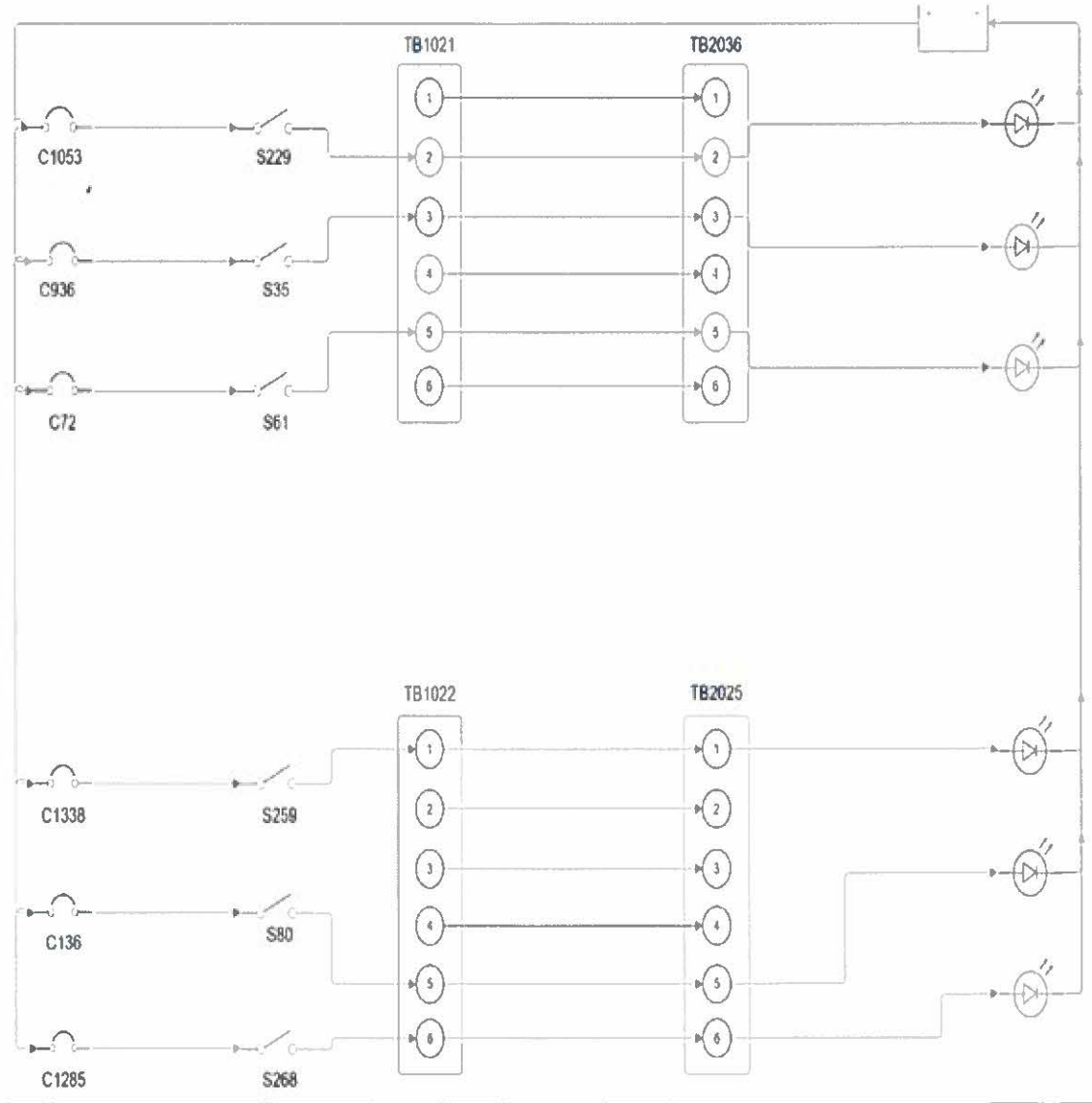




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Table 52 CAU OF THE DIFFERENT BAC3108 SHIELDS (Continued)

Shield Part Number	CAU of the Shield	An Applicable Terminal Crimp Barrel Size
BAC3108-3	96	12-10
BAC3108-3D	96	12-10
BAC3108-4	132	8

- (1) Make shield ground wire from the end of the shield of the cable or shielded wire.
Refer to Subject 20-10-15 for the assembly of a shield ground wire with a shield pull-through.
- (2) Find the CAU of the shield.
Refer to:
 - Table 42 for the table that has the CAU data for the shielded wire or cable
 - Table 52 for the CAU data for the different BAC3108 shields.
- (3) Make a selection of a terminal lug.
Use the CAU of the shield and the stud hole size to make the selection.
- (4) Assemble the terminal lug. Refer to the paragraph applicable to the assembly of the terminal lug.

