Terminal Crimp Instructions

Figure 4

The CRIMPACE Tool is designed to provide perfect terminal crimps for terminal sizes 6 AWG to 3/0 AWG. Each individual crimp position is designated by the gauge number located on the side of the crimp plate designated for terminals. See Figure 4.

TO USE THE CRIMPACE TOOL ON TERMINALS

1. After selecting the gauge to be terminated, be sure the reversible hold down spring is located on the same side as the selected gauge. Reversing the hold down spring is accomplished by removing it from the hole on one end of the crimp plate, sliding it outward until it is free to pivot, then inserting it in the opposite hole.

2. Slide selected terminal over the stripped portion of the cable. Square bolt head on terminal should be on left as your face CRIMPACE Tool side designated for terminals.

3. With crimp plate numbers facing you, push down on opposite side of the plate to allow insertion of the terminal into the proper crimp nest. After inserting terminal in proper nest, release crimp plate so the spring will hold the terminal in position. Insert wire/cable fully into terminal. See Figure 5.

Figure 5

4. Hammer on end until crimp plate and base plate come together. The terminal is now crimped and may be removed from the tool by pushing down on opposite end. See Figure 6.

5. Except for No. 6 and No. 4 AWG, when terminal is marked WELD or BATT use the next larger nest than the size shown on terminal.
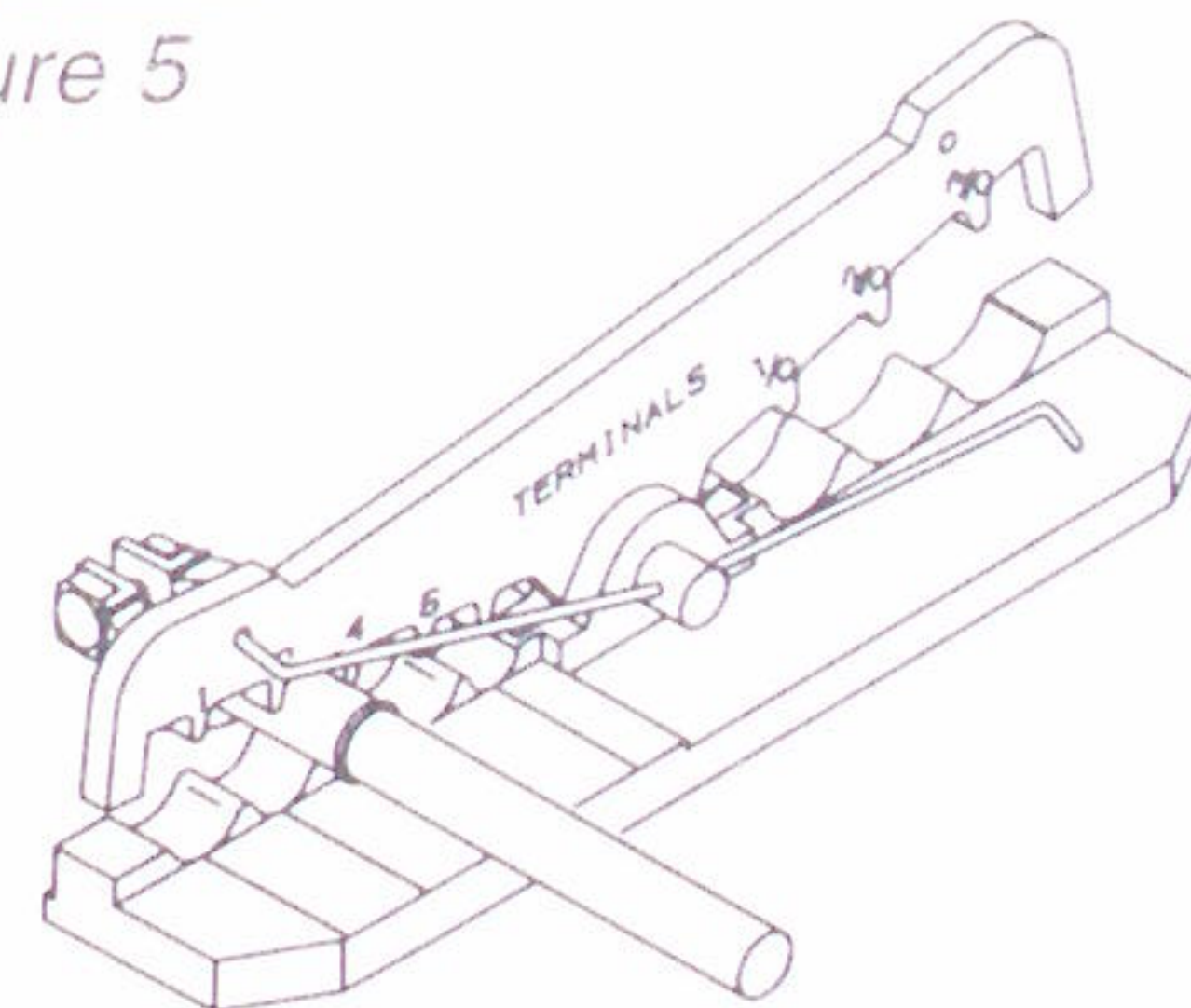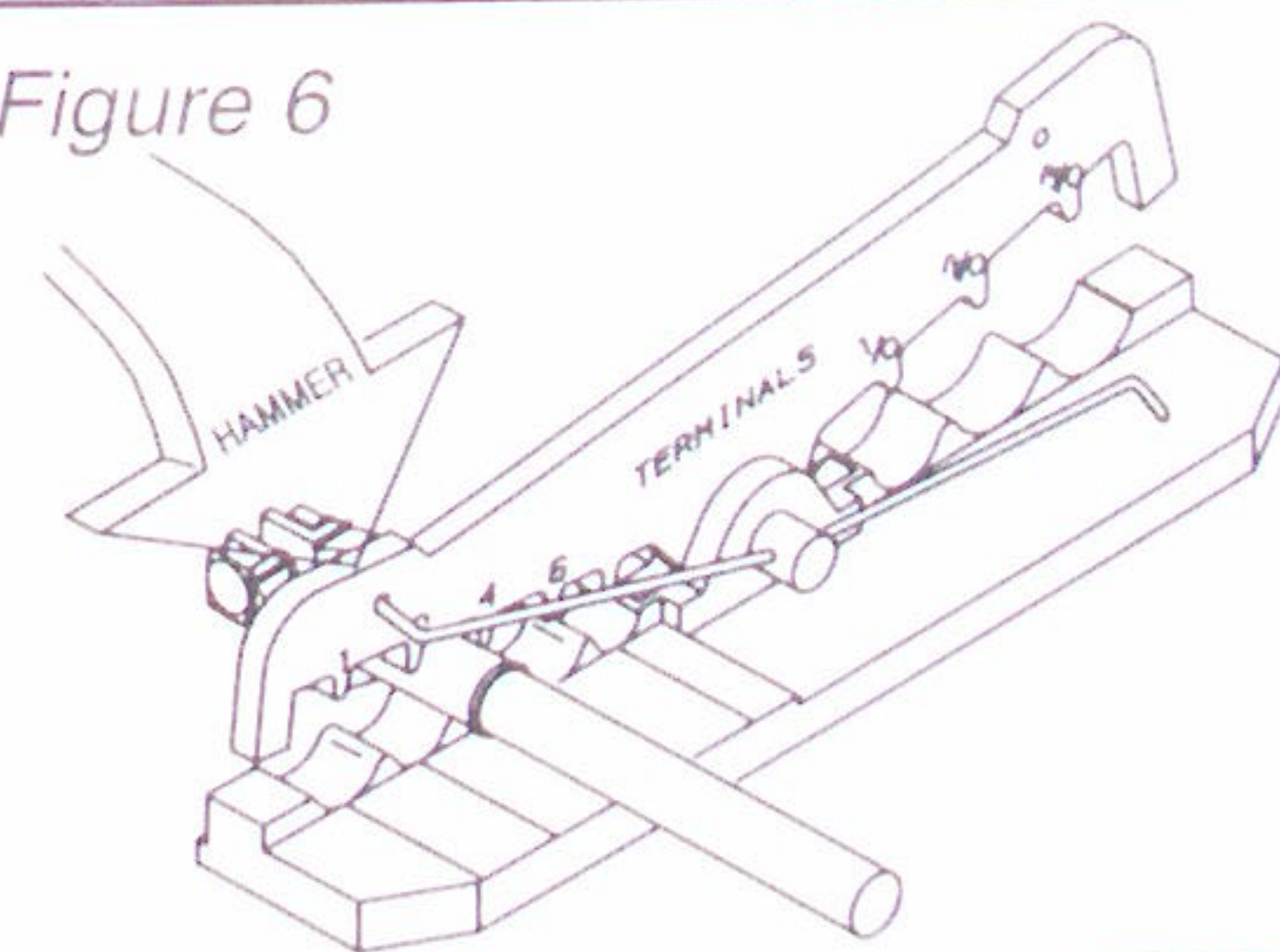
Figure 6

