Title	Drawing Number
INSTRUCTION GUIDE FOR DTT-16-02	*0425-058-0000*

Revisions			
Sym	Description	Date	Approved
A	Revised per E.O. P19060	5/01/06	D. Meyer

1. WIRE PREPARATION

Prior to crimping contacts, wire must be stripped to a length of .200" ± .025" [5.08 ± 0.64].
Wire should have no insulation tearing or stretching and no conductor strands missing or damaged.

2. CONTACT LOADING

Cycle handles to release ratchet and fully open crimp jaws. Insert contact into desired nest. Verify that contact is fully inserted into locator block. 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.

5. MAINTENANCE and INSPECTION

Maintenance and inspection should be performed regularly. Tool should be wiped clean with special emphasis on the crimping cavities. Tool may be cleaned by immersing in a suitable commercial solvent or cleaner which does not attack paints or plastic material. The tool should be re-lubricated after cleaning using a light film of medium weight oil on bearing surfaces and pivot pins. When not in use, keep handles closed to prevent objects from becoming lodged in the crimping dies. Store in a clean dry area.

6. RECOMMENDED CAVITY FOR WIRE GAUGE AND INSULATION TYPES

Use this Table 1 to insure best crimp results with Deutsch stamped and formed contacts 1060-16-12** (PIN), and 1062-16-12** (SOCKET):

Table 1. Cavity and Wire Gage and Insulation Types

Cavity	Wire Gage and Insulation Types	Insulation Range
A	**1.0 mm^2** **16 AWG (TXL)** **1.5 mm^2**	**.075 - .100** **[1.91 – 2.54]**
B	**16 AWG (TXL, GXL)** **1.5 mm^2** **14 AWG (TXL, GXL)** **2.5 mm^2** **12 AWG (TXL)**	**.095 - .132** **[2.41 – 3.35]**

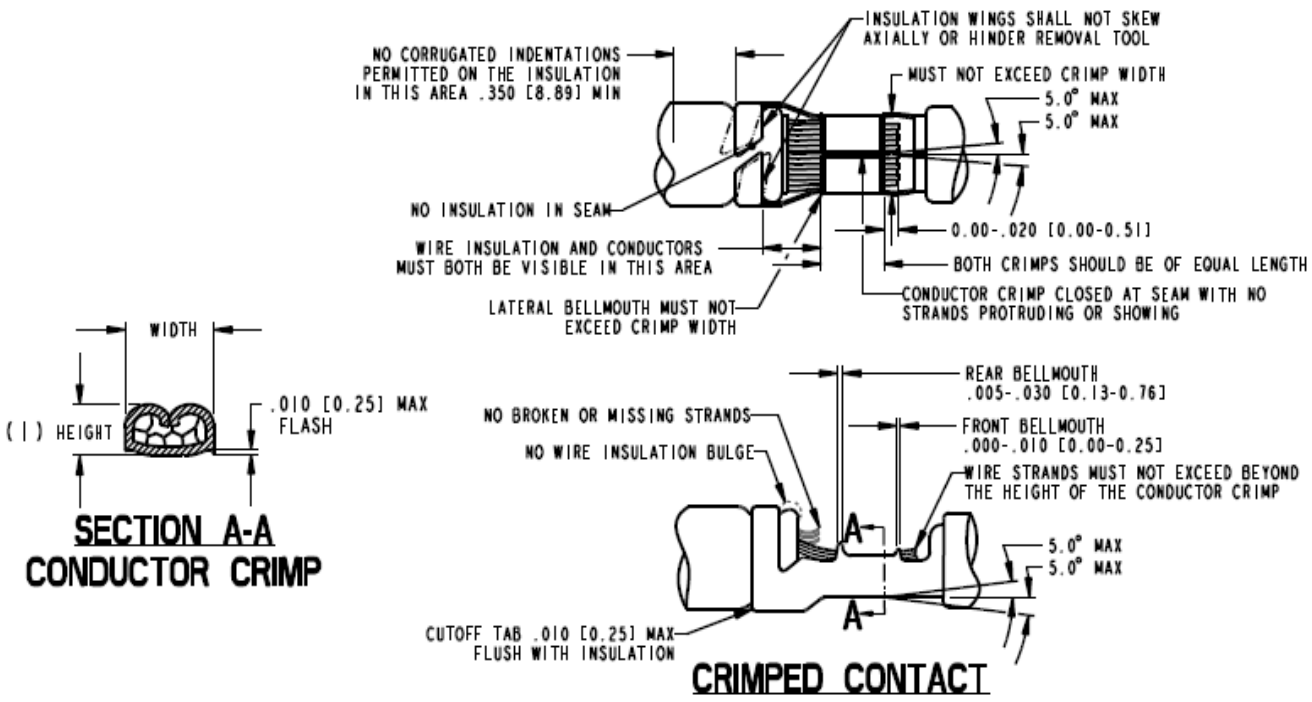
7. CALIBRATION

Table 2.
*Use conductor type per SAE J1128 AND ISO 6722(Metric)

