CAST COPPER BATTERY LUGS

Straight type   Right angle type   Left elbow type   Right elbow type

Stock No. 460
Heavy duty crimping tool which will crimp battery lugs from 8 gauge through 4/0 gauge.

Stock No. 461
Light duty crimping tool crimps battery lugs from 8 gauge through 1 gauge.

Manuf: Waytek Inc.

Manuf: Waytek Inc.

Optional ratchet

Manuf: QuickCable Part No: HexCrimp #4255-001 or HexCrrmp Jr. #4247-001

Manuf: Amp, Roto-Crimp hand tool
Part No: 600850 or 600850-1

Manuf: Molex, Part No: 19078-0007

Two crimps may be required on wire sizes 4-4/0 g

Amp Roto-Crimp Tool

Embossed Letters Must Mate as Shown in Die Order Chart

Die Locator Pin

MODEL#600850
FOR SOLISTRAND AND BATTERY TERMINALS
• DIE STORAGE E – A
DIE SETTING FOR SOLISTRAND

AWG NO.	L DIE	R DIE	NO. OF CRIMPS
8	M	K	1
6	K	K	1
4	J	H	1
2	H	H	2
1/0	E	A	2
2/0	A	C	2
3/0	A	B	2
4/0	A	A	2

Die Indexing Pin

Straight Terminals   Area 1 (Tool Die Setting)

20.64–21.43 mm [.812–.844 in.] Wire Strip Length

Area 2 (Tool Die Setting)

Flag Terminal (Left Hand)   Area

18.26–19.05 mm [.719–.750 in.] Wire Strip Length

Quick Cable and Molex Crimp Tool

Crimp Tool
Classified by Underwriters Laboratories Inc.® For use with UL Listed wire connectors and/or wire connector adaptors identified in the instructions provided.
6R37

Cable Ga.	Quick Cable Crimp Die Settings			The following Quick cable connectors are UL listed when crimped twice with UL classified Quick Cable HexCrimp 4255-001, 4255-001R, 4255-001M or 4255-001MR.
	Cast Copper Connectors	MagnaLugs 100% Copper	Copper Tube Lugs	
8	GREY 25	16	–	4008N, P, U 4808E, F 6408D, E, F, FV, FL
6	GREY 25	16	–	4006N, P, U 4906F 4806E, F 6406D, E, F, FV, FL
4	GREY 25	GREY 25	16	4004N, P, U 4904F 4804E, F, H 6404D, E, F, H, FV, HV, FL, HL 6804 68040, E, F, H 69040, E, F, H
2	GREEN 30	–	GREY 25	4002N, P, U 4102N, P 4202N, P 4302N, P 4902F, H 4802F, H
1	PINK 30	PINK 30	GREY 25	4001N, P, U 4101N, P 4201N, P 4301N, P 4901F, H 4801F, H 6401D, E, F, H, FV, HV, FL, HL 6901 88010, E, F, H 89010, E, F, H
1/0	BLACK 50	BLACK 50	GREEN 30	4010 N, P 4110N, P 4210 N, P 4310 N, P, H 4513F 4810F, H 6410 D, E, F, H, FV, HV, FL, HL 6810 8810 D, E, F, H 8910 D, E, F, H, 6210, 6311, 6321, 6511
2/0	ORANGE 70	ORANGE 70	PINK 30	4020N, P 4120N, P 4220N, P 4320N, P 4920F, H 4620F 4820F, H 4910F, H 6220 6312 6322 64200, E, F, H, FV, HV, FL, HL 6820 88200, E, F, H 89200, E, F, H 4420F 4620F 6520
3/0	PURPLE 71 or 95*	71	BLACK 50	4030 N, P 4130 N, P 4230 N, P 4330 N, P 4930F, H 4530F 4830F, H 6230 6311 6323 6430 D, E, F, H, FV, HV, FL, HL 6830 6830 8830 0, E, F, H 8930 D, E, F, H 4430F, 4630F
4/0	YELLOW 120	YELLOW 120	ORANGE 70	4040 N, P 4140 N, P 4240 N, P 4340 N, P 4840F, H 4940F, H 6440 D, E, F, H, FV, HV, FL, HL 6540 6840 8840 D, E, F, H 8940 D, E, F, H 6240 6314 6324
250 MCM	YELLOW 120	–	–	4060N, P 4160 N, P 4260 N, P 4360 N, P 4860 F, H

