

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 HDT-48-00

1.1. Wire Selection

Use Envelope Drawing HDT-48-00 for ALL wire/contact combinations (Table 1 simplifies popular sizes).



NOTE

The Dial Position is **NORMALLY** the SAME as WIRE SIZE (see Envelope Drawing for exceptions).

Contact Size	Contact PN	Wire Range AWG Wire Range [mm ²]	Strip Dim Inch Strip Dim [mm]
20 Pin 20 Socket	0460-202-20** 0462-201-20**	20 [0.50]	.156-.218 [3.96-5.54]
20 Pin 20 Socket	2325531-1 ⁽²⁾ 2325530-1 ⁽²⁾	22-20 [0.35-0.5]	
16 Pin 16 Socket	0460-202-16** 0462-201-16**	16, 18, 20 [1.5/1.0/0.75/0.50]	.250-.312 [6.35-7.92]
16 Pin 16 Socket	2325529-1 ⁽²⁾ 2325584-1 ⁽²⁾		
16 Pin 16 Socket	0460-215-16** ⁽³⁾ 0462-209-16** ⁽³⁾	14 ⁽¹⁾ [2.0]	
12 Pin 12 Socket	0460-204-12** 0462-203-12**	12, 14 [3.0/2.5/2.0]	.222-.284 [5.64-7.21]

** Contact Plating Code (31=Gold, 141 = Nickel)

⁽¹⁾ Use 1.5 dial position for these contacts on 14 AWG.

⁽²⁾ PN 2325529-1 (pin) is gold plated and identified by BROWN, BROWN, BROWN stripes.

PN 2325584-1 (socket) is gold plated and identified by BROWN, BROWN, BLUE stripes.

PN 2325531-1 (pin) is gold plated and identified by BROWN, BROWN, BLACK stripes.

PN 2325530-1 (socket) is gold plated and identified by BROWN, BROWN, GREEN stripes.

⁽³⁾ PN 0460-215-16** and 0462-209-16** can be identified by GREEN stripe.

Table 1

1.2. Wire Preparation

- A.** Strip the wire to the appropriate length as shown in Table 1.
- B.** Check for missing or nicked / damaged strands after wire is stripped.
- C.** Before crimping, verify sufficient wire length by checking that ALL wire strands are INSIDE crimp barrel and visible at the inspection hole as shown in Figure 1.

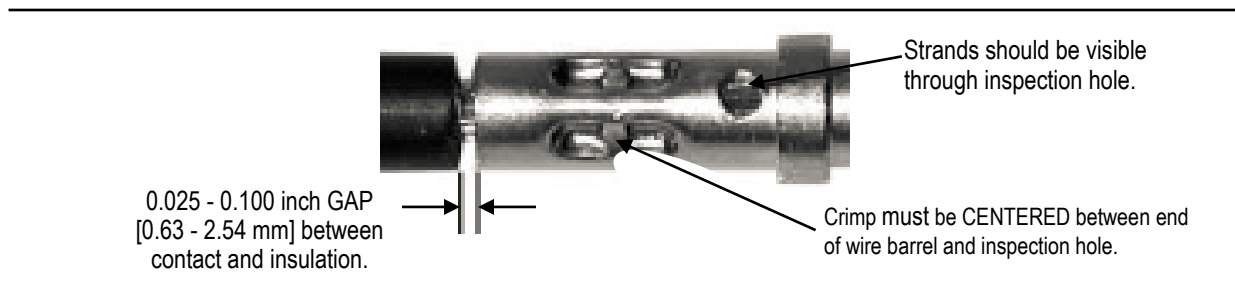


Figure 1

1.3. Tool Adjustment

- A. Cycle tool to open handles.
- B. Remove lock clip.
- C. Raise and rotate dial to select wire size.

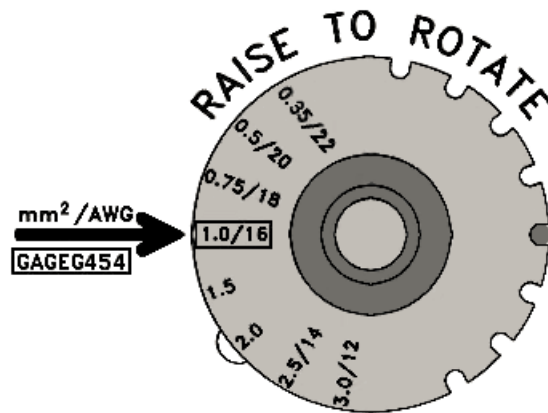


Figure 2



CAUTION

To avoid DAMAGE, ALWAYS check Dial Position BEFORE Crimping (crimping LARGE wire at a small setting may permanently damage the tool).

- D. Replace lock clip.
- E. Adjust locator to produce crimps as shown Figure 1 by performing test crimps using the same procedure described in section 1.4.

1.4. Crimping Procedure

- A. Open the tool by squeezing the tool handles until the ratchet releases (allowing the tool handles to fully open).
- B. Place the contact into the tool.
- C. Insert the stripped wire into the contact.
- D. While holding the wire in place, squeeze the tool handles together until the ratchet releases, then allow the tool handles to fully open.
- E. Remove the crimped contact from the tool.

2. MAINTENANCE

- A. Clean tool and remove debris regularly.
- B. Use GAGE G454 in Dial Position 1.0/16 to check wear annually under normal conditions. Check more often with high volume use.



NOTE

Never close tool on GAGE G454. Close tool first, then insert GAGE G454. Do not use GAGE G454 with the HDP-400 Power Crimper.

- C. Inspect for loose or missing hardware.
- D. To prevent rust or environmental damage, never leave HDT-48-00 tool outdoors.

3. REPLACEMENT AND REPAIR

For customer repair service or to order a replacement tool, call 1-800-522-6752, or fax your purchase order to 717-986-7605, or write to:

Customer Service (038-035),
TE CONNECTIVITY Corporation,
P.O. Box 3608,
Harrisburg, PA, 17105-3608

4. REVISION SUMMARY

- Added #20 pin; PN2325531-1 and socket; PN 2325530-1, #16 pin; PN 2325529-1 and socket; PN 2325584-1 to Table 1, along with footnotes of descriptions of each.
- Added footnotes of descriptions of previously existing #16 pin and socket; PN's 0460-215-16** and 0462-209-16**, respectively.
- Added Revision Summary (Section 4)
- Updated enterprise name to TE CONNECTIVITY Corporation