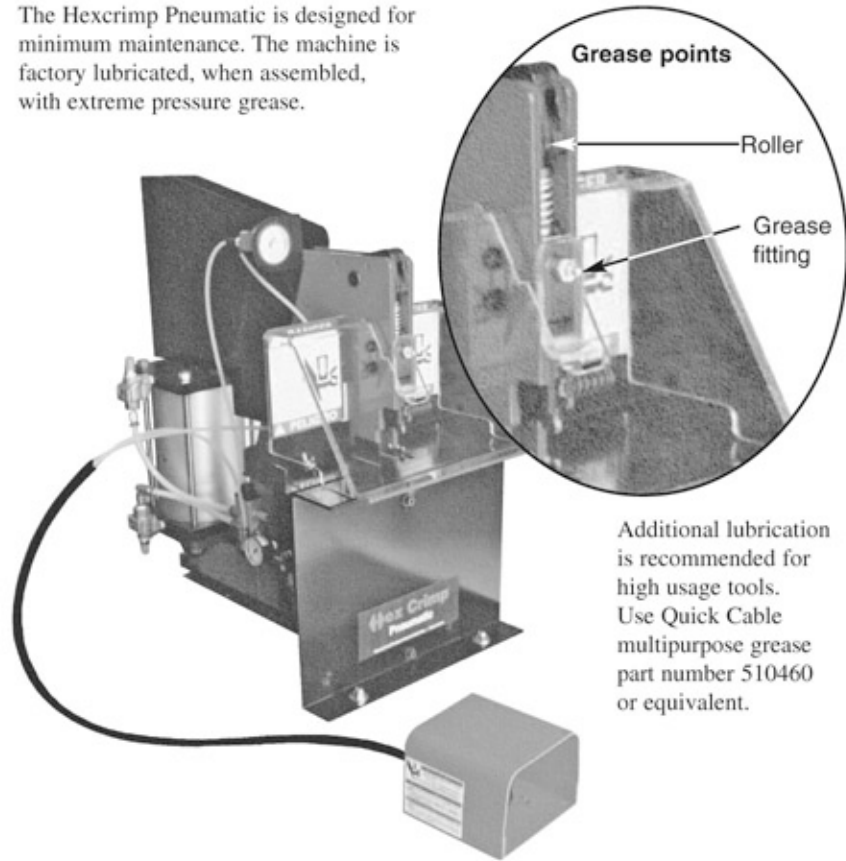


Maintaining the Hexcrimp Pneumatic:

The Hexcrimp Pneumatic is designed for minimum maintenance. The machine is factory lubricated, when assembled, with extreme pressure grease.



Additional lubrication is recommended for high usage tools. Use Quick Cable multipurpose grease part number 510460 or equivalent.

Replacement Parts

Part No.	Description
420501-001	Two color-coded hex dies, 8 gauge thru 4/0
420502-001	Two color-coded hex dies, 8 gauge thru 4/0, 2 springs, retaining rings and screw, washers, and two hardened hex pins
420503-001	Work area guard
420504-001	1 upper & lower crimp jaw shaft

