CRIMPING

1) Check Table A (page 2) and B (page 3) to assure that the contacts are the correct ones for your conductors. If the conductors are too small for your contacts, a range of reduction sleeves is available to reduce the crimping diameter of the contact (see Table 3 below). For other requirements, please contact the factory.

Crimp Reduction Sleeve

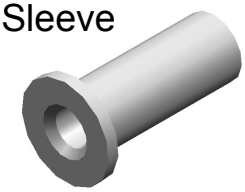


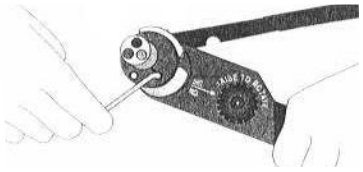
Table 3

Reduction Sleeve	Dimension	
	Contact	Conductor
3001008004	AWG 20	AWG 26
3001008006	AWG 16	AWG 22
3001008060	AWG 4	10 mm²
3001008061	AWG 4	6 mm²
3001008062	AWG 4	16 mm²
3001008063	190 mm²	AWG 4/0
3001008064	AWG 4	15 mm²
3001008065	AWG 8	AWG 12
3001008066	AWG 0	AWG 6
3001008067	AWG 0	AWG 2
3001008068	AWG 8	AWG 10
3001008069	AWG 8	AWG 18
3001008070	AWG 8	AWG 16
3001008071	AWG 4	2,5 mm²
3001008075	70 mm²	25 mm²
3001008080	AWG 0	16 mm²
3001008081	AWG 0	35 mm²
3001008082	AWG 0	25 mm²
3001008083	AWG 0	10 mm²
3001008084	AWG 0	50 mm²
3001008086	AWG 2/0	70 mm²
3009008000	AWG 2/0	50 mm²

2) The information provided by Tables A (page 2) and B (page 3) will help you to select the proper crimping/turret/insertion tooling.

3) Install the turret in the crimping tool (instructions continue on following page).

Figure 5: Turret closing



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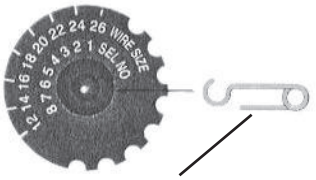
4) Adjust contact and conductor crimping depth using the crimping tool selector and turret pursuant to the Turret Table (below):

Figure 7: Turret Table

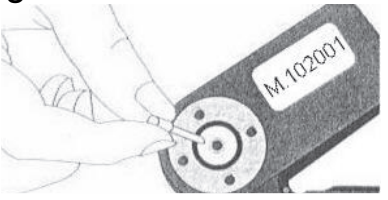
Commital P.N.	Color	6	4	12 3	2.5	14 1.9	1.5	16 1.2	18 1	.75	20 .60	.50	AWG mm²
10-40561 10-40560 -12	RED			8	7	6					6		Selector N° Use with M.105007
10-40561 10-40560 -15	RED								7	7	6	6	
10-40561 10-40560 -18	RED						8	7	6				
10-40561 10-40560 -22	RED				6	5							
10-40561 10-40560 -30	RED		8										
10-40561 10-40560 -38	RED	8											
10-40556	RED						7	6	5	4	4	3	
10-234-10S	RED								4				
10-234-15S	RED						7	6	5				
10-234-25P 10-234-25S	RED			8	7								
10-40557	BLUE						7	6	5	4	4	3	
10-234-15P	BLUE						7	6	5				
10-234-15SS	BLUE						7	6	5				
10-40553 10-40552	GREEN						7	6	5				
10-234-15SP	GREEN						7	6	5				

Figure 6: Selector Knob



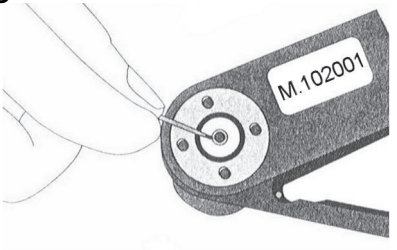
5) Insert the contact into the open tool in the same position as the turret and close the tool just enough to hold the contact without crushing it.

Figure 8: Contact Insertion



6) Insert the stripped conductor to dimension C (Table 2, Page 10) into the contact, being careful to assure that all individual wire strands are within the contact. Ensure wire is visible through the inspection hole. If not, the conductor strip length is too short. Activate crimp tool through a full cycle. Contact will not release unless the tool has closed completely.

Figure 9: Conductor Insertion



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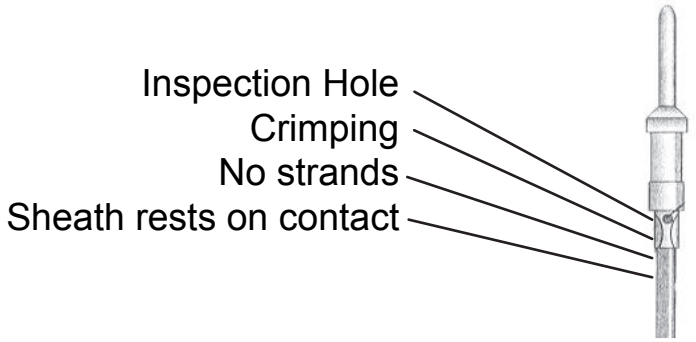

7) Remove the crimped contact from the tool and inspect it for the following:
   - All wire strands are inside the contact.
   - Conductor is visible from the inspection hole.
   - Sheaths rest on the contacts.
   - No breaks are present near the deforming side.
   - Mechanical tightness of the contact on the conductor is to Table 4 (below):

TABLE 4: CRIMP RETENTION FORCES

Cable AWG	Section mm²	Min. conductor tightness Ag+Sn	Ni
4/0	107	397 Kg	356 Kg
0	53	317 Kg	285 Kg
4	22	181 Kg	163 Kg
8	9	100 Kg	90 Kg
12	3	50 Kg	45 Kg
16	1.2	23 Kg	16 Kg

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