

COLOR-KEYED® DIES AVAILABLE FOR 13642 (12 Ton) HEAD

DIE CAT. NO.	WIRE RANGE*		DIE NO. or COLOR CODE	GAGING	GAGE NO.
	AL.	CU.			
11732	12-10 AWG	8	21 RED	.191 / .207	683-G-1045
11733	8	6	24 BLUE	.222 / .234	683-G-736
11734	6	4	29 GREY	.282 / .294	683-G-1046
11735	—	2	33 BROWN	.326 / .337	683-G-738
11736	4	1	37 GREEN	.369 / .383	683-G-739
11737	2	1/0	42 PINK	.409 / .423	683-G-740
11738	1	2/0	45 GOLD/BLACK	.445 / .459	683-G-741
11739	1/0	3/0	50 TAN/ORANGE	.494 / .506	683-G-742
11740	2/0	4/0	54 OLIVE/PURPLE	.535 / .553	683-G-743
11741	3/0	—	60 RUBY	.587 / .605	683-G-744
11742	4/0	—	62 YELLOW	.613 / .631	683-G-1181
11743	250 MCM	350 MCM	68H WHITE	.657 / .675	683-G-747
11744	300 MCM	400 MCM	71H RED	.707 / .725	683-G-1159
11746	350 MCM	500 MCM	76 BLUE	.751 / .769	683-G-749
11747	400 MCM	600 MCM	87H BROWN	.861 / .879	683-G-751
11748	500 MCM	700 MCM	94H GREEN	.935 / .953	683-G-777
11749	600 MCM	750 MCM	99H PINK	.979 / .997	683-G-1082
11750	700 MCM	800 MCM	106H BLACK	1.049 / 1.071	683-G-1124
11751	750 MCM	900 MCM	107H ORANGE	1.064 / 1.076	683-G-1180
11753	—	—	112H PURPLE	1.118 / 1.131	683-G-1125
11761	8	—	115 YELLOW	1.141 / 1.163	683-G-1070
11762	6	—	—	.283 / .293	683-G-360
11763	4	—	—	.327 / .337	683-G-361
11764	2	—	—	.395 / .405	683-G-362
11765	1	—	—	.495 / .505	683-G-363
11766	1/0	—	—	.515 / .525	683-G-364
11767	2/0	—	—	.539 / .549	683-G-365
11768	3/0	—	—	.618 / .628	683-G-366
11769	4/0	—	—	.651 / .661	683-G-367
11780	See Connector Chart	—	GREEN	.737 / .747	683-G-368
11790	—	—	BLUE	.832 / .852	683-G-1126
	—	—	—	1.110 / 1.130	683-G-1127

* EXCEPTION — Consult installation stuffer sheets for connector Cat. No. Series 61900, 6110, 61300.

For parts or service, contact the tool service center at 1-800-284-TOOL (8665).

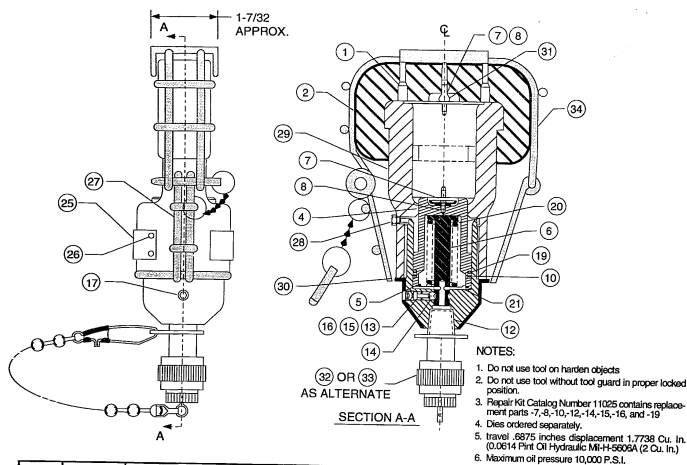
WARRANTY: Thomas & Betts sells this product with the understanding that the user will perform all necessary tests to determine the suitability of the product for its intended use. Thomas & Betts manufactures its goods and tools in a manner to be free of defects. Should any defect occur in its goods within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