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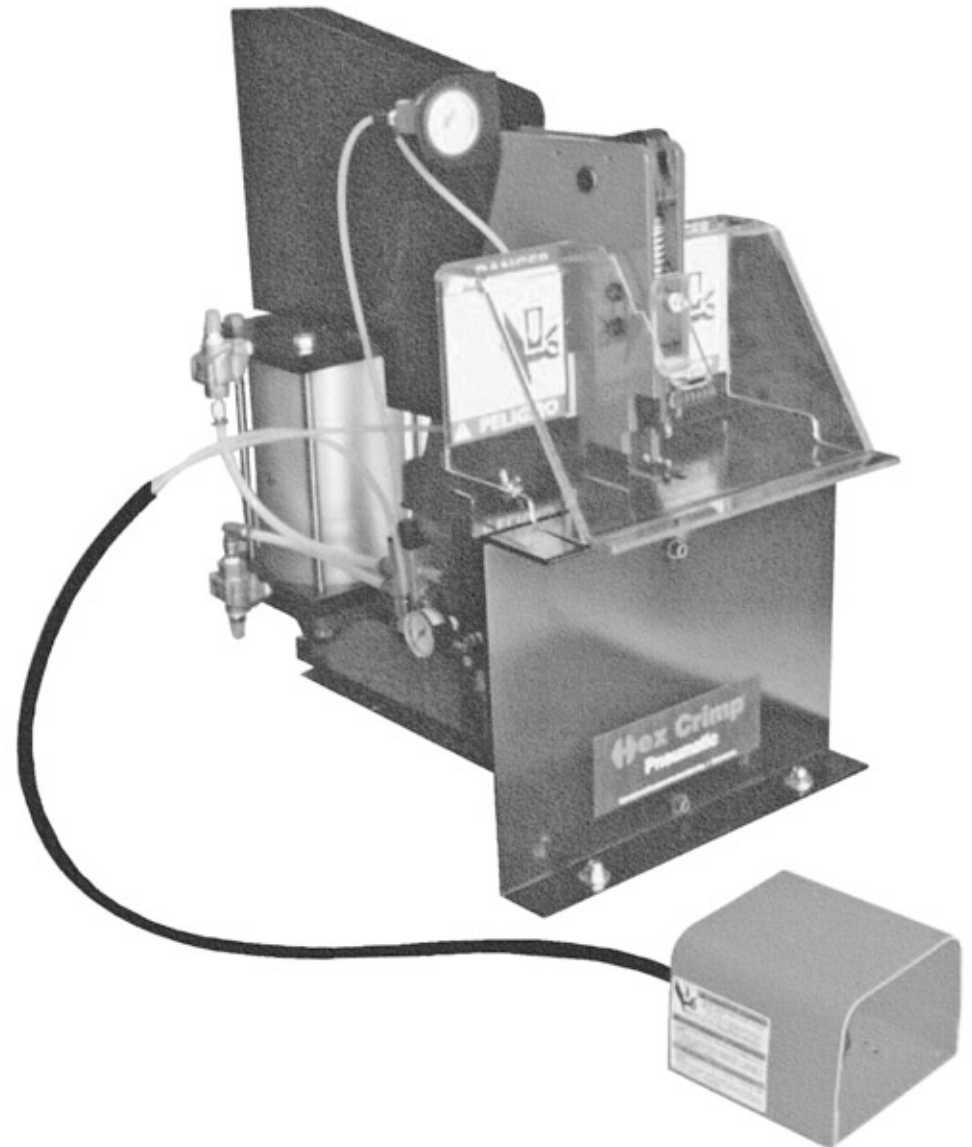
3700 Quick Drive Franksville, WI 53126-0509 U.S.A.
Phone 800-558-8667 Fax 800-733-8611
Email sales@quickcable.com

6395 Kestral Road, Mississauga, Ontario, L5T 1Z5 Canada
Phone 905-362-1606 Fax 905-362-1614
Email cdnsales@quickcable.com

www.quickcable.com

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HexCrimp™ Pneumatic

Instructions • Safety • Maintenance

Safety & Performance

- The HexCrimp™ Pneumatic is designed to crimp battery and electrical connectors, typically for 8 - 4/0 gauge wire (9 - 107 mm²).
- It is designed to work with Quick Cable connectors such as Quick Connectors, MagnaLugs, MaxLugs, SB, SBX, and DIN connectors. However it may be used with other comparable connectors.
- The machine comes equipped with a standard crimp die with 8 crimp positions.
- Custom crimp dies can be made for this machine. The HexCrimp Pneumatic comes with a standard set of crimp dies that work with most battery connectors and lugs. However if you have a special connector or require a unique crimp design, custom dies can be made for your requirements. Please contact Quick Cable.

Technical Information Upgrades

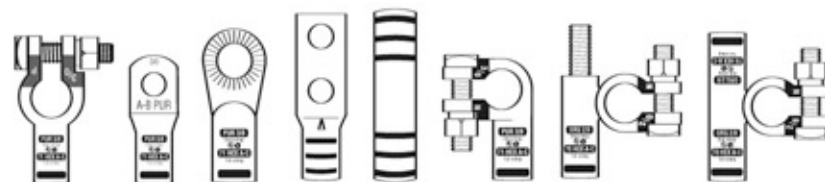
We continually upgrade our tool program.
For current information, please visit our website
at quickcable.com



Limited Warranty

Quick Cable Corporation manufactures the highest quality tools to exacting engineering standards. Quick Cable will repair or replace any HexCrimp Pneumatic tool found to be defective and returned within one year from date of purchase. Warranty excludes replaceable crimp die components. This warranty replaces all other warranties. Replacement of defective product is your exclusive remedy. Quick Cable is not responsible for injury, property damage or other consequential damages arising out of use of our products, even though injury, property damage or other consequential damage may have been directly or indirectly caused by an actual defect in material or workmanship.

We like to know how our products have performed for you. We welcome your comments and suggestions regarding our products, their installation or performance. Contact us at: Quick Cable Corporation, 3700 Quick Drive, Franksville, WI 53126-0509 U.S.A.



