

CRIMPING INSTRUCTIONS FOR CATALOG # 1396G1 MECHANICAL CRIMP TOOL

This cycle controlled mechanical tool is designed to crimp, in one operation, Anderson's Powerpole® Pin and Socket contact to #10 AWG wire.

CRIMPING INSTRUCTIONS:

Prior to crimping, check the die opening with gage pins. For #10 wire a .120 diameter gage pin should be allowed to pass through the indenter opening, while a .125 gage pin should not fit through. To adjust the tool, unlock the locking nuts and turn screw in appropriate direction. (Figures 1 and 2)

Strip the wire to $.31 \pm .03$ inches for both the pin and socket.

Insert the stripped wire into the contact barrel. Insure that the wire is fully inserted into the barrel and no insulation lies in the contact barrel.

Place the contact with wire into the locator cavity as shown in Figures 3 and 4.

Holding the wire in place, close the tool until the adjustment screw bottoms out on the opposite handle.

Open the handles and remove the crimped terminal from the locator cavity. Contact should not be distorted or bent after crimp is made.

To verify that a good crimp is obtained it is recommended that a tensile (pull) test is performed on the crimped contact. The contact to wire retention force should be approximately 125 pounds (548 N) or greater.

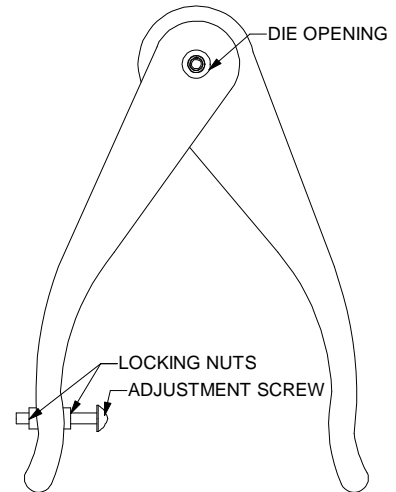
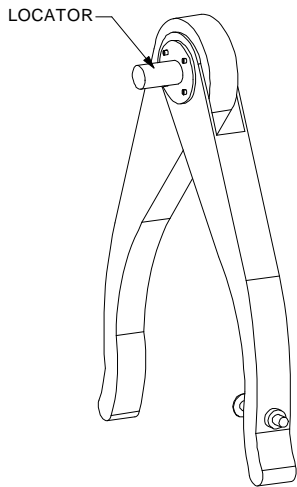


Figure 3

Figure 4

