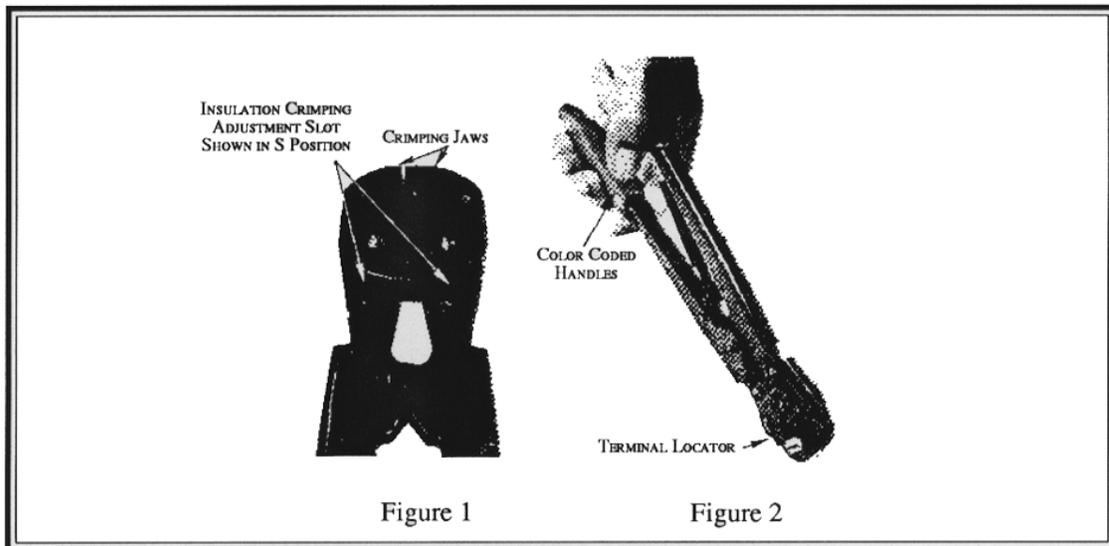


RATCHET HAND CRIMPING TOOL INSTRUCTIONS

FOR INSULATED TERMINALS, SPLICES, QUICK CONNECTS
AND INSULATION-SUPPORT-TYPE TERMINALS



OPERATION

A. Crimping Long and Short Barrel Terminals

1. Open tool by first closing the handles sufficiently for the ratchet mechanism to release.
2. ETC crimping tool features a Terminal Locator (see Figure 2).
 - a) Hold tool (handles open) in right hand with terminal locator facing down. Right hand should be positioned on handles close to crimping head of tool. Insert terminal by dropping through nest of crimping jaws so that tongue slides into terminal locator. Seat terminal against pressure pad with thumb (See Figure 3).
 - b) Close jaws slightly to secure terminal, slide hand back onto plastic grips. Squeeze handles until crimping jaws are snugly pressed against terminal. Do not deform terminal.

- c) Insert properly stripped wire into terminal.
- d) Hold wire in position and complete crimp by squeezing haneles until ratchet mechanism releases. Upon completion of full crimping cycle, handles will open automatically.

B. Crimping Butt Splices

1. Remove terminal locator by loosening screw one quarter turn, and stop will slide off.
2. Insert butt splice into crimping jaws 1/16 of an inch from outside surface of insulation crimping die. (See Figure 4)
 - a) Squeeze handles lightly until crimping jaws are snugly pressed against splice.
 - b) Insert properly stripped wire into splice.
 - c) Hold wire in position and complete crimp by squeezing handles until ratchet mechanism releases. Upon completion of full crimping cycle, handles will open automatically.
 - d) To crimp other half of butt splice, turn splice around and repeat procedures a), b), and c). If splice cannot be turned, turn tool around. Repeat steps a), b), and c).

C. Crimping Parallel Splices

1. Insert parallel splice into crimping jaws 1/16 of an inch inside insulation crimping die. (See Figure 5)
 - a) Squeeze handles lightly until crimping jaws are snugly pressed against splice.
 - b) Insert properly stripped wire into splice.

