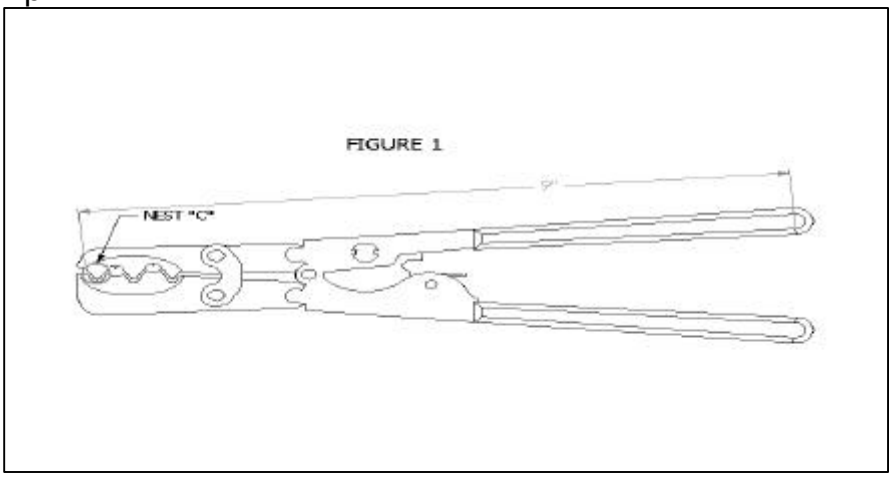
CRIMPING INSTRUCTIONS FOR CATALOG # 1374
MECHANICAL CRIMP TOOL

This five cavity, cycle controlled mechanical tool is designed to crimp, in one operation, Anderson Power's PP10 263G1 and 264G1 contacts. The 1374 tool produces an "F" style crimp.

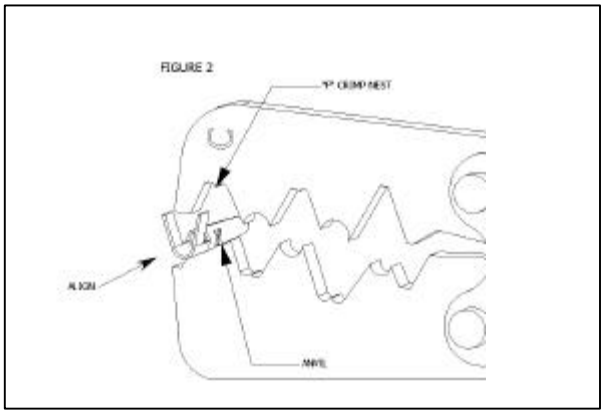


CRIMPING

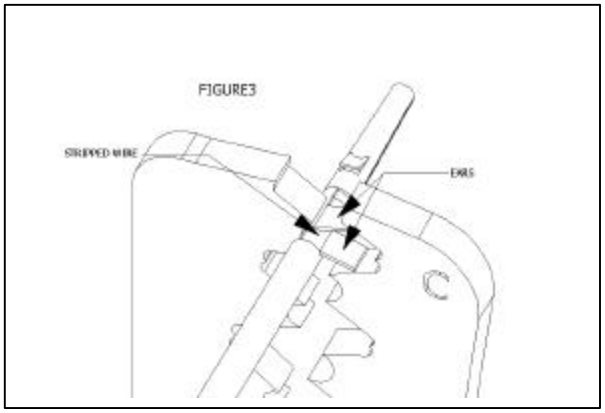
INSTRUCTIONS:

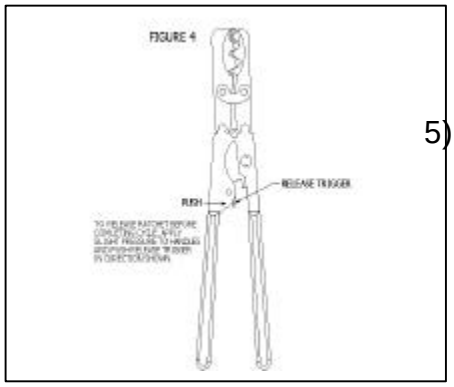
1) Select nest to be used based on the wire size:

Nest	AWG Wire	Pull- out	Crimp Hgt.
C	16	7 lbs	.095"
C	14	18 lbs	.095"



2) Align the contact centrally on anvil "C" and within angular orientation as shown (see Figures 1).
3) Close tool carefully until jaws grip the terminal without distortion.
4) Insert the properly stripped wire (5/16" strip length) into contact barrel. Note that the wire extends about 1/32" pass the contact "ears".





