Crimp Tool Overview

The two types of DEUTSCH contacts are solid and stamped & formed. Both styles of contacts are designed for crimp style terminations - no solder is required or recommended. A crimp style termination displaces the wire strands creating a superior bond between the wire and the contact.

Several tools are available for hand and production wire crimping, wire insertion and removal, and wedgelock/terminal position assurance removal. The tools are specific to the solid contacts or the stamped & formed contacts. To create a proper crimp and achieve the highest performance specifications, contacts must be crimped with the recommended tooling.

Automated Tooling Overview

For higher production volumes, a pneumatic power crimp tool is available for the DEUTSCH solid contacts, and applicator dies for stamped & formed contacts. The HDP-400, a pneumatic solid crimp tool, is a fast, bench-top tool that crimps most DEUTSCH contacts. The HDP-400 has a foot control, and easy-to-change dies and locators for each contact size. TE's stamped & formed OCEAN applicator dies are heavy duty mini-dies that work in many industry standard presses. The OCEAN applicator dies offer simple adjustments and the flexibility to accept different sized contacts and wire gauge.

AUTOMATED TOOLING FOR SOLID CONTACTS

Tool Part Number	Contact Size	Contact Part Number
HDP-400	4	0460-204-0490 0462-203-04141
	8	0460-204-08141 0462-203-08141
	12	0460-204-12** 0462-203-12**
	16	0460-202-16** 0462-201-16**
		0460-215-16** 0462-209-16**
	20	0460-202-20** 0462-201-20**

For the appropriate die and locator, see drawing 0425-205-0000

HDP-400 TOOLING ACCESSORIES

The Go-No-Go gauge is used to determine if the HDP-400 tool is calibrated within the recommended specifications to produce a proper crimp.

Part Number	Go-No-Go Gauges
GA20N	HDP-400 Size 20
450GA-16N	HDP-400 Size 16
450GA-12N	HDP-400 Size 12
GA8-SPEC	HDP-400 Size 8
450GA-4-SPEC	HDP-400 Size 4

AUTOMATED TOOLING FOR STAMPED & FORMED CONTACTS

	Pin P/N	Socket P/N	Insulation Range O.D. (mm)	Applictor P/N Conversion Kit P/N
Size 12 -Group 1	1060-12-0144 1060-12-0166	1062-12-0144 1062-12-0166	.151-.176 (3.83-4.47)	2266124-1 7-2266124-8
			.130-.154 (3.30-3.91)	2266125-1 7-2266125-8
			.113-.135 (2.87-3.43)	2266126-1 7-2266127-8
Size 12 -Group 2	1060-12-0222 1060-12-0244	1062-12-0222 1062-12-0244	.185-.204 (4.70-5.18)	2266127-1 7-2266127-8
			.155-.190 (3.94-4.83)	2266128-1 7-2266128-8
			.140-.160 (3.56-4.06)	2266129-1 7-226129-8
Size 16 -Group 1	1060-14-0122 1060-14-0144 1060-14-0177 1060-14-1077 1060-14-1088	1062-14-0122 1062-14-0144 1062-14-0177 1062-14-1077 1062-14-1088	.120-.150 (3.05-3.81)	2266100-1 7-2266100-8
			.105-.125 (2.67-3.18)	2266101-1 7-2266101-8
	1060-16-0122 1060-16-0144 1060-16-0177 1060-16-0722 1060-16-0744 1060-16-0777 1060-16-0977 1060-16-0988	1062-16-0122 1062-16-0144 1062-16-0177 1062-16-0722 1062-16-0744 1062-16-0777 1062-16-0977 1062-16-0988	.105-.125 (2.67-3.18)	2266101-1 7-2266101-8
			.085-.111 (2.16-2.82)	2266102-1 7-2266102-8
			.075-.105 (1.91-2.67)	2266103-1 7-2266103-8
			.063-.094 (1.60-2.39)	2266104-1 7-2266104-8

The -1 suffix on the applicator p/n represents a mechanical feed, for other feed options contact your representative. The conversion kit is to convert applicators within the same group. For more information, please reference TE catalog 1-1773730-8 or contact your representative.

