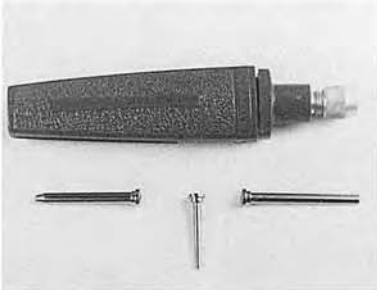


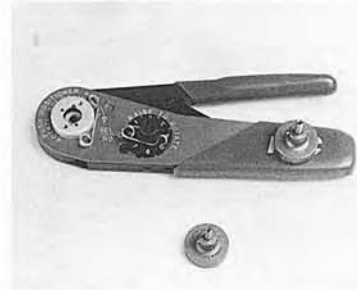
termination tooling for 17/117/220 series



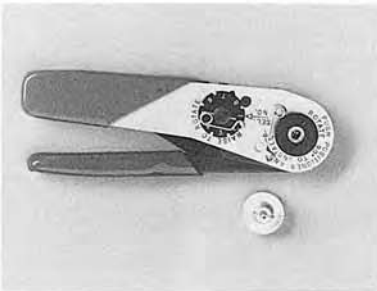
insertion tool
356-200 - tool handle only. Select correct insertion or removal bit from chart



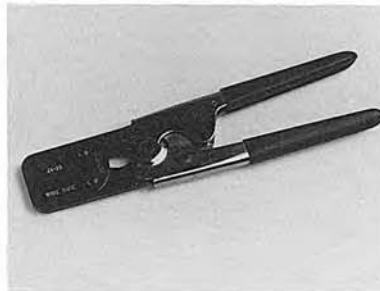
removal tool
356-271 - for 117/177/777 rear-release series - replaceable tips



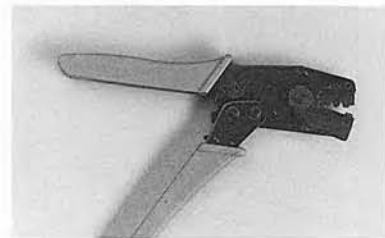
hand crimp tool
357-100 - adjustable, 4-indent miniature to MIL-C-22520. Requires contact locator bushing. For specific contact used, see section 15, page 3.



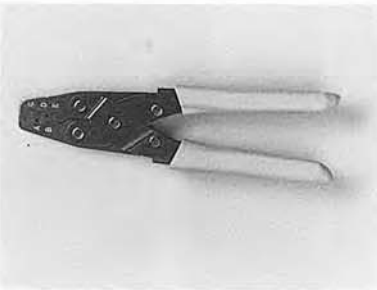
hand crimp tool for mini-tac contacts
357-101 - adjustable, 4-indent miniature to MIL-C-22520. Requires contact locator bushing. For specific contact used, see section 15, page 3.



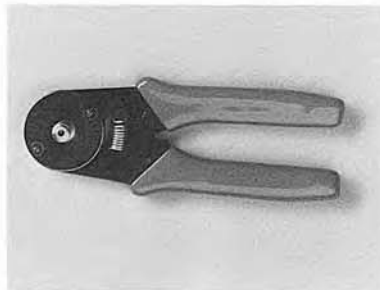
hand crimp tool
357-570 - used to crimp contacts - 220 stamped & formed



hand crimp tool
357-574 - Used to crimp contacts 17 - RRD_X - FXX, 17 - RRD_X - MXX 20-30 AWG wire.



hand crimp tool
357-2500 - economy tool for 117 rear-release contacts - ideal for occasional use

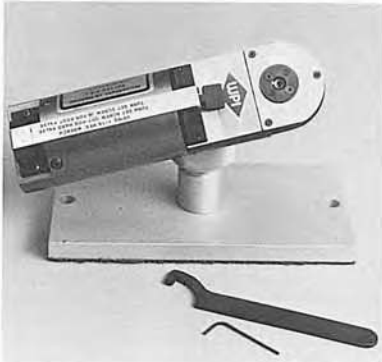


hand crimp tool
357-2501 - economy tool for 17 series - standard crimp contacts

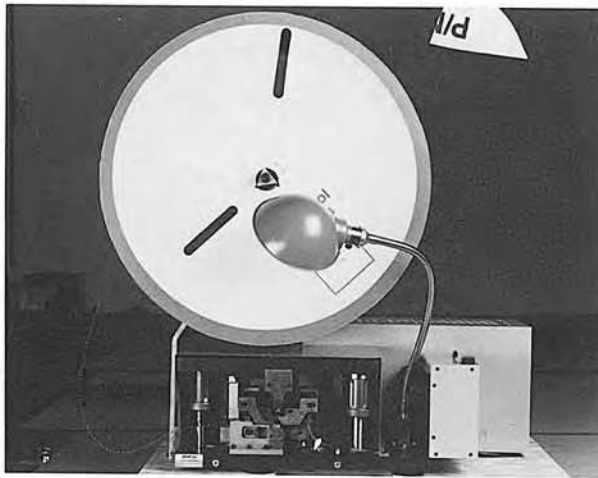
crimping procedure for 357-574 crimp tool

1. With locator side of tool facing downward, be sure that tool is completely open.
2. Place contact crimp barrel on correct anvil with open end facing toward crimper.
3. Properly locate contact by nesting slot in front of wire crimp barrel onto clip of locator. This should align both wire and insulation crimp barrels with their respective crimping jaws.
4. Slowly close handles until contact is locked into crimping die. Do not over-close.
5. Insert stripped wire to maximum depth. Be sure all strands of wire are inside barrel.
6. Close handles until ratchet disengages. Ratchet insures tool has completed crimp cycle and contact has been crimped before tool re-opens.

termination tooling

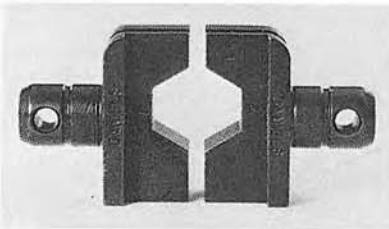


manual-feed pneumatic crimp tool 359-401 - 4-indent, cycle-controlled, less contact locator bushing. See chart for correct locator bushings and settings.