See Instruction Sheet For Safety Information   *BilFre 3/0 use 95 die setting   Made in U.S.A.   X11200
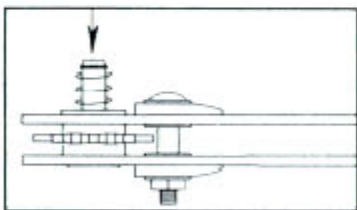
Fig. 1 - Die setting chart
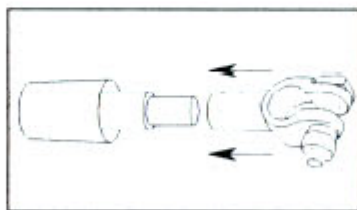
Fig. 2 - Push pin, rotate dies
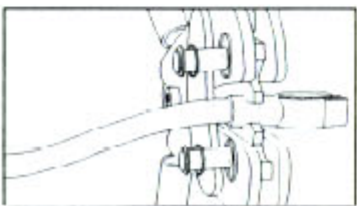
Fig. 3 - Slide heat shrink on first

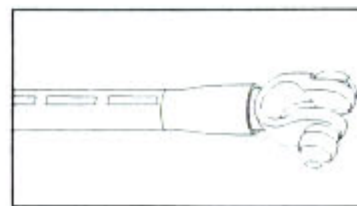**Fig. 4 - Position connector in dies**

Fig. 5 - Crimp twice

1st 2nd

Fig. 6 - Shrink on tubing

4

CLOSED END CONNECTORS (Nylon Insulated)

| 22-14 WIRE RANGE	22-12 WIRE RANGE	16-10 WIRE RANGE	8 WIRE RANGE
NC-2214	NC-2212	NC-1610	NC-8

NYLON-INSULATED, CLOSED-END CONNECTORS

Molex Nylon Closed-End Connectors feature 2-piece construction. A translucent nylon-molded insulation is adhered to the metal connector insert. The connector's insert is annealed, Tin-plated, seamless, pure electrolytic, tough pitch Copper. Individual design and performance requirements dictate the use of Copper inserts. These connectors are all rated for a maximum of 600V.

Wire Range AWG (mm²)	Loose Piece Order No.
14-22 (2.00-0.35)	19160-0012
12-22 (3.30-0.35)	19160-0009
10-16 (5.00-1.90)	19160-0002
8 (8.50)	19160-0024

molex® Splices

Figure 2

ACCEPT

Crimp Centered on Wire Barrel

Stripped Wires Fully Bottomed in Splice
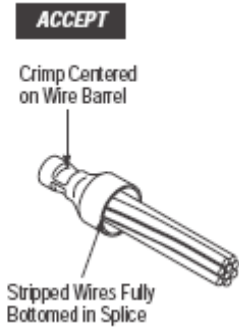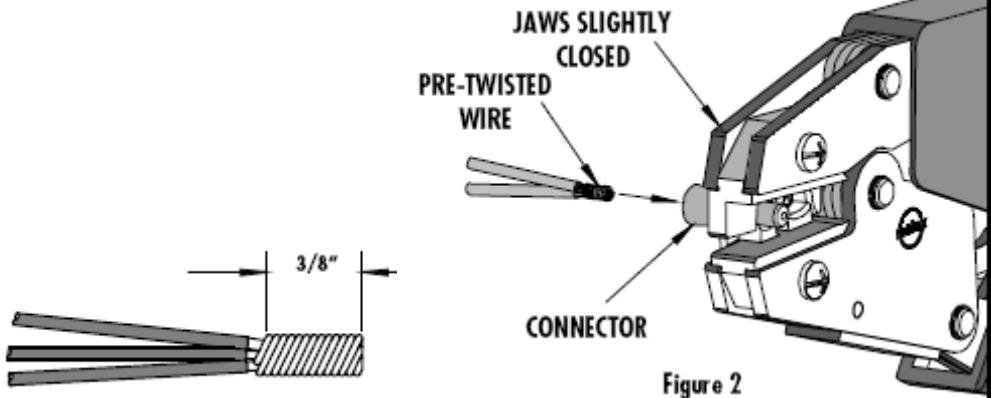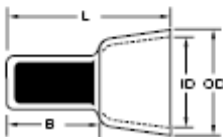
For stranded wire strip leads to approximately 3/4 of an inch. Twist the wire combination even and tight. Trim stripped pre-twisted area to 3/8 of an inch and insert into connector and crimp. For more information follow the Quality Crimping Handbook.

