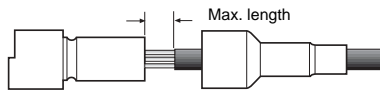


# Assembly Instructions

## Wire and Jacketed Cable Preparation



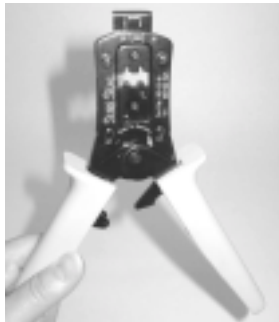
Strip wires to appropriate length (See contact chart on [page 6](#) for strip lengths). If using a boot, strip jacket so no more than listed dimension is exposed when contact is full inserted.

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	030-2196-001 030-2196-005	031-1267-001 031-1267-006	.155-.185 (4.0-4.7)
SS-CS10	Non-Insulation Support	030-2196-000 030-2196-008	031-1267-000 031-1267-007	.185-.220 (4.7-5.6)
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)