AUTOMATED TOOLING FOR STAMPED & FORMED CONTACTS (CONTINUED)

	Pin P/N	Socket P/N	Insulation Range O.D. (mm)	Applictor P/N Conversion Kit P/N
Size 16 -Group 2	1060-16-0622 1060-16-0644 1060-16-0677 1060-16-0688	1062-16-0622 1062-16-0644 1062-16-0677 1062-16-0688	.063-.094 (1.60-2.39)	2266110-1 7-2266110-8
			.050-.075 (1.27-1.91)	2266111-1 7-2266111-8
Size 16 -Group 3	1060-16-1222 1060-16-1244 1060-16-1277 - - -	1062-16-1222 1062-16-1244 1062-16-1277 1062-16-1422 1062-16-1444 1062-16-1477	.120-.140 (3.05-3.56)	2266112-1 7-2266112-8
			.105-.125 (2.67-3.18)	2266113-1 7-2266113-8
			.090-.110 (2.29-2.79)	2266114-1 7-2266114-8
			.075-.095 (1.91-2.41)	2266115-1 7-2266115-8
Size 20 -Group 1	1060-20-0122 1060-20-0144 1060-20-0177 - - -	1062-20-0122 1062-20-0144 1062-20-0177 1062-20-0322 1062-20-0344 1062-20-0377	.105-.125 (2.67-3.18)	2266116-1 7-2266116-8
			.085-.111 (2.16-2.82)	2266117-1 7-2266117-8
			.075-.105 (1.91-2.67)	2266118-1 7-2266118-8
	1060-20-0222 1060-20-0244 1060-20-0277	1062-20-0222 1062-20-0244 1062-20-0277	.063-.085 (1.62-2.16)	2266119-1 7-2266119-8
			.050-.075 (1.27-1.91)	2266120-1 7-2266120-8

The -1 suffix on the applicator p/n represents a mechanical feed, for other feed options contact your representative. The conversion kit is to convert applicators within the same group. For more information, please reference TE catalog 1-1773730-8 or contact your representative.

Hand Tool Overview

For field service, prototype, and low-volume production, there are several easy-to-use hand crimp tools for both solid barrel and stamped & formed contacts. All hand crimp tools provide a tight, complete crimp with minimal effort. The HDT-48-00, the most commonly used tool for solid contacts, crimps a wide range of contact sizes. It provides a symmetrical four indent crimp, is compact and easy-to-use for field service, yet sturdy and reliable enough for low volume production. Hand crimp tools for DEUTSCH stamped & formed contacts are wire gauge specific and simultaneously crimp the insulation and conductor, saving time and effort during field service.

HAND TOOLS FOR SOLID CONTACTS

HDT-04-08

HDT-48-00

HDT-50-00

HDT-1561

Contact Size	Contact Part Number	Tool Part Number	Crimp Type
4	0460-204-0490 0462-203-04141	HDT-04-08	Two indent crimp
8	0460-204-08141 0462-203-08141	HDT-04-08	Two indent crimp
12	0460-204-12** 0462-203-12**	HDT-48-00	Four indent crimp
		HDT-1561	Two indent crimp
		HDT-50-00	One indent crimp
16	0460-202-16** 0462-201-16** 0460-215-16** 0462-209-16**	HDT-48-00	Four indent crimp
		HDT-1561	Two indent crimp
		HDT-50-00	One indent crimp
20	0460-202-20** 0462-201-20**	HDT-48-00	Four indent crimp
		HDT-1561	Two indent crimp
		HDT-50-00	One indent crimp

HDT-48-00 TOOLING ACCESSORIES

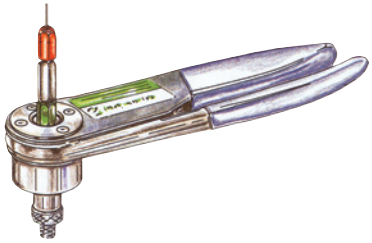
Replacement parts, such as adjustment screws, locking nuts, and inspection tools are available for the HDT-48-00 hand tool.

