

HD 120 CRIMPING TOOL FOR UN-INSULATED ELECTRICAL TERMINALS



INSTRUCTIONS FOR USE

Model HD-120 is a heavy-duty non-ratcheting manual crimping tool for uninsulated (solderless) copper or brass electrical terminals, for wire /cable sections 6 to 4/0AWG (16 to 120 mm²).

The tool has an adjustable die set continuously variable between the minimum setting (16 mm² ~ 6AWG) and the maximum setting (120mm² ~ 4/0AWG). A metal scale is affixed on the side of the tool head: set the line appearing on the moving part of the adjustable die against the desired setting in mm².

Here is an (approximate) equivalence between mm² (appearing on the scale) and AWG:

mm ²	AWG
120	4/0
C	3/0
70	2/0
50	1/0
35	2
25	4
16	6

The equivalence is **APPROXIMATE**. The correct setting of the die depends also upon the nature of the terminal and its overall dimensions.

Shape of indent: "C" shape

Type of wire: copper, solid or stranded, uninsulated or insulated

Width of crimp imprint: approx. 10mm

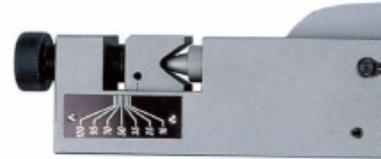
Tool length: approx. 645mm

Tool weight: approx. 3.5kg

Operation Guide:

To adjust the die:

- 1) Rotate the knurled screw (by hand only) until the marking on the die matches the appropriate value on the indicating plate.



To crimp:

- 1) Strip the wire for insertion in the terminal (length to be stripped depending on the terminal)
- 2) Twist the exposed strands and insert them into the barrel of the crimp terminal
- 3) Place wire and terminal into the proper die
- 4) Depress the handles until the jaws have firmly gripped the terminal, but not enough to leave an indent mark
- 5) Ensure that the barrel of the terminal is centered in the jaw
- 6) Firmly depress handles until a full compression cycle has been completed. Release the jaws, remove the crimped terminal from the jaw
- 7) Do a quick pull test of the crimped terminal
- 8) Should the crimped terminal come off the wire during the pull test, do not crimp again the same terminal. Instead, repeat the entire process using a new terminal

- **Warning:** do not use this crimping tool for crimping other types of terminals, or uninsulated terminals of sizes different from those specified. Use of the tool for such purpose may cause breakage or personal injury and void all warranties.
- **Warning: never use any crimping tool on LIVE electrical wires. Always make sure that all sources of power are disconnected before intervening on any electrical conductor.**
- **Warning:** repetitive use of any manual tool may produce stress or injuries to the operator. ITC Inc. makes no statements regarding the safety of any tools with regards to the risk of such syndromes or injuries. For high-production environments, use automatic, power assisted or semi-automatic tools instead.