E. Assembly of BACT12AC Terminal Lugs

Refer to Paragraph 1.B. for the description of the BACT12AC terminal lugs.

Table 53
CRIMP TOOLS FOR SMALL BACT12AC TERMINAL LUGS

Crimp Barrel Size	Insulation Color	Crimp Tool				Special Instructions
		Basic Unit	Holder	Head	Die	
26-24	Yellow	59275	-	-	-	-
22-18	Red	189721-1	356303-1	-	314270-1	For one 24 AWG wire, fold back the conductor
		314423(-)	-	-	314270-1	
		314423(-)	-	-	314270-2	
		314597(-)	-	-	314270-1	
		314597(-)	-	-	314270-2	
		48110	-	-	-	
		482-457540-8	-	687658-1	68872	
		59250	-	-	-	
		68075	-	-	68872	
		69004	-	-	47451	
		69005	-	47516	-	
		69118(-)	-	-	45185-7	
69365(-)	-	-	47806-2			
69875	-	-	68872			



With our integrity,
Professionalism,
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Table 53 CRIMP TOOLS FOR SMALL BACT12AC TERMINAL LUGS (Continued)

Crimp Barrel Size	Insulation Color	Crimp Tool				Special Instructions
		Basic Unit	Holder	Head	Die	
16-14	Blue	189721-1	356303-1	-	314269-1	
		314423-()	-	-	314269-1	
		314423-()	-	-	314269-2	
		314597-()	-	-	314269-1	
		314597-()	-	-	314269-2	
		46110	-	-	-	
		565435-5	-	567200-2	69872	
		565435-5	-	567200-2	69873	
		59250	-	-	-	
		68075	-	-	69873	
		69004	-	-	47852	
		69005	-	47517	-	
		69118-()	-	-	45225-2	
		69118-()	-	-	45225-5	
		69365-()	-	-	47807-1	
12-10	Yellow	189721-1	356302-1	-	679300-1	
		1901235-1 (Battery powered)	1804902-1	59239	-	
		314590-()	-	-	314268-1	
		314590-()	-	-	314268-2	
		314590-2	-	-	314268-1	
		314590-2	-	-	314268-2	
		314700-()	-	-	314268-1	
		314700-()	-	-	314268-2	
		565435-5	-	567200-2	69874	
		59239-()	-	-	-	
		68075	-	-	69874 Model C	
		69004	-	-	47453	
		69010	-	47518-1	-	
		69365	-	-	47808	
		69365-()	-	-	47808-6	
69875	-	-	69874 Model C			



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Table 54
CRIMP TOOLS FOR LARGE BACT12AC TERMINAL LUGS

Crimp Barrel Size	Insulation Color	Crimp Tool			
		Basic Unit	Holder	Head	Die Set
8	Red	1213875-1 (Battery powered)	-	-	1490597-1
		1901343-1 (Battery powered)	-	-	1901006-1
		189721-1	358443-1	-	804395-1
		59974-1	-	-	47820
		69010	-	68285-1	-
		Power Pump	-	69051	47820
			-	69061	47820
			-	ST970-12	47820
6	Blue	1213875-1 (Battery powered)	-	-	1490598-1
		1901343-1 (Battery powered)	-	-	1901007-1
		59974-1	-	-	47821
		Power Pump	-	69051	47821
			-	69061	47821
			-	ST970-12	47821
4	Yellow	1213875-1 (Battery powered)	-	-	1490599-1
		59974-1	-	-	47822
		Power Pump	-	69051	47822
			-	69061	47822
			-	ST970-12	47822
2	Red	1213875-1 (Battery powered)	-	-	1490406-1
		59974-1	-	-	47823
		Power Pump	-	69051	47823
			-	69061	47823
			-	ST970-12	47823
1/0	Blue	1213875-1 (Battery powered)	-	-	1490700-1
		Power Pump	-	58422-1	47824
			-	69066	47824
			-	PPFC-1H	47824



