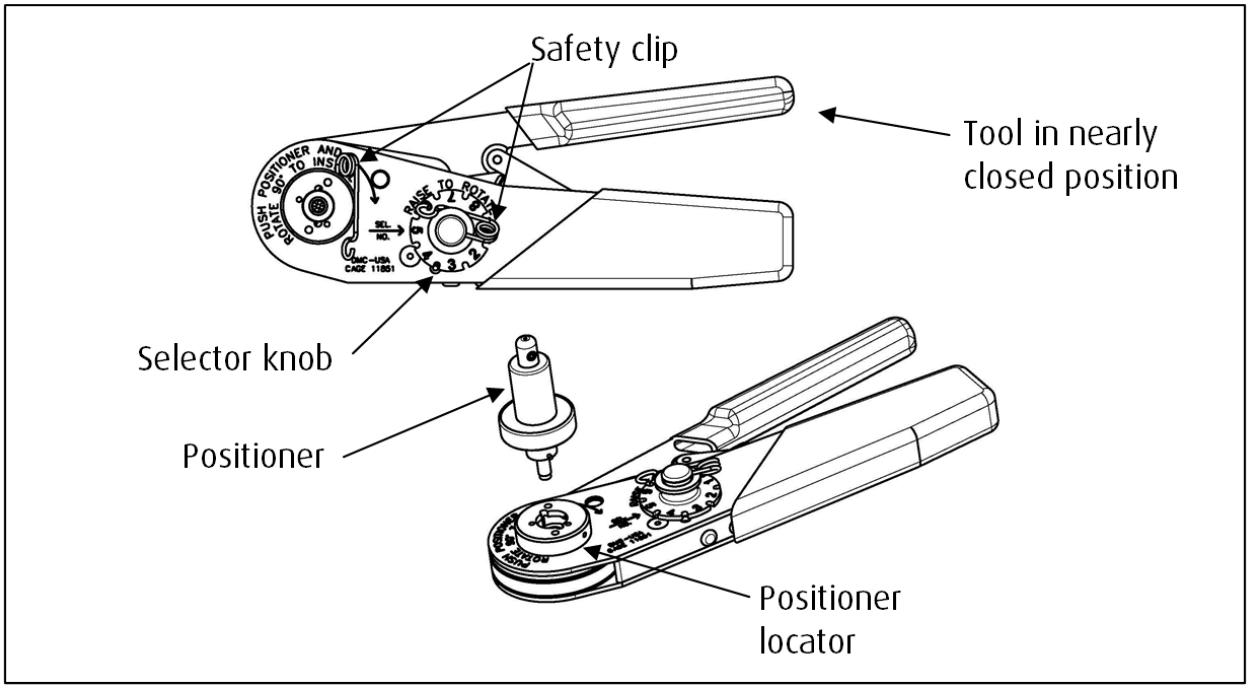
GECKO HAND CRIMP TOOL Z125-900 (MH-999)



This Hand Crimp Tool has been designed for use with the following Gecko Crimp Contacts (when used with Positioner Z125-901 (k1860SE)):

G125-00100XX ..... Large bore Female crimp contact for 26 AWG wire
G125-00200XX..... Small bore Female crimp contact for 28-32 AWG wire
G125-10100XX ..... Large bore Male crimp contact for 26 AWG wire
G125-10200XX ..... Small bore Male crimp contact for 28-32 AWG wire

General Information

The Hand crimp tool Z125-900 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.

Table 1

Contact	Crimp Type	Wire Gauge (AWG)	Stranding (mm)	Crimp Tool Setting	Minimum pull-off force
G125-00100XX G125-10100XX	Large Bore	26	7/0.15	6	18N
G125-00200XX G125-10200XX	Small Bore	28	7/0.12	5	12.5N
		30	1/0.25	5	7N
		32	7/0.08	5	4N

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) using a PTFE Wire stripper, preferably with adjustable rotating cutter. 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.

