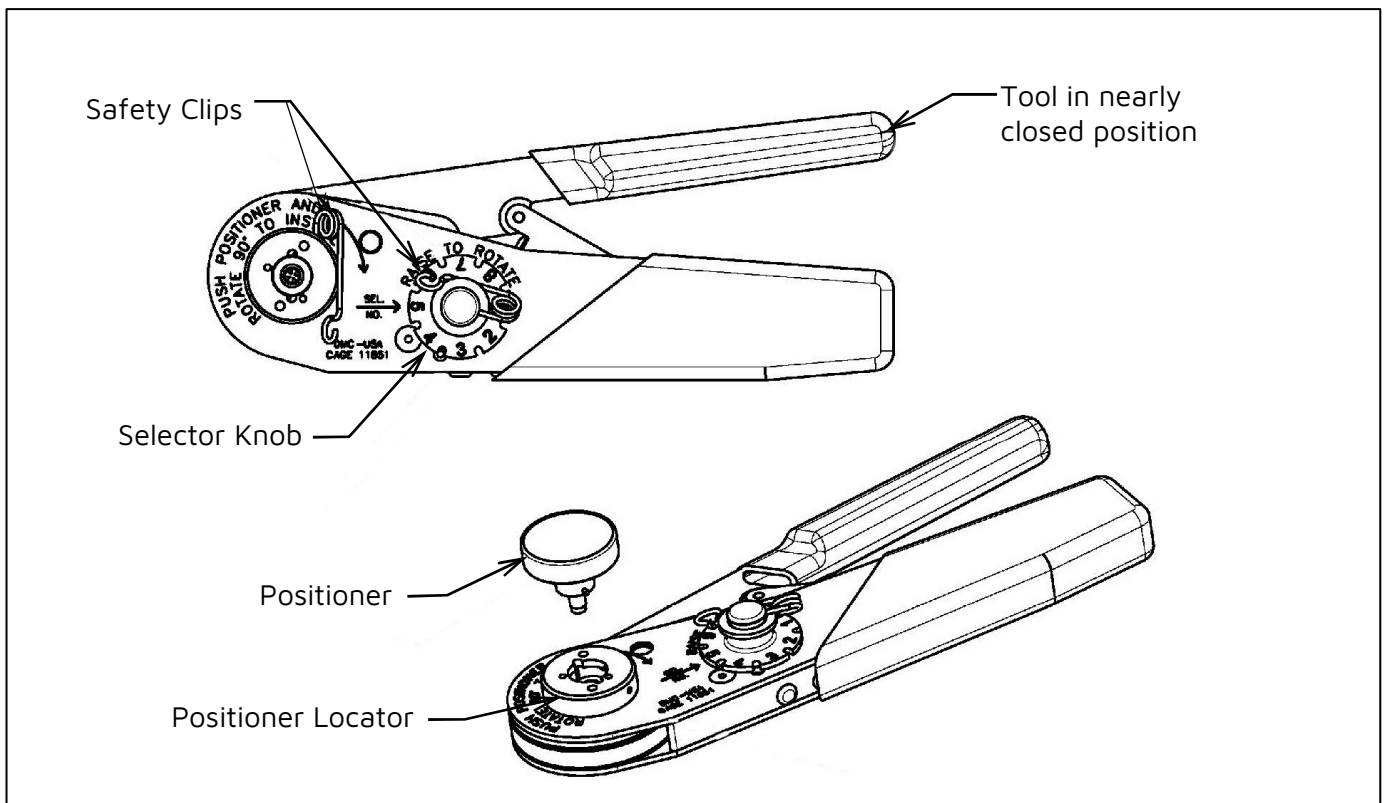


HARWIN

Instruction Sheet

IS-44

Gecko-MT Hand Crimp Tools Z125-903 & Z125-904



CRIMP CONTACT INFORMATION

This Hand Crimp Tool has been designed for use with the following Gecko-MT Power Crimp Contacts:

- G125-0500005 Female crimp contact for 18 AWG wire
- G125-1500005 Male crimp contact for 18 AWG wire

GENERAL INFORMATION

The Hand crimp tool Z125-903 consists of a basic hand tool, which should be used with a positioner.

The contact is correctly crimped when the tool is free to open at the fully closed position, i.e., when the ratchet releases. The tool cannot be opened without completing the cycle.

