

## 1309G8 Tool Kit Assembly Instructions



Figure 1

NOTE: Instructions are included with each crimp tool for terminating specific contacts. Use of non-Anderson Power crimp tools can affect UL & CSA approval. See website for comprehensive tooling data.

The **1309G8 Tool Kit** has three die sets, three locators and one frame for crimping 15-45 Amp APP contacts (See Figure 1). The following instructions describe how to change the configuration from the 1309G2, 1309G3 and 1309G6 configurations.

The dies and locators are color coded to identify the components required for each configuration (See Figure 2). See table below for configurations.

### Modification Procedure

#### Disassemble

1. Remove the nut, wavy washer and locator.
2. Unscrew the top and bottom die screws.
3. Remove the dies from the frame. The tool can now be assembled with a different configuration.

#### Reassemble

1. Assemble the desired die in the top position with the supplied screw. (See Figure 3)
2. Place the bottom anvil die in the frame. (See Figure 3)
3. Tighten the screws until they bottom on the frame and loosen ½ turn.
4. Place the locator, wavy washer and nut on the screw; in that order. (See Figure 4 & Figure 5)
5. Tighten until the nut & locator bottom-out. (9 mm or 11/32" Wrench)
6. **LOOSEN THE NUT ONE COMPLETE TURN.** This is required for correct tool operation.
7. Adjust the release force to 25 lbf (111.21 N) minimum at the handle ends. The load can be checked by placing the end of one of the handles on a scale and pushing the other grip until the ratchet releases. If the tool requires adjustment, follow the adjustment procedure.



Figure 2

Color coded dies and locator

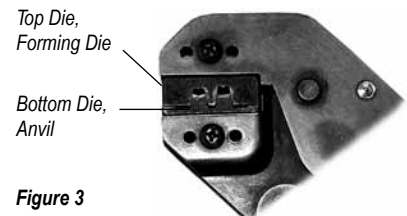


Figure 3

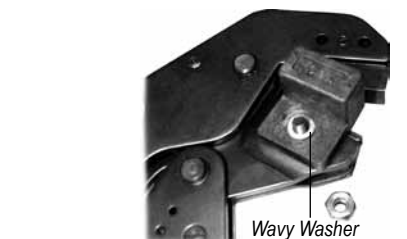


Figure 4

Wavy Washer in place

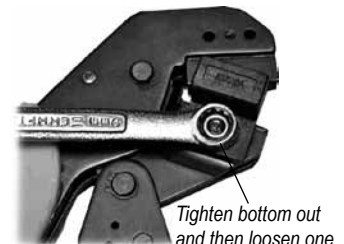


Figure 5

Tighten bottom out and then loosen one complete turn

**How to Adjust Tool Preload**

(It may be necessary, when changing dies, or over the normal life of the tool, to adjust the tool handle preload.)

1. To adjust tool to obtain proper crimp force values, open the handles and remove the cam lock screw with a hex key wrench supplied. (See Figure 6)
2. Rotate the cam clockwise to increase handle load or counterclockwise to decrease handle load.
3. Position odd numbers on the cam in the locking screw hole adjacent to the letter "L" and even numbers adjacent to the letter "T".
4. Lock the cam at the desired handle load setting and remeasure the force.
5. Continue adjustment if necessary.

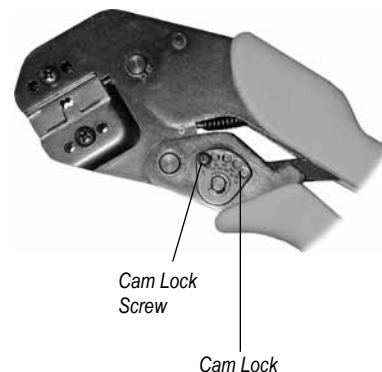


Figure 6

**1309 Crimp Tool Series Operating Procedure**

1. Strip cable according to manufacturer's specifications.
2. Select the appropriate tool cavity for the contact being crimped.
3. Place contact in die end of modular locator. Insert contact fully until the wire stops on the contact are recessed into the locator (See Figure 7a).
4. Close tool carefully until jaws grip the contact.
5. Insert the properly stripped wire into the contact.
6. Holding the wire in place, close the tool past the ratchet release position and allow the jaws to open.
7. Remove and inspect the crimp.
8. Test by holding contact and pulling firmly on cable.

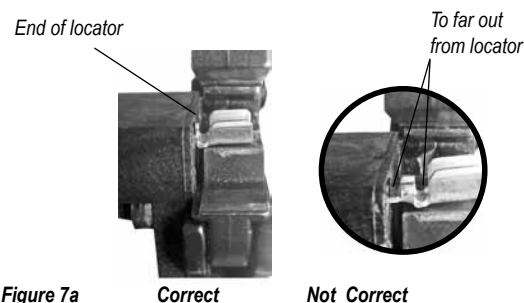


Figure 7a

| Tooling Part Number | Contact Series Loose Piece Only | Locator Color Code | Die Color Code | Wire Size AWG (mm <sup>2</sup> ) | Pullout Values (lbf) (per UL standard 486A) When Properly Crimped ** | Tool Cavity |
|---------------------|---------------------------------|--------------------|----------------|----------------------------------|--|-------------|
| 1309G2              | 1331                            | Red                | Red            | #12-16 (4.0-1.5)                 | 70-30  | 30          |
|                     | 1332                            | Red                | Red            | #16-20 (1.5-0.5)                 | 30-13  | 15          |
|                     | 262G1, 262G2                    | Red                | Red            | #16-20 (1.5-0.5)                 | 30-13  | 15          |
|                     | 200G2L, 200G4L                  | Red                | Red            | #16-20 (1.5-0.5)                 | 30-13  | 15          |
|                     | 269G2                           | Red                | Red            | #16-20 (1.5-0.5)                 | 30-13  | 15          |
| 1309G3              | 261G1, 261G4                    | Yellow             | Yellow         | #12-16 (4.0-1.5)                 | 70-30  | A           |
|                     | 261G2, 261G3                    | Yellow             | Yellow         | #10-14 (6.0-2.5)                 | 80-50  | B           |
|                     | 261G2, 261G3                    | Yellow             | Yellow         | #14-16 (2.5-1.5)                 | 50-30  | A           |
|                     | 269G1                           | Yellow             | Yellow         | #12-16 (4.0-1.5)                 | 70-30  | A           |
|                     | 269G3                           | Yellow             | Yellow         | #10-14 (6.0-2.5)                 | 80-50  | A           |
| 1309G6              | 200G1L, 200G3L                  | Blue               | Blue           | #10-14, 6mm (6.0-2.5)            | 80-50  | B           |
|                     | 201G1H, 201G3H                  | Blue               | Blue           | #10-14, 6mm (6.0-2.5)            | 80-50  | B           |
|                     | 1830G1, 1830G2                  | Blue               | Blue           | #10-14, 6mm (6.0-2.5)            | 80-50  | B           |

\*\* Tool user is responsible to ensure that the crimps made conform to the required quality and agency specifications.

**Certification**

Tool user is responsible to ensure that the tool is adjusted to provide proper crimps, that conform to required quality and pull force values.

- If the tool does not meet minimum pull force values, handle preload should be increased and the pull test rerun, (See How to Adjust Preload).
- When the hand tool is no longer capable of achieving minimum pull force, it should be taken out of service and replaced.