

TYCO Crimp Hand Tool Guide

Version 2.00

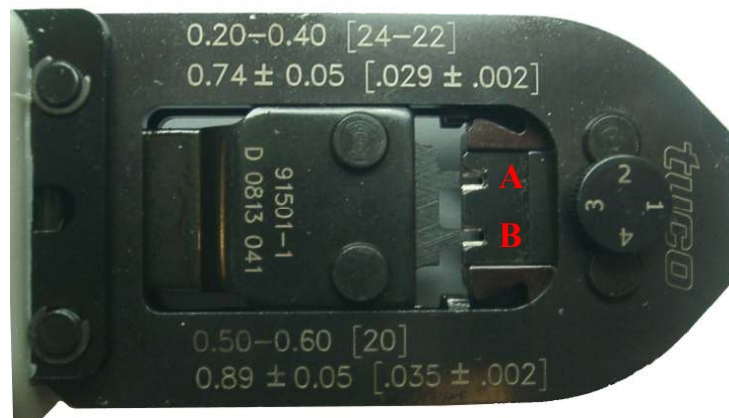


Introduction

This document describes in detail how to use the TYCO Crimp hand tool to make receptacle for the MX2 Series.

Limitations

Wire Size, A:	0.2 to 0.40 mm ²
Wire Size, B:	0.5 to 0.60 mm ²
Insulation Diameter:	2.0 mm (max)
Strip Length:	3.0 to 3.2 mm



Step-by-Step

1. Prepare the wire by removing 3mm of insulation, see Figure 1.

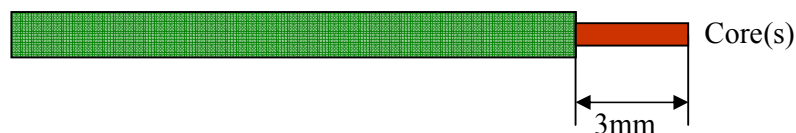


Figure 1 – Isolation removal.

2. Place a crimp contact in the TYCO tool as shown on Figure 2 and 3.



Figure 2 – Front view of crimp contact placement.



Figure 3 – Back view of crimp contact placement.

3. Press the handles carefully together until the tool locks, usually two clicks.

4. Place the prepared wire into the crimp contact, make sure that the isolation is inside the tools “jaws” as shown on Figure 4.

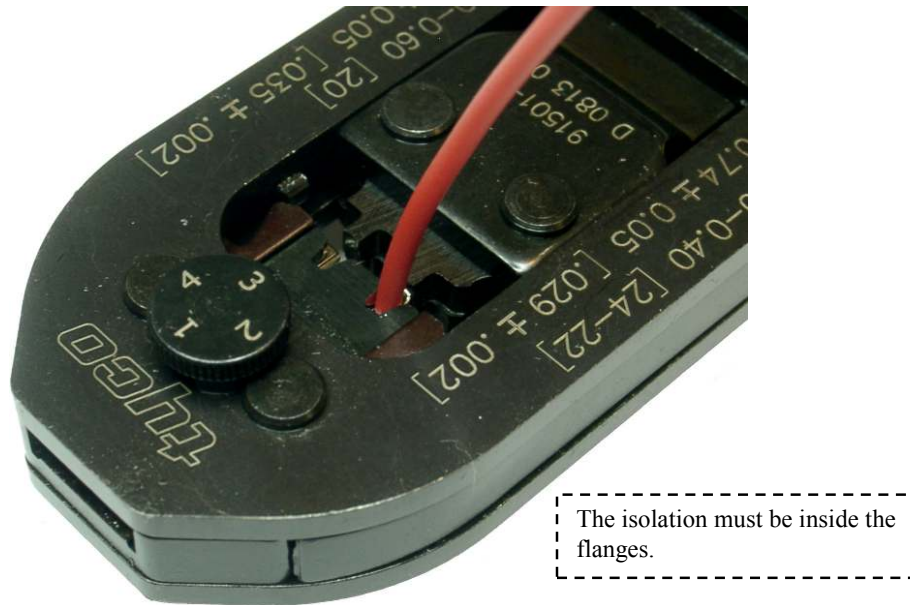


Figure 4 – Crimp contact with wire inserted.

