

INSTRUCTION SHEET - T-11 OPEN BARREL CRIMP TOOL

This five cavity, two jaw tool is designed to crimp a wide variety of open barrel contacts including pins, sockets, spring, box and slide-on type.

The tool has five "F" nests for crimping the conductor and insulation portion of open barrel contacts.



Conductor
Crimp

"F" CRIMP



Insulation
Crimp

"F" CRIMP

NEST
DESIGNATION

C
D
E

WIRE
RANGE

14-16 A.W.G.
18-20 A.W.G.
22-24 A.W.G.

NEST
DESIGNATION

A
B

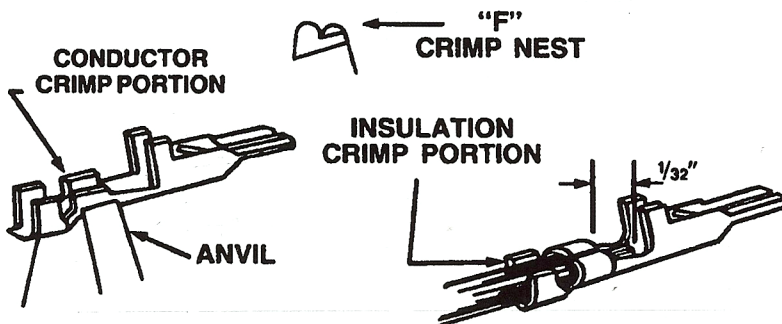
WIRE
RANGE

14-18 A.W.G.
20-24 A.W.G.

- Select the nest to be used by determining wire size, crimp appearance and tensile pull-out values for A.W.G. sizes listed below:

A.W.G.	PULL-OUT/LBS.
14	50
16	30
18	20
20	13
22	8
24	5

- Align contact centrally on anvil as shown in illustration. Crimp conductor portion first.
- Close tool carefully until contact is held in place without distorting ears. Insert stripped wire allowing it to protrude about $\frac{1}{32}$ " past conductor ears. Squeeze handles to complete crimp.
- Select proper "F" crimp and proceed to crimp the insulation portion of contact.



NOTE: Nests may not be suitable for certain contacts due to the wide range of material thicknesses, length of ears and design variations.