

1309G8 Tool Kit Assembly Instructions Used to make tools 1309G2, 1309G3 or 1309G6



Figure 1

NOTE: Instructions are included with each crimp tool for terminating specific contacts. Use of non-Anderson crimp tools can affect UL & CSA approval. See website for comprehensive tooling data.

The 1309G8 Tool Kit has three die sets, three locators and one frame for crimping 15/45 Amp Anderson Power™ contacts (see figure 1). The following instructions describe how to change the configuration from the 1309G2, 1309G3 and 1309G6 configurations.

The dies and locators are color coded to identify the components required for each configuration (see figure 2). See table below for configurations.

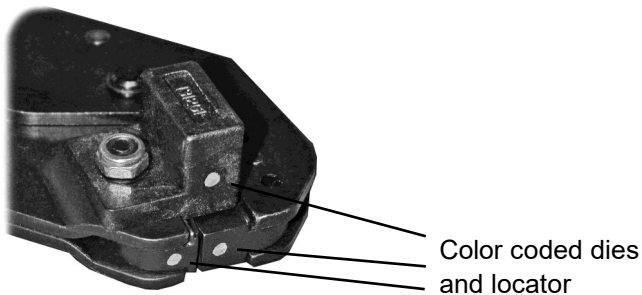


Figure 2

Modification Procedure

Disassemble

Step 1

Remove the nut, wavy washer and locator.

Step 2

Unscrew the top and bottom die screws.

Step 3

Remove the dies from the frame. The tool can now be assembled with a different configuration.

Reassemble

Step 1

Assemble the desired die in the top position with the supplied screw. Place the bottom anvil die in the frame (see figure 3).

Step 2

Tighten the screws until they bottom on the frame and loosen ½ turn.

Step 3

Place the locator, wavy washer and nut on the screw, in that order (see figure 4).

Step 4

Tighten until the nut & locator bottom-out, 9 mm or 11/32" wrench (see figure 5).

Step 5

Loosen the nut one complete turn. This is required for correct tool operation.

Step 6

Adjust the release force to 25 lbf (111.21 N) minimum at the handle ends. The load can be checked by placing the end of one of the handles on a scale and pushing the other grip until the ratchet releases. If the tool requires adjustment, follow the adjustment procedure.

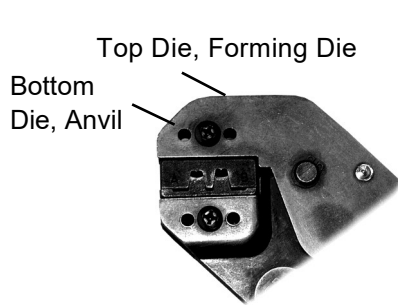


Figure 3



Figure 4

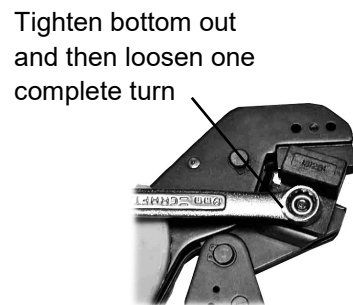


Figure 5

How to Adjust Tool Preload

(It may be necessary, when changing dies, or over the normal life of the tool, to adjust the tool handle preload).

Step 1

To adjust tool to obtain proper crimp force values, open the handles and remove the cam lock screw with a hex key wrench supplied (see figure 6).

Step 2

Rotate the cam clockwise to increase handle load or counterclockwise to decrease handle load.

Step 3

Rotate cam to next available hole in handle. Rotate toward the "+" symbol on the lock face to increase force and toward the "-" symbol to decrease force.

Step 4

Lock the cam at the desired handle load setting by inserting the locking screw and remeasure the force (25 lbs.)

Step 5

Continue adjustment if necessary.