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Table 54 CRIMP TOOLS FOR LARGE BACT12AC TERMINAL LUGS (Continued)

Crimp Barrel Size	Insulation Color	Crimp Tool			
		Basic Unit	Holder	Head	Die Set
2/0	Yellow	Power Pump	-	58422-1	47825
			-	69066	47825
			-	PPFC-1H	47825
4/0	Blue	Power Pump	-	58422-1	47918
			-	69066	47918

NOTE: Refer to [Table 40](#) for the part numbers of the recommended Power Pumps.

NOTE: Refer to [Subject 20-30-22](#) for the assembly of a terminal lug with a conductor that is smaller than the crimp barrel size of the terminal lug.

- (1) Make a selection of a terminal lug from [Table 3](#).

NOTE: For the selection of the terminal, use:

- The crimp barrel size, if one wire is to be terminated
- The CAU range, if more than one wire is to be terminated.

NOTE: Refer to [Subject 20-30-22](#) if more than one wire is to be terminated.

- (2) Make a selection of a crimp tool from [Table 53](#) or [Table 54](#).



IF THE PRESSURE OF THE POWER PUMP IS MORE THAN THE MAXIMUM PRESSURE PERMITTED FOR THE CRIMP TOOL HEAD, AN INJURY TO PERSONNEL CAN OCCUR.



IF THE PRESSURE OF THE POWER PUMP IS MORE THAN THE MAXIMUM PRESSURE PERMITTED FOR THE CRIMP TOOL HEAD, DAMAGE TO THE CRIMP TOOL HEAD CAN OCCUR.

- (3) If the crimp tool basic unit is a power pump, adjust the pressure to make it satisfactory for the crimp tool head. Refer to [Table 41](#).

- (4) Remove the necessary length of the insulation from the end of the wire.

Refer to [Subject 20-00-15](#) for the insulation removal procedures.

To attach one 24 AWG wire to a terminal lug with a 22-18 size crimp barrel, remove twice the length of insulation and fold back the conductor.

Make sure that:

- When the wire is in the terminal lug, and the end of the wire insulation is in the insulation grip of the terminal lug, the end of the conductor extends farther than the end of the crimp barrel
- The clearance from the end of the conductor is sufficient for the installation of the washer and the nut
- The conductor does not have nicked or cut strands



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- If the insulation is removed by the application of heat, the conductor has not moved from the center of the wire
 - If the insulation is removed by the application of heat, the remaining insulation does not have blisters or evidence of overheating
 - The remaining insulation is not frayed.
- (5) Put the conductor of the wire in the crimp barrel of the terminal lug.

Make sure that:

- All of the strands of the conductor are in the crimp barrel
 - The end of the conductor extends farther than the end of the crimp barrel
 - If the terminal lug has an insulation grip, the end of the wire insulation is in the insulation grip of the terminal lug
 - If the terminal lug does not have an insulation grip, the maximum distance from the end of the wire insulation of a single wire to the end of the crimp barrel is 0.12 in. (3.05 mm) for 10 AWG and smaller, and 0.25 in. (6.35 mm) for 8 AWG and larger
 - The clearance from the end of the conductor is sufficient for the installation of the washer and the nut.
- (6) Crimp the terminal lug.

Make sure that:

- All of the strands of the conductor are in the crimp barrel
- The end of the conductor extends farther than the end of the crimp barrel
- If the terminal lug has an insulation grip, the end of the wire insulation is in the insulation grip of the terminal lug
- If the terminal lug has an insulation grip, the crimp tool is adjusted to give the correct insulation support. Refer to [Paragraph 2.C](#).
- If the terminal lug does not have an insulation grip, the maximum distance from the end of the wire insulation of a single wire to the end of the crimp barrel is 0.12 in. (3.05 mm) for 10 AWG and smaller, and 0.25 in. (6.35 mm) for 8 AWG and larger
- The clearance from the end of the conductor is sufficient for the installation of the washer and the nut.

F. Assembly of BACT12AL Terminal Lugs

Refer to [Paragraph 1.C](#) for the description of the BACT12AL terminal lugs.