

4. Wire Stripping

Make sure stripped length of the wire is in the range of 1.2 to 2.5mm.

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 obtained.

5. Crimping procedure

- (1) Hold handles with the stamp of wire size (shown in Figure 2) faced an operator to release ratchet to open them.
- (2) Feed terminals by one pitch (cut to proper length) into the crimping area of handtool through terminal guide (see Figure 3) by hand.
- (3) Insert stripped wire into wire barrel of terminal as shown in Figure 3. It is preferable that the above insertion is done after wire conductors are straightened.
- (4) Close handles with wire held in crimping area until ratchet releases.
This hand tool is provided with a ratchet mechanism on its handles in order to obtain an appropriate crimp condition close the handles until ratchet releases to open handles.
- (5) Remove terminal after complete of crimping.

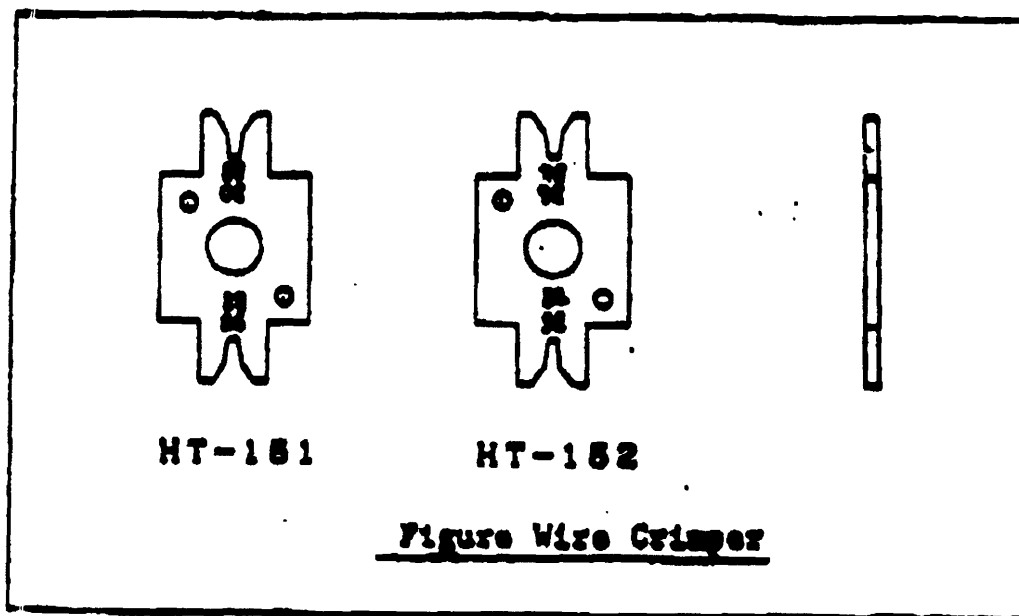
3. Terminal and Applicable Wire Range

HT-151 is used to crimp the terminal with wires consisting of conductor ranging from 0.05 to 0.13mm² (AWG 30-26) and insulation of 1.4mm Max diameter in nominal size. HT-152 is used to crimp the terminal with wires having conductor from 0.01 to 0.03 mm² (AWG #36-32) and insulation of 0.6mm Max diameter.

The crimping conditions of each hand tool are as shown in Table-1.

The crimper of this hand tool has two crimping areas. Each of which is applicable to a different range of wire. The crimper can be easily changed by pulling off the adjust rod shown in Figure 1.

Figure 2 shows the crimpers removed from the hand tool.



The crimper has marks showing AWG wire size applicable each crimping area. Refer to the above marks and Table-1 including Terminal P/N, Applicable wire size and insulation diameter, when crimping.

