

*** PLEASE READ VERY IMPORTANT INSTRUCTIONS ***

FAILURE TO USE A PROPER TOOL AND NOT FOLLOW THESE INSTRUCTIONS VOIDS ANY WARRANTY!

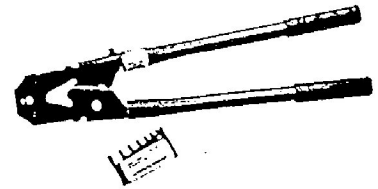
PERSONAL INJURY CAN RESULT FROM USE OF IMPROPER TOOLS.

Johnson Marine Hand Crimp Fittings Installation Instructions For Johnson Hand Crimp Tool (Cat. # 53-215)


FAILURE WILL RESULT IF YOU DO NOT USE THE PROPER TOOLS

You will require the following tools for Installation:

- 1) Cable cutter
- 2) Johnson Marine Tool # 53-215
- 3) Sharp knife or Johnson # 53-Series Cable Stripper for coated cable
- 4) Marking pen



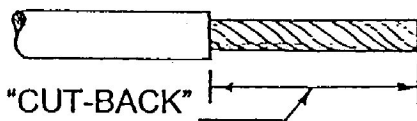
IMPORTANT: Use only 1/8" or 3/16" preformed, corrosion resistant cable in 7x7, 1x19, or 7x19 construction with finish dimensions to Military Standard MIL-W-5424B.

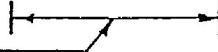
- 1) Adjust all turnbuckles and fittings to 2/3 extended.
- 2) If using coated cable strip back cover to expose bare cable to dimension shown in figure A.
- 3) Place the terminal into the proper die on the tool:
 - 1/8" cable - Johnson Tool # 53-215 die marked " 1/8" .
 - 3/16" cable - Johnson Tool # 53-215 die marked " 3/16" .
- 4) Insert cable into terminal and position terminal approximately 1/8" from end in die. Make sure that the vinyl cover is tight against the terminal before crimping if using coated cable.
- 5) Complete three crimps as shown in B. Use the gauge provided with tool to check the after crimp dimension. Measure here  adjust tool if required. *
- 6) Attach completed terminal at required position and lead cable through supports. Attach next terminal to be crimped at required position and while holding cable taut, mark cable as shown in C.
- 7) Repeat steps 2 through 4.

Hand Crimp terminals when properly applied will withstand pullout strains of 65 to 70% of 7x7 cable strength. We do not warrant use of these terminals for standing rigging or other high load applications.

1/8" cable can be used in 3/16" terminals by sliding adapter sleeve #36-611 over 1/8" cable and then inserting into 3/16" terminal and crimping with 3/16" groove on tool.

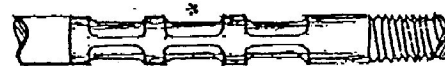
A. STRIP COVER (if applicable)



"CUT-BACK" 

1/8" CABLE - 1 1/2"
3/16" CABLE - 1 3/4"

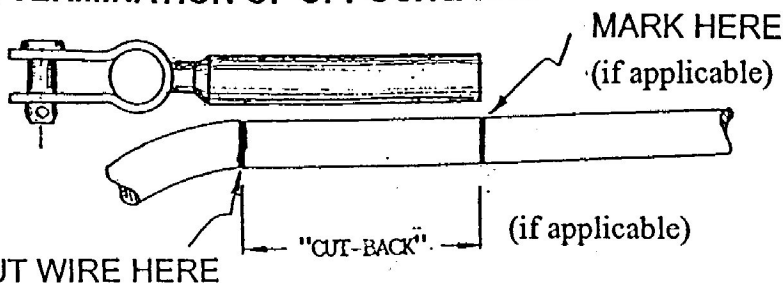
B. COMPLETED TERMINATION



1/8" 1/8" 1/8"

*Rotate tool or terminal 180 degrees for center crimp.

C. TERMINATION OF OPPOSITE END



* Micrometer / Caliper
Dimensions:
1/8" Cable = .185
3/16" Cable = .260