



Hand Tool 1309 Series

Crimp Tool Operating Procedure

Tool Maintenance

- Maintenance and inspection should be performed regularly.
- Tool should be wiped clean with special emphasis on the crimping cavities.
- Tool may be cleaned by immersing in a suitable commercial solvent or cleaner which does not attack plastic material or paints.
- Tool should be relubricated after cleaning using a light film of medium weight oil on bearing surfaces and pivot pins.
- When not in use keep handles closed. Store in a clean dry area.

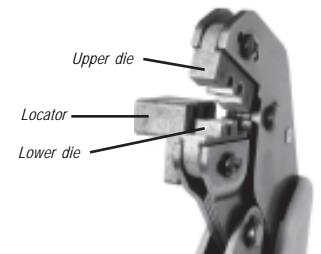
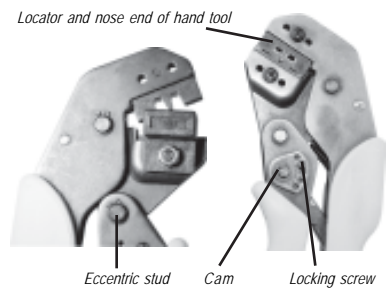
Eccentric Adjustment

- To adjust tool to obtain proper force values, open the handles and remove the cam jack screw with a Phillips screwdriver.
- Rotate the cam clockwise to increase handle load or counterclockwise to decrease handle load.
- Position odd numbers on the cam in the locking screw hole adjacent to the letter "L" and even numbers adjacent to the letter "T".
- Lock the cam at the desired handle load setting and remeasure the force.
- Continue adjustment if necessary.

1309 Crimp Tool Series Operating Procedure

- Strip cable according to manufacturer's specifications.
- Select the appropriate nest for the contact being crimped.
- Place contact in die end of modular locator, butting against back of die cavity.
- Close tool carefully until jaws grip the contact.
- Insert the properly stripped wire into the contact.
- Holding the wire in place, close the tool past the ratchet release position and allow the jaws to spring open.
- Remove and inspect the crimp.
- Test by holding contact and pulling firmly on cable.

Apply torque as shown until ratchet releases. The force at a point 1-3/4" from handle end should be between 15-25 pounds for most crimping situations.



Tooling Part Number	Contacts	Wire Size AWG(mm ²)	Pullout Values (lbs) (per UL standard 486A)	Tool Cavities
1309G1	1202G1	#14-16 (2.5-1.5)	50-30	C
	1203G1	#14-16 (2.5-1.5)	50-30	C
1309G2	1331	#12-16 (4.0-1.5)	70-30	30
	1332	#16-20 (1.5-0.5)	30-13	15
	262G1	16-20 (1.5-0.5)	30-13	15
	200G2L	16-20 (1.5-0.5)	30-13	15
	269G2	16-20 (1.5-0.5)	30-13	15
1309G3	261G1	12-14-16	70-50-20	A
	261G2	14-16 (2.5-1.5)	50-30	A
	261G2	10-12 (6.0-4.0)	80-70	B
	269G1	12-16 (4.0-1.5)	70-30	A
	269G3	10-14 (6.0-2.5)	80-50	A
1309G4	1307	#6 (16.0)	100	Large
	5900	#6 (16.0)	100	Large
	5914	#10-12 (6.0-4.0)	80-70	Small
	5915	#10-12 (6.0-4.0)	80-70	Large
	5952	#8 (10.0)	90	Large
	903G1	#6 (16.0)	100	Large
	904G1	#10-12 (6.0-4.0)	80-70	Large
1309G5	200G1L	6mm, #10-14	80, 80-50	B
	201G1H	6mm, #10-14	80, 80-50	B

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS. A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZED CONTACT. ADJUST RATCHET RELEASE HANDLE FORCE TO 5-15 LBS.

For additional updates see APP website

All Data Subject To Change Without Notice

ASM-1309 1S6373 REV04

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