DANGER *To prevent serious eye injury, always wear appropriate eye protection when striking objects with a hammer.*

See Other Side for Lug Crimps
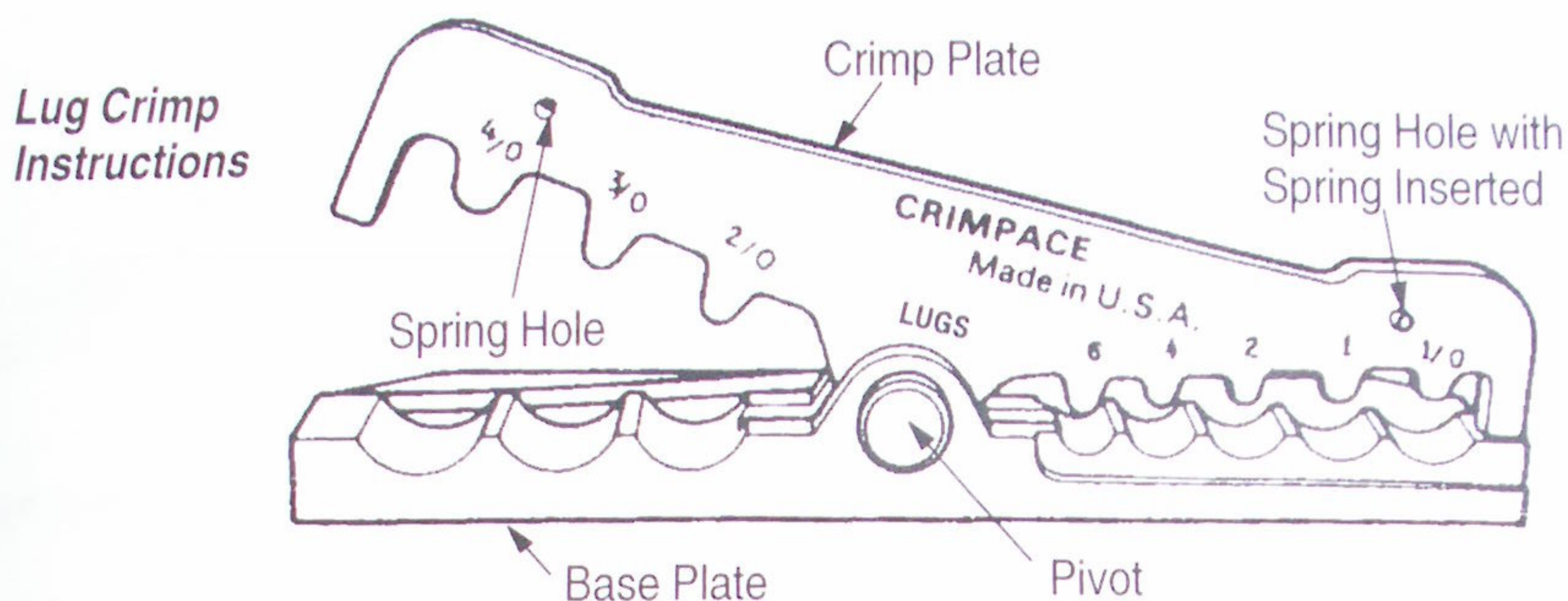
Lug Crimp Instructions

Figure 1

The CRIMPACE Tool is designed to provide perfect lug crimps for lug sizes 6 AWG to 4/0 AWG. Each individual crimp position is designated by the gauge number located on the crimp plate. See Figure 1.

TO USE THE CRIMPACE TOOL ON LUGS

1. After selecting the gauge to be terminated, be sure the reversible hold down spring is located on the same side as the selected gauge. Reversing the hold down spring is accomplished by removing it from the hole on one end of the crimp plate, sliding it outward until it is free to pivot, then inserting it in the opposite hole.

