

544
"COMPANY PRIVATE"

FIRST CLASS MAIL

Installation Engineering Handbook 18 (File Ahead of Section 7J)
Temporary Instruction
Western Electric Company, Incorporated
Kearny Works

Section T.I. 7J

11-30-70

CONNECTING

COMPRESSION TYPE LUGS AND CONNECTORS

1. GENERAL

1.1 Section 7J indicates that the new KS-15977 connectors can not be compressed with commercial dies and can not be soldered. This T.I. and T.I. 7G rescinds these two prohibitions. Crimping with certain commercial dies is covered in Section 7G and this T.I. permits soldering under certain circumstances.

2. INSTRUCTIONS

2.1 Replace Paragraph 1.1 with the two following paragraphs:

"1.1 This section lists available KS compression lugs and connectors. Installing instructions are covered in Section 7G."

"1.2 Although these connectors are designed to be compressed on to wire ends, there are circumstances under which they may be soldered."

2.2 Replace Paragraph 2.4 with the following paragraphs:

"2.4 Except in equipment rooms of Electronic offices, these KS-15977 Connectors may be soldered in accordance with Section 7C. Soldering is authorized for jobs where a KS-19964 Compression tool is not available or where the number of connections is too small to justify the use of the KS tools."

"2.41 In electronic offices, R-3799 Heads are available in sufficient quantity that soldering is not authorized. Also, because only crimped connections are permitted in electronic offices, soldering is not authorized."

2.3 Add the following to Table "A":

(TABLE "A" Continued)

Tool	WIRE SIZES						
	14, 12, 10	8, 6	4, 2	1/0 and 2/0	4/0	350 and 500	750
R-3699 12 ton Yoke Head			T & B Die 41* R-4229 2 crimps	T & B Die 60 R-4230 1 crimp	T & B Die 66H R-4231 3 crimps	T & B Die 96H R-4232 3 crimps	T & B Die 115H R-4233 3 crimps

*For verification purposes, this die embosses "4AL" on the connector.

2.4 Make requirements of Paragraphs 2.2 and 2.5.

Manager, Product Engineering