Revisions			
Sym	Description	Date	Approved
NC	*New Release per E.O. P19742*	*1/24/08*	*David Meyer*
A	*Revised per E.O. P20709*	*12/20/10*	*Steve Beard*

1. WIRE PREPARATION

This tool is designed primarily for **AWG** Sizes (**LARGE** Insulation Diameters). For METRIC or small diameter insulations, use DTT-20-02 (See Instruction Guide 0425-073-0000). Prior to crimping contacts, remove .175" ± .025" [4.45 ± 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. Insert contact in recommended cavity for wire size. Adjust alignment and width of crimp wings if necessary to insure capture by crimp jaws.

> **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

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:
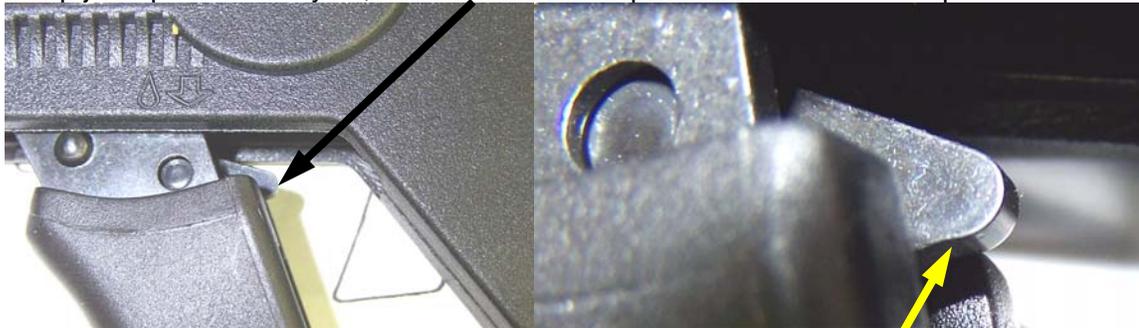

LIFT Pawl **UP** to "**RELEASE**" crimp Ratchet and **OPEN** Crimp Jaws

4. CONTACT REMOVAL

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

5. MAINTENANCE

Perform maintenance on a regular basis. This includes:
    Lubrication of moving parts ("Droplet" symbol).
    Removal of debris from crimp jaw areas.
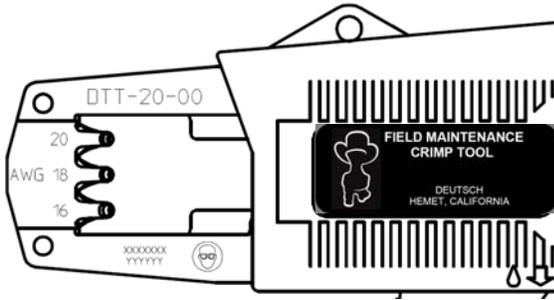   Visual inspection for loose/broken/missing hardware.
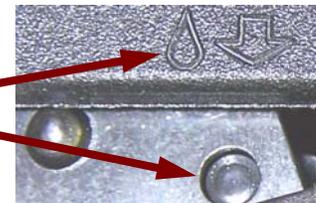
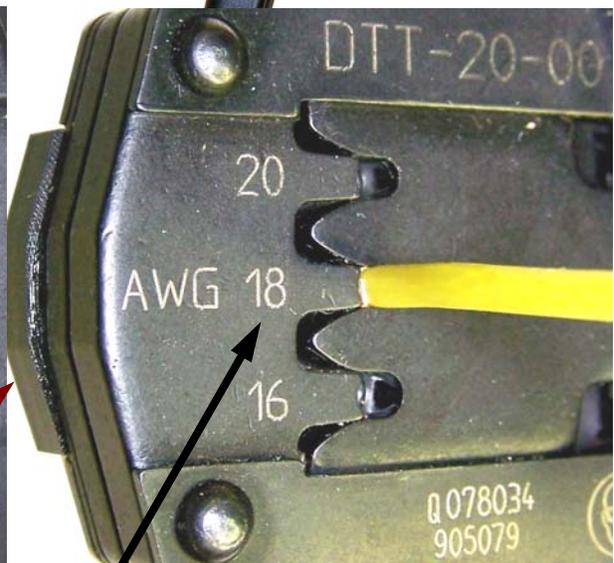

6. RECOMMENDED CAVITY FOR WIRE GAUGE AND INSULATION TYPES

Use this chart to insure best crimp results with stamped and formed Pin 1060-**20-01****,
        Sleeved Socket 1062-**20-10****,
    or Sleeveless Socket 1062-**20-03****.

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

Cavity	**AWG** Insulation Types/**mm²**
20	**20 T**XL,**G**XL,**S**XL/0.**5**mm²
18	**18 T**XL,**G**XL,**S**XL/0.**8**mm²
16	**16 T**XL,**G**XL,**S**XL/**1.0-1.5**

Revision Letter:	*A*	Engineering Order Number:	*P20709*	Page	*1*	of	*2*

I N F O R M A T I O N
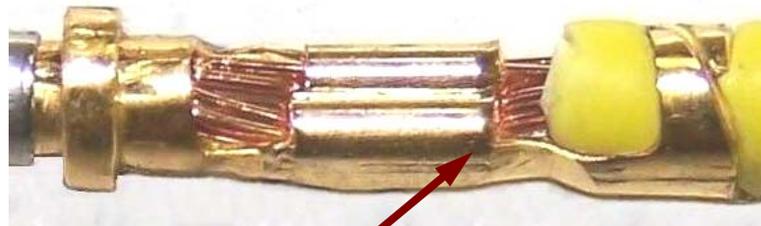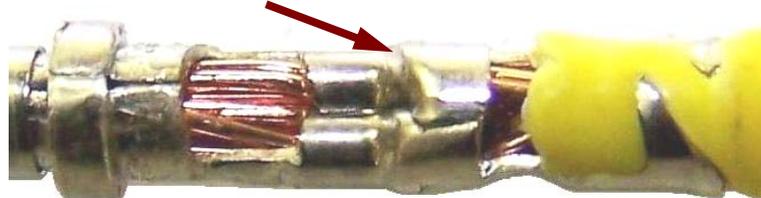
**CONDUCTOR
Cavity FARside**

**INSULATION
Cavity NEARside**

LOCATOR

Wire Sizes

Crimp Examples:

NOT fully set into Locator

Crimp IS centered as shown when properly Located

Revision Letter:	*A*	Engineering Order Number:	*P20709*	Page	*2*	of	*2*

I N F O R M A T I O N