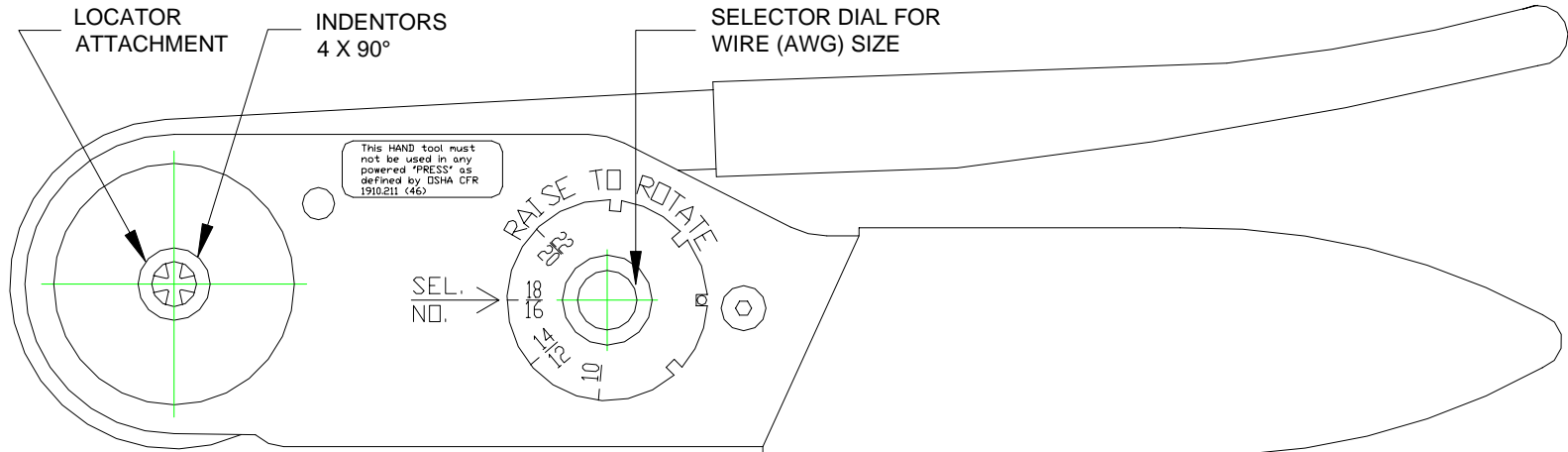
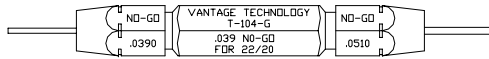


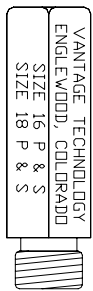
# Instructions for T-104-CT-K Crimp Tool Kit



**T-104-TO  
CRIMP TOOL**



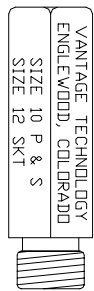
**T-104-G GAGE**



T-104-16/18



T-104-12M



T-104-10/12

**LOCATORS**

**Table 1. Tool Kit Components**

Part Number	Description
T-104-TO	Crimp tool only.
T-104-10/12	Locator for number 10 pin & socket and number 12 socket only.
T-104-16/18	Locator for number 16 & 18 contacts.
T-104-12M	Locator for number 12 pins only.
T-104-G	No-go gage to check indenter closure dimensions.
T104CTK-PB	Plastic bottle (3 ea, not shown), empty.

**APPLICATION:**

THE T-104-CT-K IS DESIGNED FOR USE IN TERMINATION OF VARIOUS VANTAGE TECHNOLOGY CONNECTORS, IN CONTACT SIZES #10 THRU #18. CONSULT VANTAGE FOR COMPLETE INFORMATION REGARDING SUITABILITY OF THIS TOOL TO SPECIFIC CONNECTORS AND CONTACTS.

**USAGE:**

1. SELECT THE CORRECT LOCATOR TO ACCURATELY POSITION THE CRIMP ON THE CONTACT. SELECTION IS BASED ON THE CONTACT'S SIZE AND GENDER. REFERENCE TABLE 1. HAND TIGHTEN ONLY.
2. SELECT THE CORRECT CRIMP/ INDENTOR SETTING. THIS SELECTION IS BASED ON THE WIRE SIZE. THE CRIMP TOOL'S HANDLE MUST BE IN THE OPEN POSITION TO ROTATE THE SELECTOR KNOB.
3. STRIP WIRE INSULATION. SEE CONNECTOR ASSEMBLY INSTRUCTIONS FOR STRIP LENGTH. ASSEMBLE CONTACT AND WIRE. INSERT CONTACT ALL THE WAY INTO THE LOCATOR AND CRIMP. THIS "FULL CYCLE" TOOL CANNOT BE OPENED UNTIL THE CRIMP CYCLE IS COMPLETED.

**NOTES:**

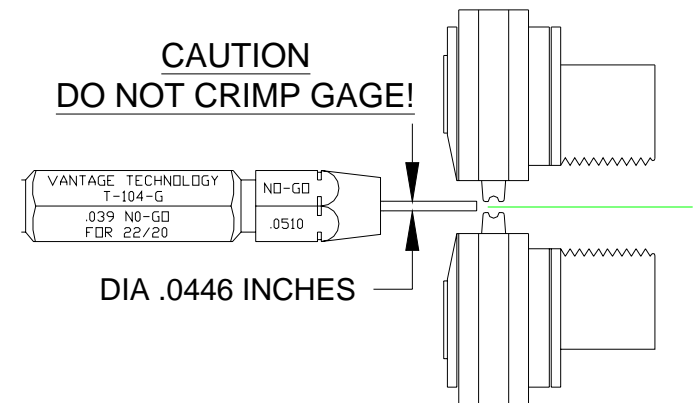
1. DURING USE, PERIODICALLY CHECK THAT THE LOCATOR IS SNUGGED UP TO TOOL.
2. TO ENSURE MINIMUM WIRE RETENTION FORCES ARE ACHIEVED (TABLE 2.), THE CRIMP TOOL SHOULD BE INSPECTED PRIOR TO EACH TERMINATION SESSION. FOLLOW THE INDENTOR CLOSURE INSPECTION PROCESS BELOW.

**TOOL INSPECTION:**

1. ROTATE THE SELECTOR KNOB TO 22/20. CLOSE HANDLES AND INSERT THE .039 NO-GO PIN AS SHOWN. (TABLE 3.) GAGE MUST NOT PASS BETWEEN INDENTOR TIPS. IF GAGE CAN PASS, THE TOOL IS OUT OF CALIBRATION.
2. ROTATE THE SELECTOR KNOB TO 16/18. CLOSE HANDLES AND INSERT THE .051 NO-GO PIN AS SHOWN. (TABLE 3.) GAGE MUST NOT PASS BETWEEN INDENTOR TIPS. IF GAGE CAN PASS, THE TOOL IS OUT OF CALIBRATION.

**Table 2. Crimped Contact Specification  
Min. Wire Retention Forces in lbs.**

Contact Size	Wire Size						
	10	12	14	16	18	20	22
10	180	110	70				
12		110	70	50			
16				50	38	19	
18					38	19	15



**Table 3. Indentor Closure with  
Tool Closed in Inches.**

Selector Setting	Go +/- .0001	No-Go +/- .0001
22/20	.034	.039
18/16	.044	.051

M-615-EC, 10/03