



Title <i>INSTRUCTION GUIDE FOR DTT-12-01</i>	Drawing Number 0425-045-0000 OCT 17 2001
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Revisions			
Sym	Description	Date	Approved
NC	New Release per E.O. P17438	9-21-01	RDR

1. WIRE PREPARATION

Prior to crimping contacts, wire must be stripped to a length of .250"±.025" [6.35±0.64]. Wire insulation shall not be torn or stretched. Conductor strands should not be missing or damaged.

2. CONTACT LOADING

Cycle handles to release ratchet and fully open crimp jaws. Adjust insulation selector for size to be crimped. Insert terminal into locator. Adjust alignment and width of crimp wings if necessary to insure capture by crimp jaws.

WARNING: Terminals may have sharp edges. Use finger protection to avoid cuts. Do not place fingers in tool areas which may pinch during crimp cycle. Use safety glasses to avoid eye injury.

3. HAND-CRIMP CYCLE

Close crimp tool until full-cycle ratchet control releases.

4. CONTACT REMOVAL

After completing the crimp cycle, open jaws fully. Remove crimped contact.

5. MAINTENANCE

Maintenance must be performed on a regular basis. This includes:
 Tool cleaning, debris removal, and lubrication of moving parts.
 Check tool calibration values after 5,000 crimps (or 6 months).
 Visually inspect for loose hardware and broken or missing parts.

6. CALIBRATION SETTINGS FOR WIRE GAUGE AND INSULATION TYPES

Use this chart to insure best crimp results with Deutsch stamped and formed contacts 1060-12-02** (PIN), and 1062-12-02** (SOCKET):

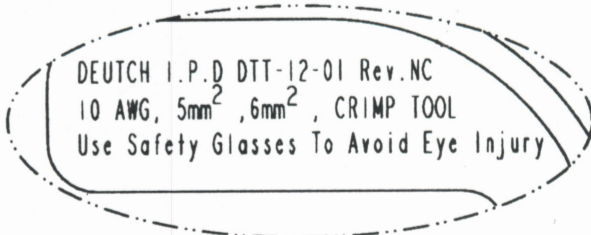
WIRE TYPE	INSULATION SELECTOR	CONDUCTOR CALIBRATION		INSULATION CALIBRATION	
		HEIGHT	WIDTH	HEIGHT	WIDTH
10 TXL	.150-.170 [3.81-4.32]	.096-.102 [2.44-2.59]	.140-.146 [3.56-3.71]	.145-.165 [3.68-4.19]	.162-.174 [4.11-4.42]
10 GXL	.160-.180 [4.06-4.57]	.096-.102 [2.44-2.59]	.140-.146 [3.56-3.71]	.168-.178 [4.27-4.52]	.162-.174 [4.11-4.42]
10 SXL	.170-.205 [4.32-5.21]	.096-.102 [2.44-2.59]	.140-.146 [3.56-3.71]	.170-.190 [4.32-4.83]	.164-.176 [4.17-4.47]
5.0 mm ²	.160-.180 [4.06-4.57]	.096-.102 [2.44-2.59]	.140-.146 [3.56-3.71]	.145-.165 [3.68-4.19]	.162-.174 [4.11-4.42]
6.0 mm ²	.170-.205 [4.32-5.21]	.098-.104 [2.49-2.64]	.142-.148 [3.61-3.76]	.175-.195 [4.44-4.95]	.164-.176 [4.17-4.47]



