2- and 3-Wire Tel-Splice Connectors (Loose-Piece)

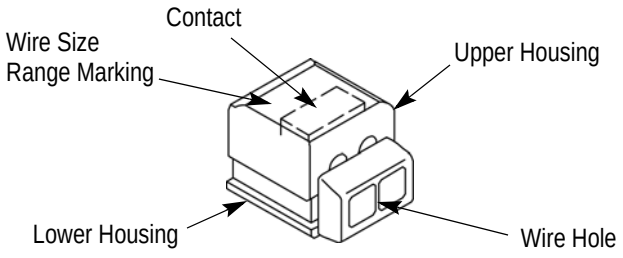

Figure 1

1. INTRODUCTION

These instructions cover domestic, international, and flame retardant (sealed and unsealed) 2-wire (for example, part numbers 552795-[ ] and 553395-[ ]), shown in Figure 1, and 3-wire (for example, part numbers 552678-[ ] and 553759-[ ]) loose-piece Tel-Splice connectors. The connectors terminate wires by using the insulation displacement technique.

NOTE

Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

PRO-CRIMPER* III Hand Tool Assembly 58610-1 (instruction sheet 408-4235) or Economy Hand Tool 231839-1 (408-3183) can be used to terminate these connectors.

NOTE

Industry-standard tools having parallel-action jaws can be used to terminate these connectors; however, as with any tool used, the terminated connector must be gaged periodically to ensure proper wire insertion depth.

Crimp Height Gage 230495-1 (included with the connectors) is used to check the crimp height (wire insertion depth) of the connector after termination.

NOTE

For detailed application requirements for the connectors, refer to Application Specification 114-6010.

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

2. DESCRIPTION

These connectors will accept any combination of solid copper wire sizes 26 through 19 AWG with an insulation diameter range of 0.51 through 2.0 mm [.020 through .080 in.]. Wire insulation must be filled, foam skin, or air core plastic for domestic and international connectors and paper pulp or air core plastic for flame retardant connectors.

Attached to the upper housing is a U-shaped contact or two blades. The lower housing contains 2 or 3 wire holes or a wire hole and a wire slot. Each hole or slot accepts only one wire. The contact has 4 or 6 wire contact slots-2 for each wire. The lower housing contains a wire stuffer which forces the wires into the contact slots when the housings are pressed together for termination.

3. TERMINATING PROCEDURE

Make sure that the wire size matches the wire size marking on the connector being terminated, and proceed as follows:

1. Cut the wires evenly to length; except for 2-wire half-tap connectors, cut the tap wire to length and leave the through wire uncut (wires must not be stripped).

2. Insert the wires into the wire holes until the wires bottom in the lower housing (refer to Figure 2, Detail A); except for half-tap connectors, insert the wires into the wire hole and wire slot making sure that the through wire is fully contained in the wire slot and extends past the housing (see Figure 2, Detail B).

3. Press the upper housing and lower housing together for pre-crimp, and hold the wires in place.

4. Position the connector in the tool according to the instructions packaged with the tool.

5. Holding the wires in place, actuate the tool.

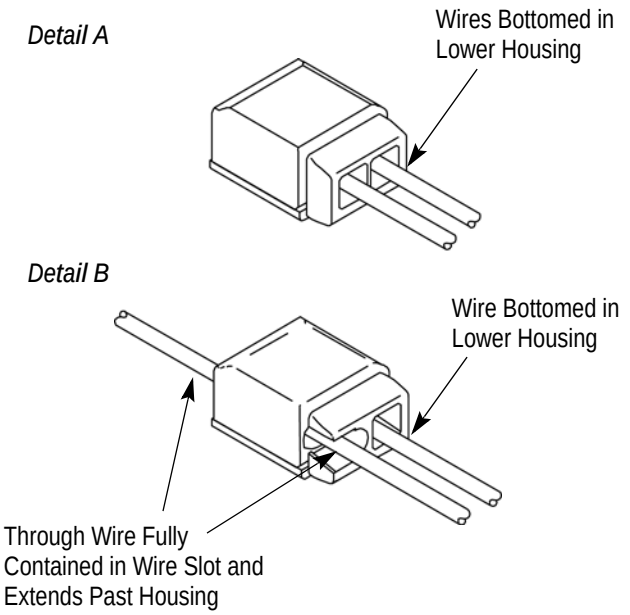

Figure 2

6. Refer to Figure 3 and using the gage, check the crimp height of the connector as follows:

a. Slide the connector into the gage slot marked with the wire size used. Make sure that the contact is aligned with the gage members.

b. Slide the gage off of the connector. If the connector slides off easily with little or no drag, the connector is properly terminated. If the connector sticks in the gage, the connector is not properly terminated.

NOTE

If the connector sticks in the gage, terminate and gage a few sample connectors. If the sample connectors also stick in the gage, re-terminate the connectors with another hand tool. If these connectors still stick in the gage, replace the connectors.

4. REPLACEMENT AND REPAIR

The connectors are not repairable. DO NOT use damaged connectors or connectors that are improperly terminated. DO NOT re-use terminated connectors by removing the wires.

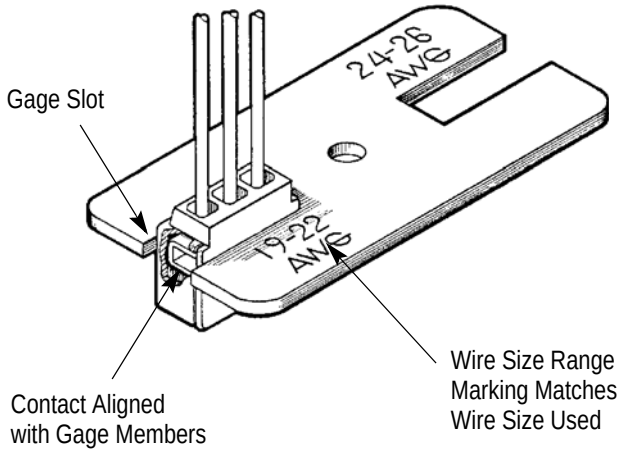

Figure 3

5. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements