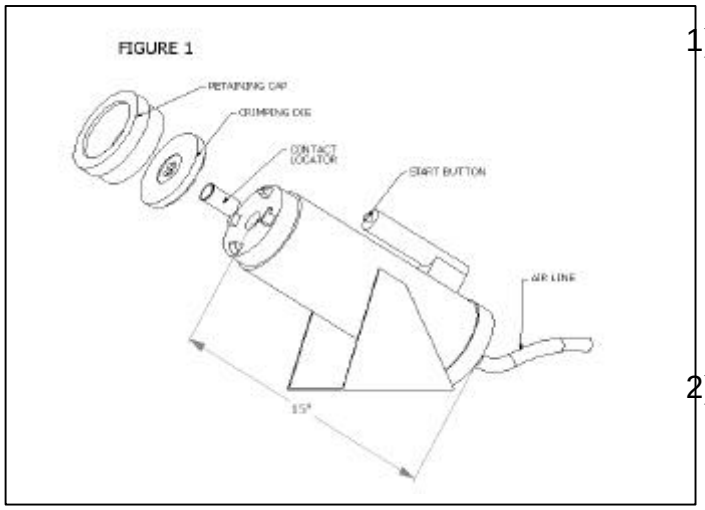
CRIMPING INSTRUCTIONS FOR CATALOG # 1387G1
PNEUMATIC CRIMP TOOL

The 1387G1 is a heavy-duty pneumatic tool which crimps Anderson contacts with a wire range from #10/12 AWG to 4/0 cable. This tool is either bench mountable or portable and operates off of standard shop air pressure (90 to 125 psi). Interchangeable dies and locators are used to produce a four-indent crimp on numerous Anderson contacts. The list of Anderson dies and locators for this tool is shown in the following table:

Connector	Contact Size	Die P/N	Locator P/N
SB50/PP75	#6 & #8 AWG	1388G6	1389G6
SB50/PP75	#10/12 AWG	1388G7	1389G7
PP120	#2 THRU #6 AWG	1388G4	1389G4
SB175/PP180	#2 AWG & 1/0	1388G3	1389G3
SB175/PP180	#4 AWG	1388G5	1389G5
SB350	2/0 & 3/0	1388G2	1389G2
SB350	4/0	1388G1	1389G1
PP30 PIN/SOCKET	#10/12 AWG	1388G8	1389G8

The exploded view of the tool, die and locator is shown in Figure 1.



CRIMPING INSTRUCTIONS:

1) Wire Preparation: Wire should be stripped to length specified in the table above. Care should be taken not to cut or damage any strands of the wire. Wire must be clean and fee of contaminates and oxidation.

2) Tool Preparation: Connect the tool to a dry air source. Air pressure requirement is 90-125 psi (620-860 kPa).

3) Once the proper die and locator are selected, the die opening should be verified using calibrated pin gages of the proper diameter. The die has a diameter value (in inches) stamped on the outer casing. This value should be used to select the necessary "GO" and "NO GO" pin gages. The stamped value + .002" is the "NO GO" diameter and the stamped value -.005" is the "GO" diameter. Contact the factory for prefabricated "GO/NO GO" gages.

4) Follow operation instructions provided with the tool. ***IMPORTANT:*** Do not operate the tool without a locator installed. Loose parts can cause ***severe*** damage if they fall into the body of the tool through the locator opening.

5) Crimp Validation: Make several sample crimps after tool calibration is verified. Take one or more samples and perform a pull test on the contact-wire assembly. The pull test is done by securing the contact from the front (not the contact barrel) and pull on the wire until it pulls out of the contact, breaks, or meets the required value. Typically if

the force value meets the value specified in the table below, for a one minute duration, a satisfactory crimp has been made. However, a good crimp should exceed the value specified in the table. Once the crimped contact passes the pull test, measurements for the crimp indent should be taken using a point micrometer or similar instrument. If possible, crimp resistance should also be measured on the same sample. Note: the crimped sample should meet all applicable local agency requirements. These requirements take precedence over all suggested values in this document.