12-22 ga and 10-16 ga
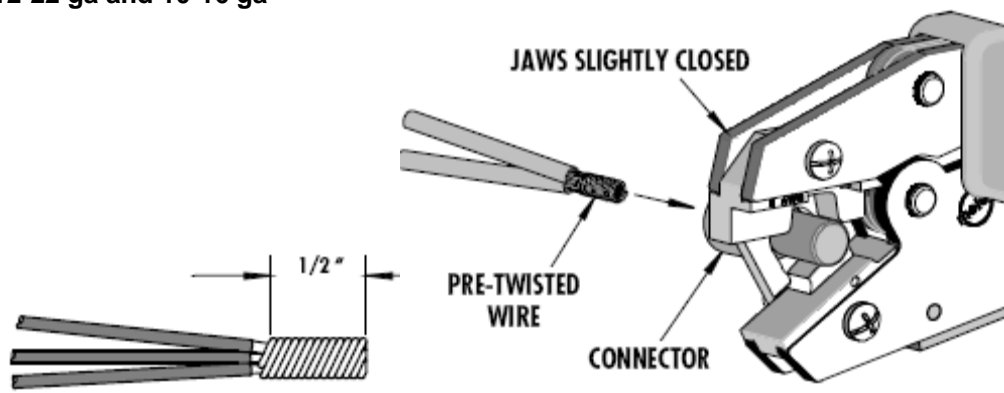
Wire Preparation

For stranded wire strip leads to approximately 7/8 of an inch. Twist the wire combination even and tight. Trim stripped pre-twisted area to 1/2 of an inch and insert into connector and crimp. For more information   8 GA
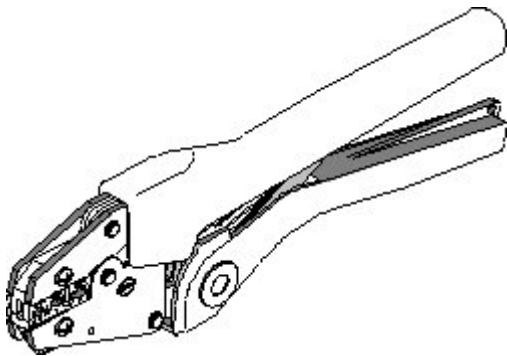
CRIMP TERMINALS: CLOSED END

Hoffman Products (Cadillac Electric) For 22-10 ga.
Part No: YS2210

Hoffman Products (Cadillac Electric) For 8 ga.
Part No: YS8S

Molex
For 22-10 ga Part No: 64001-0600
For 8 ga Part No: 64001-2500

NH 36 B (HAND RATCHET TOOL)
CLOSED ENDS & INTERMEDIATE CONNECTORS
2, 5.5, 8mm²

NH 37 (HAND RATCHET TOOL)
CLOSED ENDS & INTERMEDIATE CONNECTORS
1.25, 2, 5.5mm²

NTM (Nichifu) For 14-10-8 ga Part No: NH-36B

NTM (Nichifu) For 22-10 ga part No: NH-37

HEAVY DUTY LUGS AND SPLICES NON INSULATED
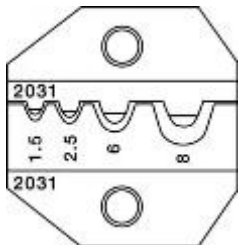## LIGHT DUTY TERMINALS (16-10 ga)

Standard Eyelets

Solid electrolytic copper eyelets are available either tinned plated or in bare copper. Several sizes are offered in this heavy duty terminal and flared ends help with wire insertion. The wire gauge is stamped on the terminal and they meet UL requirements.

