

CRIMPING INSTRUCTIONS FOR CATALOG # 1351G1 MECHANICAL CRIMP TOOL

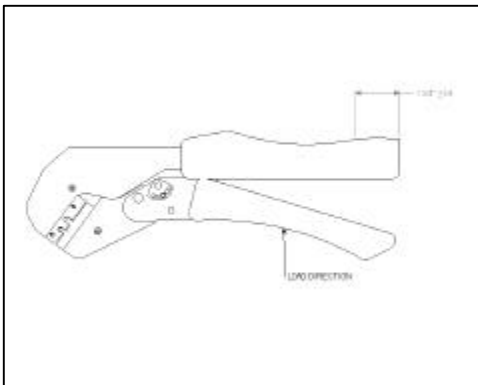
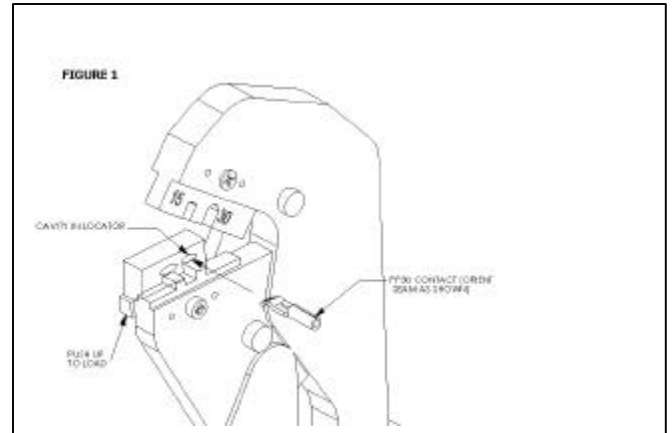
This two cavity, cycle controlled mechanical tool is designed to crimp, in one operation, Anderson's Powerpole® contact, rated for 15 and 30 amps to the following range of wire sizes:

PP15- Wire size 20 to 16 AWG, Cavity 15

PP30- Wire size 16 to 12 AWG, Cavity 30

CRIMPING INSTRUCTIONS:

- 1) Select the appropriate locator cavity for the wire size being crimped (see Figure 1).
- 2) Raise the spring loaded locator to allow contact entry. Insert contact into appropriate cavity as shown in Fig. 1
- 3) Close tool carefully until jaws grip the terminal without distortion.
- 4) Insert the properly stripped wire (.31 inch strip length) into contact barrel. Note that the wire is fully inserted in contact and no wire insulation lies in the contact barrel.
- 5) Holding the wire in place, close the tool past the ratchet release position and allow the jaws to spring open. Note: A ratchet release trigger is provided to allow for removal of an incorrectly placed or oversized connector.
- 6) Raise the locator and release the crimped terminal from locator cavity.



When properly calibrated, the ratchet mechanism should release with a load of 35 to 50 pounds applied (without a contact in place) at 1-3/4 inches from the end of the handle (see Figure 2). To adjust tool release load, follow steps under Tool Adjustment

TOOL ADJUSTMENT:

- 1) Open the handles and remove the locking screw with a 1/16 inch hex ALLEN wrench (See Figure 3).

- 2) On the other side of the tool, turn the eccentric stud clockwise to increase handle load or counter-clockwise to decrease the handle load (See Figure

4).

- 3) While turning eccentric stud, position eccentric lock to desired

number position and tighten locking screw back in place (See Figure 3).

- 4) Re-measure force and continue to adjust as necessary.

