



Hand Tool 1309 Series

Crimp Tool Operating Procedure

Tool Maintenance

- Maintenance and inspection should be performed regularly.
- Tool should be wiped clean with special emphasis on the crimping cavities.
- Tool may be cleaned by immersing in a suitable commercial solvent or cleaner which does not attack plastic material or paints.
- Tool should be relubricated after cleaning using a light film of medium weight oil on bearing surfaces and pivot pins.
- When not in use keep handles closed. Store in a clean dry area.

Eccentric Adjustment

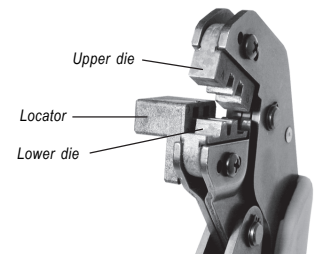
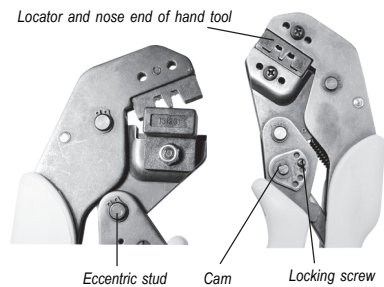
- To adjust tool to obtain proper force values, open the handles and remove the cam jack screw with a Phillips screwdriver.
- Rotate the cam clockwise to increase handle load or counterclockwise to decrease handle load.
- Position odd numbers on the cam in the locking screw hole adjacent to the letter "L" and even numbers adjacent to the letter "T".
- Lock the cam at the desired handle load setting and remeasure the force.
- Continue adjustment if necessary.

1309 Crimp Tool Series Operating Procedure

- Strip cable according to manufacturer's specifications.
- Select the appropriate nest for the contact being crimped.
- Place contact in die end of modular locator, butting against back of die cavity.
- Close tool carefully until jaws grip the contact.
- Insert the properly stripped wire into the contact.
- 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.
- Test by holding contact and pulling firmly on cable.

| Tooling Part Number | Contacts | Wire Size AWG(mm ²) | Pullout Values (lbs) (per UL standard 486A) | Tool Cavities |
|---------------------|----------|---------------------------------|---|---------------|
| 1309G1 | 1202G1 | #14-16 (2.5-1.5) | 50-30 | C |
| | 1203G1 | #14-16 (2.5-1.5) | 50-30 | C |
| 1309G2 | 1331 | #12-16 (4.0-1.5) | 70-30 | 30 |
| | 1332 | #16-20 (1.5-0.5) | 30-13 | 15 |
| | 262G1 | 16-20 (1.5-0.5) | 30-13 | 15 |
| | 200G2L | 16-20 (1.5-0.5) | 30-13 | 15 |
| | 269G2 | 16-20 (1.5-0.5) | 30-13 | 15 |
| 1309G3 | 261G1 | 12-14-16 | 70-50-20 | A |
| | 261G2 | 14-16 (2.5-1.5) | 50-30 | A |
| | 261G2 | 10-12 (6.0-4.0) | 80-70 | B |
| | 269G1 | 12-16 (4.0-1.5) | 70-30 | A |
| | 269G3 | 10-14 (6.0-2.5) | 80-50 | A |
| 1309G4 | 1307 | #6 (16.0) | 100 | Large |
| | 5900 | #6 (16.0) | 100 | Large |
| | 5914 | #10-12 (6.0-4.0) | 80-70 | Small |
| | 5915 | #10-12 (6.0-4.0) | 80-70 | Large |
| | 5952 | #8 (10.0) | 90 | Large |
| | 903G1 | #6 (16.0) | 100 | Large |
| | 904G1 | #10-12 (6.0-4.0) | 80-70 | Large |
| 1309G5 | 200G1L | 6mm, #10-14 | 80, 80-50 | B |
| | 201G1H | 6mm, #10-14 | 80, 80-50 | B |
| 1309G6 | 1830G1 | 6mm, #10-14 | 100, 80-50 | B |

Apply torque as shown until ratchet releases. The force at a point 1-3/4" from handle end should be between 15-25 pounds for most crimping situations.



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 OVERSIZED CONTACT. ADJUST RATCHET RELEASE HANDLE FORCE TO 5-15 LBS.