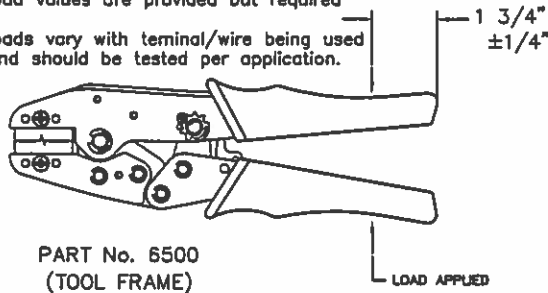


6500 SERIES CRIMP TOOL OPERATING INSTRUCTIONS

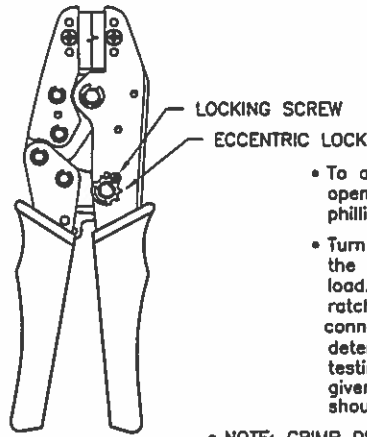
MAINTENANCE AND INSPECTION

Apply force as shown until ratchet releases. The force at a point 1-3/4" from handle ends should be adjusted for terminal/wire size being crimped to provide required pullout/tensile values. Suggested handle-load values are provided but required

loads vary with terminal/wire being used and should be tested per application.



PART No. 6500
(TOOL FRAME)



ECCENTRIC ADJUSTMENT PROCEDURE

- To adjust the tool to obtain the proper force values, open the handles and remove the locking screw with a phillips head screwdriver.
- Turn the eccentric stud counter-clockwise (+) to increase the handle load....or clockwise (-) to decrease the handle load. The handle load is the force required to release the ratchet. Higher handle loads are required to crimp large connectors and/or large wire gages to completion. The determination of the proper handle load is obtained through testing of the specific connector/wire combination. Values given in the following instructions are approximate and should be verified with proper testing techniques.

• NOTE: CRIMP DIMENSIONS MAY NOT MEET U.L. REQUIREMENTS.

NON-INSULATED

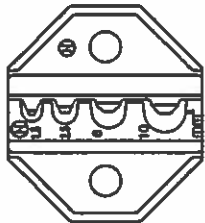


22-8 AWG

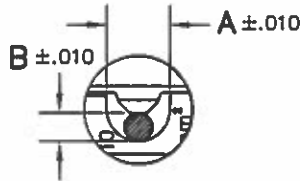
GAGING INFORMATION

| NEST | A (WIDTH) mm(in) | B (HEIGHT) mm(in) |
|-----------------------------|------------------|-------------------|
| 1.5 mm ² (20-18) | 3.50 (.138) | 0.90 (.035) |
| 2.5 mm ² (18-14) | 4.20 (.165) | 1.90 (.075) |
| 6 mm ² (12-10) | 6.0 (.238) | 2.90 (.114) |
| 10 mm ² (8) | 7.40 (.291) | 3.30 (.130) |

* GAGING USING GO/NO GO PIN/PLUG GAGES WITH TOOL CLOSED TO LAST TOOTH OF RATCHET



SEAM GOES DOWN INTO NEST



PART No. 6500-25 SHOWN

THE NON-INSULATED CRIMP DIE CRIMPS STANDARD NON-INSULATED RING, FORK AND SPADE BRAZED AND UNBRAZED CONNECTORS AS WELL AS MISCELLANEOUS OTHER TYPES OF NON-INSULATED CONNECTORS.

ALL CRIMPS SHOULD BE TESTED FOR ACCEPTABLE TENSILE VALUES FOR THE PARTICULAR TERMINAL AND WIRE BEING USED AND COMPARED AGAINST ACCEPTED STANDARDS (UL OR MIL). VALUES FOR THE INTENDED WIRE SIZES ARE LISTED AND SHOULD BE CHECKED WITH AN APPROPRIATE TENSILE TESTING MACHINE OR OTHER DEVICE.

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

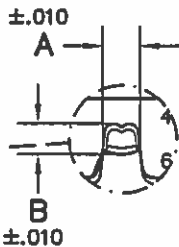
A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

ADJUST RATCHET RELEASE HANDLE FORCE TO 10-20 LBS. FOR OPEN BARREL TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.