Limitations and Exclusions: THIS WARRANTY IS IN LIEU OF ALL OTHER REPRESENTATIONS AND EXPRESSED AND IMPLIED WARRANTIES (INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR USE) AND UNDER NO CIRCUMSTANCES SHALL THOMAS & BETTS BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL PROPERTY DAMAGES OR LOSSES OF ANY KIND.

Thomas & Betts Corporation
Memphis, Tennessee

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TA01635 A



ITEM NO.	SPARE PART NO.	FORMER DESIGNATION*	REQ'D PER UNIT	DESCRIPTION
1	R014501	13642-1	2	Friction—Catch
2	R206703	—	1	Cap, Yoke
4	R205701	13642-4	1	Ram
5	R002101	13642-5	1	Retaining Ring
6	R205801	13642-6	1	Rod, Spring
7	R205901	13642-7	2	Button Unit, Snap, Female
8	R014402	13642-8	2	Screw
10	R002201	13642-10	1	"O" Ring Packing
12	R206001	13642-12	1	Screen
13	R206101	13642-13	1	Plug, Retaining
14	R002301	13642-14	1	Steel Ball
15	R002901	13642-15	1	"O" Ring Gasket
16	R002401	13642-16	1	Set Screw, Socket
17	R004814	13642-17	1	Ring, Back-up
19	R206201	13642-19	1	Spring Compression
20	R206301	13642-20	1	Support, Spring
21	R206401	13642-21	1	Nameplate
25	R206501	13642-25	4	Drive Screw, Nameplate
26	R004815	13642-26	1	Screw, Set, Dog Point
27	R004816	13642-27	1	Nut, Lock
28	R003204	13642-28	1	Yoke, Head
29	R206601	13642-29	1	Cylinder
30	R206803	—	1	Bottom Snap Male (For 13642M Only) Replaces Item No's 7 and 8 in Yoke Cap
31	R017301	13691	1	Hydraulic Coupler Assembly (Female) Blackhawk
32	R228801	13599	1	Hydraulic Coupler Assembly (Female) Pioneer
33	R210903	13799	1	Tool Guard
34	255F001	—	1	Steel Carrying Case
—	297-15878	—	1	—

* Former designation of spare parts. Use spare part number when ordering.

Thomas & Betts

12 TON HYDRAULIC INSTALLING TOOL FOR COLOR-KEYED® & STA-KON® CONNECTORS

INSTRUCTION SHEET

CATALOG NUMBER
13642M

General Description

This hydraulically operated crimping tool, will install Thomas & Betts COLOR-KEYED® or STA-KON® connectors, to meet or exceed U.L. or Mil. specifications.

Specifications

Size: 10-1/4" long x 5-1/8" wide x 2-7/8" thick
Approx. Size With Guard: 10-1/2" long x 5-1/2" wide
Weight: Approx. 8 Lbs.
Output: 12 tons

Material: Quality steel
Finish: Black Oxide
Hydraulic Pressure Required: 9,800 ± 100 P.S.I.
FINISH: (Tool Guard) ZINC Plate

To Install Dies

CAUTION: Keep fingers clear of die area when operating tool. Do not operate tool without guard in proper locked position.

Pull locking pin from tool guard. Swing open top half of guard. Hold yoke and rotate yoke cap, until it releases from the yoke. Place die half without die plate, in grooves of yoke. Press die half home against ram, be certain the button snap unit is firmly engaged with the mating snap unit. Snap remaining die half on the cap. Turn the die perpendicular to the cap and slide die into groove of yoke. Rotate cap until it engages the yoke and the friction catches engage the notches in the yoke. Swing top half of tool guard closed. Line up holes and insert locking pin.