Bare Copper   Tinned Copper

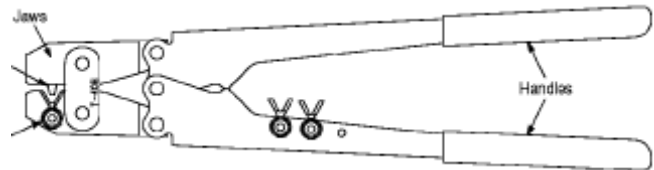**For 16-14-10-8 ga. Non Insulated terminals and lugs**

Manuf: Paladin. Part No: Die only #2031   and   CrimpAll tool frame #8000
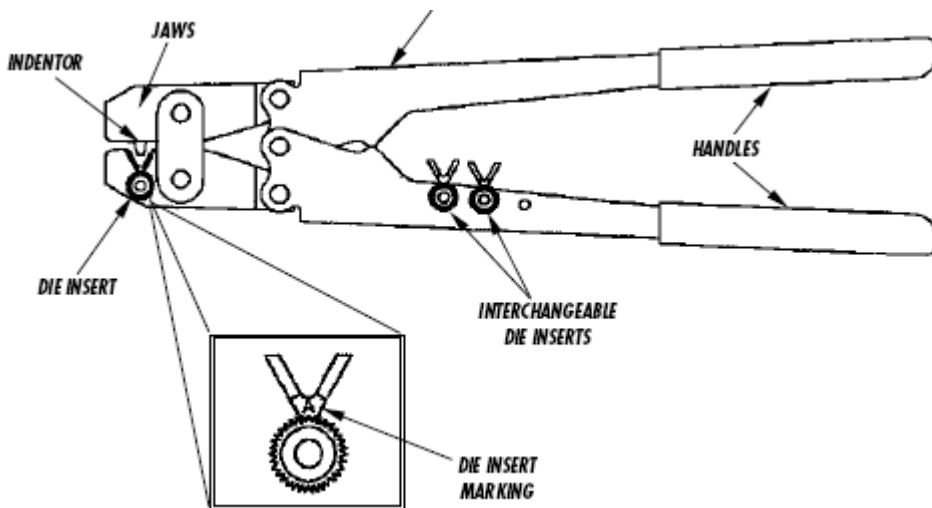
Eyelet Crimper
Stock No. 497
Hand tool that crimps eyelet style copper lug terminals
8 - 4/0 ga. Comes with 3 separate dies.

Jaws   Handles

Manuf: Waytek Inc.   Manuf: Amp Part No: 1526955-1

JAWS
INDENTOR
JAWS
HANDLES
DIE INSERT
INTERCHANGEABLE
DIE INSERTS
DIE INSERT
MARKING

Manuf: Molex

Order No	Description
19284-0034	Hand Crimp Tool

7

PROPER USE GUIDELINES Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications.
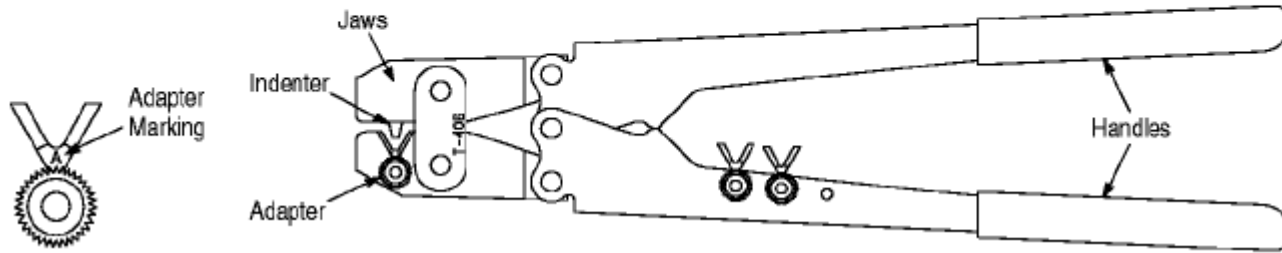
ADAPTER			WIRE		
CRIMP TOOL 1526955–1		AMERICAN ELECTRICAL TERMINAL (AET) CRIMP TOOL T–406	For Heavy–Duty Lug Terminal		
PART NUMBER	MARKING		SIZE (AWG)	STRIP LENGTH	S
1527508–1	A	5992	6	11.11 [$^7/_{16}$]	
			4	12.70 [$^1/_2$]	
1527507–1	B	5991	1/0	17.46 [$^{11}/_{16}$]	
			2/0	17.46 [$^{11}/_{16}$]	
1527505–1	C	5989	2	14.29 [$^9/_{16}$]	
			1	15.87 [$^5/_8$]	
No Adapter	—	No Adapter	3/0	19.05 [$^3/_4$]	
			4/0	20.64 [$^{13}/_{16}$]	

Figure 1

1. INTRODUCTION

Crimp Tool 1526955–1 is used to crimp heavy–duty lug terminals (reference part number 1526000–2) and AMP Power Series 50 and 75 contacts (reference part number 647877–1) onto the wire sizes given in Figure 1.

