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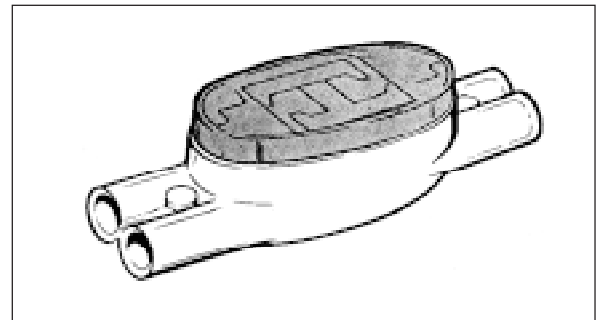
Scotchlok™ U1B and U1R Inline Connectors

Instructions

1.0 General

- 1.1 This instruction covers the 3M™ 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.

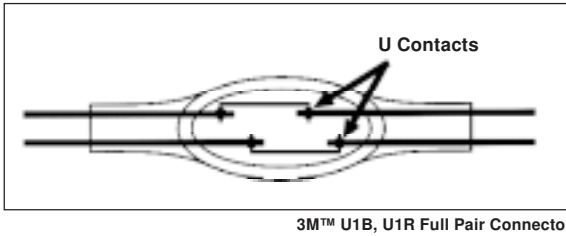
The operation of the 3M E-9BM Scotchlok tool required is also covered.



3M U1 Series Scotchlok Connector

2.0 Description

2.1 Schematic:



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

Product	Wire Size		Max Insulation O.D.	
	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

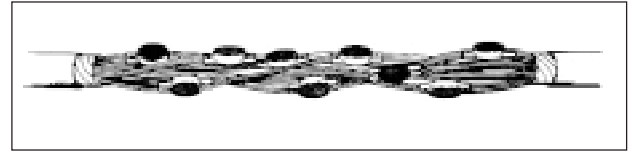
- 3.1 Hold a pair of conductors from one cable end together.
- 3.2 Clip ends evenly at desired position of connector. **DO NOT STRIP INSULATION.**
- 3.3 Insert both wires all the way into ports at one end of connector.
- 3.4 Repeat with corresponding pair of conductors from the other cable.

4.0 Crimping

Note: Use only the 3M™ 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.

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

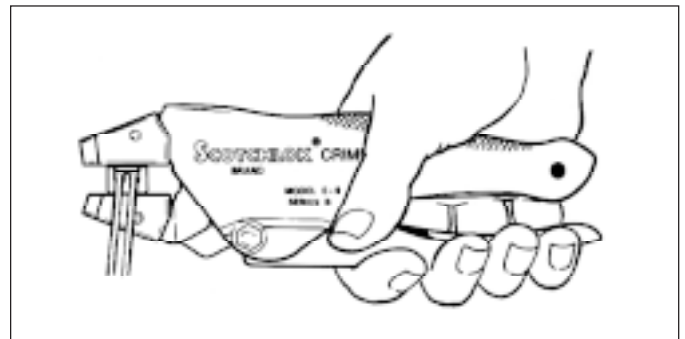


Typical Inline splice made with 3M U1 Scotchlok Connector

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-9BM Crimping Tool

6.0 Product Summary

Product	Packaging		
	Quantity per Primary	Quantity per Shipper	Wt. per 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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