Die Settings for Battery Connectors and Lugs

Cable Ga.	Quick Cable Crimp Die Settings			Typical Connector Part Numbers
	Cast Copper Connectors	MagnaLugs 100% Copper	Copper Tube Lugs	
8	GREY 25	16	-	4008N, P, U 4808E, F 6408D, E, F, FV, FL
6	GREY 25	16	-	4006N, P, U 4906F 4806E, F 6406D, E, F, FV, FL
4	GREY 25	GREY 25	16	4004N, P, U 4904F 4804E, F, H 6404D, E, F, H, FV, HV, FL, HL 6804 8804D, E, F, H 8904D, E, F, H
2	GREEN 30	-	GREY 25	4002N, P, U 4102N, P 4202N, P 4302N, P 4902F, H 4802F, H
1	PINK 30	PINK 30	GREY 25	4001N, P, U 4101N, P 4201N, P 4301N, P 4901F, H 4801F, H 6401D, E, F, H, FV, HV, FL, HL 6801 8801D, E, F, H 8901D, E, F, H 8901D, E, F, H
1/0	BLACK 50	BLACK 50	GREEN 30	4010N, P 4110N, P 4210N, P 4310N, P, H 4510F 4810F, H 6410D, E, F, H, FV, HV, FL, HL 6810 8810D, E, F, H 8910D, E, F, H 8910D, E, F, H 8910D, E, F, H
2/0	ORANGE 70	ORANGE 70	PINK 30	4020N, P 4120N, P 4220N, P 4320N, P 4920F, H 4520F 4820F, H 4910F, H 6220 6312 6322 6420D, E, F, H, FV, HV, FL, HL 6820 8820D, E, F, H 8920D, E, F, H 4420F 4620F 6520
3/0	PURPLE 71	95	BLACK 50	4030N, P 4130N, P 4230N, P 4330N, P 4930F, H 4530F 4830F, H 6230 6313 6323 6430D, E, F, H, FV, HV, FL, HL 6530 6830 8830D, E, F, H 8930D, E, F, H 4430F, 4630F
4/0	YELLOW 120	YELLOW 120	ORANGE 70	4040N, P 4140N, P 4240N, P 4340N, P 4940F, H 4840F, H 6440D, E, F, H, FV, HV, FL, HL 6540 6840 8840D, E, F, H 8940D, E, F, H 6240 6314 6324
250 MCM	YELLOW 120	-	-	4060N, P 4160N, P 4260N, P 4360N, P 4860F, H

See Instruction Sheet For Safety Information

Pneumatic Crimp Guide for Anderson® Crimp-Type Contacts

Cable Gauge	Die Settings		Stripped Cable Length	
	1st Crimp	2nd Crimp		
4	Green 30	Green 30	1-1/8" (29mm)	
2	Green 30	Green 30	1-1/8" (29mm)	
1/0	Green 30	Green 30	1-1/8" (29mm)	
2/0	Orange 70	Orange 70	1-3/8" (35mm)	
3/0	Purple 71	Purple 71	1-3/8" (35mm)	
4/0	Setting 95	Setting 95	1-3/8" (35mm)	

Certain connectors require a double crimp at each crimp point, see chart above. To double crimp, complete first crimp following steps 2-8. Rotate the connector 90 degrees at the same crimp point and complete the second crimp following steps 5-7.

