

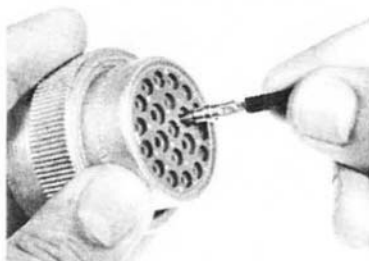
DEUTSCH* Hand Tool

HDT-50-00

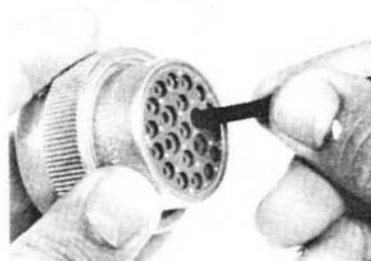
CONTACT INSERTION



1. Grasp contact approximately (25.4 mm) one inch behind the contact crimp barrel.

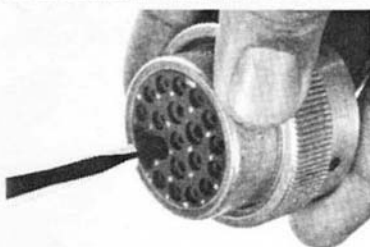


2. Hold connector with rear grommet facing you.

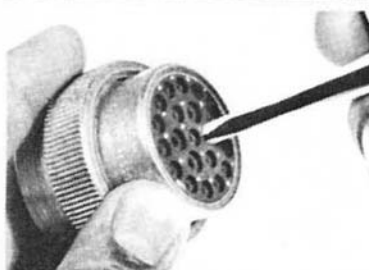


3. Push contact straight into connector grommet until a positive stop is felt. A slight tug will confirm that it is properly locked in place.

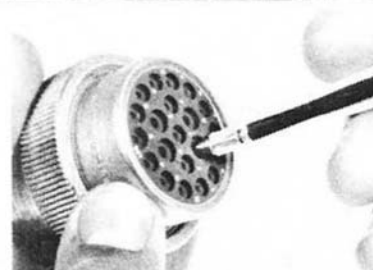
CONTACT REMOVAL



1. With rear insert toward you, snap appropriate size extractor tool over the wire of contact to be removed.

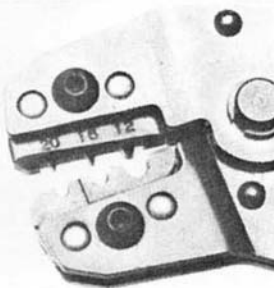


2. Slide tool along wire into the insert cavity until it engages contact and resistance is felt. **NOTE:** Do not twist or insert tool at an angle.

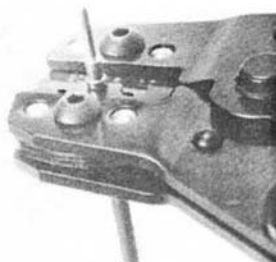


3. Pull contact-wire assembly out of connector.

CRIMPING PROCEDURE FOR FIELD REPAIR TOOL



1. Strip insulation from wire .250 (1/4") Pull wire straight from stripper (not at an angle). If wire is pulled at an angle more strands may be cut off.
2. Using the hand crimping tool, position the proper size terminal into, the correct pocket to be crimped.



3. Close ratchet until terminal is secure and will not fall out. Place the stripped end of the wire in the crimp barrel and fully depress the tool handles. Release, and remove. If tool does not release, press further on handle.



4. Make sure shoulder of contact is flush on the outside of crimping die.



5. Inspect terminal for evidence of crimp and to insure that all strands are in crimp barrel.

NOTE: This tool crimps a "U" crimp for field repair ONLY...Not to be used for O.E.M. crimping.



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