

Wire Crimping Instructions for 5030-T Manual Crimp Tool

The 5030-T hand held “F” style crimp tool is used to crimp wires to the 50110 and 50250 terminals supplied with the 50430 plug kit. It uses a ratcheting lever design to apply sufficient pressure to the crimp die to wrap the terminal tabs around the conductor wire and insulation.

50250 Terminals

Strip the end of the wire to be crimped $\frac{1}{4}$ ” (6.3mm) +0, -.040” (1mm) so the wire strands do not extend past the conductor tabs after crimping. Hold the 5030-T crimp tool in the right hand with the movable jaw down as shown in Figure 1. (Open the jaws by either pushing on the release lever, or by completely closing the tool past the ratcheting stop.) Hold the 50250 terminal by the contact end between the thumb and index finger with the tabs up and towards you. Position the tabs in the center cavity of the upper die from behind the tool with the insulation tabs against the step. (Fig. 2) Begin closing the lower die while centering the tabs in the upper cavity. Continue applying pressure, keeping the tabs centered, until the tabs locate against the top of the cavity, and the tool ratchets in place. (Fig. 3) Insert the stripped end of the wire in position for crimping, making sure the insulation does not go past the conductor tabs. Hold the wire in position while completing the crimp. The tool will release at the fully closed position.

50110 Terminals

Strip the end of the wire to be crimped $\frac{3}{16}$ ” (4.8mm) +0, -.040” (1mm) so the wire strands do not extend past the conductor tabs after crimping. Prepare the 5030-T crimp tool as per 50250 instructions above. Hold the 50110 terminal by the contact end between the thumb and index finger with the tabs up and towards you. Position the tabs in the outer (smallest) cavity of the upper die from behind the tool with the insulation tabs against the step. (Fig. 4) Begin closing the lower die while centering the tabs in the upper cavity. Continue applying pressure, keeping the tabs centered, until the tabs locate against the top of the cavity, and the tool ratchets in place. (Fig. 5) Insert the stripped end of the wire in position for crimping, making sure the insulation does not go past the conductor tabs. Hold the wire in position while completing the crimp. The tool will release at the fully closed position.

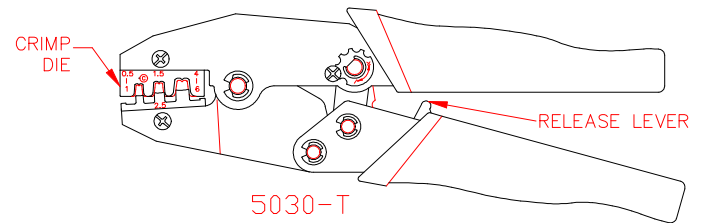


Fig. 1

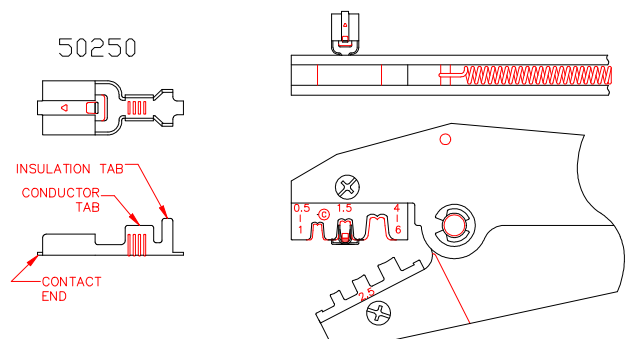


Fig. 2

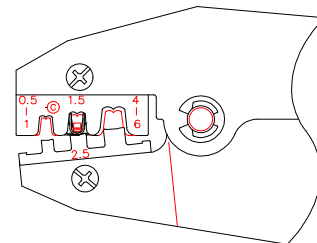


Fig. 3

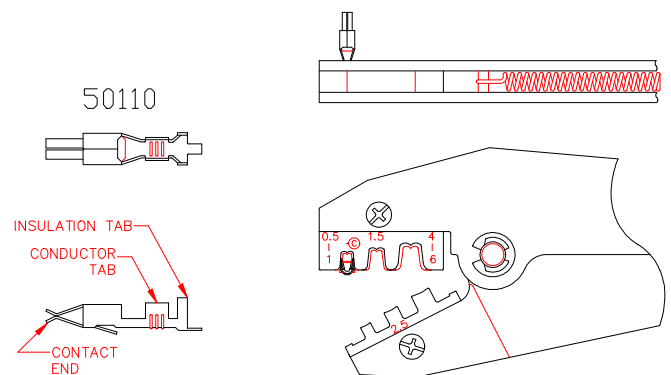


Fig. 4

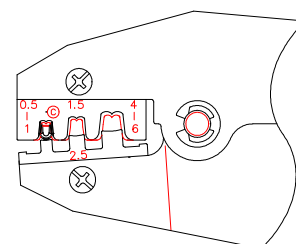


Fig. 5