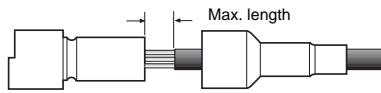


Assembly Instructions

Wire and Jacketed Cable Preparation



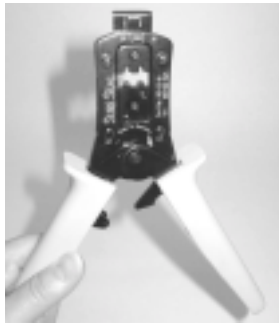
Strip wires to appropriate length (See contact chart on [page 6](#) for strip lengths). If using a boot, strip jacket so no more than listed dimension is exposed when contact is full inserted.

Note: Try stripping back jacket approximately **1.25 inches (32mm)** because strip lengths will vary depending on cable being used.

# Circuits	Max. exposed length Inches (mm)
2, 3, 4	.87 (22)
5, 6, 7	1.02 (26)
8, 9, 10	1.02 (26)

Sure Seal Hand Crimp Tool Operation Instructions

The Sure Seal hand crimp tool has a full cycle ratchet controlled release and straight action crimp jaws. The flap locator makes it easy to load the terminal and the pre-positioner assures that the terminal is loaded for proper crimping. To open the tool, you must apply force to the handles to allow the tool to spring open.



1. Open hand crimper by squeezing handles until handles spring open.



2. Open flap locator. Insert contact up to stop. Make sure contact is inserted properly.



3. Close flap locator.



4. Press pre-positioner downward firmly for contact alignment. (crimp area should be facing upward).



5. Pre-close the handles



6. (Above, left) Insert stripped* wire into contact up to insulation stop.



7. (Above, right) Squeeze handles until they pop open. Remove contact from locator.

Hand Tool Part Number	Contact Type	For Contacts		Wire Strip Length
		Pin	Socket	
SSI-CS10	Insulation Support	030-2196-001	031-1267-001	.155-.185 (4.0-4.7)
		030-2196-005	031-1267-006	
SS-CS10	Non-Insulation Support	030-2196-000	031-1267-000	.185-.220 (4.7-5.6)
		030-2196-008	031-1267-007	
MSS-CS10	Mini	330-8672-100	031-8703-100	.118-.130 (3.0-3.3)

Tool Maintenance: Maintenance and inspection should be performed regularly. The tool should be wiped clean with special emphasis on crimping cavities. The tool may be cleaned by immersing in a suitable commercial solvent or cleaner that does not attack paints or plastic material. The tool should be re-lubricated after cleaning using a light film of a medium weight oil on bearing surfaces and pivot pins. When not in use, keep handles closed to prevent objects from becoming lodged in the crimping dies. Store in a clean dry area.

Power Sure-Seal® Machined Contact Crimp Tool

400BHD



The SS400BHD is a pneumatically power heavy duty crimp tool designed for contacts that are too large to be crimped by hand tools. The 400BHD comes with a power unit and bench mounting bracket. The 400BHD is actuated with either the standard handle actuating switch or optional Pneumatic Foot Pedal (PFP). Crimp Die Kits are ordered separately [\(see page 7\)](#). It is highly recommended that you provide a sample of your wire when ordering these Crimp Die Kits. Your wire sample will be crimped and tested for proper crimp tensile strength.

Power Requirements: 90-125 PSI 1-2 CFM of dry, oil free, air

Operating Instructions: (Call for operating instructions)