

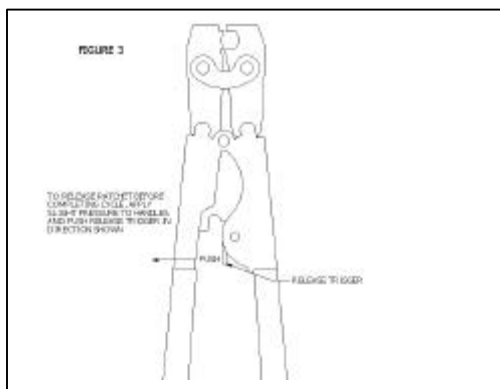
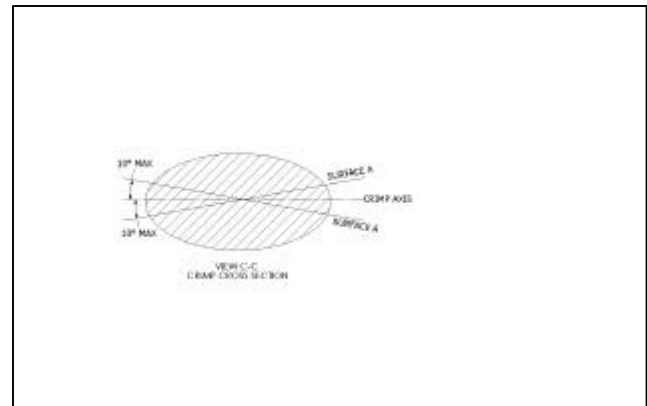
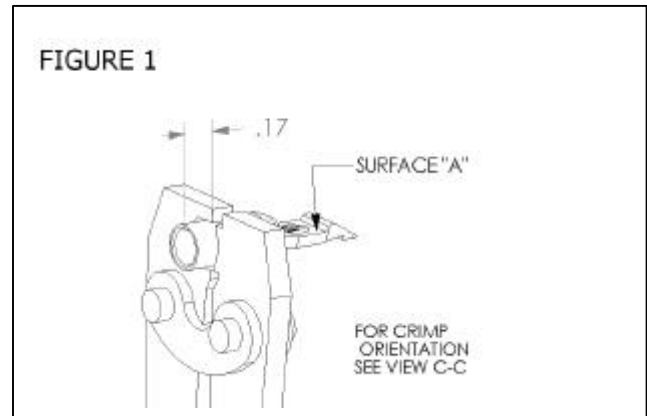
# CRIMPING INSTRUCTIONS FOR CATALOG # 1352G1 MECHANICAL CRIMP TOOL

This single cavity, cycle controlled mechanical tool is designed to crimp, in one operation, Anderson's Powerpole® 75 amp contact and the SB® 50 amp contact. The tool has an "oval" nest for crimping the contacts to wires ranging from 6 to 16 AWG. For wires smaller than 16 AWG, a reducing bushing and tool adjustment may be required.

## CRIMPING INSTRUCTIONS:

- 1) Align the contact centrally on anvil and within angular orientation as shown (see Figures 1 and 2).
- 2) Close tool carefully until jaws grip the terminal without distortion.
- 3) Insert the properly stripped wire (.56" strip length) into contact barrel. Note that the wire butts against the inside of the contact barrel.
- 4) 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 (FIGURE 3).**



## Maintenance Instructions- 1352G1

Maintenance and inspection should be performed regularly. Tool should be wiped clean with special emphasis on the crimping cavities.

Clean tool by immersing in a suitable commercial solvent or cleaner which does not attack paint or plastic material. The tool should be re-lubricated after cleaning using a light film of medium weight oil on bearing and pivot points.

### Calibration:

Insert a .159 hardened steel pin and apply force as shown in Figure 4 until ratchet releases. The force at a point  $1\frac{3}{4}$ " from handle ends should be 35-45 lbs.

To adjust the tool to obtain the proper force values, open the handles and loosen the lock nut with the spanner wrench\* or similar tool. On the opposite side of the tool, turn the eccentric stud clockwise to increase handle load...or counter-clockwise to decrease the handle load. Tighten lock nut, re-measure force and continue to adjust if necessary.

\*Available from the manufacturer