Crimp Spec

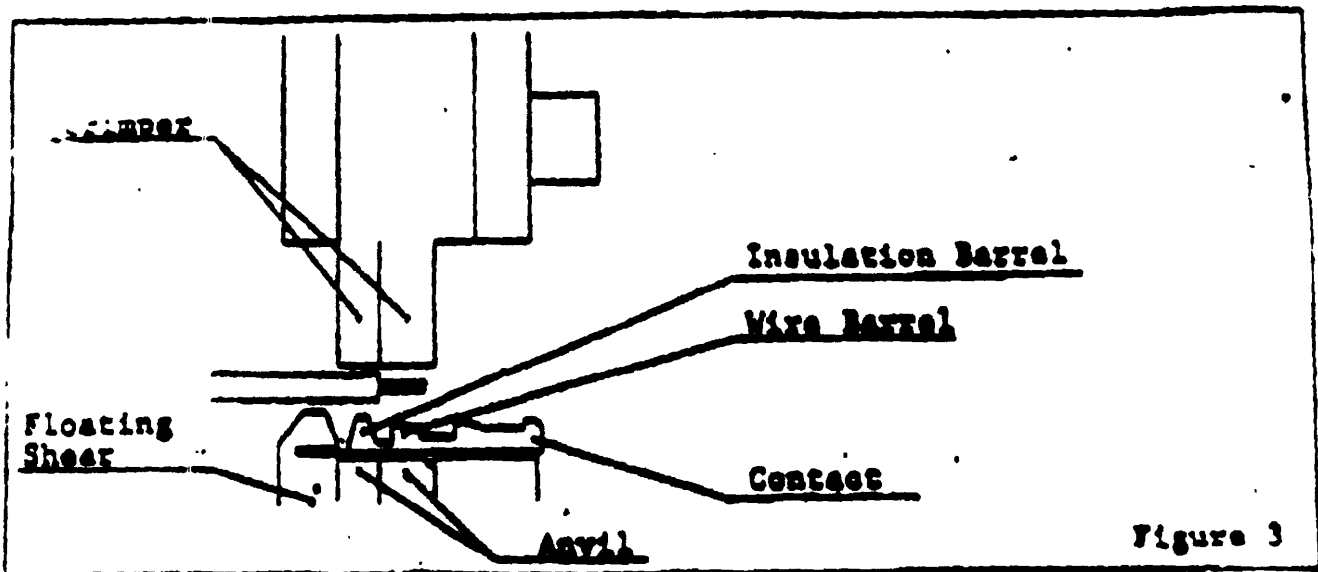
Table-1

Terminal	Hand Tool	Wire Range AWG#	Wire Barrel Height mm	Ins. Barrel Height mm
77138-001	HT-151	26 ~ 28	0.60-0.65	1.4 MAX
		28 ~ 30	0.67-0.62	
100-81171	HT-152	32 ~ 34	0.43-0.48	1.25 Ref.

6. Maintenance and Precaution

In order to assure that continued use of the handtool can be made under the proper conditions, pay attention to the following.

- (1) Don't throw nor use tool in place of hammer.
- (2) Periodically lubricate bearing surfaces.
- (3) After use of handtool, wipe the tool, particularly crimping area to prevent it from rust, scratch or dent. on the other hand, keep handles closed to prevent crimping area from dirt when the handtool is not in use.



3. Crimp Conditions

The wires specified by UL-1007 (AWG #26 - #30) and UL-2851 (AWG #32 - #36) or equivalent wires shall be crimped in accordance with the following conditions in Table 1 and Table 2.

3.1 Crimp Conditions-Semi-automatic Crimping Machine

Table 1

Terminal P/N	Applicator P/N	Wire Gauge AWG (mm ²)	Wire Barrel		Ins. Barrel		Crimp Strength (Kg)
			Width (mm)	Height (mm)	Width (mm)	Height (mm)	
77138-001	901-026 901-034	#26 (0.13)	1.0	0.63 - 0.68	1.5 MAX.	1.4 MAX.	2.0 MIN.
		#28 (0.08)		0.60 - 0.65			1.2 MIN.
		#30 (0.05)		0.57 - 0.62			0.7 MIN.
77139-001	901-027 901-035	#32 (0.03)	0.75	0.44 - 0.49	1.0	1.35 REF.	0.2 MIN.
		#34 (0.02)		0.43 - 0.48			0.2 MIN.
		#36 (0.01)		0.42 - 0.47			0.15 MIN.

3.2 Crimp Conditions - Manual Crimping Tool

Table 2

Terminal P/N	Hand Tool P/N	Wire Gauge AWG (mm ²)	Wire Barrel		Ins. Barrel		Crimp Strength (Kg)
			Width (mm)	Height (mm)	Width (mm)	Height (mm)	
77138-001	MT-148	#26 - #28 (0.13-0.08)	1.0	0.60 - 0.65	1.5	1.4	1.2 MIN.
		#28 - #30 (0.08-0.05)		0.57 - 0.62			MAX.
77139-001	MT-149	#32 - #34 (0.03-0.02)	0.75	0.43 - 0.48	1.0	1.35	0.2 MIN.
		#34 - #36 (0.02-0.01)		0.42 - 0.47			REF.