OPEN BARREL



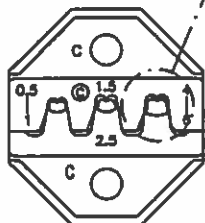
22-10 AWG



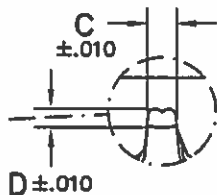
GAGING INFORMATION (FRONT/INSUL)

| FRONT | A (WIDTH) mm(in) | B (HEIGHT) mm(in) |
|-----------------|------------------|-------------------|
| 0.5-1.0 (20-18) | 3.50 (.138) | 2.00 (.079) |
| 1.5-2.5 (18-14) | 4.40 (.173) | 2.70 (.106) |
| 4-6 (12-10) | 6.0 (.238) | 3.60 (1.42) |

* GAGING USING SOLID WIRE SOLDER WITH TOOL CLOSED TO LAST TOOTH OF RATCHET



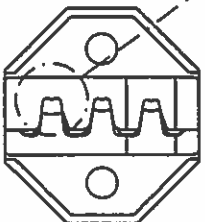
FRONT



GAGING INFORMATION (REAR/COND.)

| NEST | C (WIDTH) mm(in) | D (HEIGHT) mm(in) |
|-----------------|------------------|-------------------|
| 0.5-1.0 (20-18) | 2.20 (.087) | 1.10 (.043) |
| 1.5-2.5 (18-14) | 3.20 (.128) | 1.60 (.063) |
| 4-6 (12-10) | 4.30 (.169) | 1.90 (.075) |

* GAGING USING SOLID WIRE SOLDER WITH TOOL CLOSED TO LAST TOOTH OF RATCHET



REAR

TEST VALUES FOR CONNECTORS

| AWG | OR | WCM (mm ²) | UL (COPPER) | MIL |
|-----|----|------------------------|-------------|-----|
| 22 | | 0.32 | 8 | 15 |
| 20 | | 0.52 | 13 | 19 |
| 18 | | 0.82 | 20 | 38 |
| 16 | | 1.3 | 30 | 50 |
| 14 | | 2.1 | 50 | 70 |
| 12 | | 3.3 | 70 | 110 |
| 10 | | 5.3 | 80 | 150 |
| 8 | | 8.4 | 90 | |

THE OPEN BARREL CRIMP DIE IS DESIGNED TO CRIMP A VARIETY OF OPEN BARREL TERMINALS AVAILABLE IN THE MARKET-PLACE. IT MAY NOT WORK ON SOME MANUFACTURER'S TERMINALS OR TYPES. DUE TO THE MIRIAD OF TERMINALS AVAILABLE, THIS CAN BE DETERMINED ONLY THROUGH TESTING AND TRIAL AND ERROR.

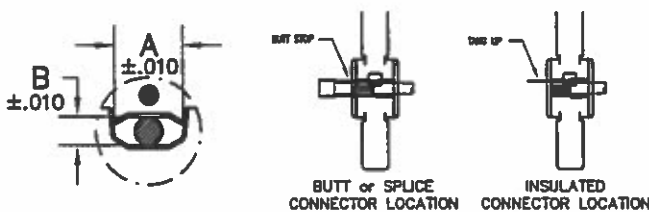
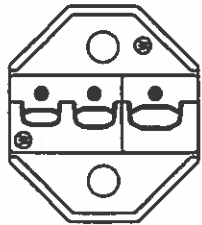
THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS.

A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.

ADJUST RATCHET RELEASE HANDLE FORCE TO 10-20 LBS. FOR OPEN BARREL TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.



RED 18-22 BLUE 14-16
YELLOW 10-12



GAGING INFORMATION

| NEST | A (WIDTH) mm(in) | B (HEIGHT) mm(in) |
|--------|------------------|-------------------|
| RED | 6.0 (.236) | 2.2 (.087) |
| BLUE | 6.50 (.256) | 2.2 (.087) |
| YELLOW | 8.50 (.335) | 3.40 (.134) |

*GAGING USING GO/NO GO PIN/PLUG GAGES WITH TOOL CLOSED TO LAST TOOTH OF RATCHET

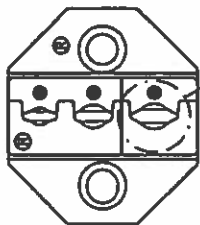
PART No. 6500-40

Select the appropriate nest for the terminal or wire splice being crimped. Position terminal or splice as shown in diagram. Close tool carefully until jaws grip the terminal without distortion. Insert the properly stripped wire into the terminal. 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.

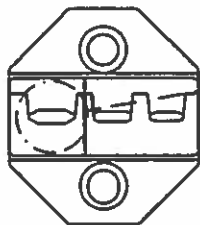
ADJUST RATCHET RELEASE HANDLE FORCE TO **15-25 LBS** FOR INSULATED TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION DEPENDING ON WIRE SIZE AND CONNECTOR BRAND AND STYLE OR TYPE.