NOTE *Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.*

2. DESCRIPTION

The tool consists of jaws, handles, and three adapters. Each adapter is marked with an alphabetic letter to correspond with the wire size being used. See Figure 1.

3. CRIMPING PROCEDURE

1. Strip the wire to the dimension given in Figure 1.

2. Install the applicable adapter onto the jaw.

3. *Fully* insert the wire into the wire barrel.

4. Center the wire barrel with the wire in the adapter. For the lug terminal, make sure that the pad side of the wire barrel faces the tool indenter.

5. Completely close the tool handles. Open the handles, and remove the product.

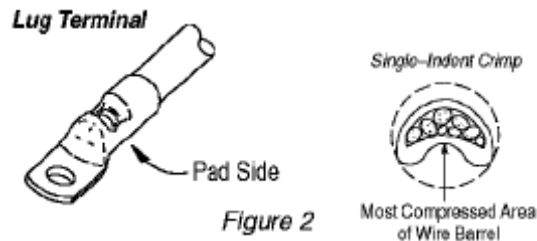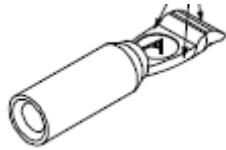6. Inspect the product for a quality crimp. Refer to Figure 2.

Figure 2

POWERPOLE (SY) SB175 AMP CONNECTOR

4 ga Contract, Part No: SY944-2
Wire strip length 1 1/8"

Stock No. 460
Heavy duty crimping tool which will crimp battery
lugs from 8 gauge through 4/0 gauge.

Stock No. 461
Light duty crimping tool crimps battery lugs
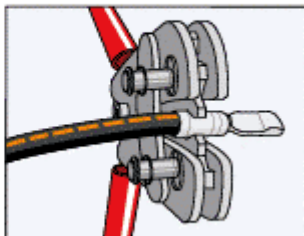from 8 gauge through 1 gauge.

Manuf: Waytek Inc.   Manuf: Waytek Inc.

Manuf: QuickCable Part No: HexCrimp #4255-001 or HexCrrmp Jr. #4247-001

Manuf: Amp, Roto-Crimp hand tool Part No: 600850 or 600850-1

① SBC™ Crimp

- Use a crimp tool for solid dependable crimps
- Excellent for general commercial and industrial applications
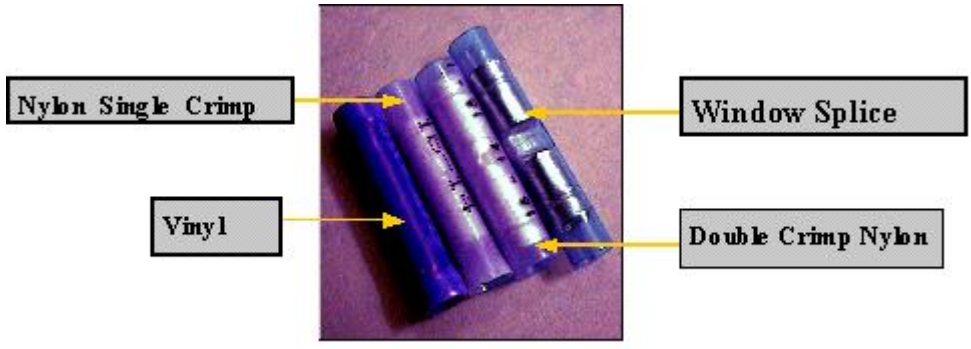
Crimp contact twice, ready to use

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CRIMP TERMINALS: RED BLUE YELLOW

SOLDERLESS CRIMP TERMINALS AND SPLICES, NYLON INSULATED, DOUBLE CRIMP STYLE

(THIS REPRESENT SOME OF THE MANY CHOICES AVAILABLE IN CRIMP TERMINALS)

Nylon Single Crimp

Window Splice

Vinyl

Double Crimp Nylon

NYLON DOUBLE CRIMP STYLE (THE ONES WITH THE COPPER SLEEVE OVER THE TERMINAL BARREL) ARE THE BEST FOR HIGH VIBRATION ENVIRONMENTS BECAUSE THEY SUPPORT THE WIRE INSULATION WHERE IT EXITS THE TERMINAL
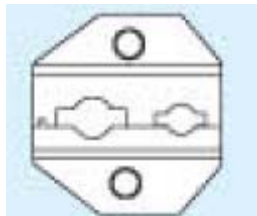
Manuf: Paladin Tools
Crimp Tool Frame #1302

