneath the terminal guide cover, positioning the strip such that the insulation tines of the terminal are under the cover and the conductor tines are on the outside of the cover.
- (2) You will notice that the terminal is located in the proper crimping area of the tooling when the “ball-detent” feature of the tool restricts the removal of the strip.



*Figure 2*

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### ***Crimping Procedure***

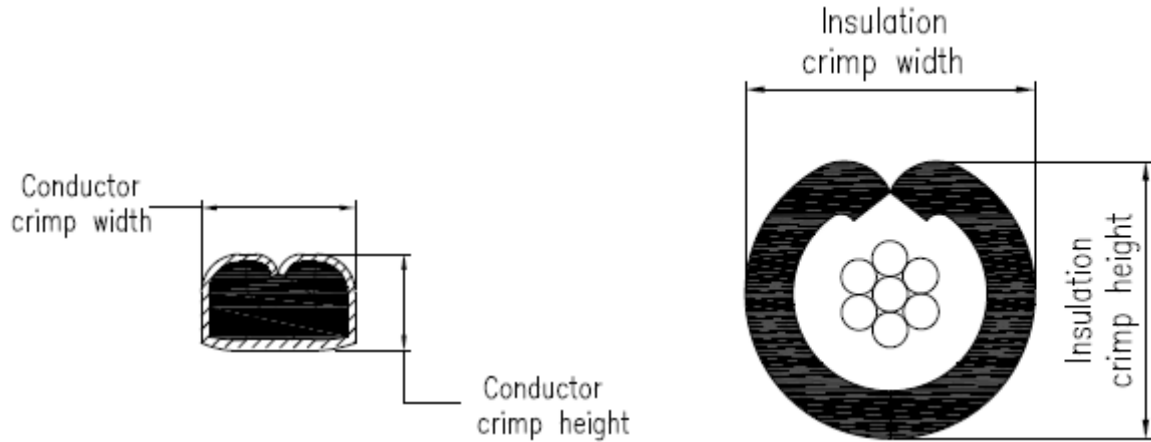
- (1) Hold the handles with the tool positioned as shown in **Figure 2**, facing the operator. Feed terminals one at a time (pre-cut strips) into the crimping area of hand-tool through terminal guide (see Figure 3) by hand.
- (2) Close the handles completely until ratchet releases to open handles.
- (3) Straighten wire before placing in hand-tool. Insert the stripped end of the wire into wire barrel of terminal.
- (4) Close handles with wire held in crimping area until ratchet releases. In order to obtain the appropriate crimp condition, this hand-tool is provided with a ratchet mechanism. Close the handle fully to reach the proper crimp condition and allow for opening of the hand tool.
- (5) Remove terminal after crimping.
- (6) Lightly oil every third to fourth wire and insulation terminal barrels using terminal lubrication (IE Stoner E805).



*FIGURE 3*

**FRONT VIEW OF HAND TOOL TO ILLUSTRATE TERMINAL LOADING**

TERMINAL PART NUMBER	WIRE SIZE		INSULATION DIAMETER		INSULATION STRIP LENGTH	
	mm <sup>2</sup>	AWG	mm	Inch	mm	Inch
10114827-001LF	0.08 - 0.03	28 - 32	1.00 Max	.039" Max	1.40 - 1.90	.055" - .075"
10114827-002LF	0.08 - 0.03	28 - 32	1.00 Max	.039" Max	1.40 - 1.90	.055" - .075"



TERMINAL PART NUMBER	CONDUCTOR CRIMP WIDTH		CONDUCTOR CRIMP HEIGHT		INSULATION CRIMP HEIGHT	
	mm	Inch	mm	Inch	mm	Inch
10114827-001LF	0.82 Ref.	.032" Ref.	0.55 +/1 0.04	.0215" +/- .0015	0.90 Ref.	.035" Ref.
10114827-002LF	0.82 Ref.	.032" Ref.	0.55 +/1 0.04	.0215" +/- .0015	0.90 Ref.	.035" Ref.