

FOR DETAILS ON EMER-
GENCY RATCHET RELEASE
SEE FIGURE 1.

RECOMMENDED
FOR R&D,
PROTOTYPING,
MAINTENANCE &
REPAIR

PRECISION
CONSTRUCTION
OF DURABLE
HIGH CARBON
STEEL

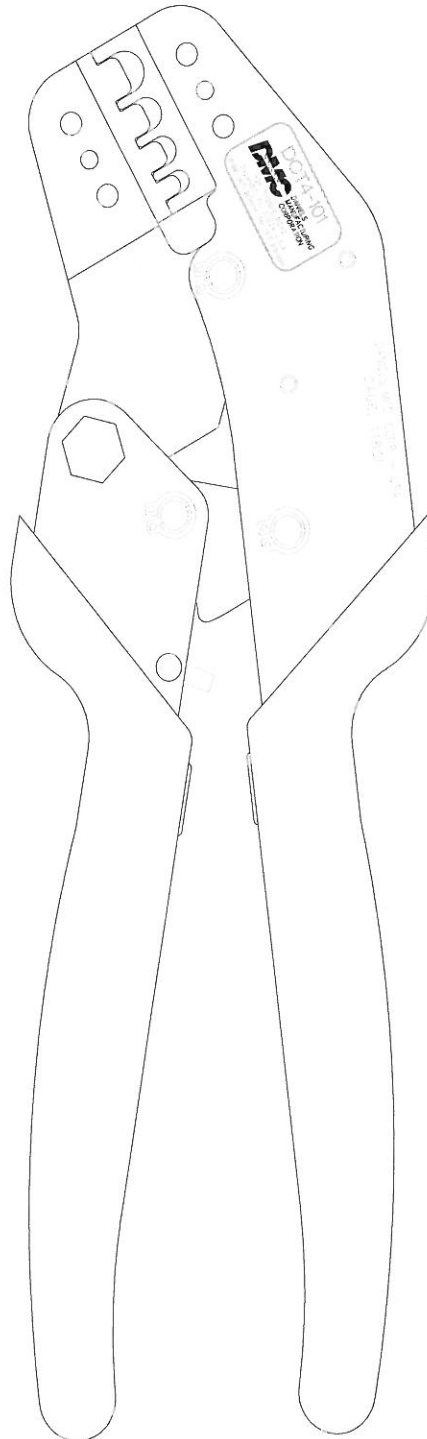
ANGLED HEAD
FOR COMFORT-
ABLE HAND &
WRIST POSITION

EXTRA
STRENGTH
PIVOT PINS FOR
GREATER
DURABILITY

RATCHET CON-
TROL ASSURES A
COMPLETE
CRIMPING
CYCLE

EMERGENCY
RATCHET
RELEASE

INTERCHANGE-
ABLE DIES ARE
AVAILABLE



DMC
PRECISION CRIMPING TOOL
4

DCT4-101 DATA SHEET



INTRODUCTION:

The Daniels DCT4-101 Hand Crimping Tool is designed to crimp standard and moisture resistant spare wire caps onto single unstripped wire (see Figure 2). The tool has a replaceable die assembly with four crimping cavities. Each cavity has a letter designation which corresponds to the color of the four sizes of spare wire caps to be crimped. See Figure 1 below.

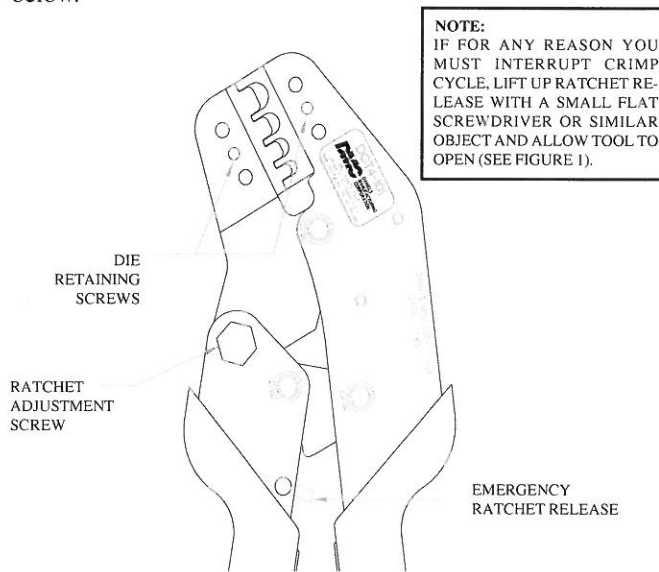


FIGURE 1

WIRE INSUL. DIA. RANGE mm (in)	AMP SPARE WIRE CAP NOS.		CAP COLOR CODE	TOOL COLOR CODE LETTER
	STANDARD	MOISTURE RESISTANT		
1.22 - 1.91 (.048 - .075)	324484	324693	WHITE	W
2.03 - 2.92 (.080 - .115)	324485	324694	RED	R
3.05 - 3.68 (.120 - .145)	324486	324695	BLUE	B
3.81 - 5.33 (.150 - .210)	324487	324696	YELLOW	Y

FIGURE 2

CRIMPING PROCEDURE:

1. Refer to Figure 2, and select a cap of the correct size for the insulation diameter of the wire being used.
2. Identify the color code of the cap, and insert the cap into the crimping cavity with the same color letter. Be sure that the cap is fully inserted.
3. Begin closing the tool handles until the cap is held firmly in place. **Do not deform the cap.**
4. Insert the unstripped wire completely into the cap.

