

## Crimping Guidelines for Panduit® Pan-Term® Terminals, Disconnects, Splices and Wire Joints

### 1. Select the proper Panduit terminal for the application and wire size used

- Ring terminals are used for high vibration and grounding applications
- Fork terminals are used for static (non-vibration) applications
- Disconnects are used for applications that require quick connection of wires without the use of tools
- Splices and wire joints are used to join wires together



### 2. Strip wire to the proper length as specified on:

- Panduit product packaging label
- Packaging instructions included with the Panduit product
- Or if no packaging instructions are available, plan your strip length so that 1/32" of wire can be seen protruding through the tongue end of the terminal barrel



### 3. Select the proper crimp tool to be used

- Use crimping tools that provide a UL Listed and/or CSA Certified electrical termination, to assure a safe and reliable connection
- Panduit terminals are UL Listed and CSA Certified when crimped with Panduit plier type crimping tool or with the preferred Contour Crimp™ Controlled Cycle Crimping Tool specified on the packaging label



Plier Type Crimping Tool



Contour Crimp™ Controlled Cycle Crimping Tool

### 4. Select the proper crimp pocket for the terminals and wire size you are using

- Panduit crimping tools simplify this process with color-coded crimp pockets. The yellow, blue, and red pockets are specifically designed for the industry standard barrel sizes, each with a specific color code.



### 5. Perform the electrical crimp for the plier type tool Insulated Terminals and Disconnects

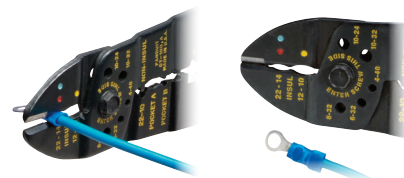
- Locate terminal in appropriate size color-coded crimp die pocket with tool centered on insulation sleeve. (See Note 1, page D.4)
- Rotate terminal so tongue is level with crimp die.
- Insert properly stripped wire into terminal until a minimum of 1/32" of wire extends beyond the terminal barrel.
- Squeeze tool handles firmly to perform the electrical crimp. (See Note 2, page D.4)
- Provide second crimp on the flared portion of the insulation housing to close the insulation as shown. Caution: When using plier type crimping tools, do not squeeze as firmly as you did for the electrical crimp. (See Note 3, page D.4)



Step A

Step B

Steps C and D



Step E

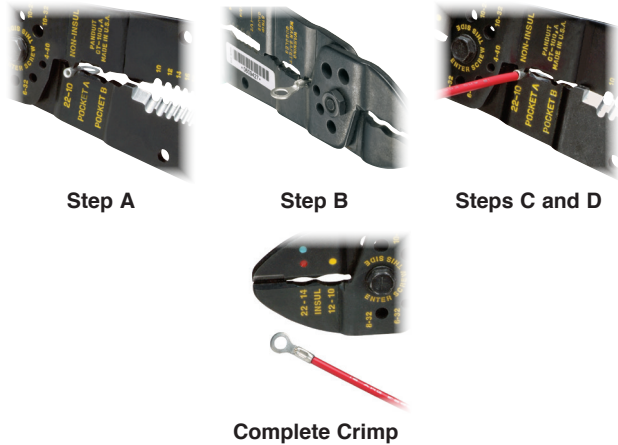
Complete Crimp

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## Crimping Guidelines for Panduit® Pan-Term® Terminals, Disconnects, Splices and Wire Joints (continued)

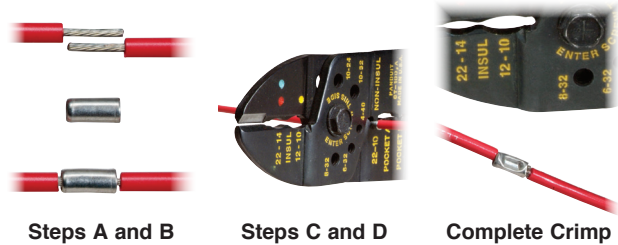
### Non-Insulated Terminals and Disconnects

- Locate terminal in appropriate wire gauge crimp die pocket with indenter centered on barrel seam.
- Rotate terminal so tongue is level with crimp die.
- Insert properly stripped wire (based on recommendations on package label) into terminal until a minimum of 1/32" of wire extends beyond the terminal barrel.
- Squeeze tool handles firmly to perform the electrical crimp. (See Note 2, page D.4)