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 (FIGURE 4).

Maintenance Instructions- 1374

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:

Apply force as shown in until ratchet releases. The force at a point 1 ¾ " from handle ends should be 45-55lbs. (Figure 5)

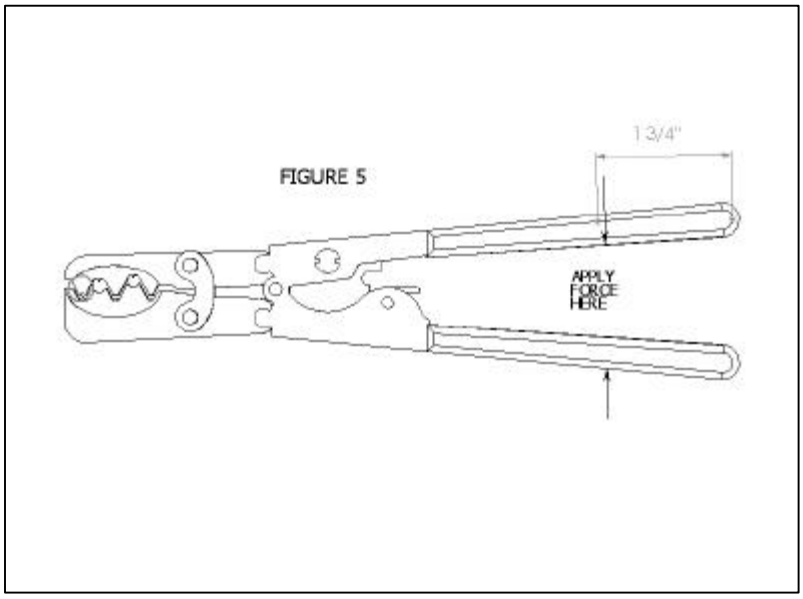


FIGURE 5

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. (Figures 6 and 7)

*Available from the manufacturer

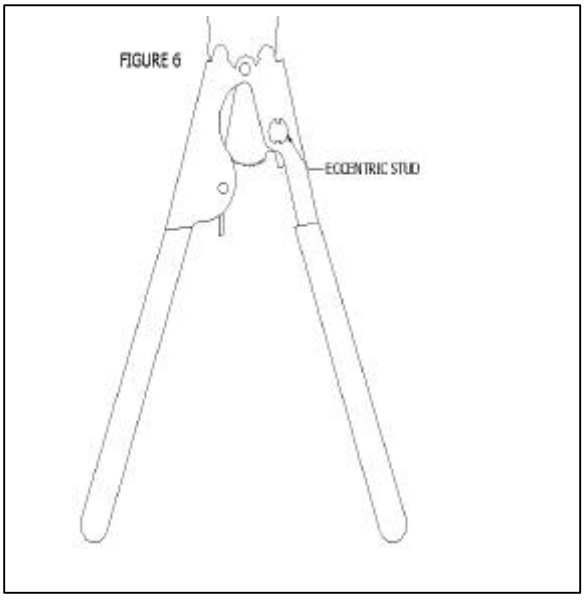


FIGURE 6

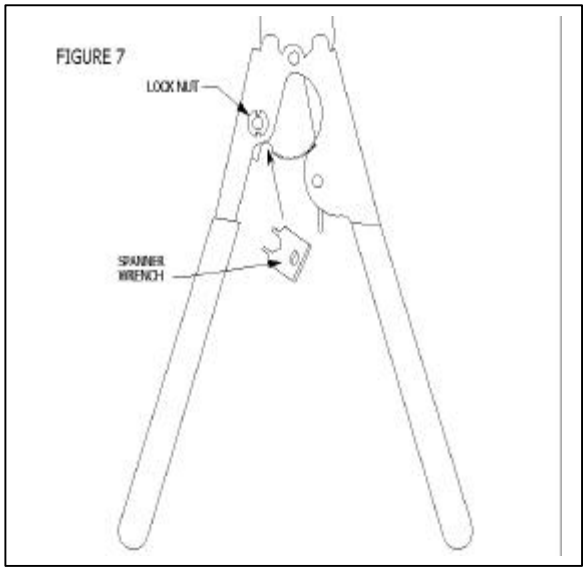


FIGURE 7

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

Anderson Power Products:

1374