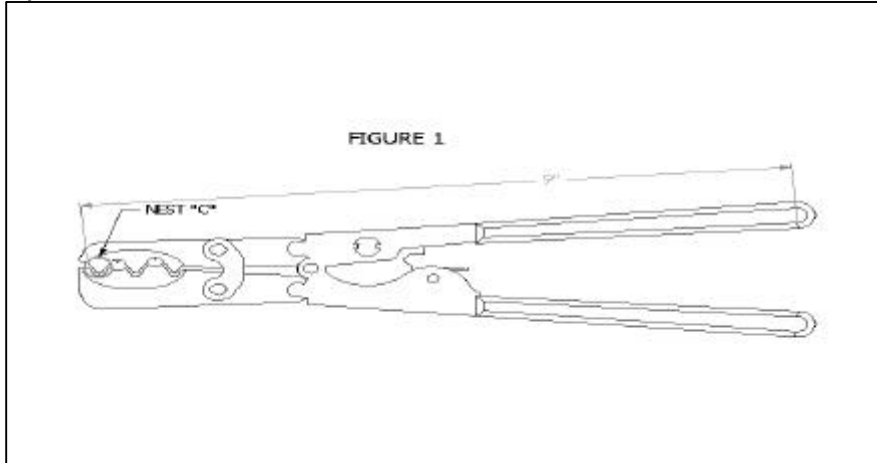


CRIMPING INSTRUCTIONS FOR CATALOG # 1374

MECHANICAL CRIMP TOOL

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



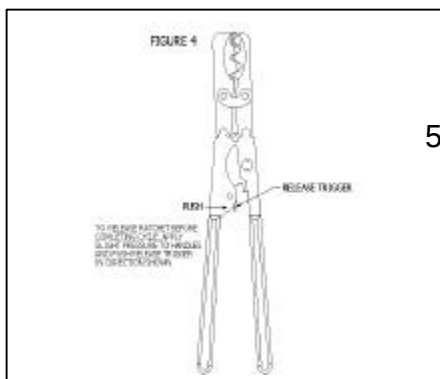
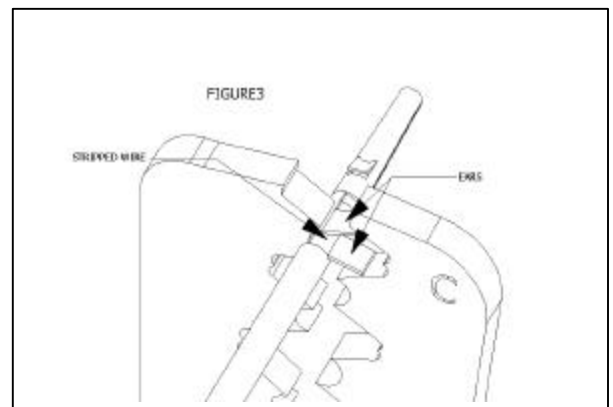
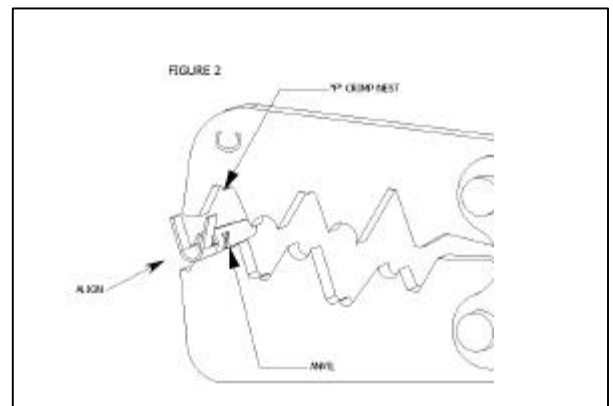
CRIMPING

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" past 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 $1\frac{3}{4}$ " from handle ends should be 45-55lbs. (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

