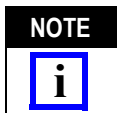


SPARE WIRE CAP	WIRE		CRIMPING TOOL	
	SIZE RANGE (AWG)	STRIP LENGTH RANGE	PART NUMBER	INSTRUCTION SHEET
328307 (Red)	22-16	7.94-8.73 [ <sup>5</sup> / <sub>16</sub> - <sup>11</sup> / <sub>32</sub> ]	47386	408-1559
			47386-2	
			59170	408-1610
			59250	
328308 (Blue)	16-14	7.94-8.73 [ <sup>5</sup> / <sub>16</sub> - <sup>11</sup> / <sub>32</sub> ]	47387	408-1559
			47387-2	
			59170	408-1610
			59250	
328309 (Yellow)	12-10	8.73-9.52 [ <sup>11</sup> / <sub>32</sub> - <sup>3</sup> / <sub>8</sub> ]	59239-4	408-1261

Figure 1

### 1. INTRODUCTION

This instruction sheet covers crimping the spare wire caps onto the wire sizes listed in Figure 1.



*Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.*

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.

### 2. DESCRIPTION

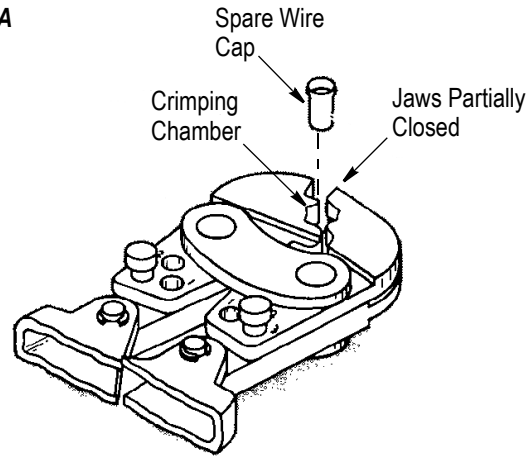
Each spare wire cap consists of a wire barrel and a sleeve encased in insulating material. The insulation is color coded to correspond with a specific wire size range. See Figure 1.

### 3. CRIMPING PROCEDURE

- Strip the wire to the dimension indicated in Figure 1.
- Place the tool insulation adjustment pins in the appropriate position as indicated:
  - Tools 47386, 47386-2, 47387, 47387-2, and 59239-4 — No. 3
  - Tools 59170 and 59250 — No. 4
- Close the tool handles until the jaws or dies partially close, but leave enough space for the spare wire cap to be inserted into the crimping chamber. Refer to Detail A of Figure 2, Figure 3, or Figure 4.

Tools 47386, 47386-2, 47387, and 47387-2

Detail A



Detail B

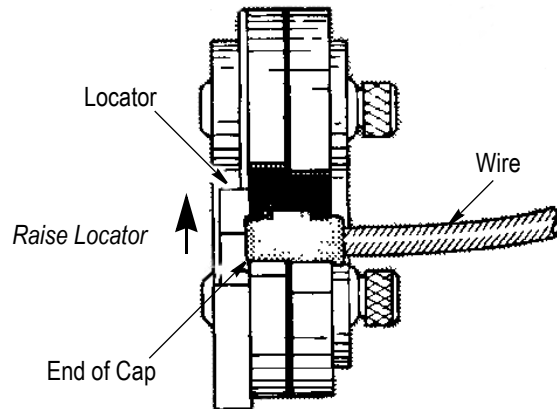


Figure 2

- Place the wire barrel of the cap in the crimping chamber as shown in Detail A of Figure 2, Figure 3, or Figure 4. Then, proceed with the following:

Tools 47386, 47386-2, 47387, and 47387-2

Raise the locator so that the end of the cap rests against the recessed surface of the locator. Refer to Detail B of Figure 2.

