STÄUBLI

Attention
Important crimp tool information!

Dear valued Customer,

Please note
This is a supplementary document. For complete operation instructions review documents MA231 and MA704 available on our website (www.staubli.com/re-downloads.html). Please contact our North American Headquarters with any questions.

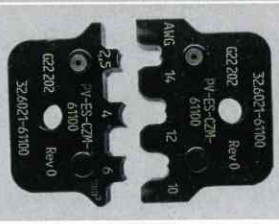
Thank you for purchasing crimp tool kit PV-CZM-64100. The tool kit is intended for crimping MC4 connector crimp contacts. It comes with crimping pliers PV-CZM-, crimp insert PV-ES-CZM-61100 and locator PV-LOC-MC4 2.5/4/6 preinstalled. The preinstalled combination is used for crimping of open (aka 'B') crimp contacts. Next to this assembly you will find crimp insert PV-ES-CZM-63100 and locatorPV-LOC-MC4 14/12-10/8 as loose items. This combination is used for crimping of closed barrel (aka 'O') crimp contacts.

Picture – **open crimp metal contact**

Picture – **closed barrel crimp metal contact**

Please pay close attention to the appropriate combination of metal contact type, crimp insert/locator, and cable conductor size. **Using the wrong combination can result in a compromised and potentially dangerous cable crimp connection.**

Tab. 1: Crimp insert and locator for **open crimp contacts**

Designation of connector	**Cable cross-section**	**Crimp insert PV-ES-CZM-61100** (Order no. 32.6021-61100)	**Locator PV-LOC-MC4 2.5/4/6** (Order no. 32.6082)
			
PV-KBT 4/2,5...-UR PV-KST 4/2,5...-UR	2.5 mm²	×	×
	14 AWG	×	×
PV-KBT4/6...-UR PV-KST4/6...-UR	4 mm²	×	×
	12 AWG	×	×
	6 mm²	×	×
	10 AWG	×	×

Tab. 2: Crimp insert and locator for **closed barrel crimp contacts**

Designation of connector	Cable cross-section	Crimp insert PV-ES-CZM-63100 (Order no. 32.6021-63100)	Locator PV-LOC-MC4 14/12-10/8 (Order no. 32.6085)
			
PV-KBT 4/5...-UR PV-KST 4/5...-UR PV-KBT 4/5...-UR AU PV-KST 4/5...-UR AU	14 AWG	×	×
	12 AWG	×	×
	10 AWG	×	×
PV-KBT4/8...-UR PV-KST4/8...-UR PV-KBT4/8...-UR AU PV-KST4/8...-UR AU	8 AWG	×	×

As with all crimping operations, especially manual/hand crimping, visual inspection of the crimped contact is essential. Always make sure that:

1. The proper crimp form is produced
2. All conductor strands are captured in the crimp
3. The crimp form is symmetrical and free of metal fractures or broken-off crimp material
4. That only copper conductor (not insulation material!) is captured by the crimp

Here are some representative examples of properly crimped connectors:

Example for open (or "B") crimp connector

Example of closed barrel crimp connector