

INSTALLATION TEST PROCEDURE

SHURE STAKE® TOOL

Cat. No. WT3175

STEP 1 INSTALLATION PROCEDURE

Using a tool that has passed the calibration requirements, install a minimum of 6 terminals for each die nest on the appropriate wire for which a performance check is required. In order to obtain valid and consistent results, perform installation procedure as follows:

1. Strip the insulation to the strip length specified in Table A.
CAUTION: Take care to strip the insulation of the conductor without cutting or nicking the conductor strands, as this condition will produce inaccurate results.
WARNING: This tool is equipped with the SHURE-STAKE® full stroke compelling mechanism. Keep fingers clear of die nest during operation of tool.
2. Remove setting gage from it's normal position on handle.
3. Place tool on any flat surface with handles fully closed. See Figure 1.

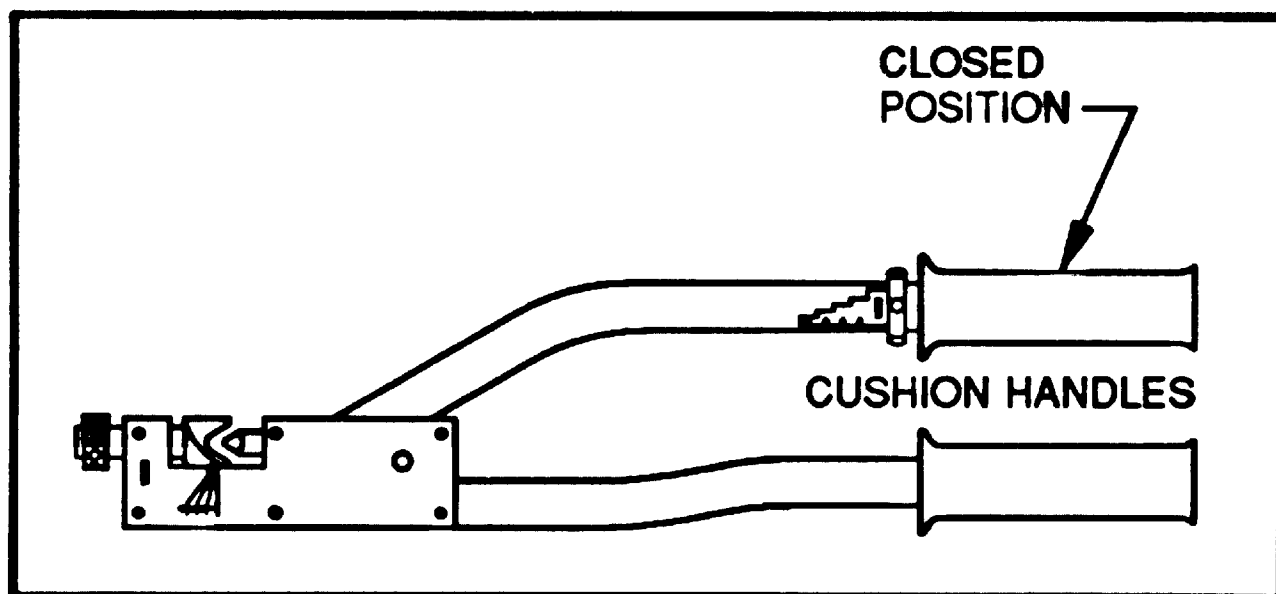


FIGURE 1

4. Select proper die nest position from nameplate on tool. Turn the die nest adjusting screw counterclockwise until the selected gage position can fit between the die nest and indenter. Position the selected gage step (1,2,3 or 4) against the indenter. See Figure 2. Turn the die nest adjusting screw clockwise until the die nest touches the rounded surface of the setting gage.

DO NOT TIGHTEN. DO NOT CRIMP GAGE.

