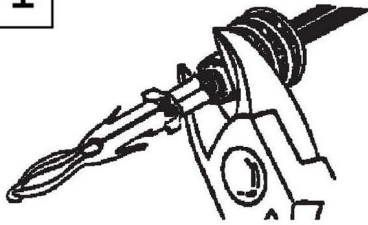


Sealed Weather Pack and Metri-Pack Terminal Replacement

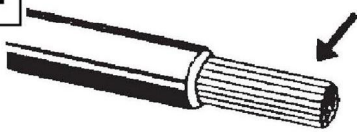
1



Cut off terminal between core and insulation crimp.

(Minimize wire length loss)

2



CAUTION: Do not cut strands

Strip Insulation—Refer to terminal/cable illustration below for strip length guide.

3



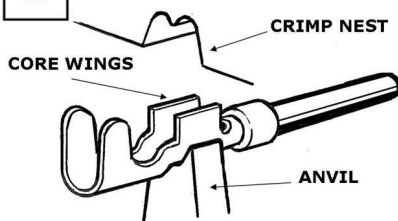
Apply correct seal per wire gauge size. Slide back seal to enable removal of insulation

4



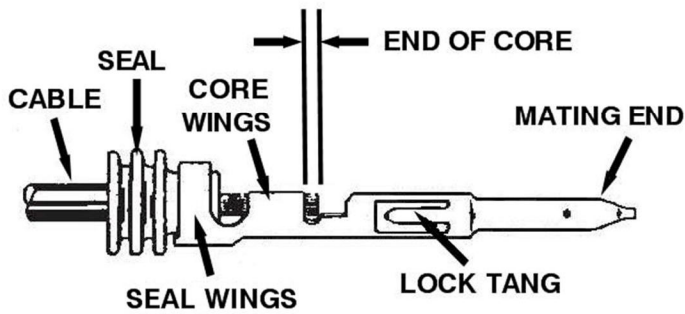
Align seal with wire insulation

5



Core wings should be crimped first. Select the appropriate tool and appropriate cavity. (See tool matrix) Lay the back of the terminal core wings on the appropriate tool anvil. Be sure the core wings are pointing towards the crimp nest.

Gently apply pressure to tool handles until crimper jaws slightly secure terminal core wings.



6 Position wire in terminal as shown.
 Caution: Do not position wire too far forward because it may interfere with mating end.

Wire "end of core" strand length = $0.50\text{mm} \pm 0.25\text{ mm}$ ($3/16'' \pm 1/16''$)

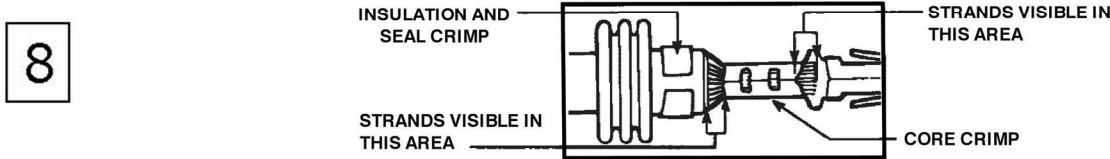
Compress handles until jaws butt at the tip. Check for loose strands out of the core crimp or strands extending beyond the side plane of the terminal. Remove any loose or extending strands.

7 Lay the back of the terminal seal wings on and appropriate anvil. Be sure the seal wings are pointing towards the forming jaws. Compress handles until jaws butt at the tip.

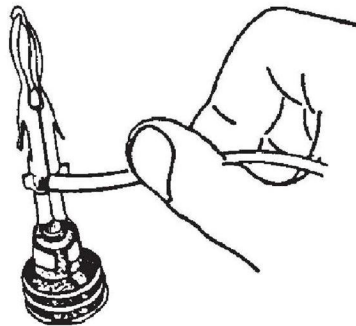
Quality Check—Terminal Straightness

Inspect terminal for damage prior to applying solder. If terminal appears bent after crimping, it should be gently straightened by hand.

The crimped terminal must slide easily into the connector housing and not drag against the side walls.



8



Solder all terminals except .100 and .64 terminals. Soldering will destroy small terminals.

CAUTION: Use extreme care on all micro-pack and 150 metri-pack terminals. Avoid solder on interface or box areas.

Electronically check repaired terminal for continuity. Make sure terminal is replaced in correct connector cavity to assure proper indexing.

This manual shows only the minimum required information based on general use and production conditions.

Use this manual for reference only.