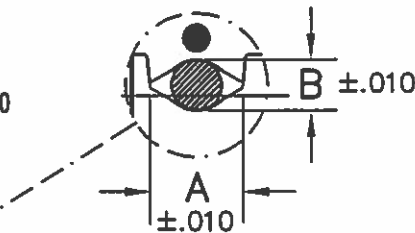
RED 18-22 BLUE 14-16 YELLOW 12-10



FRONT (INSULATION)



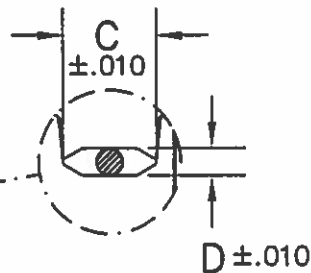
REAR (CONDUCTOR)



GAGING INFORMATION (FRONT/INSUL.)

| NEST | A (WIDTH) mm(in) | B (HEIGHT) mm(in) |
|--------|------------------|-------------------|
| RED | 6.0 (.236) | 3.0 (.118) |
| BLUE | 6.50 (.256) | 4.10 (.161) |
| YELLOW | 8.50 (.327) | 4.90 (.177) |

*GAGING USING GO/NO GO PINS WITH TOOL CLOSED TO LAST TOOTH OF RATCHET

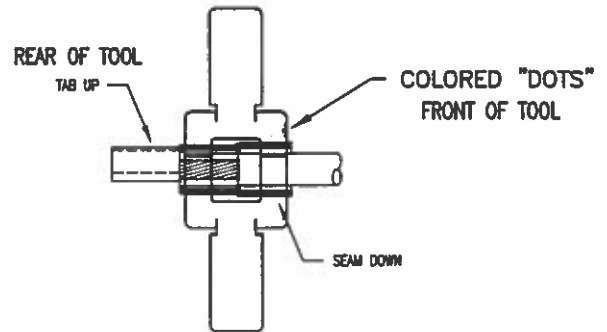


GAGING INFORMATION (REAR/COND.)

| NEST | C (WIDTH) mm(in) | D (HEIGHT) mm(in) |
|--------|------------------|-------------------|
| RED | 6.80 (.268) | 1.80 (.083) |
| BLUE | 8.40 (.331) | 1.80 (.071) |
| YELLOW | 6.30 (.248) | 2.40 (.095) |

*GAGING USING GO/NO GO PINS WITH TOOL CLOSED TO LAST TOOTH OF RATCHET

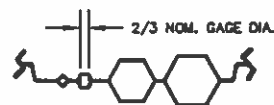
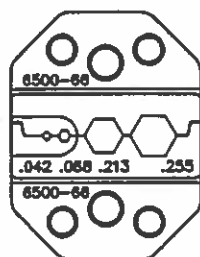
PART No. 6500-41



SELECT THE APPROPRIATE NEST FOR THE TERMINAL BEING CRIMPED. POSITION THE TERMINAL WITH INSULATION SIDE TOWARDS THE FRONT OF THE TOOL. POSITION THE TERMINAL WITH THE TAB UP AND THE SEAM DOWN IN THE APPROPRIATE NEST AS SHOWN. CLOSE THE TOOL CAREFULLY UNTIL THE JAWS GRIP THE TERMINAL WITHOUT DISTORTION. INSERT THE PROPERLY STRIPPED WIRE INTO THE TERMINAL. HOLDING THE WIRE IN PLACE, CLOSE THE TOOL PAST THE RATCHET RELEASE POSITION AND ALLOW THE JAWS TO OPEN. REMOVE AND INSPECT THE CRIMP. ADJUST RATCHET RELEASE HANDLE FORCE TO **15-25 LBS** FOR SLIDE-ON TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.



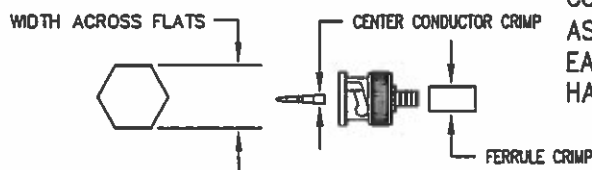
RG58/59 COAX



GAGING INFORMATION

| NEST | GAGING |
|------|----------------|
| .042 | .042 (50) NOM. |
| .068 | .071/.083 |
| .213 | .213 NOM. |
| .255 | .255 NOM. |

*GAGING USING FLATTED GO/NO GO PINS WITH TOOL CLOSED TO LAST TOOTH OF RATCHET



Strip cable according to manufacturer's specifications. Select proper hex cavity for size of cable being used. Crimp center conductor in area shown. Assemble connector and crimp outer ferrule.

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 OVERSIZE CONNECTOR. ADJUST RATCHET RELEASE HANDLE FORCE TO **20-35 LBS** DEPENDING ON SIZE OF CONNECTOR & CABLE. LARGER CONNECTORS REQUIRE HIGHER HANDLE PRE-LOADS TO ASSURE A SECURE AND SYMMETRICAL CRIMP. MEASURE EACH CRIMP ACROSS THE FLATS AND ADJUST THE HANDLE PRE-LOAD TO OBTAIN SYMMETRY WITHIN .003.

PART No. 6500-66