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Johnson Hand Crimp Fittings have proven themselves over the years, however the overall integrity of the system depends on the proper tools for the job. We cannot stress enough the need to use either our #53-210 bolt tool or our #53-215 lever crimping tools built to handle the stress of crimping Johnson stainless fittings. "Micropress" tools were designed to crimp soft copper and aluminum oval and stop sleeves only. Johnson tools are designed with special width and relief patterns which apply to Johnson hand crimp fittings and instructions only. The use of other tools or crimping fittings other than Johnson hand crimp fittings with Johnson tools can result in failure of the terminal, personal injury or loss of life.



1. Our Lever Type Tool has two cavities for 1/8" and 3/16" Hand Crimp fittings. This is a good production tool for the dealer.

Lever Type Tool CAT. NO. 53-215

2. Our Bolt Type Tool should not be confused with other similar type tools. This tool works well for the boat owner replacing several or all life line fittings on their boat.

Bolt Type Tool CAT. NO. 53-210

3. Our Felco Cable Cutter will give you a clean, crisp cut through 1/4" sized cables. Swiss made.

Felco Cable Cutter CAT. NO. 53-220

4. Our Larger Felco Cable Cutter cuts cable through 3/8."

Felco Cable Cutter CAT. NO. 53-222

Our Largest Felco Cable Cutter cuts cable through 5/8".

Felco Cable Cutter CAT. NO. 53-224 (not shown)

Installation Instructions

Johnson Hand Crimp Life Line Terminals

Using Hand Swaging Tool #53-215



TOOLS Required for Installation:

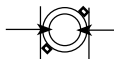
- Cable Cutter
- Marking pen or pencil
- Sharp knife
- Johnson Marine Life Line Tool (CAT. NO. 53-215)

Instructions apply to this tool only ... FAILURE could result from using other tools.

IMPORTANT: Use only 1/8" or 3/16", preformed, corrosion resistant wire in 7x7 or 1x19 construction with finish dimensions to MIL-W-5424B

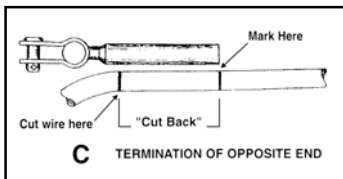
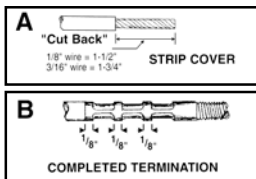
1. Adjust all turnbuckles & pelican hooks to 2/3 extended.
2. Strip vinyl cover back to expose bare wire to dimensions shown in (A).
3. ***Place terminal into proper die: 1/8" wire - Tool #53-215 die marked "1/8". 3/16" wire - Tool #53-215 die marked "3/16".
4. Insert wire into terminal positioning approximately 1/8" from end. Make sure that vinyl cover is tight against terminal before crimping. Complete 3 crimps as shown in (B). Use the gauge provided

with tool to check the after crimp dimension. Measure here...adjust tool if required.



5. Attach completed terminal at required position and lead wire through stanchion eyes. Attach next terminal to be crimped at required position and while holding wire taut, mark wire as shown in (C).
6. Repeat steps 2 thru 4.

*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. **1/8" wire may be used with 3/16 terminal by installing sleeve (CAT. NO. 36-611) into terminal.



Installation Instructions

Johnson Hand Crimp

Using Hand Tool #53-210

Applies to use of 1/8" & 3/16" wire on #27 series (3/16") Terminals only (using adapter sleeve for 1/8" wire).



TOOLS Required for Installation:

- Cable Cutter
- Marking pen or pencil
- Sharp knife
- Johnson Marine Life Line Tool #10(CAT. NO. 53-210)
- 1/2" Open End Wrench or Socket Wrench

Instructions apply to this tool only ... FAILURE could result from using other tools.

IMPORTANT: Use only 1/8" or 3/16", preformed, corrosion resistant wire in 7x7 or 1x19 construction with finish dimensions to MIL-W-5424B

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 bolts just enough to grip terminal firmly.
4. When using 1/8" wire, insert sleeve (CAT. NO. 36-611) into terminal. 3/16" wire does not require a sleeve.
5. Insert wire into terminal, tighten clamping bolts alternately making sure the vinyl cover stays tight against terminal.
6. Tighten bolts alternately until die blocks are fully closed and no space can be seen between them.

7. Loosen bolts until terminal can be repositioned for next crimp.
8. Position terminal as shown in (B) and repeat steps 6 & 7 until a total of five (5) crimps have been completed. Terminal 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 required position and while holding wire taut, mark wire as shown in (D).
10. Repeat steps 2 through 8.

*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.

