

## ERG4001 COMFORT CRIMP® COMPRESSION TOOL WITH SHURE STAKE® MECHANISM

For Installing Nylon and Vinyl Insulated Terminals,  
Disconnects, and Splices 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.



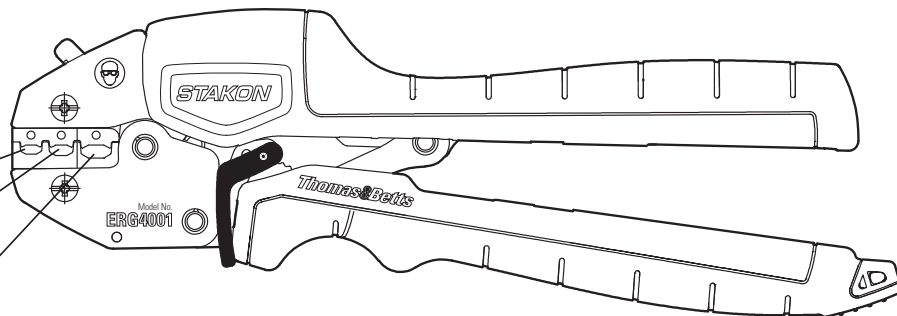
**WARNING**  
HANDLES ARE NON-INSULATING.  
DO NOT CRIMP ON HOT ENERGIZED WIRES.

\* Color coded dots red, blue and yellow, match insulator and/or splice for quick identification of crimp nest.

RED (22-18) NEST

BLUE (16-14) NEST

YELLOW (12-10) NEST



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 22-10 AWG

1. Open handles fully.
2. Insert terminal into proper nest as shown in Figure 2. Tongue markings should face up.
3. a) Rotate locator down. Position terminal so that front of barrel is flush with locator.  
b) As an alternate method without using the locator, rotate the locator away from the die nests. Insert the terminal into the proper nest. Visually center the terminal within the nest so that each end of the insulation protrudes equally beyond the edges of the nest.
4. Close handles slightly to secure terminal. Do not deform terminal.
5. Insert stripped wire.
6. Close handles until SHURE STAKE® mechanism cycle has been completed.

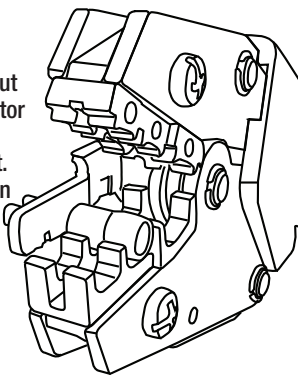


Figure 2

### 1.2

#### For Use With Insulated Splices 22-10 AWG

\*Swing terminal locator away from nest when crimping splices.

1. Open handles fully.
2. Swing locator away from nest.
3. Splices require two crimps. Position splice in proper nest, as shown in Figure 3.
4. Close handles slightly to secure terminal. Do not deform terminal.
5. Insert stripped wire.
6. Close handles until SHURE STAKE® mechanism cycle has been completed.
7. Repeat steps 3-5 on opposite end of splice.

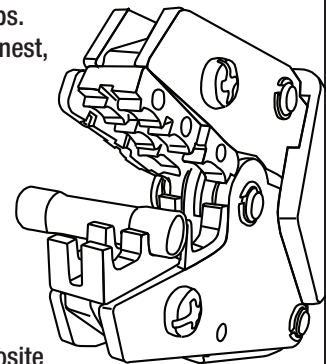


Figure 3

## 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 Crimp Assist® foot helps stabilize the tool during this type of operation.

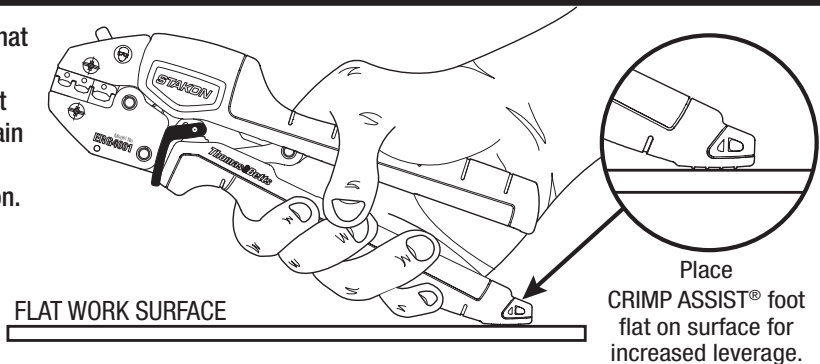


Figure 4

## 1.4 SHURE STAKE® Mechanism

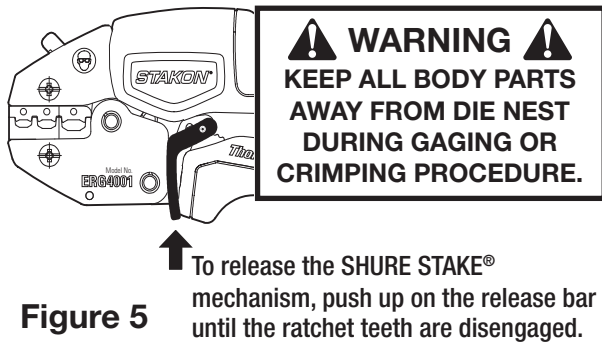


Figure 5

## 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.

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

## 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, insure that each nest meets the gaging requirements as specified, in Table 1.

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

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