



EDGE PERFORMANCE

EP917/918 Ti

**CHASSIS CONNECTIONS
INSTRUCTIONS**

■ Crimping with the HDT-48-00 Hand Tool



Note
Tool must be adjusted for each type/size of contact.



Step 1:

1. Strip insulation from wire.
2. Raise selector knob and rotate until arrow is aligned with wire size to be crimped.
3. Loosen locknut, turn adjusting screw in until it stops.



Step 2:

1. Insert contact with barrel up. Turn adjusting screw counterclockwise until contact is flush with indenter cover. Tighten locknut.



Step 3:

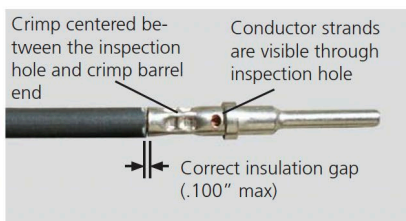
1. Insert wire into contact. Contact must be centered between indentors. Close handles until crimp cycle is completed.
2. Release handles and remove crimped contact.

■ Benefits of Crimping

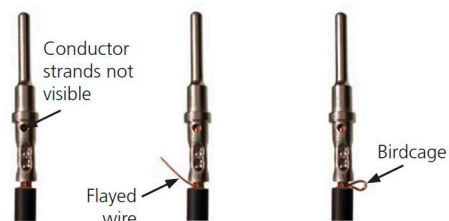
Mechanically crimping contacts is the dominant wire termination method, for some very good reasons:

1. Since no wet process is involved, corrosion is not a problem. No adhesive, flux, or additives are used.
2. Strength, accuracy and overall reliability of a crimped contact are controlled by the crimp tool, not the operator. The field tools (except size 4 solid style) release the contact only after the full crimping cycle is completed.
3. The crimp tool is universal, accepts both pins and sockets of many sizes.
4. Crimping can be done anywhere, without special preparation. Terminations are replaced or modified in the field exactly the same as in the shop, using the same tools and the same techniques, and with the same ease of operation and certainty of results.
5. Total installed and maintenance costs are lower.

■ Solid Contact Crimp Inspection



Acceptable Crimp



Unacceptable Crimps

■ Contact Insertion



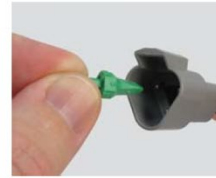
Step 1:
Grasp crimped contact approximately one inch behind the contact barrel.



Step 2:
Hold connector with rear grommet facing you.



Step 3:
Push contact straight into connector grommet until a click is felt. A slight tug will confirm that it is properly locked in place.



Step 4:
Once all contacts are in place, insert green wedge. The green wedge will snap into place.

■ Contact Removal



Step 1:
Remove green wedge using needle-nose pliers to pull wedge straight out.



Step 2:
To remove the contacts, gently pull wire backwards, while at the same time releasing the locking finger by moving it away from the contact with a screwdriver.



Step 3:
Hold the rear seal in place, as removing the contact will displace the seal.

Note

The receptacle is shown, use the same procedure for the plug.

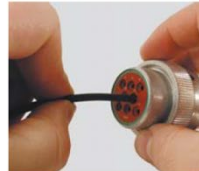
■ Contact Insertion



Step 1:
Grasp contact approximately one inch behind the contact crimp barrel.

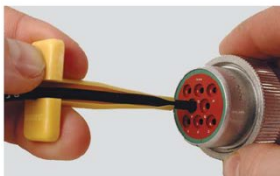


Step 2:
Hold connector with rear grommet facing you.

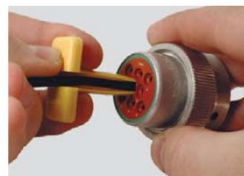


Step 3:
Push contact straight into connector grommet until a positive stop is felt. A slight tug will confirm that it is properly locked in place.

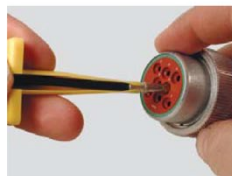
■ Contact Removal



Step 1:
With rear insert toward you, snap appropriate size removal tool over the wire of contact to be removed.



Step 2:
Slide tool along the wire into the insert cavity until it engages contact and resistance is felt.



Step 3:
Pull contact wire assembly out of connector.

Note

Do not twist or insert tool at an angle.