Part Number	Crimp Tool Replacement Part
0426-209-0000	Adjustment screw and locking nut
M2700-395-10	Locking nut

Part Number	Description
G454	HDT-48-00 Go-No-Go Gauge

helpful hint

Go-no-go gauges are used to inspect crimp tooling. The G454 gauge is used with the HDT-48-00 hand tool.



HAND TOOLS FOR DEUTSCH STAMPED & FORMED CONTACTS

DTT-12-00

DTT-12-01

DTT-16-00
DTT-16-01
DTT-20-00
DTT-20-02

Contact Size	Contact Part Number	Tool Part Number
12	1060-12-01** 1062-12-01**	DTT-12-00
	1060-12-02** 1062-12-02**	DTT-12-01
16	1060-16-01** 1062-16-01** 1060-16-06** 1062-16-06**	DTT-16-00 (14-16 AWG)
		DTT-16-01 (18 AWG)
20	1060-20-01** 1062-20-01**	DTT-20-00
	1060-20-02** 1062-20-02**	DTT-20-02

MULTI-USE REMOVAL TOOL

Part Number	Description
DT-RT1	Multi-use tool with a small hook on one end for wedgelock removal, and a small screwdriver on the other end to push back the locking fingers and release the contact. For use with the DT, DTM, DTP, DTV, DRB, and STRIKE series.

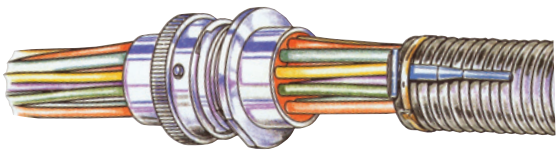
REMOVAL TOOLS

DEUTSCH removal tools are designed to simplify contact removal and field service repair in connectors that utilize a round shoulder contact retention system. Removal tools are compact, easy-to-use, and manufactured of heavy duty plastic to remove contacts without damage to the wire, insulation, connector seals, or connector body. The removal tools are required for wire removal in the DTHD, Jiffy Splices, HD10, HDP20, HD30, DRC, AEC, and WT series.

Part Number	Contact Size	Wire Gauge Range	Color
0411-027-0405	Size 4	4 AWG	Black
114009	Size 4	6 AWG	White
114008	Size 8	8-10 AWG	Green
0411-353-0805	Size 8 for HD Box	8-10 AWG	Green Extended
114010	Size 12	12 AWG	Yellow
0411-337-1205	Size 12	12-14 AWG Extra Thin Wall (E-Seal)	Orange
0411-291-1405	Size 16	14-16 AWG	Green
0411-310-1605	Size 16	16-20 AWG	Light Blue
0411-336-1605	Size 16	16-18 AWG Extra Thin Wall (E-Seal)	Dark Blue
0411-240-2005	Size 20	20-22 AWG	Red

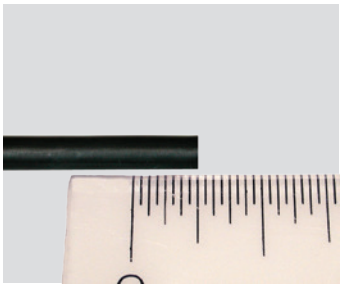
helpful hint

A contact removal tool taped or tie wrapped to the harness will make it easily available, should repairs be needed.



How To Instructions

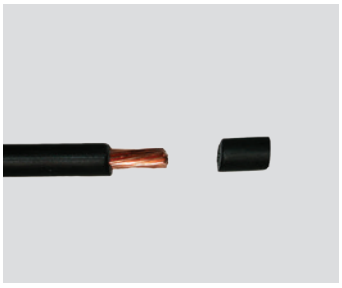
WIRE STRIPPING



Step 1:
1. Choose the correct AWG for the contact being used.

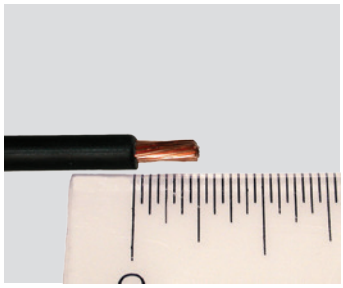
2. Measure from the end of the wire the recommended strip length according to the contact size.