2. Strip the insulation from the wire as indicated in the table:

WIRE GAUGE	6	4	2	1	1/0	2/0	3/0	4/0
STRIP LENGTH [In.]	7/16	1/2	9/16	5/8	11/16	11/16	3/4	13/16

3. Slide selected lug over the stripped portion of the cable.

4. With crimp plate numbers facing you, push down on opposite side of the plate to allow insertion of the lug into the proper crimp nest. After inserting lug in proper nest, release crimp plate so the spring will hold the lug in position. Insert wire/cable fully into lug. See Figure 2.

Figure 2

5. Hammer on end until crimp plate and base plate come together. The lug is now crimped and may be removed from the tool by pushing down on opposite end. See Figure 3.

6. Except for No. 6 and No. 4 AWG, when terminal is marked WELD or BATT use the next larger nest than the size shown on terminal.

DANGER *To prevent serious eye injury, always wear appropriate eye protection when striking objects with a hammer.*
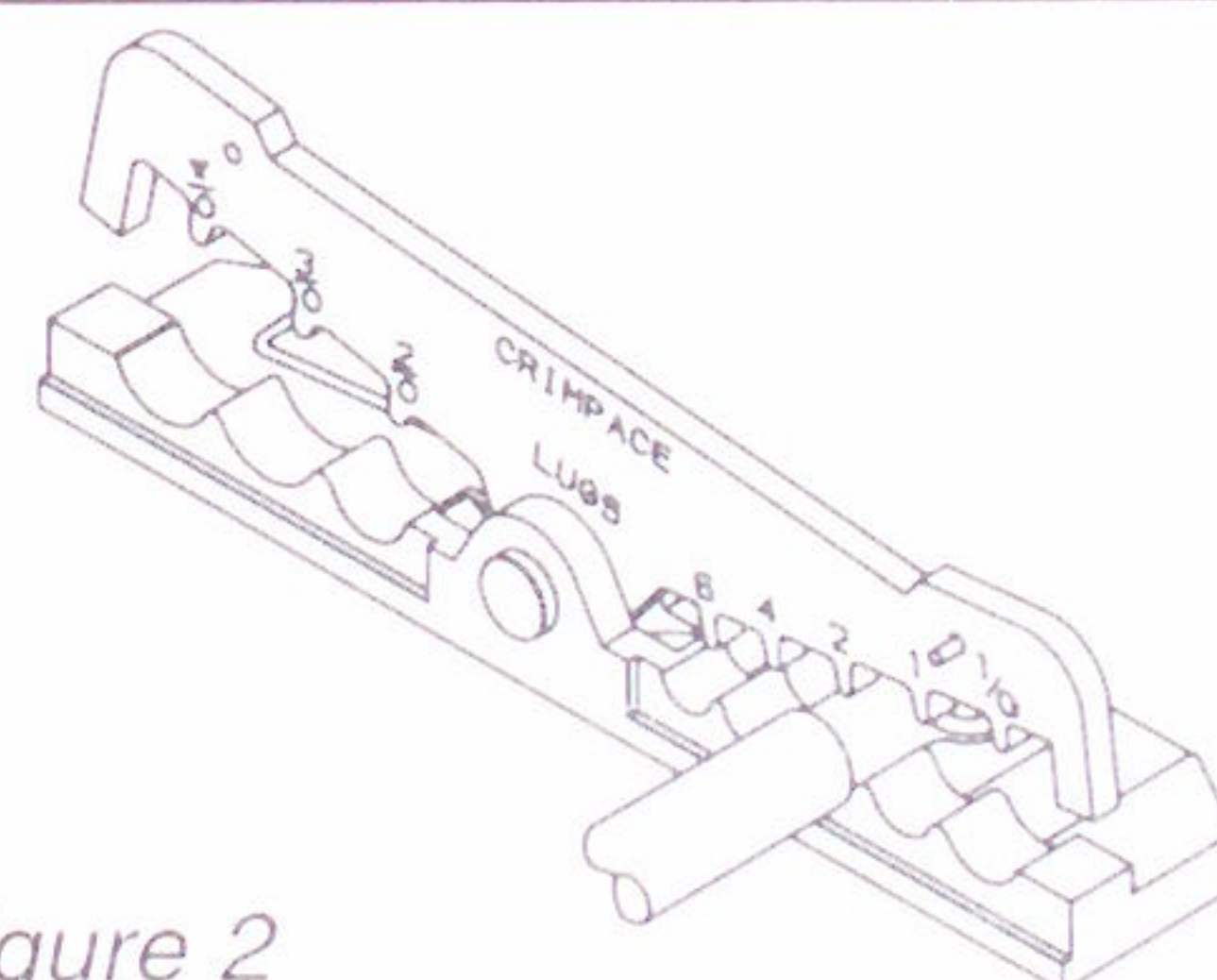
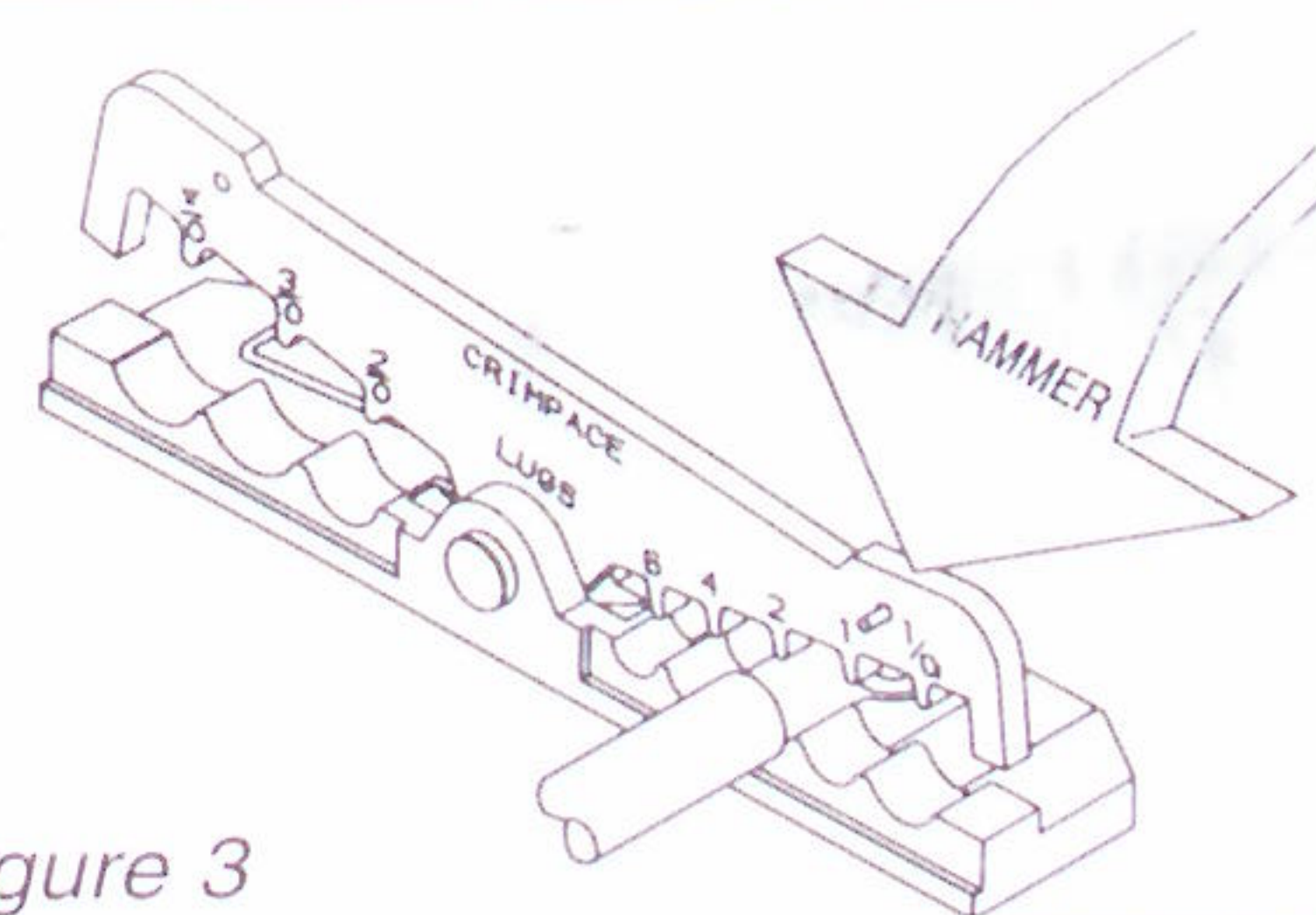*See Other Side for Terminal Crimps*

Figure 3

This controlled document is subject to change. For latest revision call the AMP FAX* number.

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