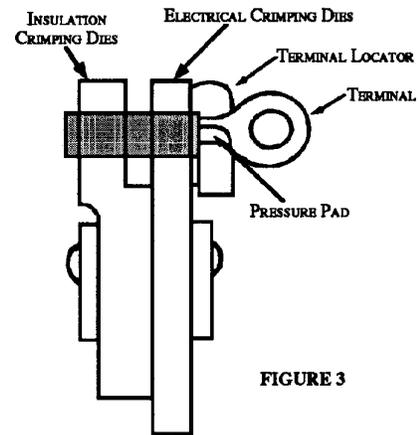


FIGURE 3

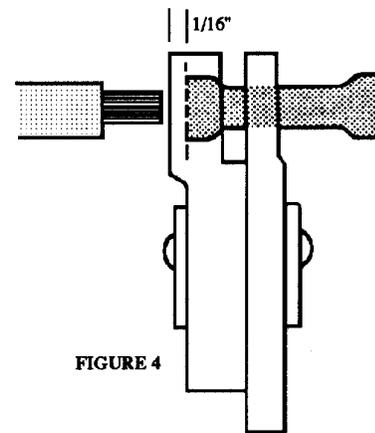


FIGURE 4

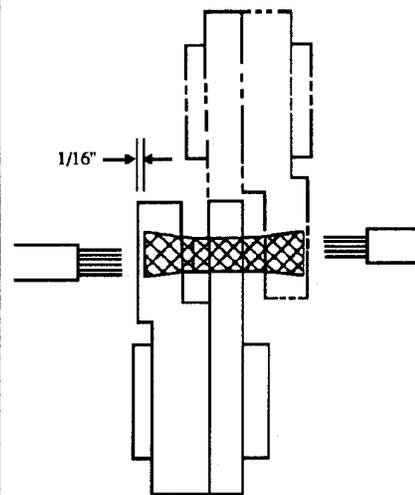


FIGURE 5

- c) Hold wire in position and complete crimp by squeezing handles until ratchet mechanism releases. Upon completion of full crimping cycle, handles will open automatically.
- d) To crimp insulation support on other end, turn splice around and over and locate jaws as before. (See Figure 5) Do not attempt the second crimp until previous electrical crimp lines up with electrical dies. When properly seated, previous electrical crimp will be repeated, but part will not be further deformed. Squeeze handles and complete the second crimp.

D. Crimping NYLAKRIMP™ Splices (Single Set of Jaws)

- 1. NYLAKRIMP butt and parallel splices do not require an insulation support crimp; only the electrical portion is crimped.
- 2. Butt Splices. Insert properly stripped wire into one end of splice's metal insert in jaws and crimp. Repeat this step for other end of metal insert.
- 3. Parallel Splices. Insert properly stripped wire in splice. Center splice in jaws and crimp.

E. To Obtain Proper Insulation Crimp

- 1. Adjust arrows on screws to the L position. (Least confined insulation crimp)
 - a) Follow procedures used in crimping terminals, butt and parallel splices.
 - b) After crimp is made, check insulation support sleeve of terminal. Adjustment is correct when insulation support sleeve is crimped snugly against insulation of wire. If configuration is too loose, set insulation adjustment arrow to M position. Repeat performance until desired insulation grip is obtained. Repeat to S position, if necessary.

MAINTENANCE

- A. All tools are factory lubricated so initial oiling is not needed. However, in order to maintain the efficiency of the precision made linkages, occasional light machine oiling is recommended to insure against excessive wear.
- B. Crimping next should be kept free of foreign particles.
- C. In the event of any damage or breakage to tool, please consult your local ETC representative or mail directly to Molex-ETC for proper factory repairs.

MISCELLANEOUS

- A. Tool is fully guaranteed when used with terminals and splices as recommended by the manufacturer.

DESCRIPTIVE DATA

TOOL NUMBER	WIRE RANGE	BARREL LENGTH	WIRE STRIPPING LENGTH	HANDLE COLOR CODE
1. AVIKRIMP® and INSULKRIMP® Terminals, Splices, Window Splices				
RHT-5756	26-24		5/32"	Yellow
RHT-2000	22-18	Standard (A)	9/32"	Red
RHT-2050	22-18	Short (AA)	3/16"	1 Red, 1 Black
RHT-2100	16-14	Standard (B)	9/32"	Blue
RHT-2150	16-14	Short (BB)	3/16"	1 Blue, 1 Black
RHT-2200	12-10	Standard (C)	9/32"	Yellow
2. AVIKRIMP® Quick Connect Terminals				
RHT-5756	26-24		11/64"	Yellow
RHT-5757	22-18		7/32"	Red
RHT-5758	16-14		7/32"	Blue
RHT-5759	14-12		7/32"	Yellow
3. INSULKRIMP® Quick Connect Terminals				
RHT-5757	22-18		7/32"	Red
RHT-2758	16-14		7/32"	Blue
4. VIBRAKRIMP® Terminals and Splices				
RHT-4000	22-18	Standard (A)	9/32"	Black
RHT-4050	22-18	Short (AA)	3/16"	Black
RHT-4100	16-14	Standard (B)	9/32"	Black
RHT-4150	16-14	Short (BB)	3/16"	Black
RHT-4200	12-10	Standard (C)	9/32"	Black
5. VIBRAKRIMP® Quick Connect Terminals and Tap Splices				
RHT-4753	26-24		11/64"	Black
RHT-4754	22-18		7/32"	Black
RHT-4754	or	16-14	7/32"	Black
RHT-4755				
RHT-4755	14-12		7/32"	Black
6. NYLAKRIMP® Splices*				
RHT-8100	22-18		9/32"	Red
RHT-8200	16-14		9/32"	Blue
RHT-9100	12-10		9/32"	Yellow
7. IN-LINE SPLICE SNAP PLUG*				
RHT-8200	16-14			Blue
8. NYLON CLOSED-END CONNECTORS*				
RHT-7000	22-14		5/16"	Black
RHT-7000	16-10		11/32"	Black

* These crimping dies do not employ insulation adjustment crimp.

IDENTIFICATION MARK CODING (Insulated Terminals)

Inspection dot marks are automatically made on each crimped barrel. The dot mark code quickly and easily tells Inspector if proper size and type crimping tool was used.

See Code Chart below:

Wire Range	Terminals and Connectors	Quick Connects
26-24	•	•
22-18	•	••
16-14	••	•
14-12	•	••
12-10	•	•

Please Note:

Part numbers have changed since this document was produced. Refer to "New Part Number Cross Reference" under the Solderless Terminal link on www.molex.com for current part numbers.