TOOL PREPARATION

1. Check that the tool is in the open position. Remove the safety clip from the positioner locator (do not discard).
2. Insert the Positioner into the positioner locator and turn it 90° in the direction shown on the tool, until the bayonet pins lock.
3. Install the safety clip back into the positioner locator (optional).
4. Check Table 1 for the correct crimp tool setting of the wire size you wish to crimp.
5. Remove the safety clip from the selector knob (do not discard).
6. Lift and turn the selector knob until the correct crimp tool setting is lined up with the "Sel. No." arrow. Lower the selector knob, ensuring the locating peg lines up with a notch.
7. Install the safety clip back into the selector knob.

CRIMPING PROCEDURE

1. Ensure that the wire to be crimped is within the specified range of sizes for the contact and the crimp tool. Failure to use the specified wire size will result in poor quality crimps and possible tool damage.

Contact	Wire Gauge (AWG)	Stranding (mm)	Crimp Tool Setting	Minimum pull-off force (N)
G125-05000XX	18	19/0.25	8	85
G125-15000XX				

Table 1 - Crimp Tool Settings and Forces

2. Cut the end of the cable to be terminated so that there is a clean cut end (Figure A). Strip the cable to the correct length (Figure B). We recommend that when the wire is stripped, it is clamped or supported close to the stripping area - this will prevent insulation slippage. Suitable wire strippers (such as a PTFE wire stripper) must be used. This should result in all the strands lying together neatly. If the lay of the strands is disturbed, it may be re-imposed with a slight twist.

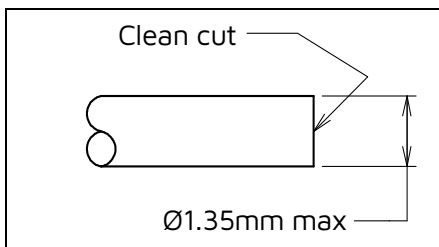


Figure A - Clean cut end

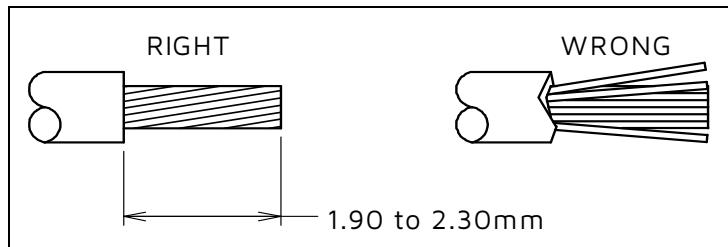


Figure B - Strip wire

3. Position the crimp contact fully into the positioner, with the crimp barrel uppermost.
4. Load the termination end of the cable into the crimp barrel of the socket. Ensure the wire is fully inserted, with all strands in place (see Figure C, contact may not be as shown).

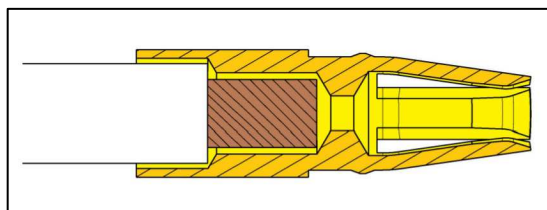


Figure C - Wire assembled to contact

Caution: Wear Nitrile/Latex powder free gloves or Finger cots when handling contacts to prevent hands from contaminating contacts.

5. Squeeze the handles of the crimp tool fully together, until the ratchet releases. The handle will return to the open position. Remove the crimped contact and wire. Crimp joints should be checked for:
 - a. Correct combination of cable, tool setting and crimp termination.
 - b. Correct form of indents and location of crimp.
 - c. Freedom of fracture, rough edges and flash.
 - d. Adequate insertion of all conductor strands in the crimp barrel.
 - e. Absence of damage to the conductor or the insulation.

ASSEMBLY PROCEDURE

Contacts are assembled to housings using the Assembly Tool Z125-905. See Instruction Sheet IS-47 for details on assembly.

**CARE OF TOOL**

There is virtually no maintenance required for the Z125-903 tool. However, it is good practice to keep the indenter tips free of debris. A small wire brush may be used for this purpose.

We strongly recommend that you:

- **DO NOT immerse tools in any cleaning solution.**
- **DO NOT spray oil into tool to lubricate.**
- **DO NOT attempt to disassemble tool or make repairs.**

This is a precision crimp tool and should be handled as such.

