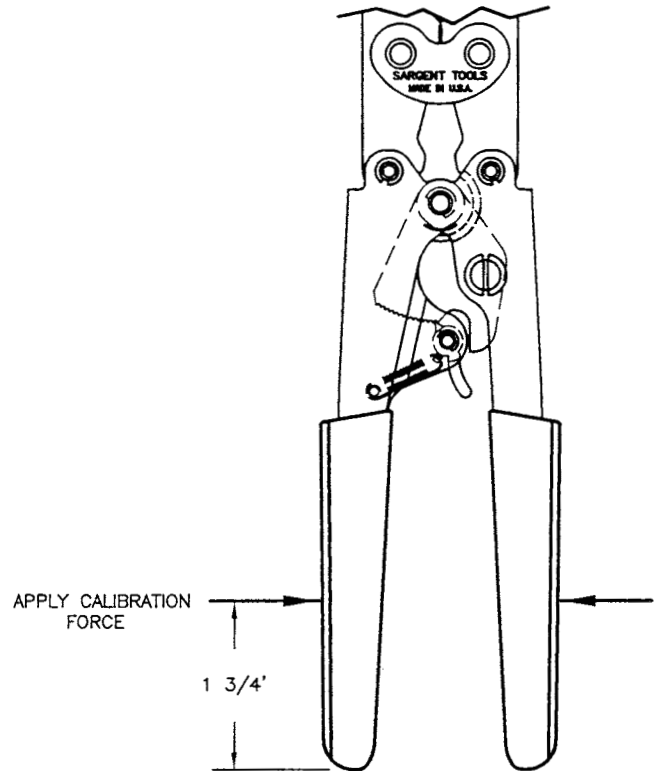
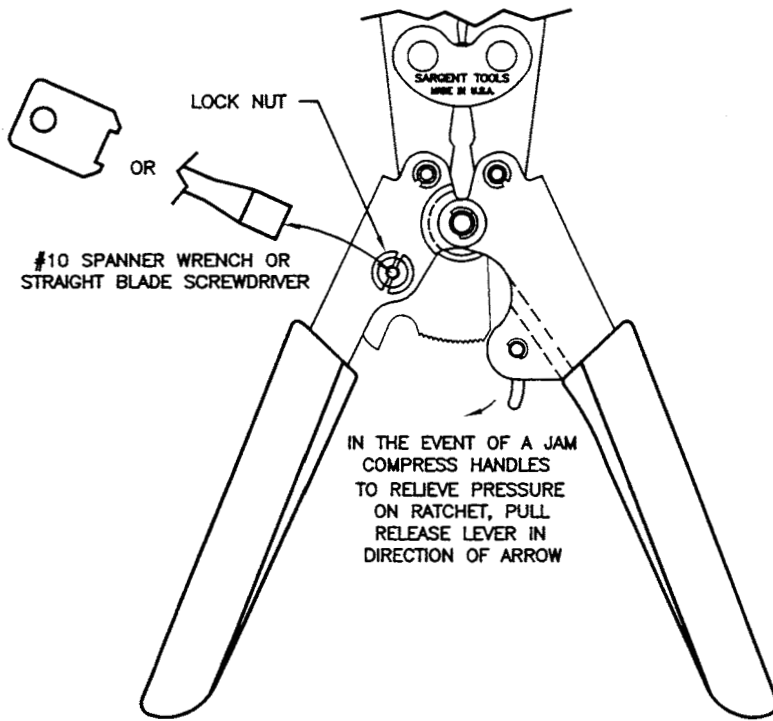


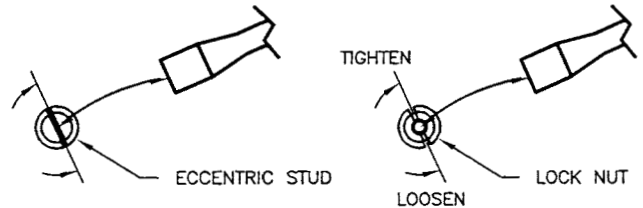
3100 SERIES CRIMP TOOL CALIBRATION PROCEDURE



APPLY CALIBRATION FORCE

1 3/4"

ROTATE CLOCKWISE TO INCREASE PRELOAD



ROTATE COUNTERCLOCKWISE TO DECREASE PRELOAD

CALIBRATION PROCEDURE

- 1.) APPLY FORCE AT A POINT 1 3/4" FROM END OF HANDLES.
- 2.) NOTE FORCE THAT RELEASES RATCHET.
- 3.) THE LOAD, TO RELEASE, MEASURED AT END OF HANDLES IS LBS.
- 4.) SHOULD THE TOOL NOT RELEASE AT THE PROPER FORCE, LOOSEN ADJUSTMENT NUT, ROTATE CAM CLOCKWISE TO INCREASE LOAD, TIGHTEN NUT, AND CHECK THE FORCE REQUIRED TO RELEASE. REPEAT PROCEDURE UNTIL SPECIFICATION IS ACHIEVED.

NOTE: THE TOOL SHOULD BE CHECKED FOR PROPER LOAD SETTING AFTER APPROXIMATELY 2500 COMPRESSION CYCLES OR MORE FREQUENTLY IF LARGE WIRES OR TERMINALS ARE BEING CRIMPED.

MODEL#	RELEASE LOAD (LBS)
3120 CT	35-45
3122 CT	35-45
3125 CT	45-60
3126 CT	45-55
3127 CT	60-70
3128 CT	45-55
3131 CT	70-80
3132 CT	55-65
3133 CT	50-60
3134 CT	50-60
3135 CT	50-60
3136 CT	50-60
3137 CT	45-55
3140 CT	65-75
3141 CT	65-75
3145 CT	40-50
3151 CT	35-45
3152 CT	35-45
3153 CT	35-45