


Figure 1

1. INTRODUCTION

This instruction sheet covers the setup and use of the Crimp Height Gage 904170-1 for 2-, 4-, 6-, 8-, and 10-position modular plugs. The gage *cannot* be used for 4-position handset and 6-position offset modular plugs.

The gage is designed to be used as a quick verification of acceptable crimp height. Read these instructions thoroughly before using the gage.

NOTE  Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 5, REVISION SUMMARY.


2. DESCRIPTION

This gage consists of a nest and a GO/NO-GO spanner. See Figure 1 .

3. USING THE GAGE

1. Push down firmly on the crimped modular plug, and slide the locking latch of the modular plug into the nest, wedging the modular plug in so that it is held tightly. Refer to Figure 2 .

2. While holding the modular plug in the nest, slide the GO end of the spanner over each contact as shown in Figure 2 . Repeat this step with the NO-GO end of the spanner.

CAUTION  DO NOT force the spanner over modular plug. Damage to the gold plated contacts or spanner may result.

If both ends of the spanner pass over a contact, the crimp height of that contact is below the allowed tolerance. If both ends of the spanner fail to pass over a contact, the crimp height of that contact is above the allowed tolerance.

NOTE  For the required crimp height dimension, refer to the applicable application specification (114-series) for the modular plug.

Acceptable Crimp Height

Side View

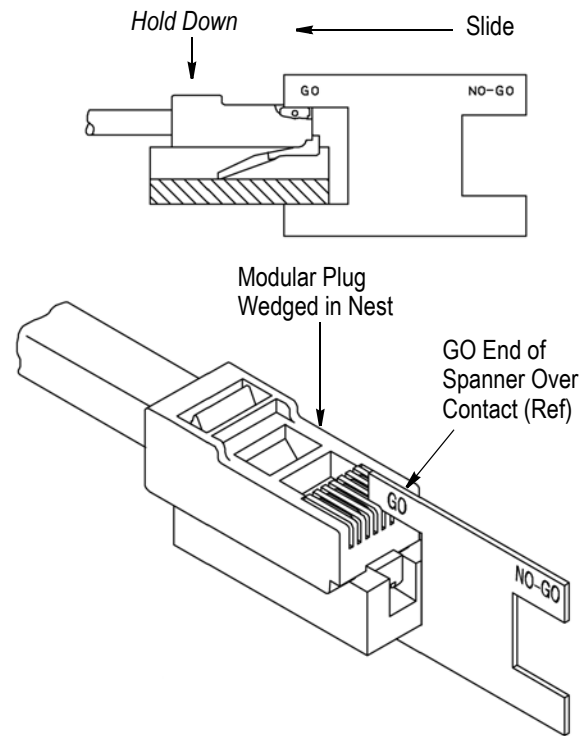


Figure 2

4. MAINTENANCE AND INSPECTION

To maintain the integrity of the measurement process, the gage should be kept clean. Customer can verify calibration by confirming dimensions shown in Figure 3.

Gage Calibration

Note: Not to Scale

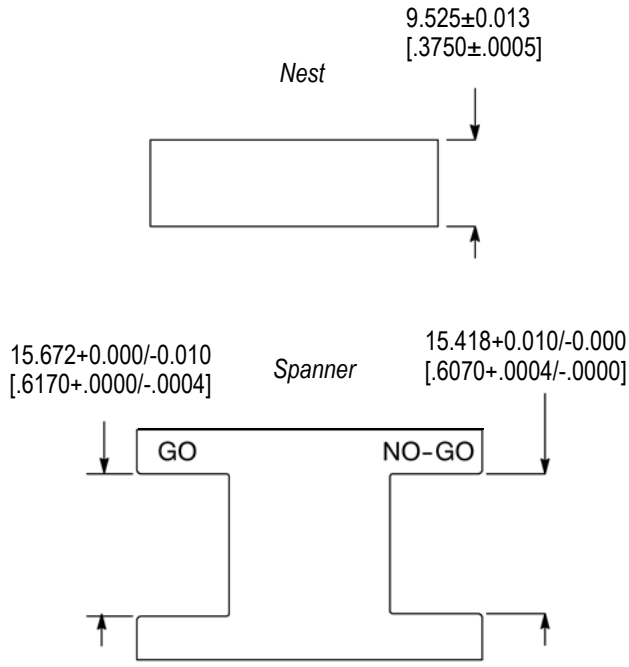


Figure 3

The crimp height gage should be covered with a light film of oil to prevent corrosion and stored in a clean, dry area.

5. REVISION SUMMARY

Revisions to this instruction sheet include:

- Revised Maintenance and Inspection section.