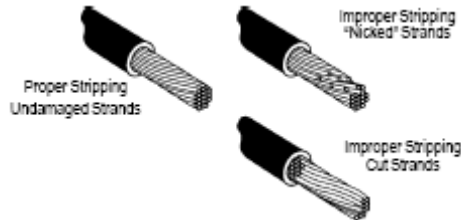Manuf: Paladin Tools
CrimpALL Tool Frame #8000

NOT RECOMMENDED
CAN'T DO A GAS TIGHT CRIMP

Improper Stripping "Nicked" Strands

Proper Stripping Undamaged Strands

Improper Stripping Cut Strands
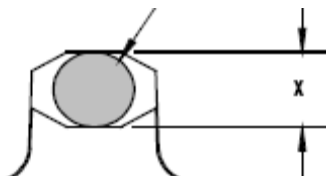
Manuf: Paladin Tools
Insulated Terminals
DIE ONLY#2035

Manuf: Eclipse Tools
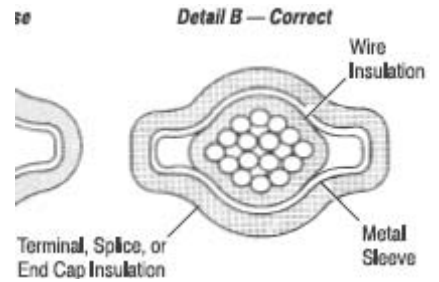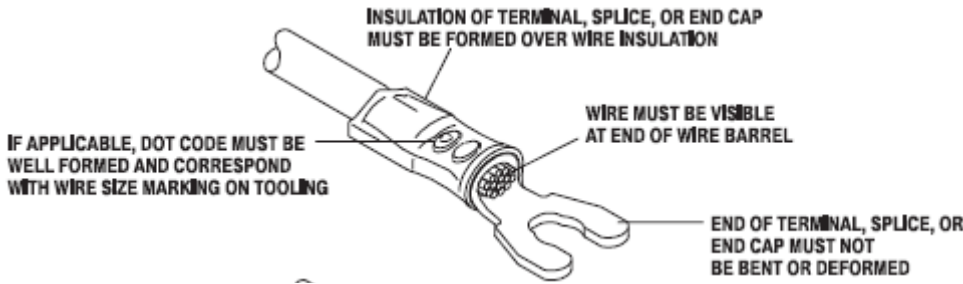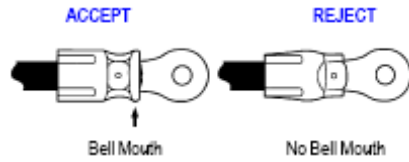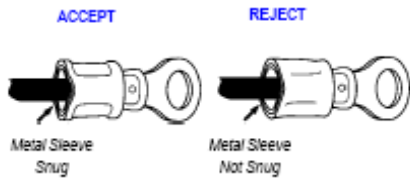Flag Terminals
DIE ONLY #300-070

RED 22-16 ga crimp height=.109 - .115"
BLUE 16-14 ga crimp height=.119 - .125"
YELLOW 12-10 ga crimp height=.169 - .175"

Strip length Terminals:
Red=7/32"
Blue=7/32"
Yellow=5/16"

Strip length **Butt splice**:
Red=1/4"
Blue=1/4"
Yellow=3/8"

ACCEPT   REJECT

Metal Sleeve
Snug

Metal Sleeve
Not Snug

ACCEPT   REJECT

Bell Mouth   No Bell Mouth

INSULATION OF TERMINAL, SPLICE, OR END CAP
MUST BE FORMED OVER WIRE INSULATION

IF APPLICABLE, DOT CODE MUST BE
WELL FORMED AND CORRESPOND
WITH WIRE SIZE MARKING ON TOOLING

WIRE MUST BE VISIBLE
AT END OF WIRE BARREL

END OF TERMINAL, SPLICE, OR
END CAP MUST NOT
BE BENT OR DEFORMED

Detail B — Correct

Wire
Insulation

Terminal, Splice, or
End Cap Insulation

Metal
Sleeve

REAR VIEW

This is what your crimped connectors should look like, oval shaped and uniform. This was crimped on a double crimp tool. In the center photo (wire at the inlet side) note the oval shape that the wire and insulation has been formed into. This is   caused by the insulation crimp sleeve being formed around the wire. The photo on the far right is so that you could see the solidity of the crimp.