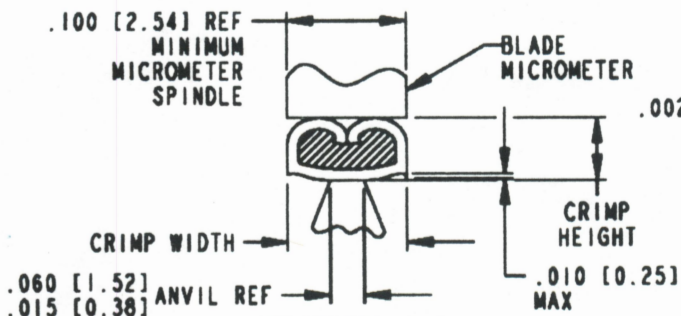
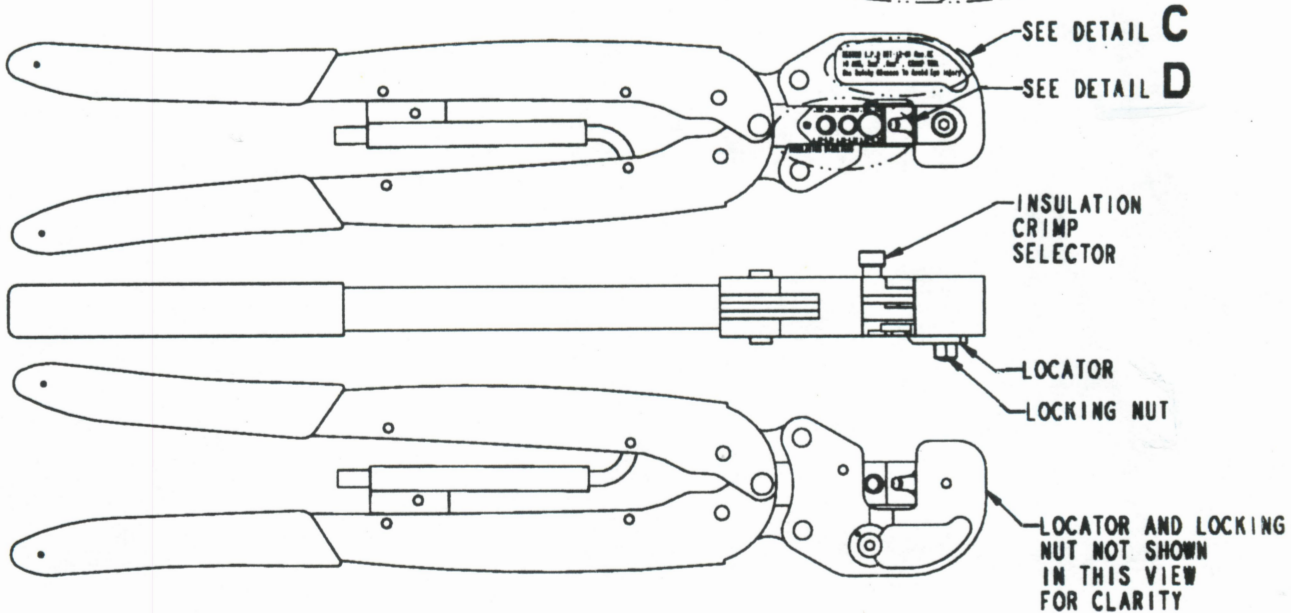
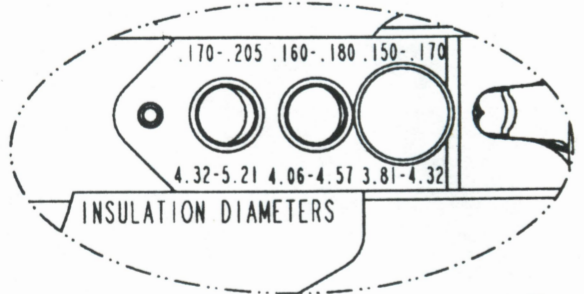
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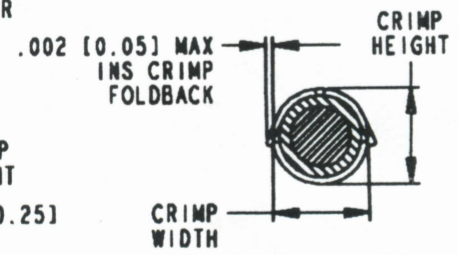
DETAIL C



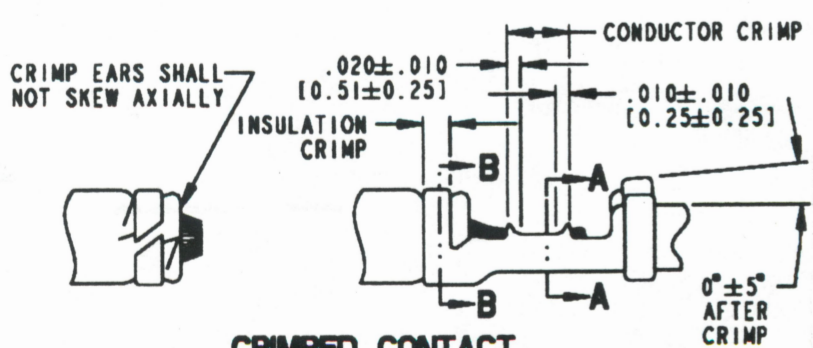
DETAIL D



**SECTION A-A
CONDUCTOR CRIMP**



**SECTION B-B
INSULATOR CRIMP**



CRIMPED CONTACT