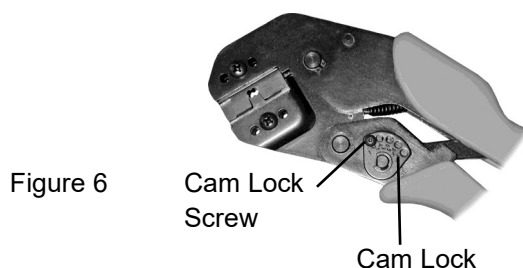


Figure 6

1309 Crimp Tool Series Operating Procedure

Step 1

Strip cable according to manufacturer's specifications.

Step 2

Select the appropriate tool cavity for the contact being crimped.

Step 3

Place contact in die end of modular locator. Insert contact fully until the wire stops on the contact are recessed into the locator (see figure 7).

Step 4

Close tool carefully until jaws grip the contact.

Step 5

Insert the properly stripped wire into the contact.

Step 6

Holding the wire in place, close the tool past the ratchet release position and allow the jaws to open.

Step 7

Remove and inspect the crimp.

Step 8

Test by holding contact and pulling firmly on cable.

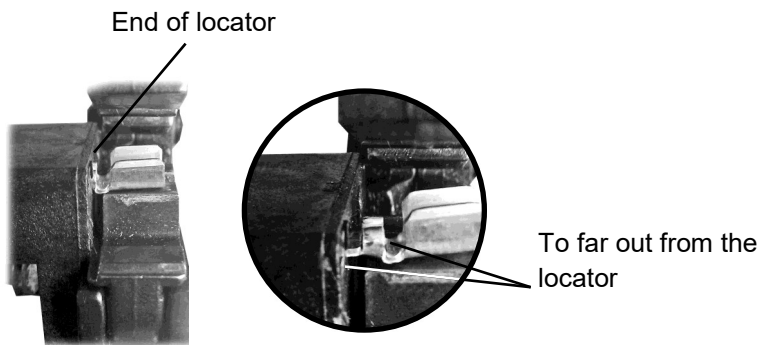


Figure 7

Certification

Tool user is responsible to ensure that the tool is adjusted to provide proper crimps, that conform to required quality and pull force values.

- If the tool does not meet minimum pull force values, handle preload should be increased and the pull test rerun, (See How to Adjust Preload).
- When the hand tool is no longer capable of achieving minimum pull force, it should be taken out of service and replaced.

Note: See Contact Reference Guide on next page

Contact Reference Guide

Tooling Part Number	Contact Series Loose Piece Only	Locator Color Code	Die Color Code	Wire Size AWG (mm ²)	Pullout Values (lbf) (per UL standard 486A) When Properly Crimped **	Tool Cavity
1309G2	1331	Red	Red	12 to 16 (1.3 to 3.3)	70 to 30	30
	1332	Red	Red	20 to 16 (0.52 to 1.3)	30 to 13	15
	262G1-LPBK	Red	Red	16 to 20 (1.3 to 0.52)	30 to 13	15
	269G2-LPBK	Red	Red	16 to 20 (1.3 to 0.52)	30 to 13	15
1309G3	261G1-LPBK	Yellow	Yellow	12 to 16 (3.3 to 1.3)	70 to 30	A
	261G2-LPBK	Yellow	Yellow	14 to 10 K* (2.1 to 5.3)	80 to 50	B
	261G2-LPBK	Yellow	Yellow	14 to 10 K* (2.1 to 5.3)	50 to 30	A
	269G1-LPBK	Yellow	Yellow	16 to 12 (1.3 to 3.3)	70 to 30	A
	269G3-LPBK	Yellow	Yellow	14 to 10 K* (2.1 to 5.3)	80 to 50	A
1309G6	200G1L-LPBK	Blue	Blue	14 to 10 SF* (2.1 to 6.0)	80 to 50	B
	201G1H-LPBK	Blue	Blue	10 to 14 (5.3 to 2.1)	80 to 50	B
	1830G1-LPBK	Blue	Blue	10 to 14 (5.3 to 2.1)	80 to 50	B

** Tool user is responsible to ensure that the crimps made conform to the quality and agency specifications.
 K* is for 10 AWG class K stranded wire or smaller. For larger wires use Super Flex contacts.
 SF* indicates wires with high stranding such as Super Flex.

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