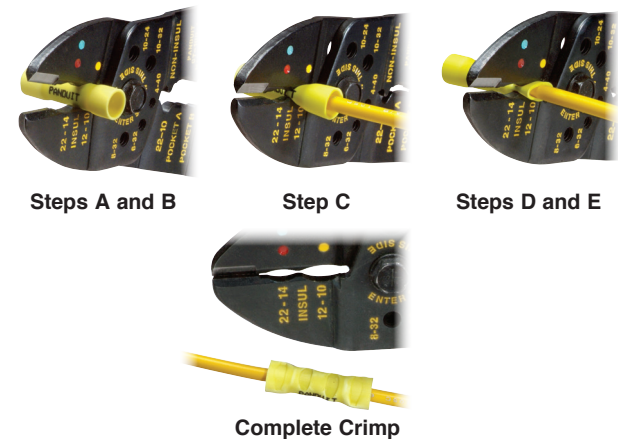
### Insulated and Non-Insulated Parallel Splices

- Locate parallel splice in appropriate wire gauge crimp die pocket and position tool on the center of the splice.
- Rotate terminal so tongue is level with crimp die.
- Insert properly stripped wire (based on recommendations on package label) into each end of the parallel splice.
- Squeeze tool handles firmly. (See Note 2, page D.4)
- An insulation crimp is not required on an insulated parallel splice.



### Insulated and Non-Insulated Butt Splices

- Locate butt splice in appropriate color-coded crimp die pocket and position crimp halfway between the wire stop (center of splice) and the end of the insulation crimp area. (See Note 4, page D.4)
- Insert properly stripped wire (based on recommendations on package label) into one end of butt splice.
- Squeeze tool handles firmly to perform the electrical crimp (See Note 2, page D.4)
- Provide second crimp on the flared portion of the insulation housing to close the insulation. Caution: When using plier type crimping tools, do not squeeze as firmly as you did for the electrical crimp. (See Note 3, page D.4)
- Repeat steps A – D for opposite end of butt splice. (See Note 3, page D.4)



A

B

C

D

E

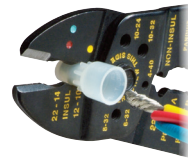
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**Crimping Guidelines for Panduit® Pan-Term® Terminals, Disconnects, Splices and Wire Joints (continued)**

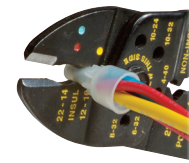
A

**Insulated and Non-Insulated Wire Joints**

- A. Properly strip wires per manufacturer’s recommendations on product package label.
- B. Twist stripped wire ends together and insert wires into wire joint.
- C. Locate wire joint in appropriate wire gauge crimp die pocket and position crimp in the center of the metal insert.
- D. Squeeze tool handles firmly to perform the electrical crimp. *(See Note 2 below)*



Steps A and B



Steps C and D



Complete Crimp

B

Note: An insulation crimp is not required on an insulated wire joint.

**NOTES for Crimping with the Preferred Hand Operated Controlled Cycle Crimping Tools:**

- 1. Panduit controlled cycle crimping tools properly locate rings, forks, and barrel insulated disconnects, and pins. No further positioning is required.
- 2. When using the preferred controlled cycle tool, once a crimp has been started, the ratchet device of controlled cycle tools will not release until the crimp is complete, independent of operator expertise.
- 3. Controlled cycle tools provide the electrical crimp and the insulation closure in a single cycle of the tool.
- 4. When using controlled cycle tooling, insulated butt splices must be inserted from the back of the tool to ensure that the electrical and insulation closure crimp pockets are properly aligned with the splice.

C

**Perform the electrical crimp using the preferred controlled cycle tool**

- A. Make sure the terminal barrel is centered correctly in the right die pocket by using the product locator on the backside of the tool.
- B. Determine the correct die pocket to use based on the color code of the terminal.
- C. Squeeze the handles of the tool until one click is heard; this click indicates the terminal is now held in place securely to insert the wire.
- D. Insert the wire and complete cycle to perform the electrical and insulation crimp simultaneously.
- E. Crimp is complete.



Step A



Step B



Step C



Step D



Complete Crimp

E

**Inspect the crimp**

Note: If your crimp looks like any of the examples shown below, cut off the terminal and re-crimp. These crimps would provide a poor connection!



Bent Back Strands



Over Crimp



Rotated Crimp

F