NO:	REV.
100-006	C

4. Requirements (See Fig. 1)

No.	Item	Requirement
①	Bend Up	3° MAX.
	Bend Down	3° MAX.
	Twist	3° MAX.
	Rolling	8° MAX.
②	Bell Mouth	0.1 - 0.4 mm
③	Cut-off Tab Length	0 - 0.3 mm
④	Exceeded Conductor Length	0 - 0.8 mm
⑤	Seam	No evidence of seam opening. No strands exist out of wire barrel.
	Wire Strip Length (REF.)	1.2 - 2.2 mm

.0305 - .056

NO:	REV
100-006	C

MINITEK

1. Scope

This specification is intended to cover the crimp conditions and requirements for MINITEK terminals.

Terminal P/N	Wire Range		Ins. Dia.
	AWG	mm ²	
77138-001	#26 - #30	0.13 - 0.05	∅ 1.4 MAX.
77139-001	#32 - #36	0.03 - 0.01	∅ 0.6 MAX.

2. Part Name

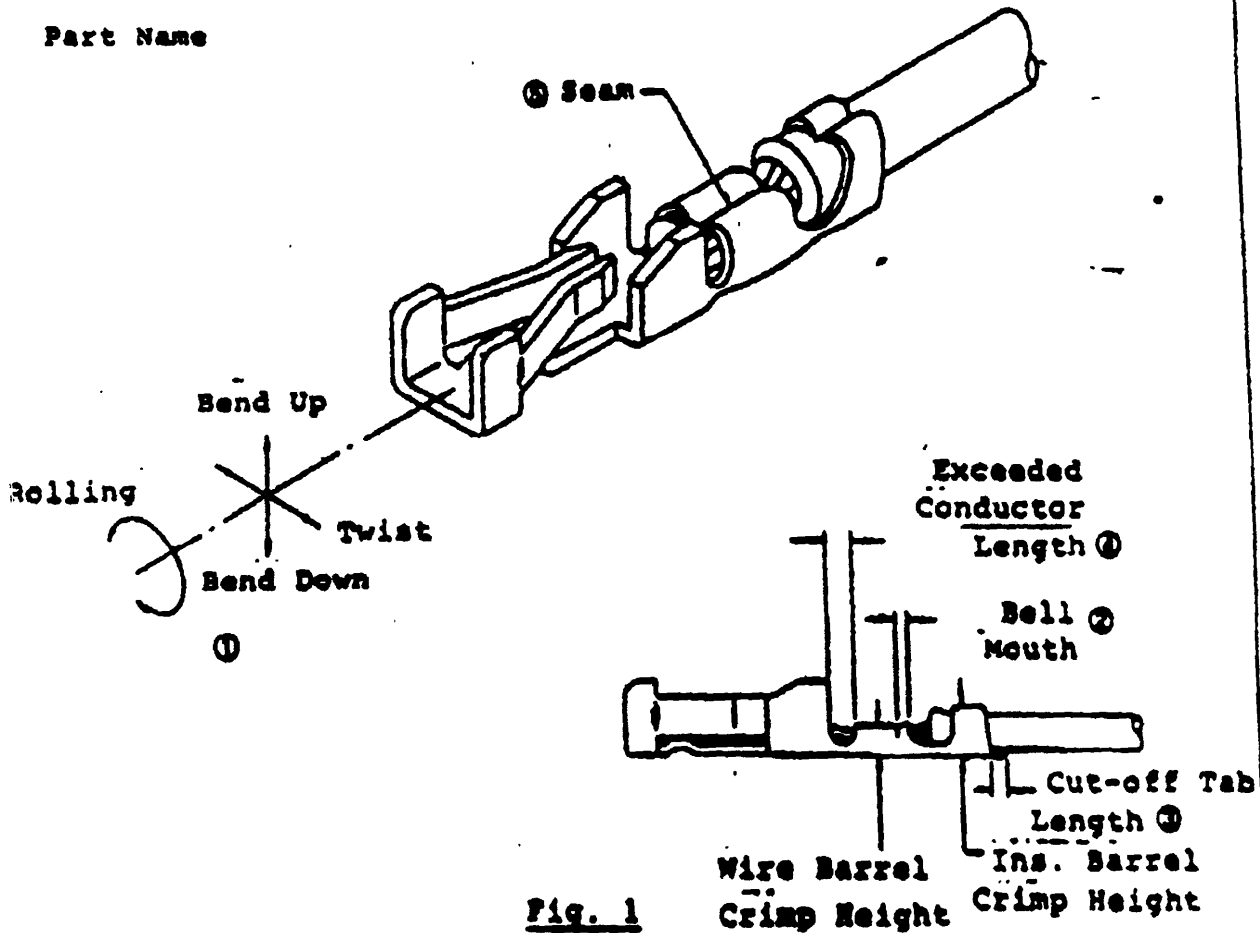


Fig. 1

				PREP'D BY: 9-3-86	NO:	REV.
				DES'D BY: <i>[Signature]</i>		
C	RELEASED	9/3/86		APPR'D BY: 9 9/3 9-3-86	100-006	C
REV.	CONTENTS	DATE	BY			

DCS-001 REV.0

Instruction Manual
for
MINITEK Hand Tool
HT-151, HT-152

Date: 6/22/87
Rev.: A

1. Instruction

This instruction manual covers application and maintenance for HT-151 and HT-152 designed for strip version of MINITEK Terminal.
Please read these instructions throughly before using the Hand Tool.

