

## Crimping Tool

### Potential Injuries & Hazards

<input checked="" type="checkbox"/>	Pinch points
<input type="checkbox"/>	Cuts
<input type="checkbox"/>	Burns
<input type="checkbox"/>	Eye injury
<input type="checkbox"/>	Respiratory hazards
<input type="checkbox"/>	Amputation
<input type="checkbox"/>	Slip, trip or falls
<input type="checkbox"/>	Head injury/concussion
<input type="checkbox"/>	Electric shock
<input type="checkbox"/>	Fire or explosion
<input type="checkbox"/>	MSI
<input type="checkbox"/>	Fatality
<input type="checkbox"/>	Other:



*Note: This task may expose workers to musculoskeletal injury (MSI) risks. Signs and symptoms include pain, burning, numbness, tingling, swelling, stiffness, and/or loss of movement or strength in a body part. Report these to your supervisor immediately.*

**This task may only be performed by trained and authorized personnel.**

### Personal Protective Equipment (PPE) required

										
Safety Glasses	CSA Safety Boots	Hearing Protection	Face Shield	CSA Respirator	Cut Resistant Gloves	Nitrile Gloves	Fire Resistant Gloves	Electrical Gloves	Hard Hat / Bump Cap	Fall Protection
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Inspect your PPE before use. Report any damage to your supervisor immediately. Take care of your PPE: clean, maintain and store it properly.

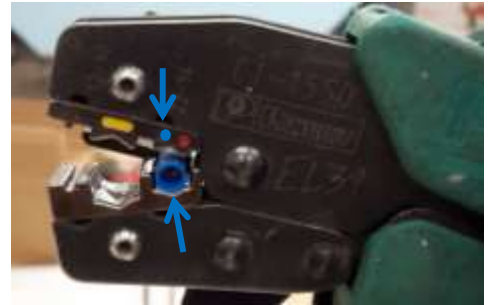
### Education and Training Prerequisites eg. Instructions or other SOP's


## Crimping Tool

### 1. INSPECT THE TOOL.

Inspect the tool for missing or loose pins, then close the tool and note the return action of the handles. Swing the locator out of the way and inspect the crimping dies for worn, chipped or broken edges.

- Put the terminal in the relevant die set. Match it up to the colour-coded dot. Then close the handles until the terminal is held snugly in place—do not deform the terminal.

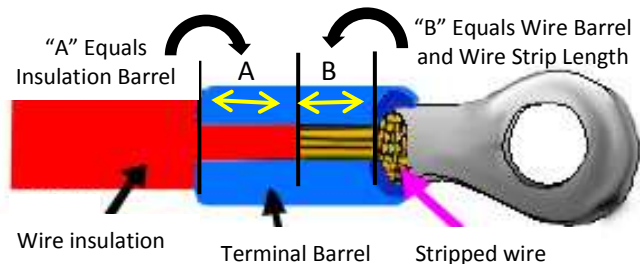


- Twist the end of the stripped wire together. Then insert the stripped wire into the terminal lug barrel until the wire insulation butts flush against the near end of the wire barrel.

Ensure when you insert the wire to the connector it goes in without bird caging and that it is not going to pull any of the actual wires back. If it is needed remove the wire and splice it to the right length so that it goes in correct and snug at the end.



Figure below is a proper insertion of stripped wire in the terminal lug.



- Crimp the terminal by squeezing the handles until the controlled cycle mechanism releases. Upon release, the handles will open automatically and the crimped terminal can be removed.



- Remove the completed assembly and examine it for the proper crimp in accordance with the following:

- Indent centered on the terminal lug barrel.
- Indent in line with the barrel.
- Terminal lug not cracked.
- Terminal lug insulation not cracked.
- Insulation grip crimped.





# Standard Operating Procedure

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Created by: R. Giancola

Approved by: L. Lewicki

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Rev #00

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## Crimping Tool

Report to your Supervisor any condition of the Tool, accessories or operation you consider unsafe.

### Reference Material:

Doc#10197 - Tool/Equipment Use and Inspection

Doc#10107 - Safety Policy

Doc#10541 - Workplace Safety and Health

Doc#10210 - Personal Protective Equipment (PPE)

Rev#	Reason for change:	Revised by:	Date:	Re Training Required
00	New SOP	Initial Release	May 12, 2017	N/A