

## ERG4255 COMFORT CRIMP® COMPRESSION TOOL WITH SHURE STAKE® MECHANISM For Installing Heat Shrinkable Nylon Insulated Terminals, Splices, and Disconnects 22-10 AWG



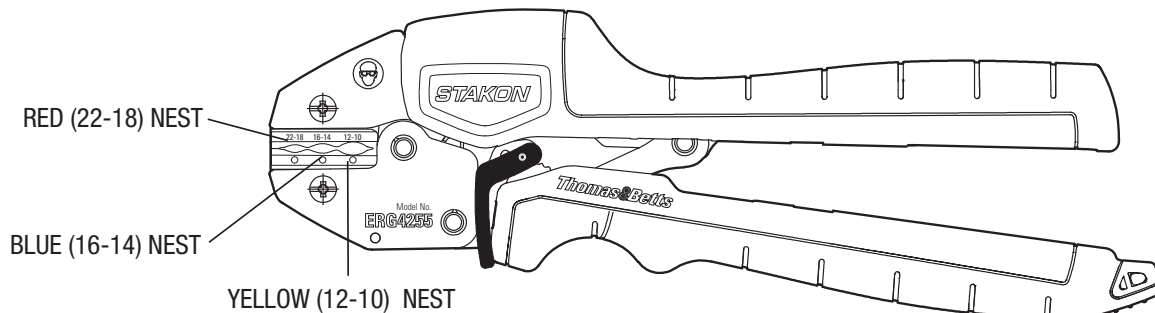
**IMPORTANT:** Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.

### ⚠ WARNING ⚠

KEEP ALL BODY PARTS AWAY FROM DIE NEST DURING GAGING OR CRIMPING PROCEDURE.

### ⚠ WARNING ⚠

HANDLES ARE NON-INSULATING. DO NOT CRIMP ON HOT ENERGIZED WIRES.



In the event the SHURE STAKE® mechanism must be released, please see Figure 5.

Figure 1

## 1.0

## INSTRUCTIONS FOR USE

### 1.1

For Use With Insulated Terminals and Disconnects 22-10 AWG

1. Open handles fully.
2. Insert terminal into proper nest. Tongue markings should face up.
3. Close the handles slightly to secure the terminal. Do not deform the terminal.
4. Insert stripped wire.
5. Close handles until SHURE STAKE® mechanism cycle has been completed.
6. Heat insulator with a recommended heat source until insulator recovers and adhesive melts and flows.

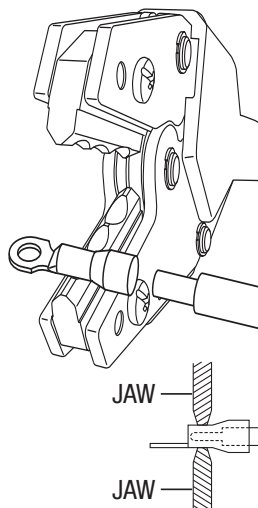


Figure 2

### 1.2

For Use With Insulated Splices 22-10 AWG

1. Open handles fully.
2. Insert splices into proper nest.
3. Close handles slightly to secure terminal. Do not deform terminal.
4. Insert stripped wire.
5. Close handles until the SHURE STAKE® mechanism cycle has been completed.
6. Repeat steps 1-5 for opposite side of splice.
7. Heat insulator with a recommended heat source until insulator recovers and adhesive melts and flows.

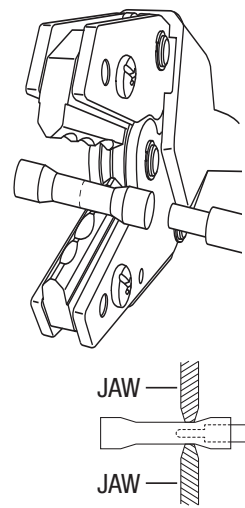


Figure 3

## 1.3

### CRIMP ASSIST™ Foot

For larger wire and terminal combinations that require more force to complete the crimp, it may be useful to press the tool against a flat work surface (i.e. worktable, floor, etc.) to gain more leverage. The patent pending Crimp Assist™ foot helps stabilize the tool during this type of operation.

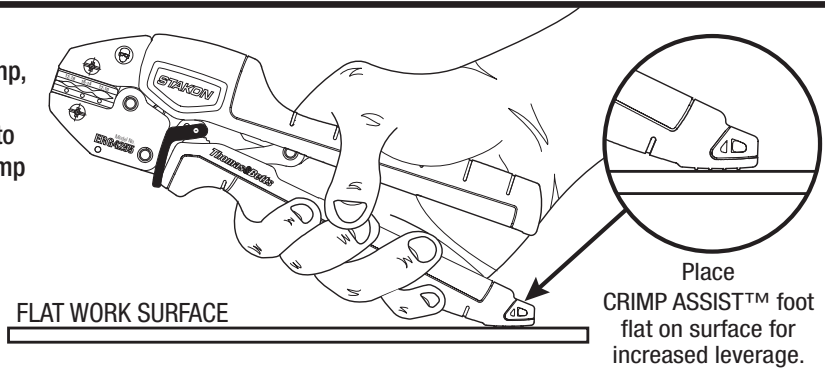
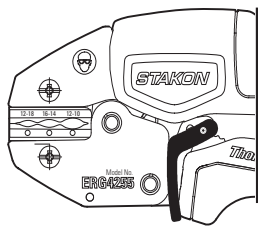


Figure 4

## 1.4

### SHURE STAKE® Mechanism



**WARNING**  
KEEP ALL BODY PARTS  
AWAY FROM DIE NEST  
DURING GAGING OR  
CRIMPING PROCEDURE.

Figure 5

To release the SHURE STAKE® mechanism, push up on the release bar until the ratchet teeth are disengaged.

## 1.5

### Maintenance

1. Remove dust, moisture, and other contaminants with a clean brush or a soft, lint-free cloth.
2. DO NOT use on objects that could damage the tool.
3. Make certain all pins, pivot points, and bearing surfaces are protected with a THIN coat of any good SAE No. 20 motor oil. DO NOT oil excessively.
4. Keep handles closed when not in use to prevent objects from becoming lodged in the crimping dies.
5. Store tool in a cool, dry area.

## 2.0

### GAGING VERIFICATION

**NOTE:** Calibration verification procedure should be performed whenever damage or suspected damage has occurred or as often as operation conditions warrant.

## 2.1

### Visual Inspection

Tool must be free of cracks, sharp edges and any other obvious imperfections that may affect performance of the tool. Nest area must be free of burrs, dents or scratches.

## 2.2

### Gaging Procedure

1. Wipe die nest before gaging.
2. Close handles until SHURE STAKE® mechanism just trips.
3. Using gage pins, insure that each nest meets the gaging requirements as specified, in Table 1.

TABLE 1

ERG4255 GAGING REQUIREMENTS		
NEST	GAGING MIN. – MAX.	WIRE SIZE AWG
RED	.090 – .094	#22 – #18
BLUE	.105 – .110	#16 – #14
YELLOW	.152 – .158	#12 – #10

For parts, service, repair and calibration, contact the Thomas & Betts Tool Service Center at 1-800-284-TOOL (8665).

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