

**INSTRUCTIONS FOR:  
6225 CT "B" STYLE BATTERY LUG CRIMPING TOOL FOR 2-6  
AWG OPEN-BARREL STYLE LUGS AND TERMINALS**



**CALIBRATION PROCEDURE:**

This tool is adjusted at the factory and no further adjustment should be required.

Should the tools, through extended use, require adjustment, wear in the parts may be compensated for as follows:

- 1) Close tool handles until pre-load is reached (this is the point at which jaws butt).
- 2) Measure the distance between the outside of the handles at the end of the handle grips. 11 1/4"- 11 3/4" is the correct distance.
- 3) To calibrate the tool, loosen the bottom set screw slightly by turning counter clockwise. Then tighten the top set screw by turning clockwise until the distance between the handles is 11 1/4"-11 3/4" as shown on figure 1. Tighten the bottom set screw to clamp the setting.
- 4) Recheck the distance between the handles after making three crimps.

In addition, always:

- 1) Check tool calibration at least daily. It is recommended that at least the first and last crimp of the day are tested.
- 2) Never exceed the specified handle distance when adjusting your crimp tool. Premature wear will result.
- 3) Lubricate linkages on a regular basis to maximize tool life.

**CRIMPING PROCEDURE:**

- 1) Follow terminal manufacturer's recommendations for wire size and preparation
- 2) Select the proper nest by AWG wire size and type of terminal being used from the crimping matrix (Fig 2) and on the frame of tool.
- 3) Insert the terminal in the proper nest with the tab or post portion to the rear. Partially close the tool to begin forming the ears. This will help by holding the terminal in place.
- 4) Insert the properly stripped wire into the terminal and finish the crimp by closing the handles fully. Inspect the crimp for stray or mis-crimped wire strands. Remove if necessary.
- 5) Should an insulation crimp be required it is performed in the "C" nest. The insulation crimp is best done after the conductor crimp and finish the insulation crimp by fully closing the handles. See Fig. 3

**Note:** Some open-barrel terminals may need to be closed up slightly to fit into the nest of the tool

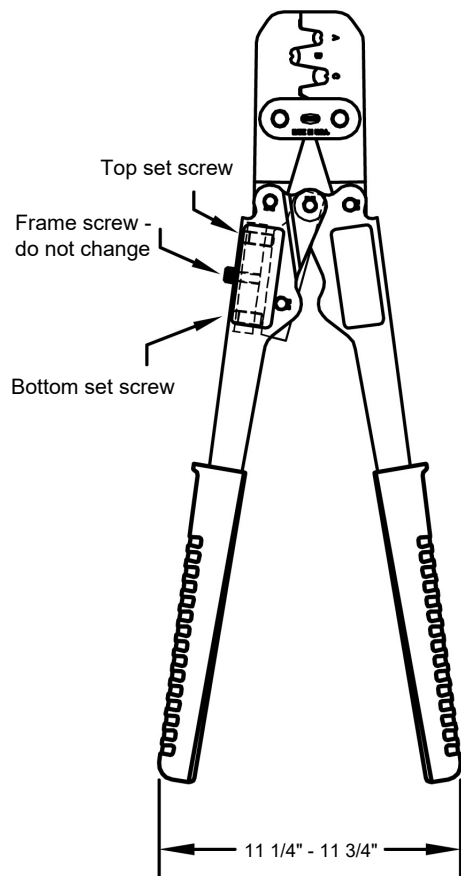


Figure 1

NEST	A	B	C
LUGS	2-6 AWG CONDUCTOR		2-6 AWG INSULATION
TERMINALS		4-6 AWG	1-2 AWG

Figure 2

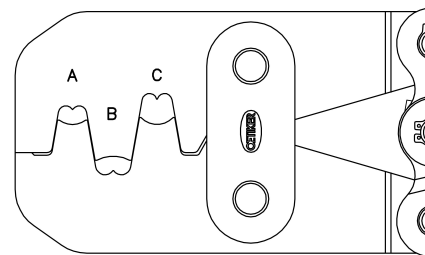


Figure 3

Warranty is null and void if the date the date coded adjustment sticker is removed from the tool.



Manufactured by:  
Oetiker Tool Corp.  
30 E. Industrial Rd. Branford, CT 06405  
USA Tel 203-488-8665  
www.sargenttools.com