

Miscrimps or Jams

Should this tool ever become stuck or jammed in a partially closed position. Do Not force the handles open or closed. The tool will open easily by pressing up on the ratchet release lever in the movable handle. (See Figure 8).

How to Adjust Tool Preload

This hand tool is factory preset to 25 to 45 lbf. (111 to 200 N) preload. It may be necessary over the life of the tool to adjust tool handle preload force. (See Figure 9)

1. Hold the hand tool in the palm of your hand as shown in Figure 9. Using the index finger squeeze the **LINK** towards the top of the hand tool frame. This will release the preload adjustment wheel.
2. Rotate the setting wheel counterclockwise to increase handle force. The numbers will display higher. To decrease handle force rotate the setting wheel clockwise.
3. Release the **LINK** to lock the setting wheel in place.
4. Check the crimp specifications or conduct a pull test after tool handle preload force is adjusted.

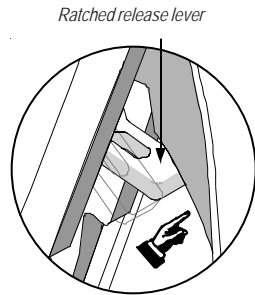


Figure 8

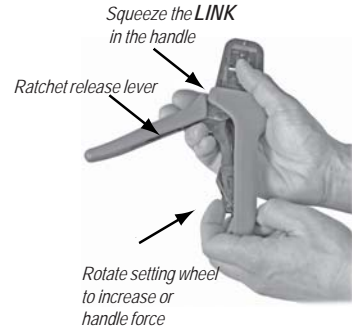


Figure 9

Certification

Tool user is responsible to ensure that the tool is adjusted to provide proper crimps, that conform to required quality and pull force values.

- This tool is qualified to pull force only.
- If the tool does not meet minimum pull force values, handle preload should be increased and the pull test rerun, (See How to Adjust Preload).
- When the hand tool is no longer capable of achieving minimum pull force, it should be taken out of service and replaced.



1313G1 HAND CRIMP TOOL Specification Sheet



WIRE SIZE & STRIP LENGTH

Products: PP4x Crimp Terminals, #20 - #24 AWG

Terminal Series	Terminal Part No.	Wire Size		Insulation Diameter		Strip Length	
	Reels*	AWG	mm ²	In.	mm	In.	mm
4202	4202G1	#20 to #24	0.50-0.20	0.056 - 0.073	1.42-1.85	0.19 ^{+/-} 0.03	4.8 ^{+/-} 0.8
	4202G3						
4203	4203G1						
	4203G3						

* Contacts may be cut off from Reel: 0.18mm (.007") maximum cut-off tab

CRIMP DIMENSIONS

Terminal Part No.	Wire Size		Conductor Crimp				Pull Force Minimum		Die Pocket	
			Height (Ref.)		Width (Ref.)					
	AWG	mm ²	mm	In.	mm	In.	N	lbf.	20	22-24
4202	#20	0.50	0.89-0.99	0.035-0.040	1.40	0.055	44.50	10	X	
	#22	0.35	0.83-0.93	0.033-0.037	1.40	0.055	35.60	8		X
4203	#24	0.20	0.83-0.94	0.033-0.038	1.40	0.055	26.70	6		X

CAUTIONS:

1. Manually powered hand tools are intended for low volume or field repair. This tool is NOT intended for production use.
2. Insulated rubber handles do not protect against electrical shock.
3. Wear eye protection at all times.
4. Install only Anderson terminals listed above with this tool. Do not crimp hardened objects as damage can occur to the tool or die. Anderson crimp specifications are valid only when used with Anderson terminals and tooling.



OPERATION

Open the tool by squeezing the handles together. At the end of the closing stroke, the ratchet mechanism will release the handles and the hand tool will spring open. (See Figure 1)

Crimping Terminals

1. Select the desired terminal listed in the preceding charts.
2. Handles of the tools must be in the fully open position as in Figure 1. With the locator attached, push the locator button on the back of the hand tool to bring the locator forward through the tooling. (See Figure 2)
3. While holding the locator button in, load the terminal into the proper nest opening in the locator based on the wire gauge or terminal type markings on the hand tooling. (See Figure 3)

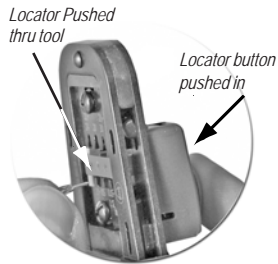


Figure 2



Figure 3

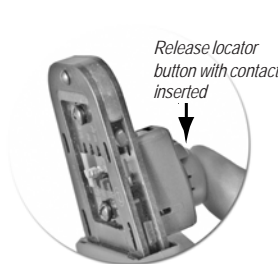


Figure 4

4. Release the locator button, allowing the locator to return to the crimping position. (See Figure 4)
5. Close the tool handle until the first ratchet position engages.
6. Insert the properly stripped wire through the terminal and against the wire stop. (See Figure 5 & 5a)



Figure 5

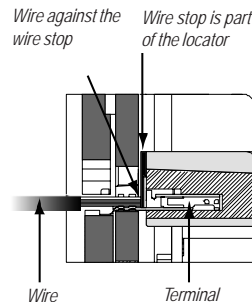


Figure 5a



Ratcheting Handle Squeeze handles together and release handle will spring open

Figure 1

7. Crimp the terminal by squeezing the tool handles until the ratchet mechanism cycle has been completed. Release the handles to open the jaws.
8. Remove the crimped terminal from the terminal locator by pulling on the wire.
9. Visually inspect the crimped terminal for proper crimp location.

Note: A crimp height chart is provided with this manual as Reference Only. Due to the wide range of wires, strands, insulation diameters, and durometers available, actual crimp height measurements may vary slightly. An occasional, destructive, pull force test should be performed to check hand tool crimp. Pull Force value Must exceed the minimum pull force specifications listed.

Maintenance

It is recommended that each operator of the tool be made aware of, and responsible for, the following maintenance steps:

1. Remove dust, moisture, and other contaminants with a clean brush, or soft, lint free cloth.
2. Do not use any abrasive materials that could damage the tool.
3. Make certain all pins; pivot points and bearing surfaces are protected with a thin coat of high quality machine oil (See Figure 6). Do not oil excessively. Light oil (such as 30 weight automotive oil) used at the oil points, every 5,000 crimps or 3 months, will significantly enhance the tool life.
4. Wipe excess oil from hand tool, particularly from crimping area. Oil transferred from the crimping area onto certain terminations may affect the electrical characteristics of an application.
5. When tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping dies, and store the tool in a clean, dry area.

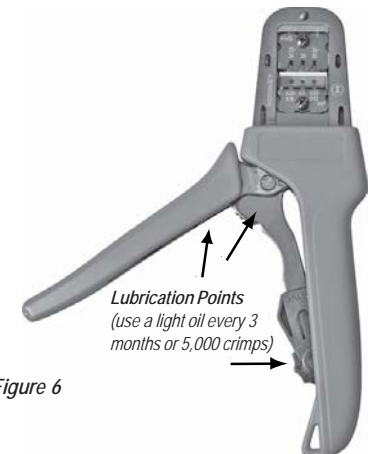


Figure 6