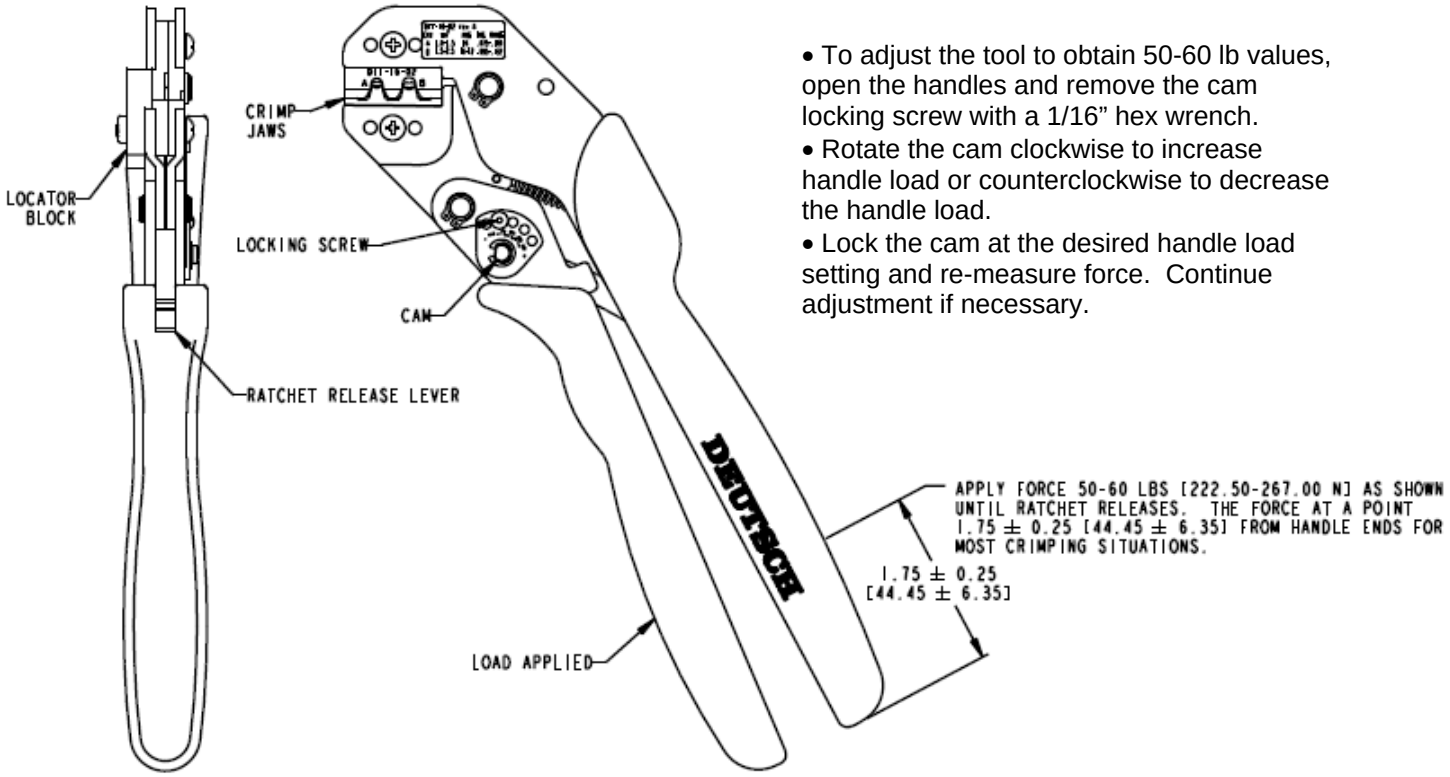
Cavity	Wire*	Conductor Height (1)	Conductor Width	Insulation Height	Insulation Width
A	**1.0 mm²**	.057-.067	.110-.115	.090-.100	.090-.096
	16 AWG	.058-.068	.110-.115	.094-.106	.092-.098
	1.5 mm²	.060-.070	.110-.115	.100-.110	.093-.099
B	**16 AWG (GXL)**	.053-.064	.108-.113	.102-.112	.100-.112
	1.5 mm²	.054-.065	.108-.113	.104-.112	.100-.109
	12 AWG	.065-.075	.110-.115	.115-.125	.115-.125

Note: check tool calibration values after 5,000 crimps (or 6 months). Visually inspect for loose hardware and broken or missing parts.

(1) Measure conductor height with a blade and point micrometer to prevent false readings which include crimp flash (burr).



8. ECCENTRIC ADJUSTMENT (Crimping Force)



- To adjust the tool to obtain 50-60 lb values, open the handles and remove the cam locking screw with a 1/16” hex wrench.
- Rotate the cam clockwise to increase handle load or counterclockwise to decrease the handle load.
- Lock the cam at the desired handle load setting and re-measure force. Continue adjustment if necessary.