

ALUMINUM TOOLING SELECTION CHART WITH DIE-LESS CRIMPING TOOLS (RANGE TAKING)

| LUG<br>SIZE | APPROVED WIRE CLASS |     |      |     | RANGE<br>TAKING (APPLICABLE<br>WIRE RANGE) | COLOR  | GREENLEE & NSI<br>DIE-LESS<br>HK12ID, EK12IDL & N12ID | BURNDY<br>DIE-LESS PAT444S |
|-------------|---------------------|-----|------|-----|--|--------|---|----------------------------|
|             | B                   |     | C    |     |  |        |   |                            |
|             | AWG                 | STR | AWG  | STR | AWG  |        |   |                            |
| 6           | 6                   | 7   | 6    | 19  | 6-8  | GRAY   | DIELESS   | DIELESS                    |
| 4           | 4                   | 7   | 4    | 19  | 4-6  | GREEN  |   |                            |
| 2           | 2                   | 7   | 2    | 19  | 2-6  | PINK   |   |                            |
| 1           | 1                   | 19  | 1    | 37  | 1-6  | GOLD   |   |                            |
| 1/0         | 1/0                 | 19  | 1/0  | 37  | 1/0-6                                      | TAN    |   |                            |
| 2/0         | 2/0                 | 19  | 2/0  | 37  | 2/0-4                                      | OLIVE  |   |                            |
| 3/0         | 3/0                 | 19  | 3/0  | 37  | 3/0-2                                      | RUBY   |   |                            |
| 4/0         | 4/0                 | 19  | 4/0  | 37  | 4/0-1                                      | WHITE  |   |                            |
| 250         | 250                 | 37  | 250  | 61  | 250-1/0                                    | RED    |   |                            |
| 300         | 300                 | 37  | 300  | 61  | 300-2/0                                    | BLUE   |   |                            |
| 350         | 350                 | 37  | 350  | 61  | 350-3/0                                    | BROWN  |   |                            |
| 400         | 400                 | 37  | 400  | 61  | 400-4/0                                    | GREEN  |   |                            |
| 500         | 500                 | 37  | 500  | 61  | 500-250                                    | PINK   |   |                            |
| 600         | 600                 | 61  | 600  | 91  | 600-250                                    | BLACK  |   |                            |
| 700         | 700                 | 61  | 700  | 91  | 700-500                                    | PURPLE |   |                            |
| 750         | 750                 | 61  | 750  | 91  | 750-500                                    | YELLOW |   |                            |
| 800         | 800                 | 61  | 800  | 91  | 800-650                                    | WHITE  |   |                            |
| 900         | 900                 | 61  | 900  | 91  | -  | GRAY   |   |                            |
| 1000        | 1000                | 61  | 1000 | 91  | 1000-750                                   | BROWN  |   |                            |



CRIMPING INFORMATION FOR ALUMINUM COMPRESSION CONNECTORS

COMPACT, CONCENTRIC OR COMPRESSED CLASS B, C COPPER AND ALUMINUM CONDUCTORS

1. Select the proper lug or splice connector for the size of cable being installed, ensuring that the size matches the description in the table below.
2. Strip the insulation from the cable to a length so that the stripped area of the cable can be completely inserted into and fill the barrel of the lug or splice.
3. Carefully strip the insulation from the cable without nicking the strands.
4. Wire brush the stripped portion of the cable to remove oxide films.
5. The stripped portion of the conductor must be clean and inserted completely into the connector barrel.
6. Using the tool and die combination specified in the table below, install 2 crimps, leaving a space of 1/8 inch minimum between successive crimps.



ALUMINUM TOOLING SELECTION CHART WITH DIE SET CRIMPING TOOLS

| LUG SIZE | COMPACT CLASS B,C ALUMINUM AND COPPER CONDUCTOR | COLOR  | DIE INDEX | BURNDY<br>Y35, Y39, Y46, Y750, PAT750, PAT750LI | BURNDY<br>Y35, Y39, Y750, PAT750, PAT750LI WITH ILSCO DIE SET | GREENLEE<br>HK1240 & EK1240LI |
|----------|---|--------|-----------|---|---|-------------------------------|
|          | AWG   |        |           |   |   |                               |
| 8        | 8   | BLUE   | 374       | U8CABT  | ILD-374   | KA12-8                        |
| 6        | 6   | GRAY   | 346       | U6CABT  | ILD-346   | KA12-6                        |
| 4        | 4   | GREEN  | 375       | U4CABT  | ILD-375   | KA12-4                        |
| 2        | 2   | PINK   | 348       | U2CABT  | ILD-348   | KA12-2                        |
| 1        | 1   | GOLD   | 471       | U1CART  | ILD-471   | KA12-1                        |
| 1/0      | 1/0   | TAN    | 296       | U25 ART   | ILD-296   | KA12-1/0                      |
| 2/0      | 2/0   | OLIVE  | 297       | U26ART  | ILD-297   | KA12-2/0                      |
| 3/0      | 3/0   | RUBY   | 467       | U27ART  | ILD-467   | KA12-3/0                      |
| 4/0      | 4/0   | WHITE  | 298       | U28ART  | ILD-298   | KA12-4/0                      |
| 250      | 250   | RED    | 324       | U29ART  | ILD-324   | KA12-250                      |
| 300      | 300   | BLUE   | 470       | U30ART  | ILD-470   | KA12-300                      |
| 350      | 350   | BROWN  | 299       | U31ART  | ILD-299   | KA12-350                      |
| 400      | 400   | GREEN  | 472       | U32ART  | ILD-472   | KA12-400                      |
| 500      | 500   | PINK   | 300       | U34ART  | ILD-300   | KA12-500                      |
| 600      | 600   | BLACK  | 473       | U36ART  | ILD-473   | KA12-600                      |
| 700      | 700   | PURPLE | -         | -   | -   | -                             |
| 750      | 750   | YELLOW | 936       | U39ART-2  | ILD-936   | KA12-750                      |
| 1000     | 1000  | BROWN  | -         | S44ART-4  | -   | -                             |

