Hand Crimping Tool 825508-5

ORIGINAL INSTRUCTIONS

1. INTRODUCTION

This tool, shown in Figure 1, is used to crimp:

- PIDG* terminals and butt splices on stranded copper wire sizes 22-10 AWG
- PLASTI-GRIP* terminals and butt splices on solid or stranded copper wire sizes 22-10 AWG

2. CUT WIRE

Insert wire in cutter, close handles briskly.

3. GAGE WIRE

Determine wire size by inserting unstripped wire into the smallest color-coded gage ring that will accept the wire. See Figure 2. After stripping, use the adjacent crimp closure to crimp terminal or splice on wire.

4. STRIP WIRE

Partially open handles and insert wire in correct notch of wire stripping blades. End of wire must butt against strip length locator (controls strip length). See Figure 3. Close handles fully and rotate tool part way around the wire. Pull wire from tool.

CAUTION

Be sure there are no cut or missing conductor strands.

5. COLOR CODE

Select the correct color-coded terminal or splice for the wire size being used:

- Red = AWG 22-16 (0.25-1.5 mm²)
- Blue = AWG 16-14 (1.5-2.5 mm²)
- Yellow = AWG 12-10 (4-6 mm²)

6. CRIMP TERMINAL OR SPLICE

(a) Insert color-coded terminal or splice in crimp closure adjacent to the matching color-coded wire gage ring.

(b) Position terminal or splice in crimp closure as shown in Figure 4 or 5.

(c) Partially close handles to hold terminal or splice firmly in die closure.

(d) Insert stripped wire into terminal until end of conductor is at least flush with or extended slightly beyond end of terminal wire barrel.

Insert stripped wire into splice until end of conductor butts against splice wire stop.

CAUTION

Do not use wires with nicked or missing conductor strands.

(e) Close handles fully, then open handles by depressing release lever.

(f) To crimp other half of splice, remove it and reposition uncrimped half in tool as shown in Figure 5. Follow same procedure used to crimp first half of splice. If splice cannot be turned, turn tool around.

(g) Refer to Figure 6 for terminal or splice crimp inspection procedure.

