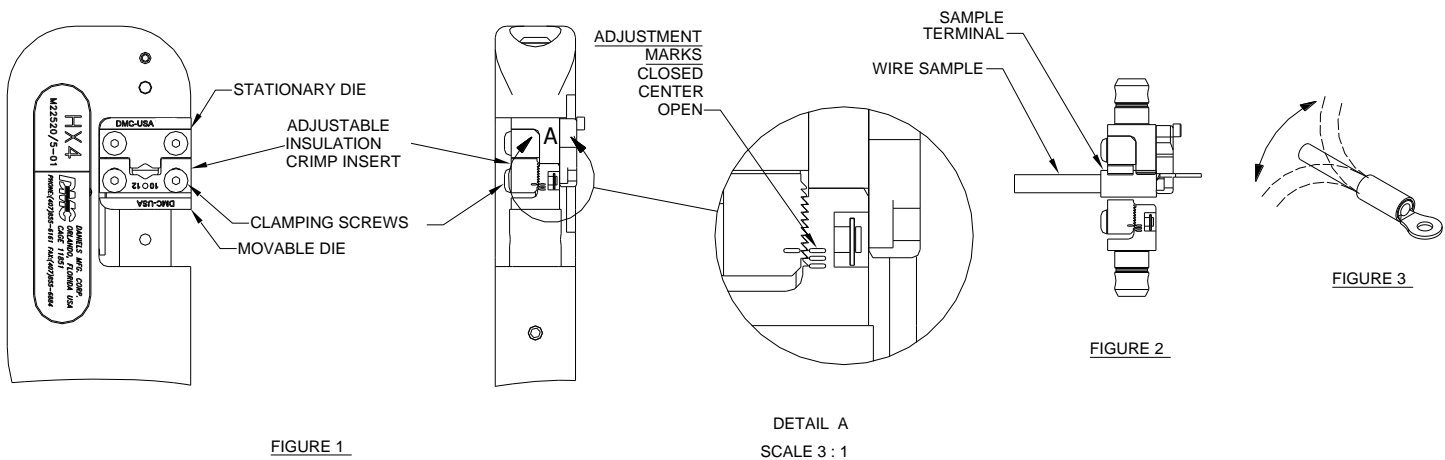


Y1115/Y1116/Y1117SERIES DIES



FOR INSULATED TERMINALS

DATASHEET



INSULATION ADJUSTMENT PROCEDURES FOR Y1115/Y1116/Y1117 SERIES TERMINAL DIES

1. Use the supplied hex wrench to loosen the clamping screws on the movable die **ONLY** (See Figure 1). The clamping screws have retaining rings on them, so that they cannot be removed completely. **DO NOT** remove the retaining rings or the screws.
 2. Move the adjustable insulation crimp insert to align the adjustment marks to the **OPEN** position. Slide the insert up and down slightly to ensure full engagement of the crimp height steps (See Figure 1 - Detail A).
 3. Re-tighten the clamping screws.
 4. Insert an appropriate size sample terminal for the die into the locator (See Figure 2).
 5. Insert an appropriate size **UNSTRIPPED** wire sample into the insulation portion of the crimp barrel **ONLY** (See Figure 2). **DO NOT** allow the wire to enter the conductor portion of the crimp barrel.
 6. Cycle the crimp tool fully.
 7. Withdraw the crimped sample and flex the wire three times (See Figure 3). If the wire is loose, or pulls out, repeat steps 1 thru 6 setting the adjustment to the **CENTER** position, and if necessary, to the **CLOSED** position.
 8. When the sample wire is held firmly after flexing, check the insulation envelope to ensure no cuts have occurred in the sheathing.
- NOTE:** Should the terminal fail to meet the above test, consult the terminal, and wire manufacturer to ensure that the appropriate components are being used.
9. The die is now ready for line service. Be sure the wire which was used in the preceding steps is consistent with wire used in line service.