Tools 59170 and 59250

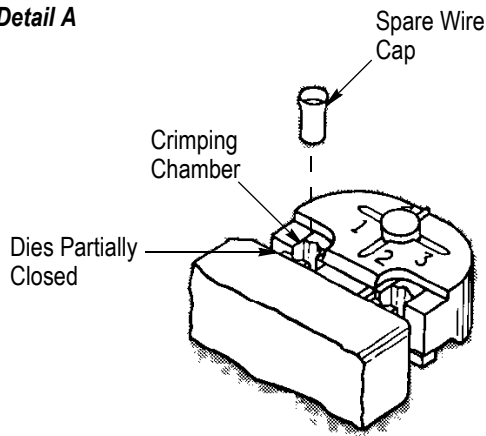
- Raise the locator so that the end of the cap rests against the recessed surface of the locator. Refer to Detail B of Figure 3.
- Squeeze the quick take-up trigger.

Tool 59239-4

Press the locator down so that the end of the cap rests against the recessed surface of the locator. Refer to Detail B of Figure 4.

Tools 59170 and 59250

Detail A



Detail B

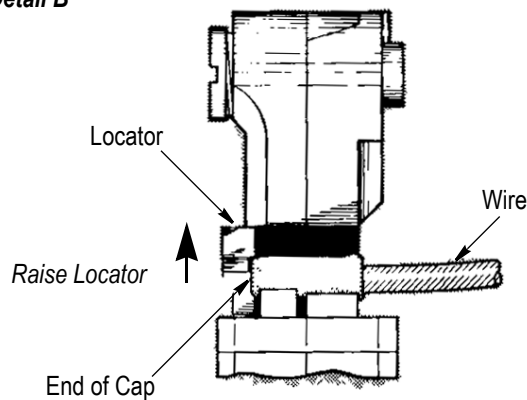
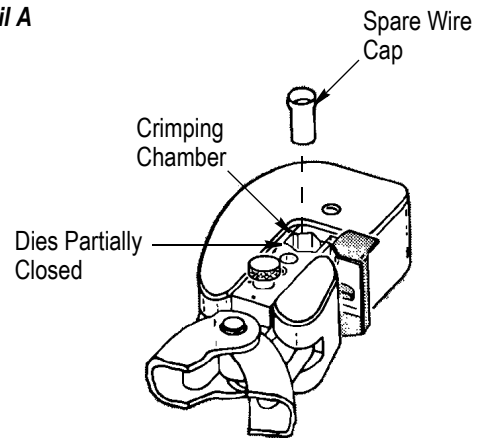


Figure 3

Tool 59239-4

Detail A



Detail B

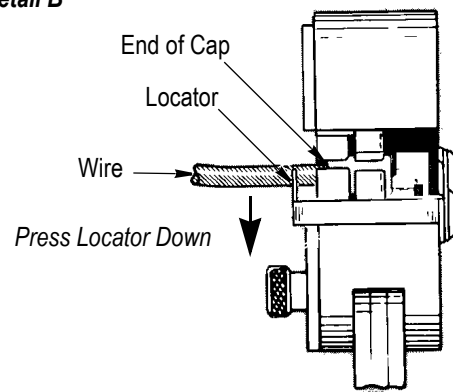
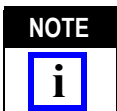


Figure 4

5. Close the tool handles until the cap is held firmly in place. DO NOT deform the wire barrel.
6. Insert the stripped wire into the wire barrel of the cap until it bottoms.
7. Hold the wire in position, and close the tool handles until the ratchet releases. The handles will open automatically.
8. Remove the crimped cap, and inspect the crimp.



For detailed crimp inspection requirements, refer to Application Specification 114-2157.

#### 4. REPLACEMENT AND REPAIR

Do not use damaged or defective spare wire caps. If damage is evident, cut the wire from the spare wire cap and replaced it with a new one.

Do not re-terminate or re-use a spare wire cap by removing the wire.

#### 5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Added color codes to Figure 1
- Added NOTE to Step 5 of Section 3
- Added Sections 2 and 4