Air-Powered Crimpers—Air power gives you higher volume output with less operator fatigue and greater crimp consistency than a hand-operated crimper. Crimpers work with 22-10 AWG insulated terminals. Operate on 85 to 95 psi air supply; air inlet connection is ¼" NPT male. Complete crimper includes aluminum crimper and steel die set. Overall length is 12".

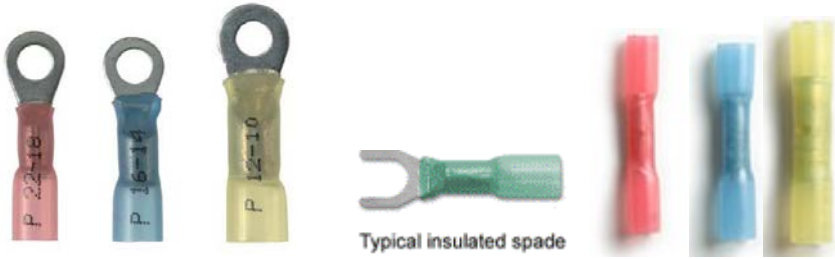| Insulated Terminal Style	Complete Crimpers Each	Replacement Die Sets Each
Rings, Spades, Splices	7754K1 ..... $738.81	7754K4 ..... $326.09

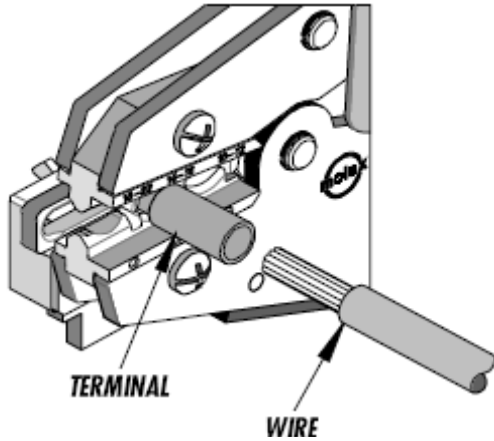McMaster Carr

Unicon 3 Universal
Conversion Tool

Paladin Tools Pneumatic Hand
Tool Operator

11

CRIMP TERMINALS WITH HEAT SHRINK
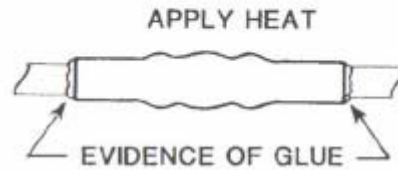# HEAT SHRINK COVERED CRIMP TERMINALS

Typical insulated spade

TERMINAL

WIRE

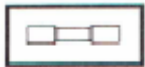Wire strip length for red, blue & yel=5/16"

GLUED HEAT SHRINK APPLICATION

APPLY HEAT

EVIDENCE OF GLUE

Perma-Seal™ Crimper
Stock No. 479
Seller: Waytek Wire.   Manuf: Molex, Part No: 64016-0041

3122 CT
- Crimps conductor portion of heat-n-seal terminals.
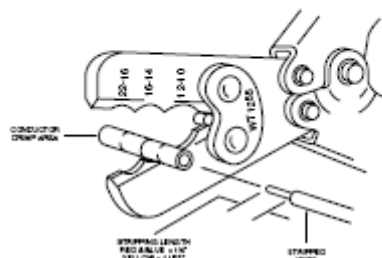- Crimps are produced in three cavities: RED 22-16 AWG, BLUE 16-14 AWG and YELLOW 12-10 AWG

Rosta Tool Co. (Sargent Quality Tools)

Rachet Hand Tools – (Continued)

Cat. No.	Description
WT1255	RA, RB, RC Heat Shrinkable nylon insulated terminals, butt splices and disconnects

Pre-load 35 to 45 pounds.

WT1255

Nest
22-18
16-14
12-10

Manuf: Thomas & Betts (Sta-Kon) Part No: WT1255

AD-1522 Crimp Tool
Manuf: Tyco (Raychem) Part No: AD-1522

DELPHI

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