



# CAT. NO. 18840, TERMINAL CRIMPER WITH ROTATING DIE SET FOR 8 - 4/0 AWG UNINSULATED TERMINALS

**GENERAL INFORMATION:**

- This crimper is for use with copper terminals. Do not use on steel terminals.
- When needed, lubricate the pivot points with 30 weight oil.
- Be sure there is no power to the cable being crimped.
- CAUTION: When working under the hood exercise extreme care as a spark could cause an explosive action from hydrogen gas produced by the battery. Open flames must not be present. Do not work over batteries or smoke nearby. Always wear safety eye and face protection.
- This crimper requires two hands for operation. The larger the diameter cable, the greater the force to complete the crimp.
- Keep body parts away from the moving pieces of the crimper.

**INSTRUCTIONS FOR USE:**

1. Use the chart to determine the position to which the rotating dies should be set.

AWG	SETTING FOR		
	STANDARD COPPER TERMINALS	THICK WALL COPPER TERMINALS	CAST COPPER BATTERY TERMINALS
8	---	16	GREY 25
6	---	16	GREY 25
4	16	GREY 25	GREY 25
2	GREY 25	---	GREEN 30
1	GREY 25	PINK 30	PINK 30
1/0	GREEN 30	BLACK 50	BLACK 50
2/0	PINK 30	ORANGE 70	ORANGE 70
3/0	BLACK 50	95	PURPLE 71
4/0	ORANGE 70	YELLOW 120	YELLOW 120
250 MCM	---	---	YELLOW 120

2. Sealing the crimped connection with double wall adhesive heat shrink tubing is recommended. Slide the appropriate size tubing over the wire's insulation to a point a few inches behind the stripped wire. After the terminal is crimped, slide the heat shrink tubing so it straddles the terminal and wire's insulation before applying heat to shrink the tubing and create the proper seal.
3. Spread the handles to open the jaws.
4. Select the required die setting position from the chart.
5. Push inward the retention pin from the side with the spring to rotate the first die to the proper position. Align the required position on the die with the arrow on the jaw. Release the retention pin to lock the die in place. Make sure the retention pin is completely seated to fully extend outward. Be sure both dies are properly set for the terminal being crimped. Die sets incorrectly set can result in an improper crimp and/or tool damage.

Continued

6. Repeat Step #5 for the other rotating die.
7. Strip the insulation from the cable to be crimped to the length recommended by the terminal manufacturer. Be careful not to remove strands.
8. Insert the cable into the terminal. Be sure to include all the strands.
9. Depending on the terminal used, some manufacturers recommend crimping the terminal twice. When this is the case, the first crimp should be at the open end of the terminal.
10. While the jaws are open, position the terminal in the die set. Completely close the handles for the proper crimp. Many terminal manufacturers indicate where the crimp(s) should be. Repeat the procedure at the other location if the second crimp is required.
11. Pull the terminal to make sure the crimp is secure.
12. Seal the connection with heat shrink tubing as noted in Step #2.