2. Part Name

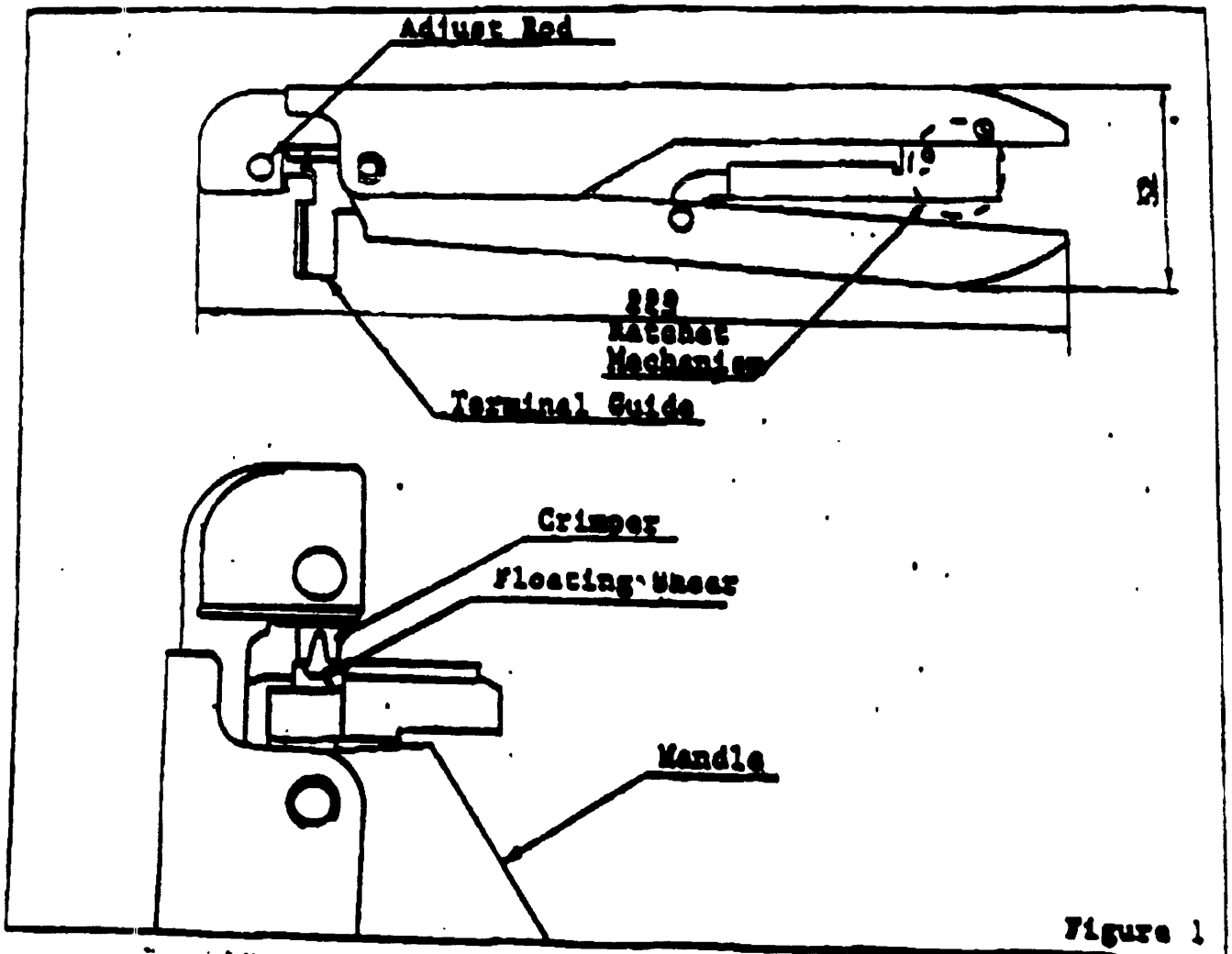


Figure 1