# *** PLEASE READ VERY IMPORTANT INSTRUCTIONS ***
## FAILURE TO USE A PROPER TOOL AND NOT FOLLOW THESE INSTRUCTIONS VOIDS ANY WARRANTY !

**JOHNSON MARINE HAND CRIMP** installation instructions for JOHNSON HAND CRIMP TOOL (**CAT. # 53-210**)

### FAILURE WILL RESULT IF YOU DO NOT USE THE PROPER TOOLS

You will require the following items for installation:
1) JOHNSON MARINE LIFE LINE TOOL (CAT. # 53-210) Instructions apply to this tool only !
2) Cable Cutter
3) 1/2" Open End Wrench or Socket Wrench
4) Sharp Knife or JOHNSON #53 SERIES CABLE STRIPPER
5) Marking Pen or Pencil
6) Use only 1/8" or 3/16" preformed, stainless steel, aircraft quality wire in 7 x 7, 1 x 19, or 7 x 19 construction.

**1)** Adjust all turnbuckles and pelican hooks to 2/3 extended
**2)** Strip vinyl cover back 1 13/16" to expose bare wire.
**3)** Insert terminal into die ( marked 3/16 ) as shown in ( **A** ) . Tighten clamping screws just enough to grip terminal firmly.
**4)** When using 1/8" wire, insert sleeve ( Cat. # 36-611 ) into terminal. 3/16" wire does not require a sleeve.
**5)** Insert wire into terminal, tighten clamping screws alternately making sure the vinyl cover stays tight against terminal.
**6)** Tighten screws alternately until die blocks are fully closed and no space can be seen between them. ( Do Not Over Tighten )
**7)** Loosen screws until terminal can be repositioned for the next crimp.
**8)** Position terminal as shown in ( **B** ) and repeat steps 6 and 7 until a total of five crimps have been completed. Terminals should appear as shown in ( **C** ).
**9)** Attach completed terminal at required position and lead wire through stanchion eyes. Attach next terminal to be crimped at the required position and while holding wire taut, mark wire as shown in ( **D** ).
**10)** Repeat steps 2 through 8.

**NOTE:** Hand crimp terminals when properly applied will withstand pullout strains of 65 to 70% of 7 x 7 wire strength. We do not warrant use of these terminals for standing rigging or other high load applications.



A FIRST CRIMP — Wire cover, Terminal, Depth of Countersink, Face of die block, End of terminal

B REMAINING CRIMPS — Line up edge of last crimp with side of die block

C COMPLETED TERMINATION — Do Not rotate fitting or recrimp over ridges left by tool. 3/32  1/8  1/8  1/8

D TERMINATION OF OPPOSITE END — Mark here, Cut wire here, 1 13/16"