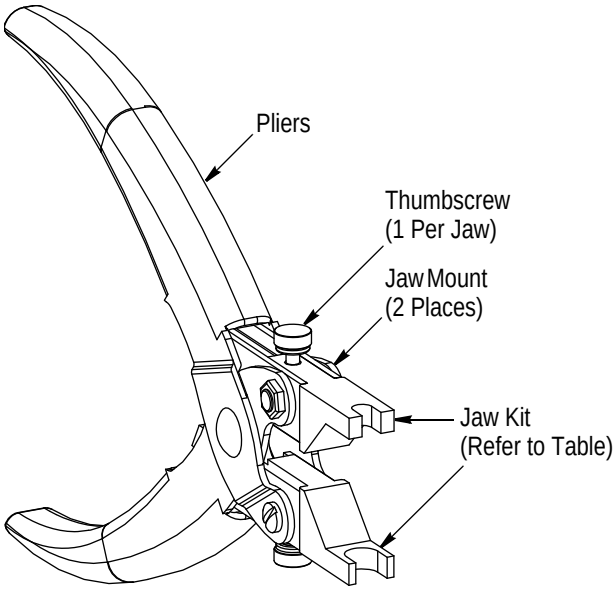
PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.



INSERTION TOOL	JAW KIT †	USED WITH
1976593-1	1976923-1	Standard Sockets 1445693-[ ]
		Boeing BACC47GB1 or BACC47GN1
1976593-2	1976923-2	Standard Pin 1445692-[ ]
		Boeing BACC47GA1 or BACC47GM1
1976593-3	1976923-3	Short Socket 2000032-1
1976593-4	1976923-4	Short Pin 2000031-1
1976593-5	All of the Above	All of the Above
1976593-6	1976923-1	Standard Socket 1445693-[ ]
		Boeing BACC47GB1 or BACC47GN1
	1976923-2	Standard Pin 1445692-[ ]
		Boeing BACC47GA1 or BACC47GM1
1976593-7	1976923-5	Long Pin 2000377-1
		Boeing BACC47GM1

† Included with Insertion Tool and Available Separately.

Figure 1

1. INTRODUCTION

Quadrax Ferrule Insertion Tools 1976593-[ ] are used to insert the ferrule into the shell of Quadrax pin and socket contacts. If used properly, the tool ensures proper insertion depth.

Boeing is a trademark.

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

2. DESCRIPTION (See Figure 1)

Each insertion tool consists of a pliers and a jaw kit except Tool -5 which includes four jaw kits (1976593-1 through -4). The jaw kit consists of a top jaw, bottom jaw, and two thumbscrews. The top jaw is designed to hold the cable and the bottom jaw is designed to hold the shell during insertion of the ferrule.

The jaws are interchangeable between the pliers (of the insertion tools) and the jaw mounts (of the pliers). The jaw kits are also available separately (part numbers are given in Figure 1).

3. JAW INSTALLATION AND REMOVAL

To install the jaws, proceed as follows:

1. Slide the top jaw onto either jaw mount of the pliers until it stops. Make sure that the thumbscrew faces outward. Tighten the thumbscrew.
2. Slide the bottom jaw onto the other jaw mount until it stops. Make sure that the thumbscrew faces outward. Tighten the thumbscrew.
3. Close the handles of the pliers until the jaws bottom. Check that the jaws align.

To remove a jaw, loosen the thumbscrew, and slide the jaw out of the jaw mount.

4. USING THE TOOL

NOTE

These instructions assume that the pin or socket contact is properly installed onto the cable.

Refer to Figure 2, and proceed as follows:

1. Fully open the handles of the pliers.
2. Position the shell of the contact in the bottom jaw so that the shoulder rests on the jaw.
3. Position the cable in the top jaw. Make sure that the cable is straight.
4. Close the handles until the jaws bottom. Fully open the handles, and pull the contact and cable from the jaws.

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DANGER

To avoid personal injury, DO NOT hold onto the cable or shell near the jaws when closing the handles. Keep fingers and objects clear of the jaws.

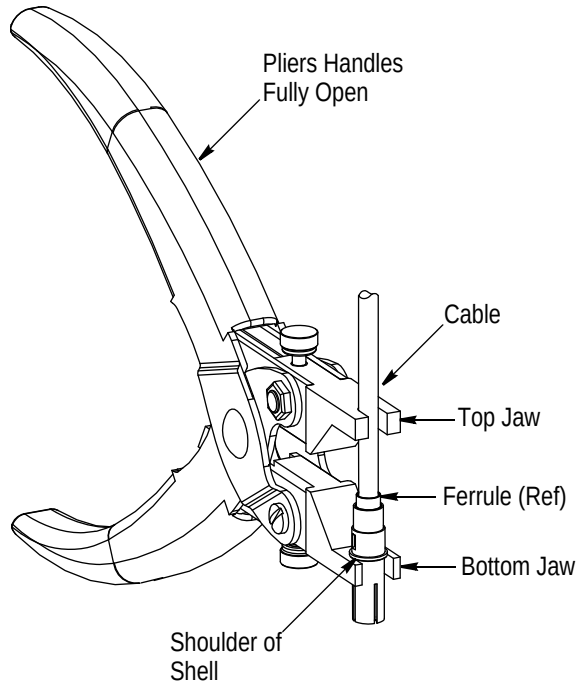


Figure 2

5. MAINTENANCE AND INSPECTION

5.1. Daily Maintenance

It is recommended that each operator be made aware of, and responsible for, the following steps of daily maintenance.

1. Remove dust, moisture, and contaminants with a clean, soft brush or a lint-free cloth. DO NOT use objects that could damage the insertion tool components.

2. Ensure that all components are in place and properly secured.

3. When the insertion tool is not in use, keep the handles closed to prevent objects from becoming lodged in the jaws. Store it in a clean, dry area.

5.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the insertion tool or be supplied to personnel responsible for the insertion tool.

6. REPLACEMENT AND REPAIR

The insertion tools are not repairable. Order insertion tools and jaw kits through your Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

7. REVISION SUMMARY

Revisions to this instruction sheet include:

- Added insertion tool and jaw kit to Figure 1
- Added jaw kit part numbers to Section 2
- Removed ORIGINAL INSTRUCTIONS