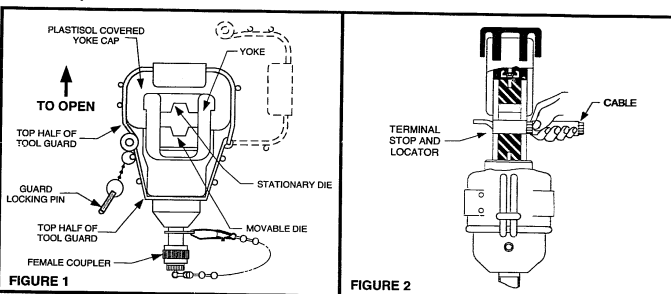
Typical Crimping Procedure

Select correct die from die chart and install in tool. Select terminal to be attached to the wire and insert stripped wire into barrel of terminal. Place terminal, with wire inserted, in the movable die and push terminal up against the terminal locator (if available) and crimp (see Figure 2). The COLOR-KEYED® connectors have color bands to show the position and number of crimps. In addition, the dies have engraved code numbers to match code numbers printed on the COLOR-KEYED® connectors.

CAUTION: Never operate this tool without the guard in proper locked position, and without a die set in the tool and the cap in place. When operating tool, always keep male and female protective caps coupled together, to keep hydraulic system free of dirt.

Field Service

These are precision tools and must be handled accordingly. Therefore, all maintenance must be performed by qualified personnel only.