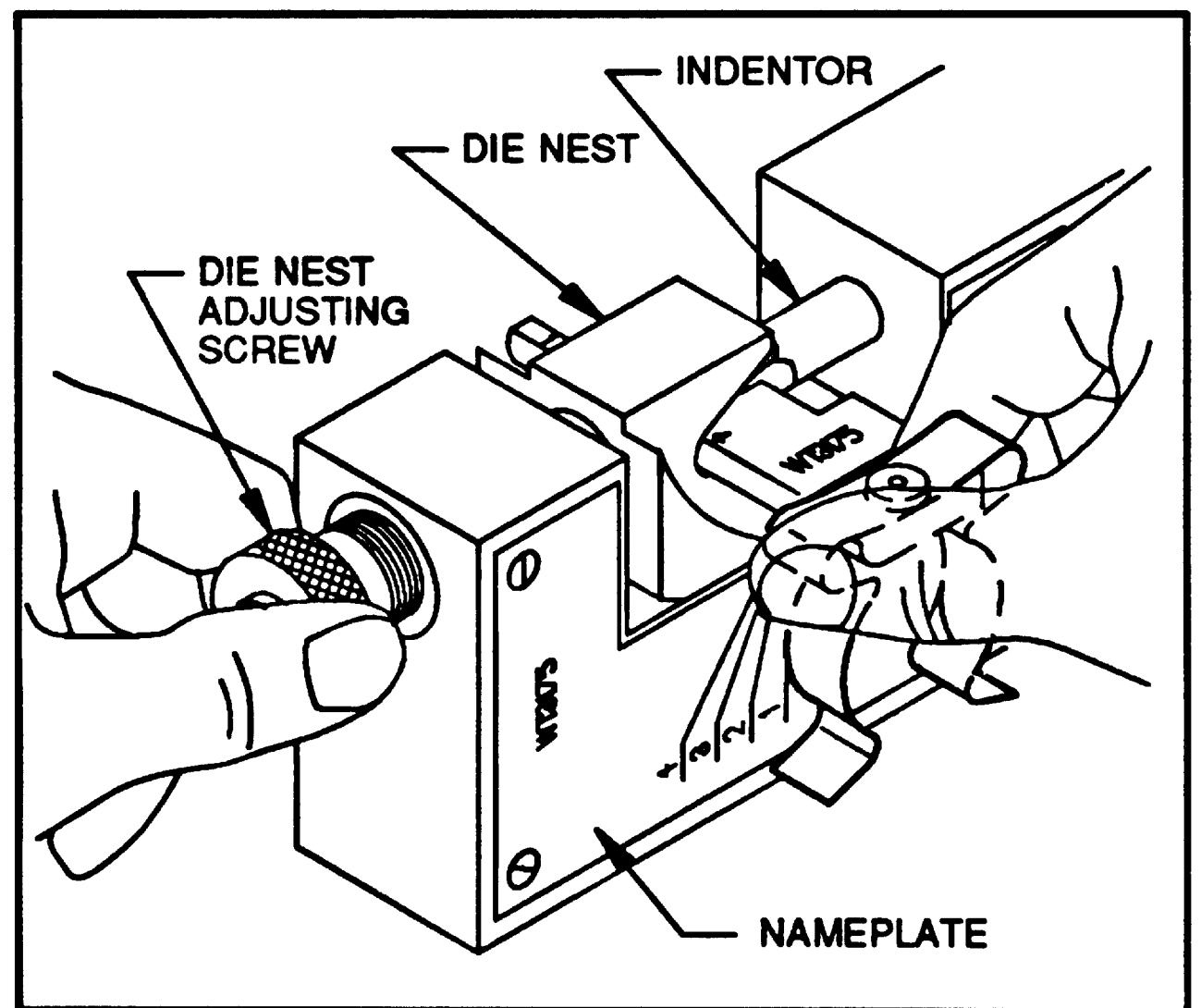


FIGURE 2

5. Remove the setting gage and clip to handle. Tool is now ready for use. Recheck with setting gage if more than 20 crimps are made.
6. Position terminal in nest opening as shown in Figure 3. Close handle sufficiently to hold terminal in place. Do not deform terminal.

