



Revisions			
Sym	Description	Date	Approved
NC	<i>New Release per E.O. P20402</i>	<i>12/14/09</i>	<i>Steve Beard</i>
A	<i>Revised per E.O. P20574</i>	<i>8/03/10</i>	<i>Steve Beard</i>

### 1. WIRE PREPARATION

This tool is designed primarily for **METRIC** Sizes (**small** Insulation Diameters). Prior to crimping contacts, remove  $.175" \pm .025"$  [ $4.45 \pm 0.64$ ] of wire insulation. Remaining insulation must be intact and not stretched. Conductor strands must not be missing or damaged.

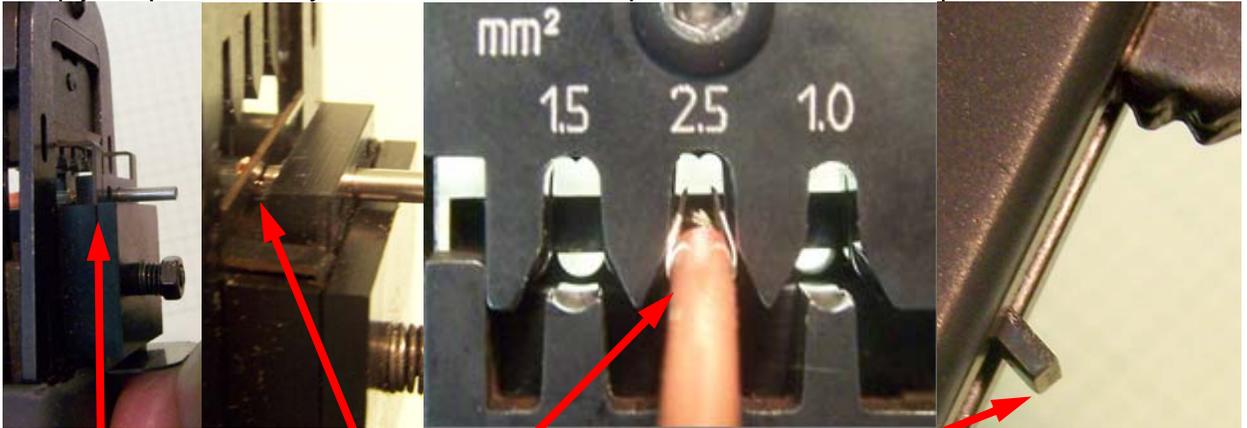
### 2. CONTACT LOADING

Cycle handles to fully open crimp jaws. Lift spring-loaded wire stop/locator and insert contact in recommended cavity for wire size. Check alignment and orientation of contact (see photos).

**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. Wire conductor strands may also have sharp edges. Exercise CAUTION.

### 3. HAND-CRIMP CYCLE

Place wire in contact crimp zone. End of wire should lightly press against wire stop/locator. Close crimp tool until full-cycle ratchet control releases. If it becomes necessary to release the crimp jaws prior to full-cycle, lift the **"RELEASE"** pawl as indicated in the photos below:



Lift Locator/Insert Contact/Release Locator/Place Wire and Crimp

Lift Pawl to **OPEN** crimp tool

### 4. CONTACT REMOVAL

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

### 5. MAINTENANCE

Lubricate moving parts; remove debris from crimp jaw areas; check hardware.

### 6. RECOMMENDED CAVITY FOR WIRE GAUGE AND INSULATION TYPES

Use this chart to insure best crimp results with stamped and formed Pin 1060-20-06\*\*, or Sleeved Socket 1062-20-06\*\*

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

Cavity	Insulation Types
2.5	2.5 mm <sup>2</sup> TxI, GxI, SxI
1.5	1.5 mm <sup>2</sup> TxI, GxI, SxI
1.0	1.0 mm <sup>2</sup> TxI, GxI, SxI



Press DOWN to release lock and rotate Force Spur if CRIMP FORCE needs adjustment (factory set).



Front View of DTT-20-03

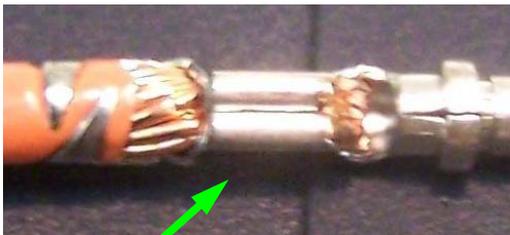


Force Adjusting Spur



Back View with Locator/Wire Stop

### Crimp Examples:



Crimp **IS** centered and properly Located



Crimp is **NOT** centered in crimp zone.