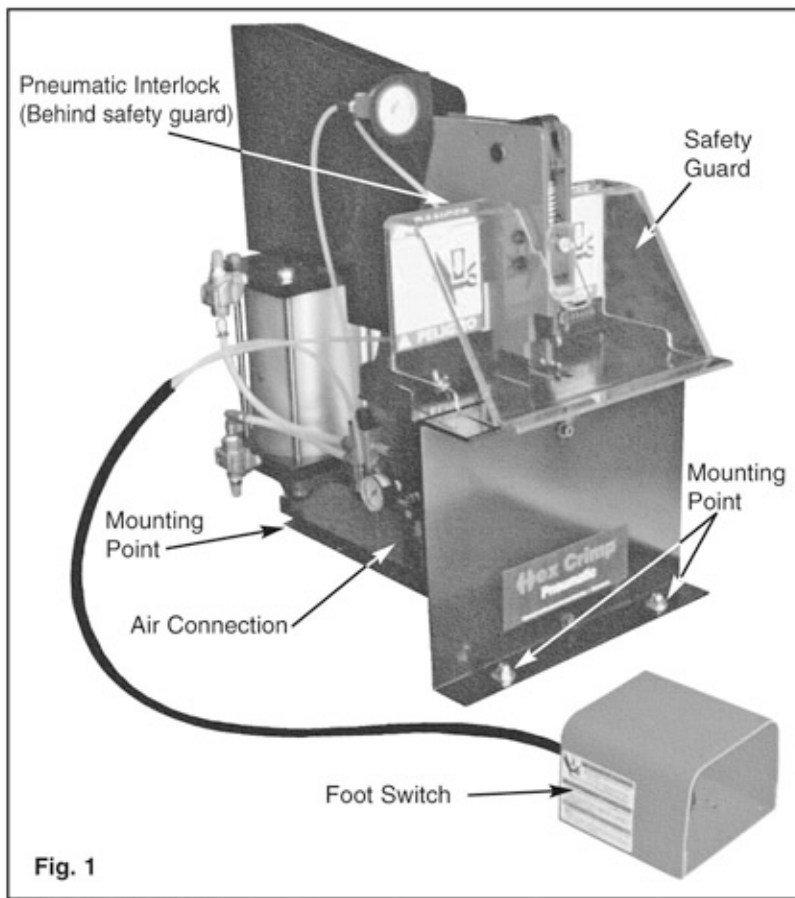


Fig. 1

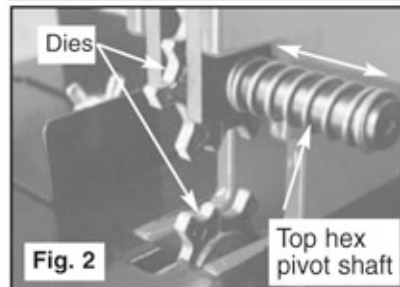


Fig. 2

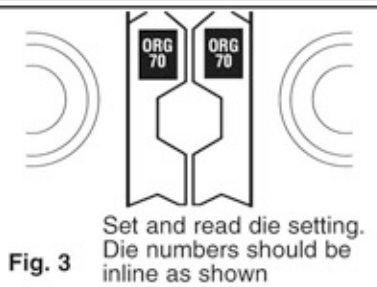


Fig. 3

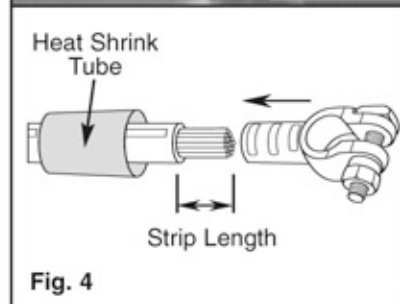


Fig. 4

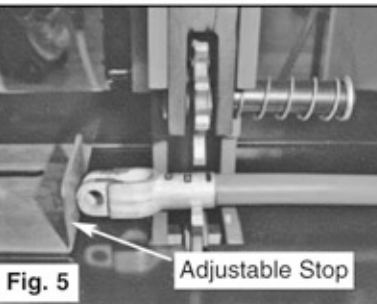


Fig. 5

Installation

The Hexcrimp Pneumatic comes fully assembled and ready for connection to your air source. The machine must be mounted to a stable work surface before operation.

1. The Hexcrimp Pneumatic can be mounted on a sturdy wood or steel bench top. The work surface you select should be adequate to support the weight of the machine (130 lbs/ 59kg) plus other tools or work pieces that will be on the bench top.
2. Make sure that the workbench with the machine mounted on top has a large enough base to prevent tipping .
3. Fasten the machine to the bench top with three 3/8" (10mm) diameter bolts and nuts at the three mounting points shown in Fig. 1. Use flat washers above and below the bench to distribute the working loads

Air connection

1. Connect your air source to the filter regulator using a 1/4" male NPT fitting (Fig. 1).
2. Air pressure – Minimum air pressure 80 psi (5.5 Bar),
Maximum air pressure 120 psi (7.0 Bar)
3. Use clean dry air.



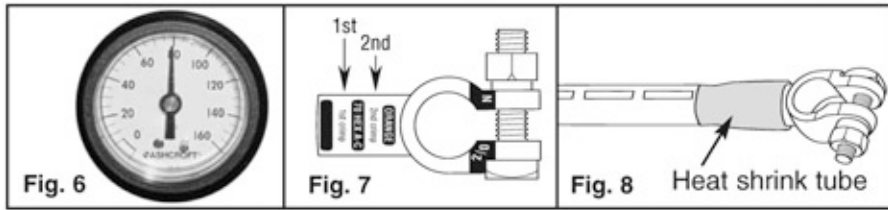
Before operating this machine check that:

- All guards are in place
- The pneumatic interlock is working properly
- All other persons are clear of the machine