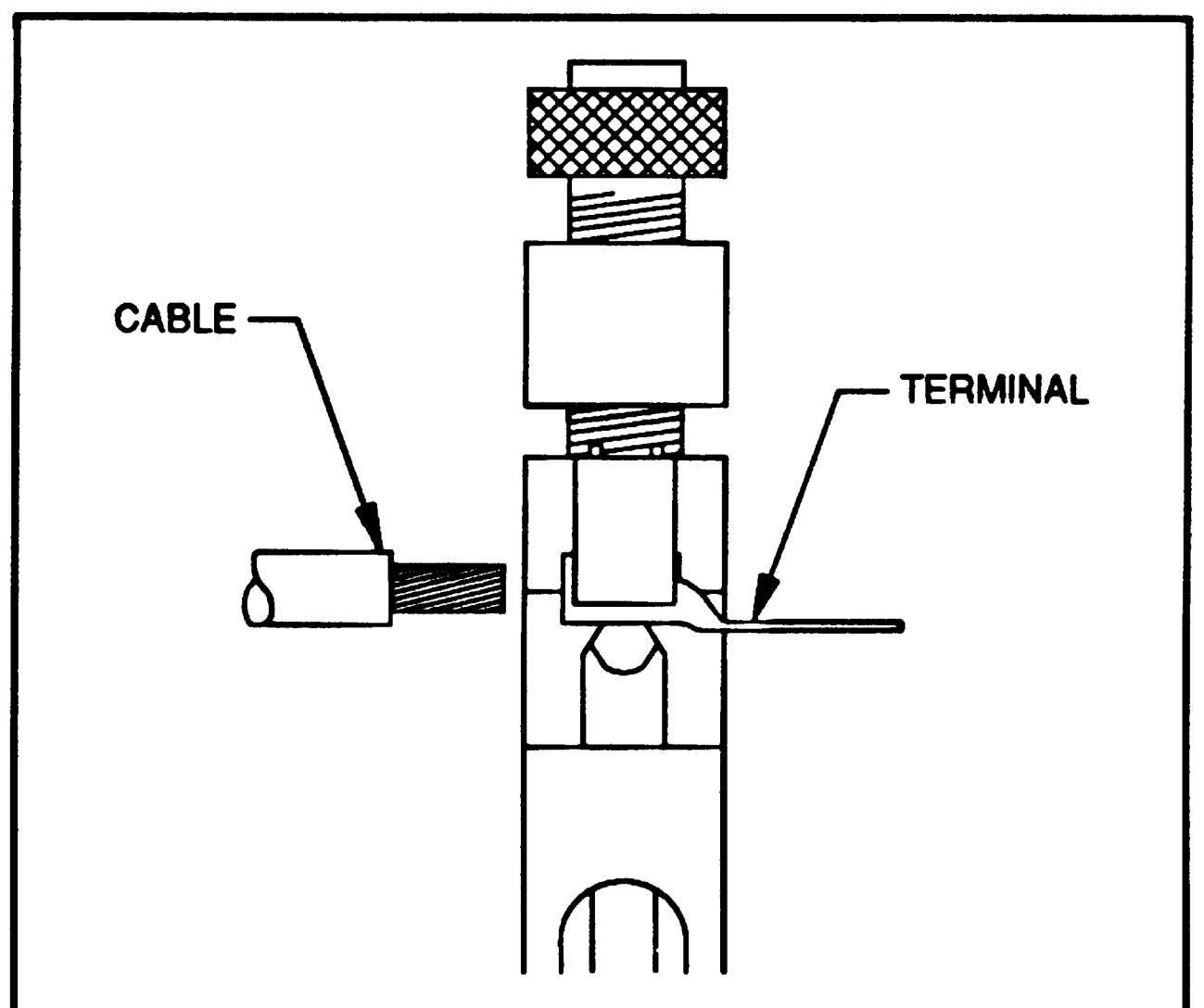


FIGURE 3

7. Insert wire into terminal barrel opening.
8. Hold wire in position and complete crimp by closing handles until the SHURE STAKE® mechanism releases. Now handles can be opened and the installed terminal withdrawn.

STEP 2
TENSILE TEST PROCEDURE

1. Install test sample in a tension-testing machine or a suitable pull-test fixture.
NOTE: The pull is to be exerted gradually. An abrupt pull is to be avoided.
2. Subject each sample to an axial pull which is to be increased until failure of the connection occurs, see Figure 4.
3. The pull force required to separate a terminal from its associated wire shall be no less than the minimum pullout shown in Table A.

