

STAKON®

ERG4001 / ERG4006 / ERG4007 / ERG4255 / ERG4500 COMFORT CRIMP® COMPRESSION TOOL WITH SHURE STAKE® MECHANISM CALIBRATION AND GAGING VERIFICATION



IMPORTANT: Read and understand all of the instructions and safety information in this document.

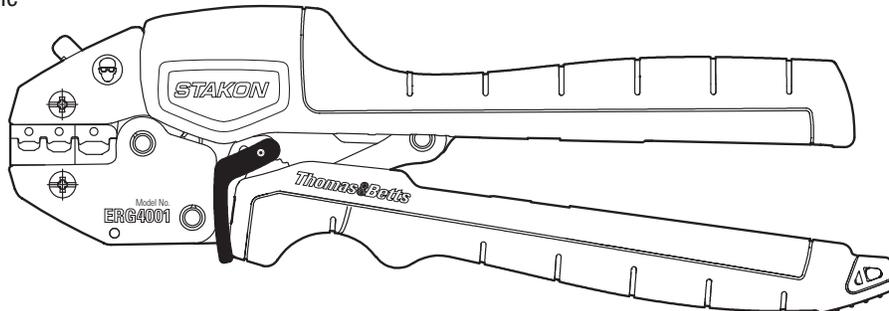


WARNING
KEEP ALL BODY PARTS AWAY FROM DIE NEST
DURING GAGING OR CRIMPING PROCEDURE.

See gaging table
on back page.



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 2.

Figure 1

1.0

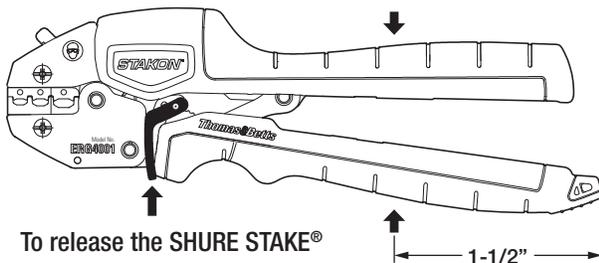
CALIBRATION VERIFICATION

1.1

SHURE STAKE® Mechanism Check



WARNING
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DURING GAGING OR CRIMPING PROCEDURE.



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

Figure 2

1. 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.
2. Squeeze handles until jaws are fully closed but before SHURE STAKE® mechanism releases.
3. Apply a force gradually at 1-1/2" from end of handles until SHURE STAKE® mechanism releases, see Figure 2.
4. The force required to release the SHURE STAKE® mechanism should be 27 lbs minimum and 37 lbs maximum.

2.0

GAGING VERIFICATION

NOTE: Perform Gaging and Calibration Verification anytime damage to the tool is suspected and on a regular basis to ensure consistent tool performance.

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. Swing locator away from nests. (Gages are to be inserted on this side.)
3. Close handles until SHURE STAKE® mechanism just trips.
4. Using gage pins, ensure that each nest meets the gaging requirements as specified, in Tables below.

TABLE 1

| ERG4001 GAGING REQUIREMENTS | | |
|-----------------------------|--------------------|---------------|
| NEST | GAGING MIN. – MAX. | WIRE SIZE AWG |
| RED | .100 – .103 | #22 – #18 |
| BLUE | .117 – .120 | #16 – #14 |
| YELLOW | .149 – .152 | #12 – #10 |

TABLE 2

| ERG4006 GAGING REQUIREMENTS | | |
|-----------------------------|--------------------|---------------|
| NEST | GAGING MIN. – MAX. | WIRE SIZE AWG |
| RA | .078 – .082 | #22 – #18 |
| RB | .098 – .102 | #16 – #14 |
| RZ | .063 – .073 | #26 – #22 |

TABLE 3

| ERG4007 GAGING REQUIREMENTS | | |
|-----------------------------|--------------------|---------------|
| NEST | GAGING MIN. – MAX. | WIRE SIZE AWG |
| RED | .190 – .196 | #8 |
| BLUE | .212 – .218 | #6 |

TABLE 4

| 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 |

TABLE 5

| ERG4500 GAGING REQUIREMENTS | | |
|-----------------------------|--------------------|---------------|
| NEST | GAGING MIN. – MAX. | WIRE SIZE AWG |
| RED | .080 – .088 | #22 – #18 |
| BLUE | .091 – .099 | #16 – #14 |
| YELLOW | .119 – .127 | #12 – #10 |

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

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 or such tool.

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