Crimping

1. Using the chart on the tool, determine the proper die setting for the gauge of cable and style of connector.
2. To select the die position, push the pivot pins from the spring side and rotate the dies to the proper setting (Fig. 2). Releasing the pivot pins locks the dies in place. The setting of upper and lower dies **must match** for proper crimping. (Fig. 3)
3. Strip the cable insulation according to the recommended length of your connector. (See Fig. 4) Typically, battery connector is 7/8" (22mm), MagnaLug is 3/4" (19mm), SB is 1-1/8" to 1-3/8" (29 to 35mm). If you are using heat shrink tubing and/or a boot, slide it over the cable **before** applying the connector. (Fig. 4)
4. Lift the guard or insert the connector through the opening on the side of the guard.
5. Position the connector in the crimp dies. Use the adjustable stop to keep pressure on the connector and insure that the base of the connector is seated firmly against the cable insulation. (Fig. 5)

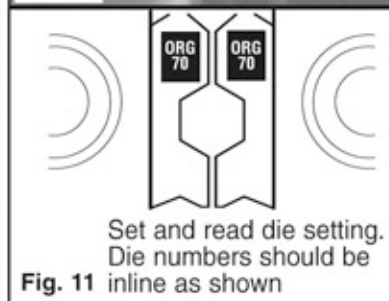
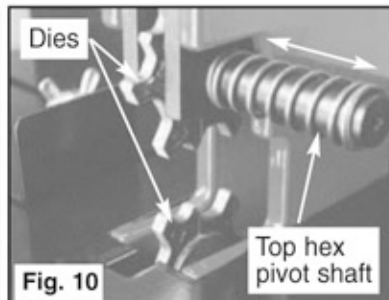
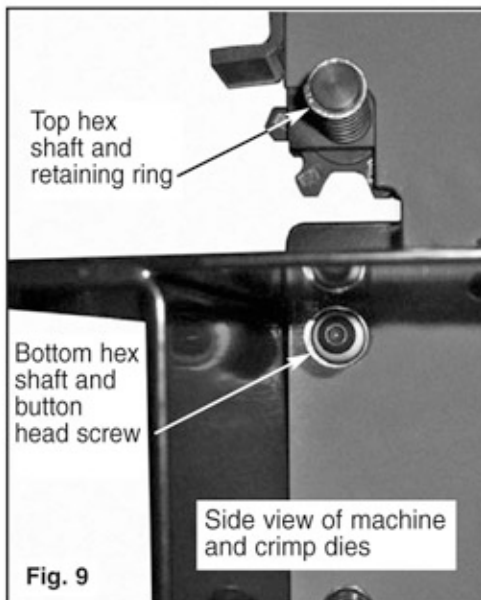
6. Fully close dies for a proper crimp. Pressure gauge should reach 80 psi before releasing the foot switch. (Fig. 6)
7. Crimp connector at both points marked on the barrel. Always crimp near the end of the barrel first. (Fig. 7)
8. For best results, protect terminals with Quick Cable heat shrink tubing. (Fig. 8)



Changing the Dies

Use only Quick Cable dies part number 420501 in the Hexcrimp Pneumatic.

1. Disconnect air source before changing the dies or performing any other maintenance on this machine. (Fig. 1)
2. Both die halves must be changed at the same time.
3. Remove the button head screw on one end of the bottom hex shaft. Remove retaining ring on the top hex shaft. (Fig. 9 & 10)
4. Slide the hex shaft out of the side plates and remove the die.
5. Insert the die between the side plates of the machine and slide the hex shaft through. Note: Make sure that die markings match between the top and bottom dies. (Fig. 11)
6. Reassemble the spring and washer, tighten the button head screw (bottom) and replace the retaining ring (top).



DANGER



Read and understand the instruction manual and all safety labels before operating this machine.

1. Never place your hand or any part of your body in between the dies (or other moving parts) of this machine. Failure to obey could result in loss of fingers, limbs, or cause death.
2. Never change or defeat the purpose of the pneumatic interlock on this machine.
3. Never operate this machine unless all safety guards are in place and functioning properly.
4. Never ride the foot pedal or foot switch. Never rest your foot on top of the foot pedal or inside the foot switch. Always remove your foot completely from the foot switch after each cycle, and any time you are not intending to trip machine.
5. Always be sure other persons are clear of the machine before operating.
6. Never perform maintenance on this machine unless the air supply is disconnected.
7. Never operate the machine unless it is securely mounted to the work surface. See installation instructions.
8. Lifting or moving this machine without mechanical assistance could result in injury.
9. Never operate this machine if physically impaired or under the influence of drugs or alcohol.
10. Wearing safety glasses when operating this machine is strongly recommended, and may be required by OSHA or other federal agencies in your work place.