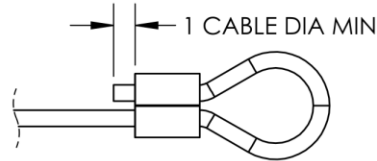


Cable Assembly Crimping Instructions

Step 1: Assemble

Loop the cable through a ferrule as shown, leaving a minimum of 1 cable diameter tail length.



Step 2: Crimp

Use the following table to select the correct tool, gauge, and appropriate number of crimps per ferrule for a given cable size or ferrule:

Cable Size	Ferrule	Tool Jaw Groove	# of Crimps	Gauge Groove
2 (.062")	CL-2-DF	VB4	2	VB4
3 (.094")	CL-3-DF	VG	3	VG

Position the crimping tool at one end of the ferrule as shown. Ensure that the oval's long axis is in the direction of the crimp with each side resting in the appropriate groove in the jaw, completely within the crimping tool.

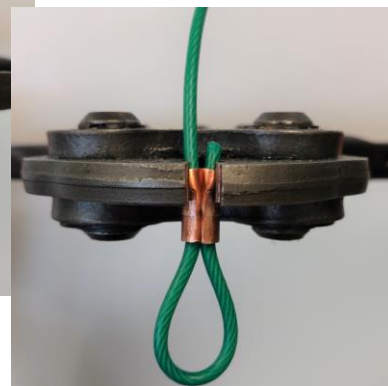
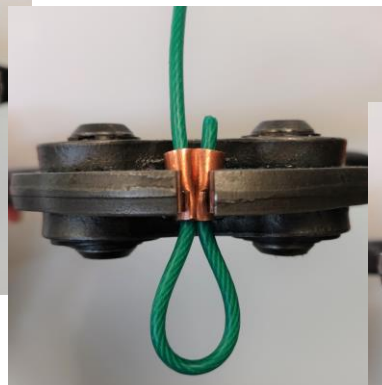
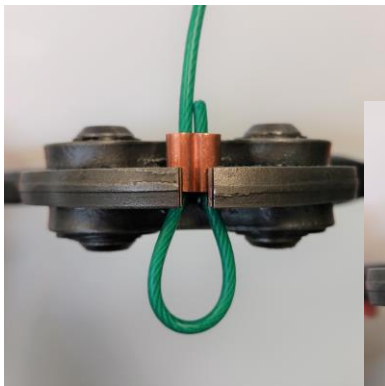


Apply pressure until the jaw closes completely.

It's good practice to gauge the first crimp to check the crimping tool is calibrated properly before crimping the rest of the ferrule. See step 3 for relevant gauging information.



When making 3 crimps on a single ferrule, it is important that the middle never be crimped last. That leaves nowhere for the deforming metal to go thereby opening up the previous crimps and weakening the hold.

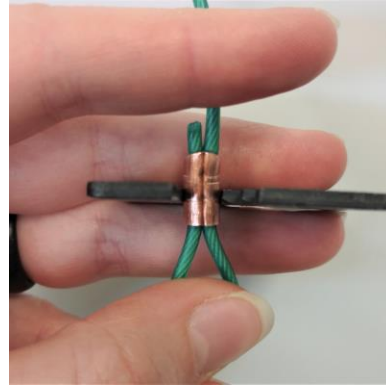


Step 3: Gauge

Hold the cable assembly in the same position relative to the gauge slot as it was to the tool jaw with the sides against the slot walls.

If the crimped ferrule slides freely into the slot, it's been sufficiently crimped.

If the crimped ferrule does not slide freely into the slot, the crimping tool will need to be adjusted.



Adjusting the Crimping Tool

Relieve pressure on the jaws by opening up the handles. On the side of one handle there should be 2 screws. The one closest to the jaws is the adjustment screw. The one furthest away is a locking screw.

Loosen the locking screw by about 2 turns.

Turn the adjustment screw clockwise $\frac{1}{4}$ turn.

Tighten the locking screw by the same 2 turns.

Repeat assembly crimping steps 1 – 3 above, adjusting the tool as necessary until the crimped ferrule slides freely through the gauge slot.

