

# NOTES:

- THE AD-1377S CRIMP TOOL IS DESIGNED TO MAKE WIRE SPLICES UTILIZING RAYCHEM CRIMP SPLICERS OF THE FOLLOWING SIZES

TOOL CAVITY	12-16		16-20		20-26	
CRIMP SPLICER SIZE	I.D.	O.D.	I.D.	O.D.	I.D.	O.D.
	.102	.153	.069	.106	.050	.080
	.097	.147	.064	.101	.045	.075

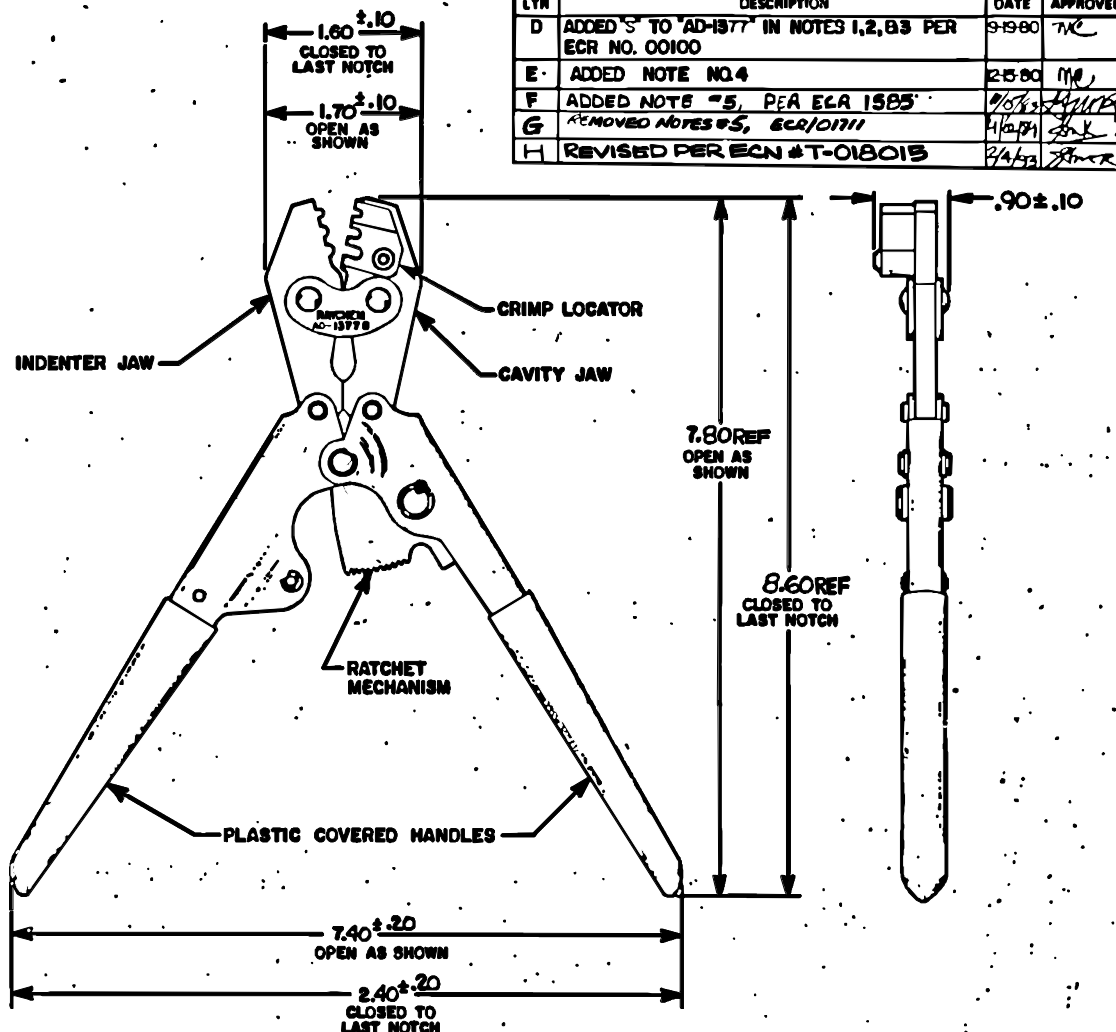
- WHEN MADE WITH A PROPERLY CALIBRATED AD-1377S CRIMP TOOL, THESE WIRE SPLICES WILL MEET THE VOLTAGE DROP AND TENSILE STRENGTH REQUIREMENTS OF THE APPLICABLE RAYCHEM SPECIFICATION CONTROL DRAWING FOR CRIMP SPLICING SYSTEMS.

- A PROPERLY CALIBRATED AD-1377S CRIMP TOOL HAS THE FOLLOWING CHARACTERISTICS:

- RATCHET ADJUSTMENT (SET AT THE FACTORY): A COMPRESSIVE FORCE OF 35 POUNDS MIN. APPLIED 1.25 ± .12 INCHES FROM THE END OF THE HANDLES SHALL BE REQUIRED TO COMPLETELY CLOSE THE JAWS BEFORE THE RATCHET MECHANISM RELEASES THE HANDLES.
- JAW CLOSING: WITH THE JAWS FULLY CLOSED (TIPS TOUCHING AND RATCHET IN LAST NOTCH) A "60" GAUGE SHALL FIT IN THE SPACE BETWEEN THE INDENTER AND ITS CORRESPONDING CAVITY. A "NO 60" GAUGE SHALL NOT FIT IN THIS SPACE. GAUGE SIZES ARE AS FOLLOWS:

TOOL CAVITY	"60"	"NO 60"
12-16	.062 DIA.	.072 DIA.
16-20	.042 DIA.	.052 DIA.
20-26	.025 DIA.	.035 DIA.

THE RAYCHEM AD-1386 CRIMP TOOL GAUGE IS RECOMMENDED FOR THIS PURPOSE.



REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
D	ADDED "S" TO "AD-1377" IN NOTES 1,2,83 PER ECR NO. 00100	9-19-80	TAC
E	ADDED NOTE NO.4	2-5-80	MM
F	ADDED NOTE "5, PER ECR 1585"	9/8/81	MM
G	REMOVED NOTES "5, ECR 10111"	4/2/81	MM
H	REVISED PER ECR #T-018015	3/4/82	MM

## SPECIFICATION CONTROL DRAWING

DRAWN	WELCH	1/28/78	RAYCHEM	
CHECKED	R. N. D. L.	25/Jan/78	TITLE	
APPROVED	R. N. D. L.	25/Jan/78	AD-1377 S	
APPROVED	—	—	CRIMP TOOL	
APPROVED	—	—	ASSEMBLY	
PART NUMBER	959025		SIZE	CODE IDENT.
PROJECT	AD-1377		C	NO 0800
			SCALE	NONE
			WEIGHT	—
			SHEET	— OF —

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