3. Place the wire into a stripping tool at the recommended strip length. Strip the wire according to stripping tool instructions.



Step 2:
1. After stripping, a small piece of the insulation should come off.

2. Check for any broken strands or for a dent in the wire. If either exist, the wire is damaged and should be cut and stripped again.

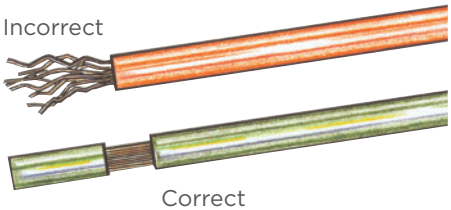


Step 3:
Measure the exposed strands to be sure the crimp length is correct.

helpful hint

Leaving the stripped portion of the insulation on the wire until crimping will avoid flayed wire strands.

Incorrect



Correct

CRIMPING WITH THE HDT-48-00 HAND TOOL

Step 1:
1. Strip insulation from wire.

2. Raise selector knob and rotate until arrow is aligned with wire size to be crimped.

3. Loosen locknut, turn adjusting screw in until it stops.

Step 2:
Insert contact with barrel up. Turn adjusting screw counterclockwise until contact is flush with indentor cover. Tighten locknut.

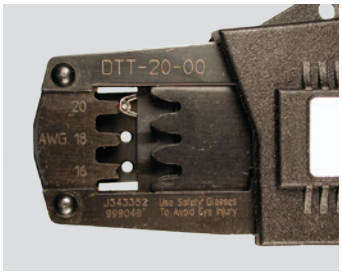
Step 3:
1. Insert wire into contact. Contact must be centered between indentors. Close handles until crimp cycle is completed.

2. Release handles and remove crimped contact.

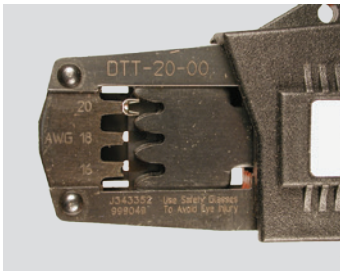
Note

Tool must be adjusted for each type/size of contact.

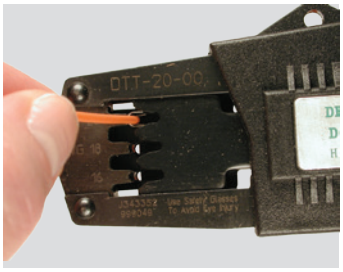
CRIMPING WITH DTT STYLE HAND TOOLS (SIZE 16 & 20)



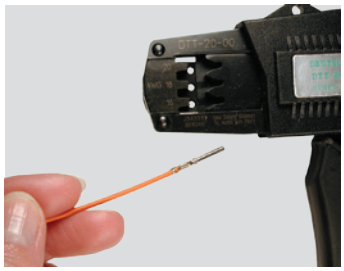
Step 1:
Cycle the hand tool to the open position. Place the contact into the correct die nest.



Step 2:
Partially close the tool until the contact is held in place.

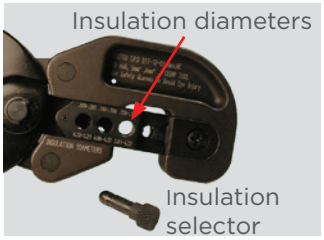


Step 3:
Insert the prestripped wire into the crimp area of the contact.



Step 4:
Close the tool until the ratchet releases. The ratchet is released when a loud click is heard and crimp is complete.

CRIMPING WITH DTT-12-01 HAND TOOL



Step 1:
Cycle handles to release ratchet and fully open crimp jaws. Pull out insulation selector and push into proper diameter using the chart below.

Wire Type	Insulation Selector
10 TXL	.150-.170
10 GXL	.160-.180
10 SXL	.170-.205
5.0 mm^2	.160-.180
6.0 mm^2	.170-.205

Step 2:
1. Insert contact into locator. Adjust alignment and width of crimp wings if necessary to help confirm capture by crimp jaws.

2. Insert stripped wire into the contact. Close crimp tool until full-cycle ratchet control releases.