STA-KON® DIES AVAILABLE

DIE CAT. NO.	WIRE RANGE	INSTALLS TERMINAL TYPE	GAGING	TYPE OF CRIMP	GAGE NO.
11733	8 AWG	D (Code)	.222 / .234	Hex	683-G-736
11734	6 AWG	E (Code)	.282 / .294	Hex	683-G-1046
11735	4 AWG	F (Code)	.326 / .337	Hex	683-G-738
11736	2, 1 AWG	G (Code)	.369 / .383	Hex	683-G-739
11737	1/0 AWG	H (Code)	.409 / .423	Hex	683-G-740
11738	2/0 AWG	J (Code)	.445 / .459	Hex	683-G-741
11739	3/0 AWG	K (Code)	.494 / .506	Hex	683-G-742
11770	4/0 AWG	L (Code)	.585 / .591	Hex	683-G-743
11771	250 MCM	M (Code)	.613 / .631	Hex	683-G-744
11781M	8 AN	D (Aircraft)	.208 / .212	Hex	683-G-1072
11782M	6 AN	E (Aircraft)	.238 / .242	Hex	683-G-1073
11783M	4 AN	F (Aircraft)	.297 / .301	Hex	683-G-1074
11784M	2 AN	G (Aircraft)	.375 / .379	Hex	683-G-1075
11785M	1 AN	H (Aircraft)	.415 / .419	Hex	683-G-1076
11786M	1/0 AN	J (Aircraft)	.454 / .458	Hex	683-G-1077
11787M	2/0 AN	K (Aircraft)	.498 / .502	Hex	683-G-1078
11788M	3/0 AN	L (Aircraft)	.542 / .546	Hex	683-G-1079
11789M	4/0 AN	M (Aircraft)	.616 / .620	Hex	683-G-1080
13643	8 AWG	D (Code) Nest	.153 / .161	Indented	683-G-548
13644	6 AWG	E (Code) Nest	.183 / .191	Indented	683-G-549
13645	4 AWG	F (Code) Nest	.214 / .222	Indented	683-G-550
13650	8, 6, 4 AWG 2 TO 4/0 AWG	G to M (Indenter)	—	Indented	—
13651	8 AN	D (Aircraft) Nest	.116 / .124	Indented	683-G-551
13652	6 AN	E (Aircraft) Nest	.156 / .164	Indented	683-G-552
13653	4 AN	F (Aircraft) Nest	.188 / .176	Indented	683-G-553
13654	2, 1 AWG / 2 AN	G (Aircraft and Code) Nest	.202 / .210	Indented	683-G-554
13655	1/0 AWG / 1 AN	H (Aircraft and Code) Nest	.230 / .238	Indented	683-G-555
13656	2/0 AWG / 1/0 AN	J (Aircraft and Code) Nest	.268 / .276	Indented	683-G-556
13657	3/0 AWG / 2/0 AN	K (Aircraft and Code) Nest	.246 / .254	Indented	683-G-557
13658	4/0 AWG / 3/0 AN	L (Aircraft and Code) Nest	.262 / .270	Indented	683-G-558
13659	250 MCM / 4/0 AN	M (Aircraft and Code) Nest	.308 / .316	Indented	683-G-559
21607	8 AWG	RD (Code)	.250 / .254	Elliptical	683-G-1128
21608	6 AWG	RE (Code)	.272 / .276	Elliptical	683-G-1129
21609	4 AWG	RF (Code)	.288 / .292	Elliptical	683-G-1130
21610	1, 2 AWG	RG (Code)	.337 / .341	Elliptical	683-G-1131
21611	1/0 AWG	RH (Code)	.368 / .372	Elliptical	683-G-1132
21612	2/0 AWG	RJ (Code)	.402 / .406	Elliptical	683-G-1133
21613	3/0 AWG	RK (Code)	.436 / .440	Elliptical	683-G-1134
21614	4/0 AWG	RL (Code)	.471 / .475	Elliptical	683-G-1135
21615	250 MCM	RM (Code)	.519 / .523	Elliptical	683-G-1136
21707	8 AN	RD (Aircraft)	.168 / .172	Elliptical	683-G-1137
21708	6 AN	RE (Aircraft)	.200 / .204	Elliptical	683-G-1138
21709	4 AN	RF (Aircraft)	.252 / .256	Elliptical	683-G-1139
21710	2 AN	RG (Aircraft)	.310 / .314	Elliptical	683-G-1140
21711	1 AN	RH (Aircraft)	.337 / .341	Elliptical	683-G-1141
21712	1/0 AN	RJ (Aircraft)	.368 / .372	Elliptical	683-G-1142
21713	2/0 AN	RK (Aircraft)	.402 / .406	Elliptical	683-G-1143
21714	3/0 AN	RL (Aircraft)	.436 / .440	Elliptical	683-G-1144
21715	4/0 AN	RM (Aircraft)	.471 / .475	Elliptical	683-G-1145
21731	8, 6, 4 AN	D, E, F, (Indenter Only)	—	Indented	—
21732	2 TO 250 MCM	G to M (Indenter Only)	—	Indented	—
21733	8 AWG / 8 AN	D Flag Terminals	.147 / .153	Indented	683-G-1146
21734	6 AWG / 6 AN	E Flag Terminals	.171 / .177	Indented	683-G-1147
21735	4 AWG / 4 AN	F Flag Terminals	.194 / .200	Indented	683-G-1148
21736	2, 1 AWG / 2 AN	G Flag Terminals	.262 / .269	Indented	683-G-1149
21737	1/0 AWG / 1 AN	H Flag Terminals	.278 / .284	Indented	683-G-1150
21738	2/0 AWG / 1/0 AN	J Flag Terminals	.309 / .315	Indented	683-G-1151
21739	3/0 AWG / 2/0 AN	K Flag Terminals	.356 / .362	Indented	683-G-1152
21740	4/0 AWG / 3/0 AN	L Flag Terminals	.382 / .388	Indented	683-G-1153
21741	250 MCM / 4/0 AN	M Flag Terminals	.434 / .440	Indented	683-G-1154

NOTE: To order the military version of the 13642, add an "M" suffix. EXAMPLE: 13642M, and suffix the die indenter catalog number with an "M". EXAMPLE: 21713M, die nest catalog number does not change.