3M

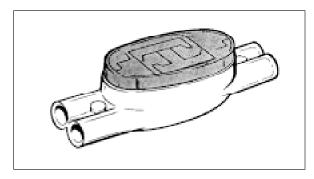
Scotchlok™ U1B and U1R Inline Connectors

Instructions

1.0 General

1.1 This instruction covers the 3MTM Scotchlok U1 Series Inline Connectors. They are self stripping, insulated and moisture resistant. Also covered are the wire sizes they can accommodate and in general, how to use them.

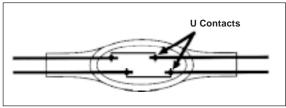
The operation of the 3M E-9BM Scotchlok tool required is also covered.



3M U1 Series Scotchlok Connector

2.0 Description

2.1 Schematic:



3M™ U1B, U1R Full Pair Connector

2.2 Wire Ranges: (Sizes may be intermixed within a connector).

	Wire Size		Max Insulation O.D.	
Product	Metric	AWG	mm	inches
U1B	1.3-0.9 mm	16-19	3.18	.125
U1R	0.9-0.5 mm	19-24	3.18	.125

3.0 Procedure for Splicing with 3M U1B and U1R Connectors

- 3.1 Hold a pair of conductors from one cable end together.
- 3.2 Clip ends evenly at desired position of connector. DO NOT STRIP INSULATION.
- 3.3 Insert both wires all the way into ports at one end of connector.
- 3.4 Repeat with corresponding pair of conductors from the other cable.

4.3 Repeat the operation until all wires are spliced. Connectors should be staggered and bundled to the core of splice.

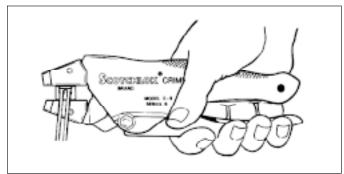


Typical Inline splice made with 3M U1 Scotchlok Connector

Note: Position each connector so as to produce the smallest possible bundle.

5.0 Scotchlok E-9BM Crimping Tool

5.1 The Scotchlok E-9BM Crimping Tool has adjustable jaws with parallel closing action, and a 7-1 mechanical advantage for proper crimping of all Scotchlok connectors.



3M Scotchlok E-9B Crimping Tool

6.0 Product Summary

	Packaging					
Product	Quantity	Quantity	Wt. per			
	per	per	Shipper			
	Primary	Shipper	Kg. Lb.			
U1B	100/box	1,000	7.3	16		
U1R	100/box	1,000	7.3	16		
E9-BM	1/box	10	2.3	5		

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4.0 Crimping

Note: Use only the $3M^{TM}$ Scotchlok E-9BM tool.

- 4.1 Set tool jaws to "thick-thin". (Jaws can be easily pried from position using a screwdriver or similar object).
- 4.2 Crimp the button. DEPRESS ALL THE WAY. Cap must be FLUSH with connector body.

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