5. Push the handles together to crimp the wire, the tool will release when the contact has been crimped, Figure 5 shows a correct crimped contact.



Figure 5 – Correct crimped contact.

- When the needed numbers of wires are made, simply insert the wires into the receptacle as shown in Figure 6.

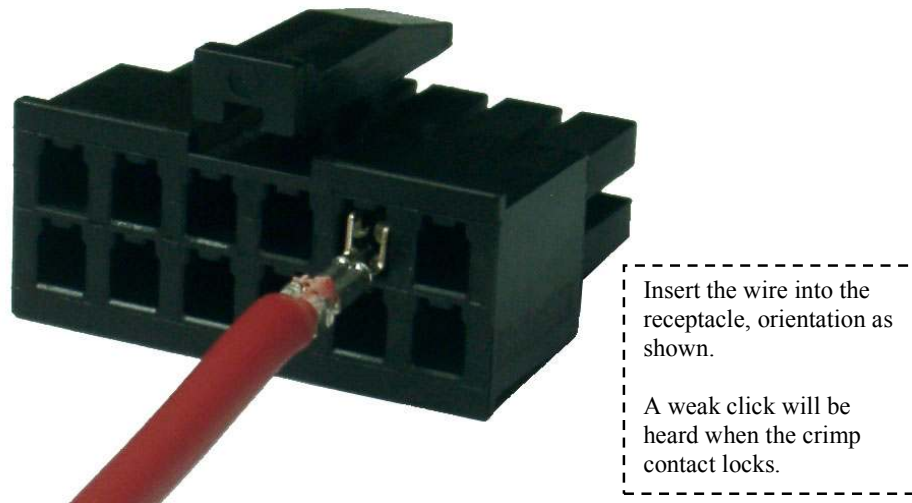


Figure 6 – Receptacle insertion.

- The cable is now finished.

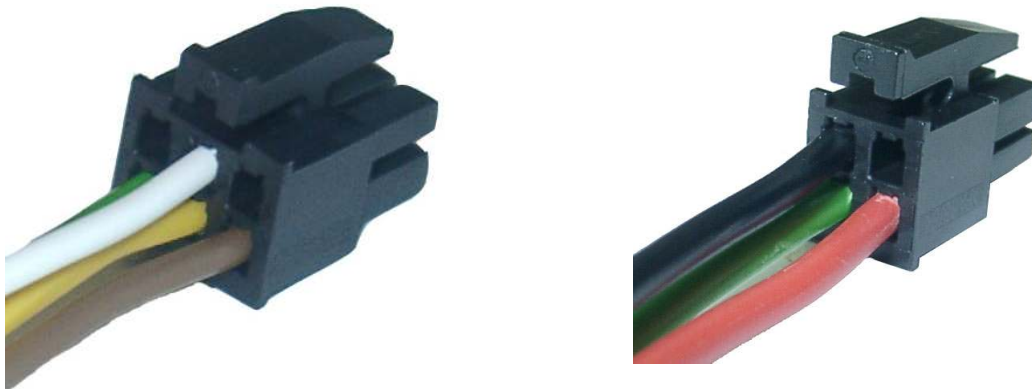


Figure 7 – Correct assembled receptacles.

Ordering information

- 4 pins connector house for the PWR connector.
 - Ordering code: **RT-O-TYCO-H4** (10pcs.)
 - TYCO p/n: 794617-4
- 6 pins connector house for the SER1 connector.
 - Ordering code: **RT-O-TYCO-H6** (10pcs.)
 - TYCO p/n: 794617-6
- 12 pins connector house for the COM connector.
 - Ordering code: **RT-O-TYCO-H12** (10pcs.)
 - TYCO p/n: 1-794617-2
- 16 pins connector house for the I/O connector.
 - Ordering code: **RT-O-TYCO-H16** (10pcs.)
 - TYCO p/n: 1-794617-6
- Crimp contacts
 - Ordering code: **RT-O-TYCO-CR** (100pcs.)
 - TYCO p/n: 794606-1
- Original TYCO Crimp hand tool for fast & easy crimp assembly.
 - Ordering code: **RT-O-TYCO-TOOL**
 - TYCO p/n: 91501-1

Additional

- Extraction Tool
 - Ordering code: RS: 495-9704, Farnell: 1111477
 - TYCO p/n: 843996-6