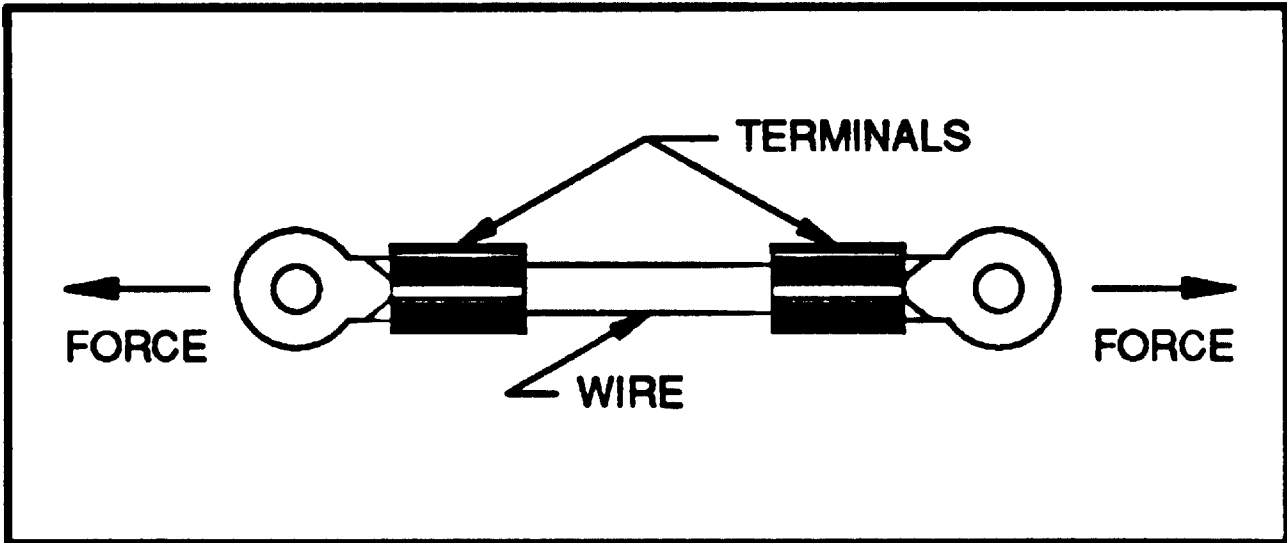


FIGURE 4

NOTICE:
If tool fails any of the above tests, do not attempt repair or adjustment. Call nearest T&B tool service center to arrange for repair service. Any change, modification or alteration of the tool or use by the customer in a manner other than as specified by T&B shall void all warranties express or implied and the customer shall, therefore, assume all liability for any damage or injury caused by said changed, modified or altered tool or improper usage of such too.

For parts or service contact the nearest tool service center.

T&B TOOL SERVICE
Suite 207
113 Fairfield Way
Bloomington, IL 60108
TEL: 1-312-894-2010

T&B TOOL SERVICE
Old Easton Road
Doylestown, PA 18901
TEL: 1-215-348-7870

T&B TOOL SERVICE
4750 Turbo Circle
Reno, NV 89509
TEL: 1-702-829-1747

WARRANTY: Thomas & Betts sells this product with the understanding that the user will perform all necessary tests to determine the suitability of this product for his intended use. Thomas & Betts manufactures its goods and tools in a manner to be free of defects. Should any defect occur in its goods (within two years) or tools (within ninety days), Thomas & Betts, upon prompt notification, will at its option, exchange or repair the goods or tools or refund the purchase price.

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TABLE A

CODE WIRE TYPE RH, TW & THW		
SIZE NO.	COPPER MIN. PULLOUT IN LBS.*	STRIP LENGTH ±
8	90#	15/32
6	100#	
4	140#	1/2
2	180#	41/64
1	200#	
1/0	250#	43/64
2/0	300#	47/64

*Conforms to UL and CSA requirements

EXAMPLE OF TENSILE TESTING MACHINES

1. Ametek Testing Equipment System, E Moline, Illinois 61244. Mechanical Force Gage Model No. D-150M, Testing Stand Model No. CTM.
2. John Chatillion & Sons, Kew Gardens, N.Y., N.Y. 11415. Gage Model No. DPPH-100 or DPPH-200, Testing Stand Model No. HTC.