



PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended-use, production operations is available.

1. CRIMPING WITH TOOL DTT-16-01

1.1. Wire Preparation

A. Prior to crimping contacts, wire must be stripped to a length of 0.175 inches \pm 0.025 inch [4.45 mm \pm 0.64 mm].

1. Wire should have no insulation tearing or stretching.
2. Wire should have no conductor strands missing or damaged.

1.2. Contact Loading

A. Cycle handles to release ratchet and fully open crimp jaws.

B. Insert contact in cavity recommended for wire size.

C. Adjust alignment and width of crimp wings, if necessary, to insure capture by crimp jaws.



NOTE

It may be necessary to slightly "bend" the conductor and insulation wings inward a little to help the punches crimp the wings easier.



CAUTION

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.

1.3. Crimping Procedure

A. Hand-Crimp Cycle

Close crimp tool until full-cycle ratchet control releases.

B. Contact Removal

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

2. RECOMMENDED CAVITY FOR WIRE GAUGE AND INSULATION TYPES

Use Table 1 and Figure 1 to insure best crimp results with Deutsch stamped and formed contacts
 106*-16-01**, 106*-16-06**, 106*-16-07**, 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
C	0.5 mm ²	---
D	0.75 mm ²	---
D	---	18 TXL, 18 GXL, or 18 SXL

Table 1

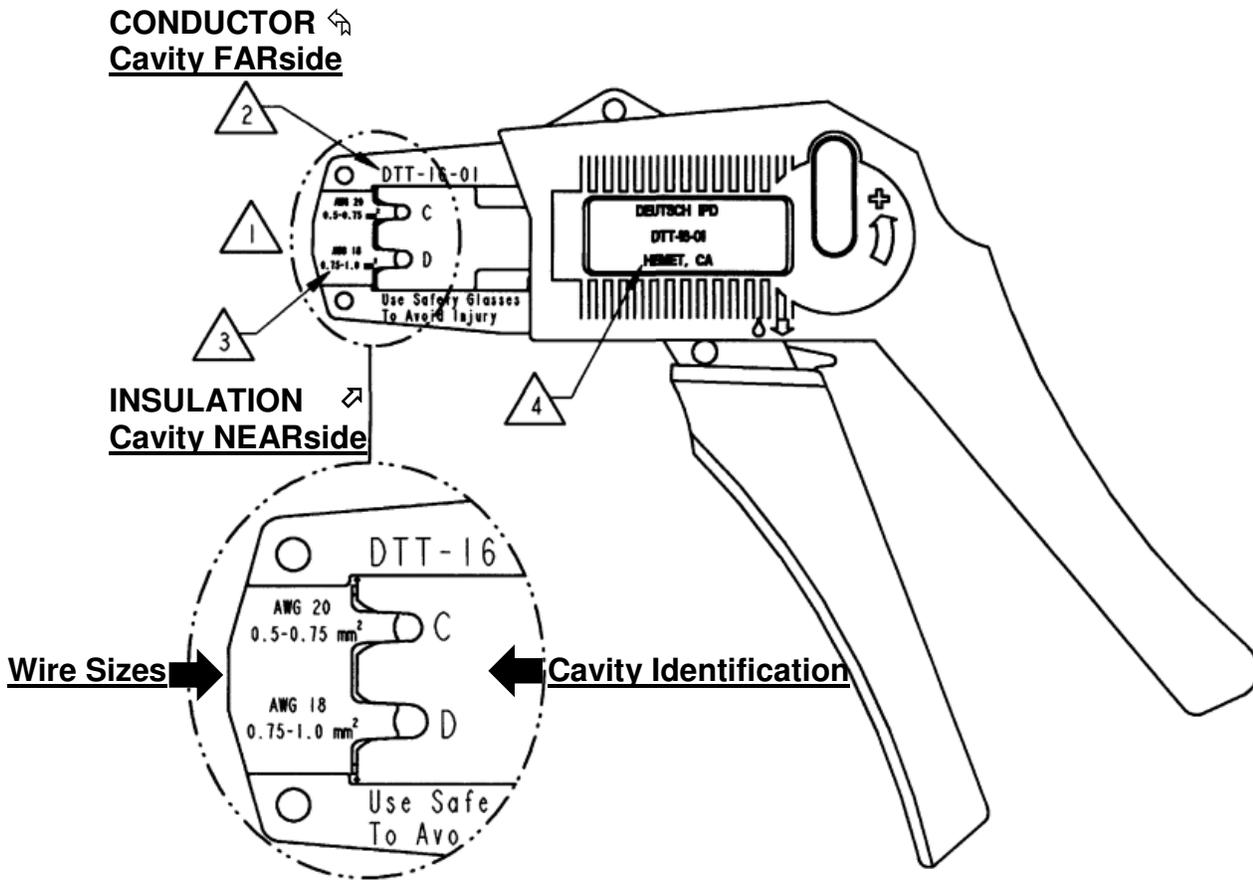


Figure 1

3. MAINTENANCE

1. 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 and/or broken or missing parts.

4. REVISION SUMMARY

- ◆ Revised to most up-to-date TE CONNECTIVITY logo and format.
- ◆ All paragraph numbering and some Sections changed due to newest format.
- ◆ Added NOTE in Section 1.2.C.
- ◆ Added Table and Figure designations and references, where applicable.
- ◆ Added Section 4; Revision Summary