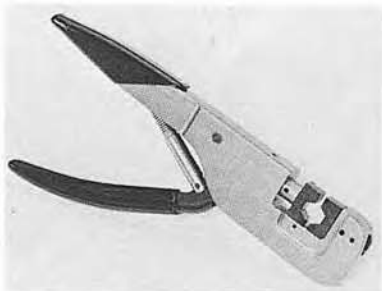


semi-automatic stripper/crimper machine 359-634 - strips and terminates discrete wire to open barrel, reel fed contacts. Used on stamped and formed 117 series contacts, auto-feed system maximizes production of crimp terminations of non-metallic insulated wire in ranges of #30-20 AWG. Termination rates can easily exceed 1500 wires per hour.

specifications
 crimping speed:
 up to 2,000 terminations per hour
 contacts:
 17 - RRD_X - FXX male and 17 - RRD_X
 - M02 female stamped and formed rear
 release contacts.
 wire size:
 20 to 24 guage AWG
 24 to 30 guage AWG
 dimensions:
 33" wide x 21" deep x 13½" high.
 weight:
 190 lbs (approx.)
 electrical requirements:
 110 VAC standard 3 wire grounded
 supply
 Meets all applicable OSHA standards.



crimp die 357-315-03
 hexagonal clamp die for use with hand crimp tool (357-115). For overmold can.



hand crimp tool 357-115
 economical hand tool, hexagonal ferrule crimp to cable and hood. Crimp die (357-315-03) purchased separately. For overmold can.



d-sub field service kit 17RR-232K
RS232 - assortment of connectors, backshells, contacts, & crimp tools - comparable to AMP model 606064-2



terminal & splice field service kit AI-177
 assortment of crimp-type terminals & splices, with hand-crimp tool

order information

NOTE: (Use 356-200 handles for insertion/removal bits)

Contact	Barrel O.D./I.D.	Crimp Tool	Bushing (Location)	Crimp Setting for Wire AWG.								Insertion Tool Bit	Removal Tool Bit
				16	18	20	22	24	26	28	30		
17-763(S) 17-766(P)	.007/.045	357-100	357-300-02			#7 .038 ±.003	#6 .034 ±.003	#5 .030 ±.003				356-400-1 or 356-400-10 (Encapsulated) Connector— to 20 Ga. Wire)	356-400-5 356-400-6
17-763(S) 17-766(P)	.007/.045	357-2501											356-400-5 356-400-6
17-764(S)	.062/.045	Solder										356-400-1	356-400-5
17-765(P)	.062/.045	Solder										356-400-1	356-400-6
17-767(P)	.062/.045	Solder										356-400-1	356-400-6
17-1005P	.106/.067	consult factory		.058 ±.003	.053 ±.003							356-400-2	356-400-6
17-1006(S)	.106/.067												356-400-5
17-1198(P)	.040 Tail	Rt. Angle										356-400-4	356-400-6
17-1207(P)	.040 Tail	Rt. Angle										356-400-4	356-400-6
17-1208(S)	.040 Tail	Rt. Angle										356-400-4	356-400-5
17-1209(S)	.040 Tail	Rt. Angle										356-400-4	356-400-5
17-1263(S)	.062/.045	Solder										356-400-1	356-400-5
17-1309(S)	.077/.032	357-100	357-300-02					#7 .036 ±.002	#6 .032 ±.002	#5 .030 ±.002		356-400-1	356-400-5
17-1310(P)	.077/.032												
17-RRD1-FXX 17-RRD1-MXX		357-574				Applicator for contacts on reels— adj. crimp setting						356-271	
		357-2500				.044 ±.011	.044 ±.001	.043 ±.001					356-400-31
17-RRD2-MXX 17-RRD2-FXX		357-574				Applicator for contacts on reels— adj. crimp setting						356-271	
		357-2500						.026 ±.001	.026 ±.001	.026 ±.001	.026 ±.001		356-400-31
220-S02(S)	.049/.031	357-100	357-300-01					.024 ± .002	.018 ± .002	.015 ± .002		356-400-11	356-400-14
220-P02(P)	.049/.031	357-100	357-300-08					.024 ± .002	.018 ± .002	.015 ± .002		356-400-11	356-400-15
220-S03(S)	.050/.036	357-100 357-104 357-110 359-400	357-300-03 357-304-03 357-310-03 359-340-05					.024 ± .002	.020 ± .002	.015 ± .002		356-400-11	356-400-14
220-P03(P)	.050/.036	357-100	357-300-08					.024 ± .002	.020 ± .002	.015 ± .002		356-400-11	356-400-15
220-830	—	Solder	—									356-400-11	356-400-15
220-831	—	Solder	—									356-400-11	356-400-14
220-834	—	Solder	—									356-400-11	356-400-15
220-883	—	Solder	—									356-400-11	356-400-15
221-759(P) 221-760(S)	.033/.023 .033/.023	357-101 357-101	357-301-03 357-301-03					.021/.018 .021/.018	.018/.015 .018/.015	.015/.012 .015/.012		356-400-20 356-400-20	356-400-21 356-400-22