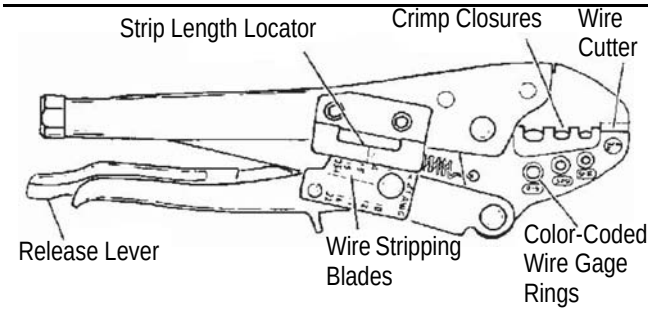

Figure 1

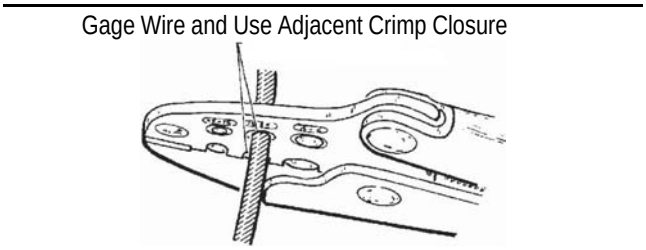

Figure 2

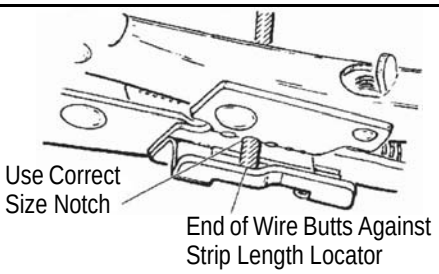

Figure 3

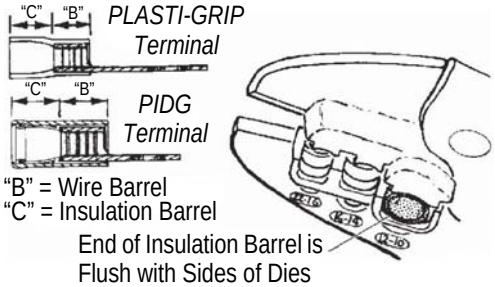

Figure 4

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7. REVISION SUMMARY

- Removed “AMPLIVERSAL” in title

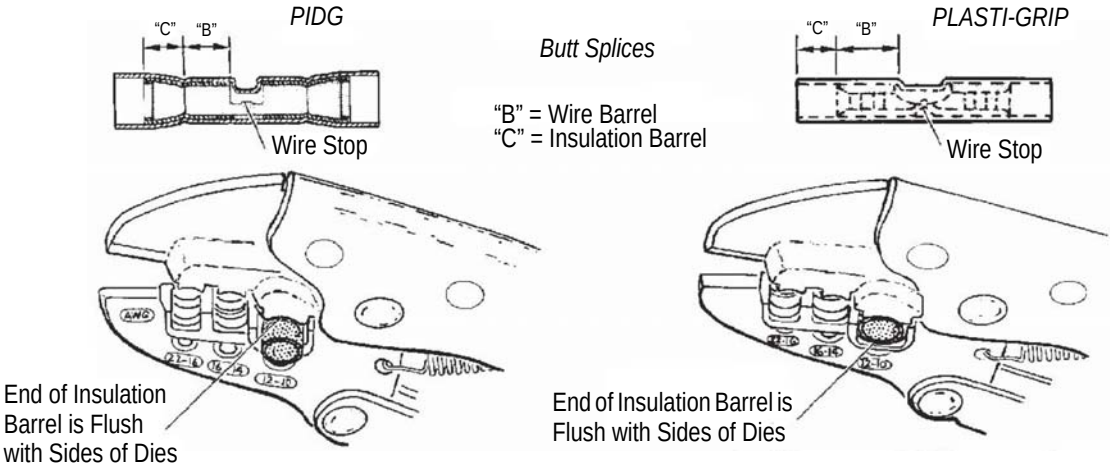

Figure 5

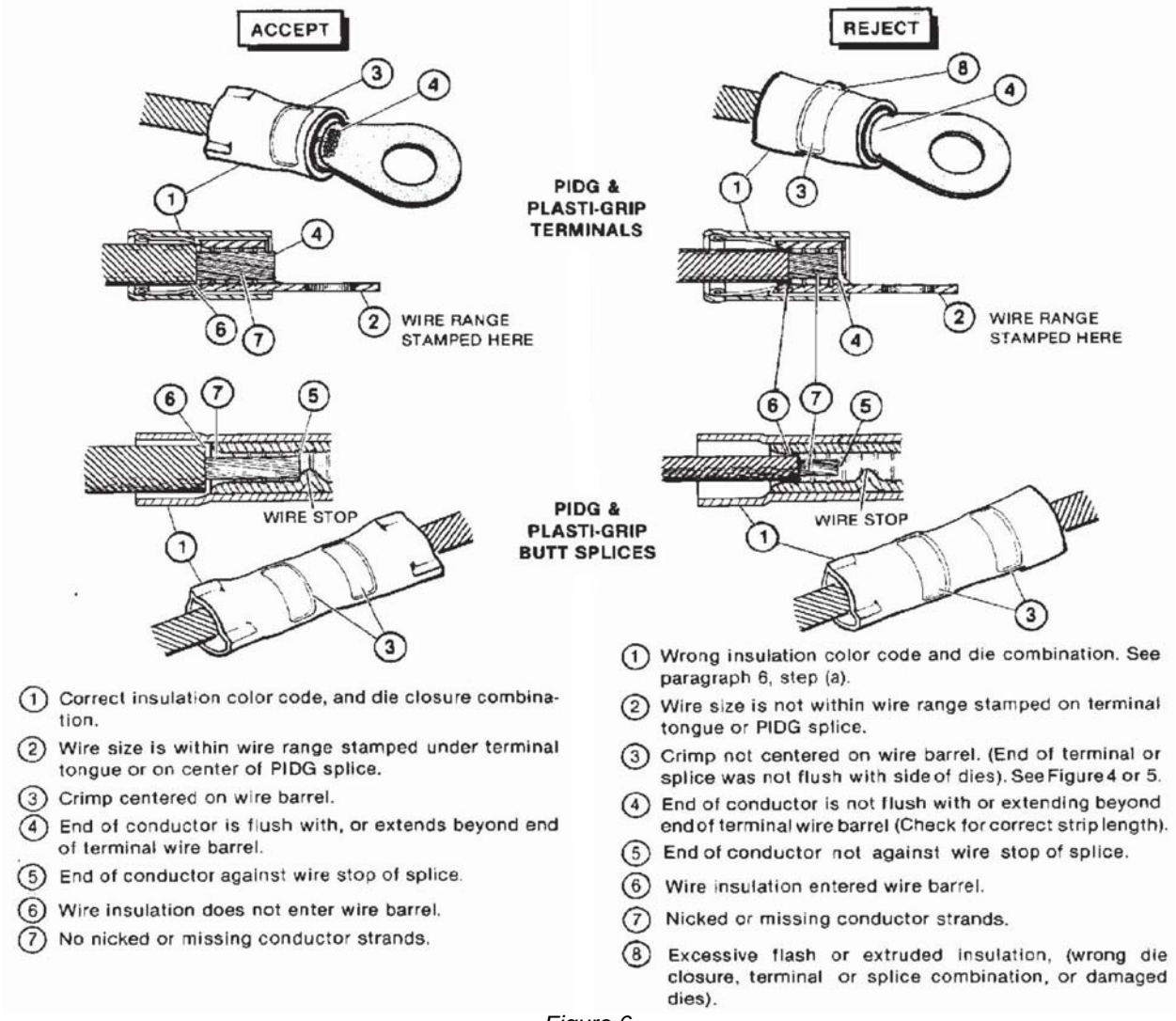

Figure 6