



Revisions			
Sym	Description	Date	Approved
<i>B</i>	<i>Revised per E.O. P19503</i>	<i>1/08/08</i>	<i>R. Reed</i>
<i>C</i>	<i>Revised per E.O. P19727</i>	<i>2/21/08</i>	<i>D. Meyer</i>
<i>D</i>	<i>Revised per E.O. P20709</i>	<i>12/20/10</i>	<i>S. Beard</i>

1. WIRE PREPARATION

Prior to crimping contacts, wire must be stripped to a length of $.175'' \pm .025''$ [4.45 ± 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 in cavity recommended for wire size. Adjust alignment and width of crimp wings if necessary to insure capture by crimp jaws.

WARNING: Contacts 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

To ensure correct functioning, maintenance must be performed on a regular basis. This includes:

Lubrication of moving parts.

Removal of debris from jaw areas.

Visual inspection for loose hardware, broken or missing parts.

6. RECOMMENDED CAVITY FOR WIRE GAUGE AND INSULATION TYPES

Use this chart to insure best crimp results with Deutsch stamped and formed contacts 106*-14-01**, 106*-14-10**, 106*-16-01**, 106*-16-07**, and 106*-16-09**:

NOTE: when * = 0, P/N is **PIN** contact; when * = 2, P/N is **SOCKET** contact

** = **PLATING CODE**; see individual contact Envelope Drawings for available types.

Cavity	METRIC Wire Sizes	AWG Insulation Types
A	1.0 mm²	
A		16 TXL, 16 GXL, or 16 SXL
B	1.5-2.0 mm²	
B		14 TXL, 14 GXL or 14 GXL



CONDUCTOR ↗
Cavity FARside

INSULATION ↗
Cavity NEARside