NOTE: When bottoming the wire in a moisture-resistant cap, greater insertion force must be exerted on the wire to displace the inhibitor present in the cap.

5. Close the tool handle until the ratchet releases.
6. Allow the tool handles to open fully and remove the crimped cap from the crimping cavity by turning the cap and wire 1/4 turn while pulling lightly on the wire.

MAINTENANCE AND INSPECTION:

Daily Maintenance:

Daniels recommends that operators of the tool be made aware of, and be responsible for the following steps of daily maintenance:

1. Remove dust, moisture, and any other contaminants from the tool with a clean, soft brush, or a clean, soft, lint-free cloth. **DO NOT** use hand or abrasive objects that could damage the tool.
2. Make certain the tool retaining pins are in place and that they are secured with retaining rings.
3. All pins, pivot points, and bearing surfaces should be protected with a thin coat of any good SAE No. 20 motor oil. Do not oil excessively.
4. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping jaw. Store the tool in a clean, dry area.

Periodic Inspection:

Regular inspections of the tool should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to supervisory personnel responsible for the tool. Inspection frequency should be based upon the amount of use, working conditions, operator training and skill, and established company standards.

Visual Inspection:

1. Make certain that all retaining pins are in place and secured with retaining rings.
2. Close tool handles until ratchet releases and then allow them to open freely. If they do not open quickly and fully, the spring is defective and must be replaced.
3. Inspect the tool frame for wear or damage, paying particular attention to the tool jaws and pivot points. If tool is acceptable, lubricate and return to service.
4. Check the crimping dies occasionally to make sure dies are not broken or chipped.

ADJUSTING RATCHET:

The ratchet adjustment is preset at the factory. If adjustment is necessary, contact the factory for instructions.

DCT4-101 DATA SHEET



DIE INSTALLATION:

Install die set into tool frame as shown in Figure 1. Install and tighten retaining screws making sure dies are aligned and fully seated against tool frame.

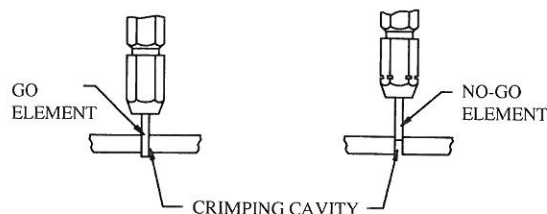
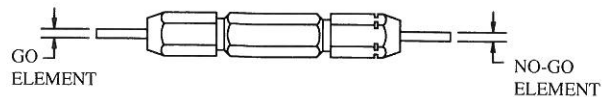
GAGING:

This inspection requires the use of a plug gage conforming to the dimensions listed below.

Procedure:

1. Close dies and hold together by squeezing tool handles with moderate pressure.
2. Insert "Go" end of gage into crimp cavity. The gage must pass freely thru the cavity.
3. Attempt to insert the "No-Go" end of the gage into the crimp cavity. The gage may start but must not pass freely thru the cavity.
4. If the dies do not pass this procedure, the dies must be replaced or repaired before use.

CAVITY LETTER	GO mm (in)	NO-GO mm (in)	PART No.
W	1.730 (.0680)	1.930 (.0760)	G818
R	2.160 (.0850)	2.360 (.0930)	G819
B	2.850 (.1120)	3.050 (.1200)	G820
Y	3.510 (.1380)	3.710 (.1460)	G821



DanComm 4™ TOOLS

DMC P/N	DESCRIPTION
DCT4-101	AMP STD & MOISTURE RESISTANT CAPS
DCT4-102	R/B/Y INSULATED TERMINALS
DCT4-103	SLIDE ON R/B
DCT4-104	HEAT-NSEAL R/B/Y
DCT4-105	UNINSULATED TERMINALS
DCT4-106	.052 SQ./ .128 HEX/ .178 HEX
DCT4-107	.068 HEX/ .178 HEX/ .324 HEX
DCT4-108	.068 HEX/ .213 HEX/ .255 HEX
DCT4-119	R/B/C SPLICES
DCT4-121	.039 SQ./ .195 HEX

CONSULT FACTORY FOR OTHER DIE CONFIGURATIONS

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*as defined by PL93-637