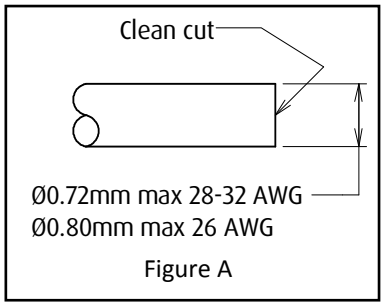


Figure A

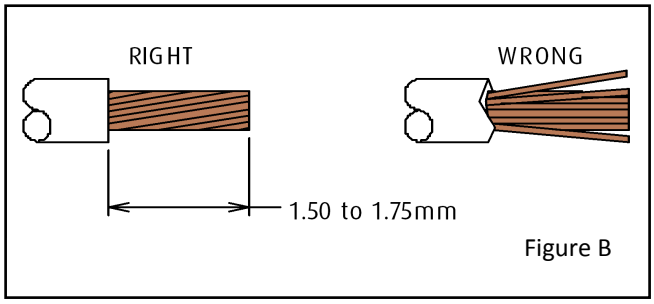


Figure B

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

3. Load the terminated 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).

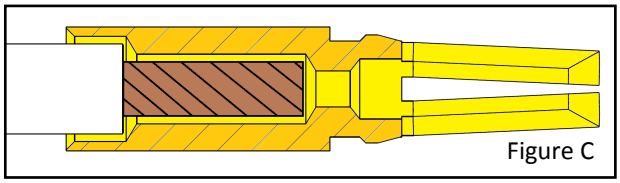
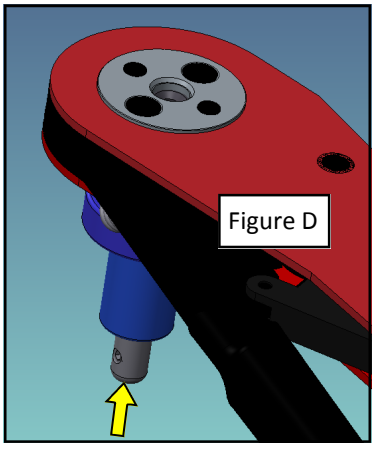


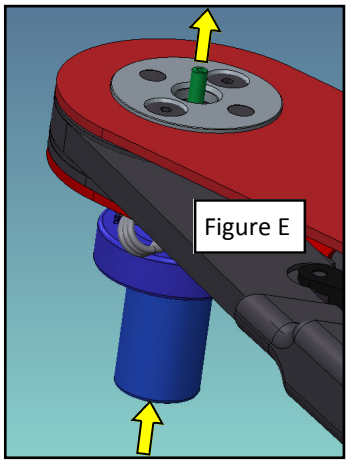
Figure C

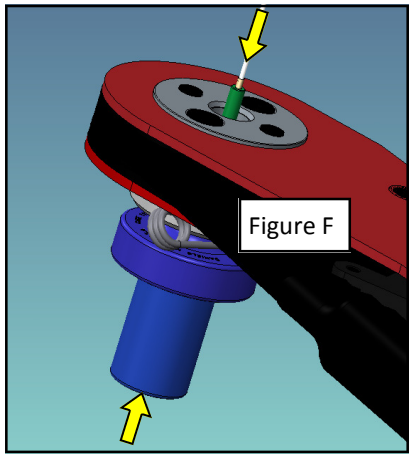
4. Apply pressure to contact positioner plunger in direction shown by the arrow (See Figure D). Release pressure to ensure plunger is free moving and returned to default position without jamming. Once you are satisfied with plungers operation (See Figure D), re-apply pressure in direction shown by the arrow.

5. Hold positioner in the load position (See Figure E).

6. Continue holding positioner in the load position and locate the crimp contact with cable, fully into the positioner (see Figure F).

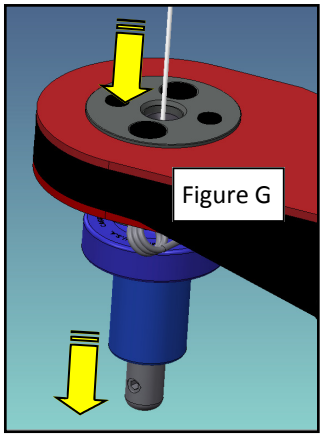




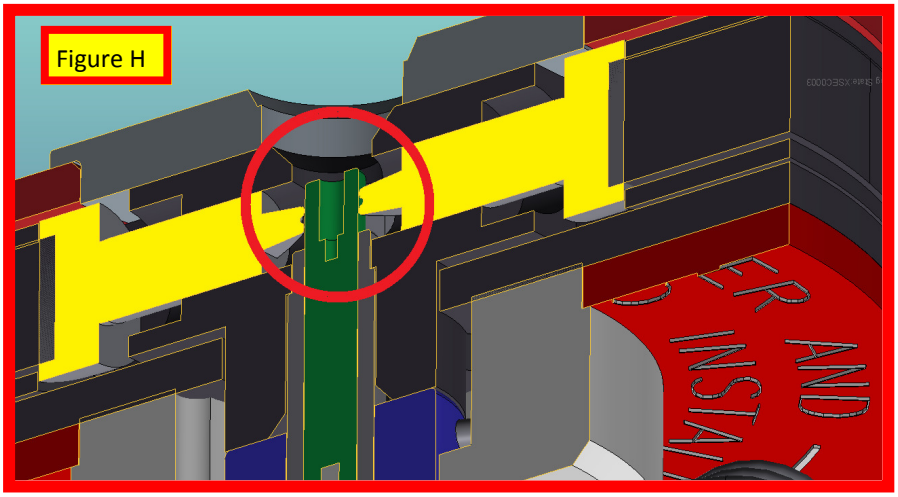


Crimping Procedure (cont'd)

7. Apply light pressure to the wire in the direction shown by arrow (See Figure G). Slowly release pressure on the plunger and allow it to return to it's default position as shown.



8. **Caution: Failure to allow contact positioner plunger to return to its default position may result in indentor damage during crimping. If plunger is not fully home, the indentors could crimp plunger and damage both the Z125-900 hand tool and Z125-901 contact crimp positioner (See Figure H).**



9. 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 Z125-902. See Instruction Sheet IS-38 for details on assembly.

Care of Tool

There is virtually no maintenance required for the Z125-900 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.