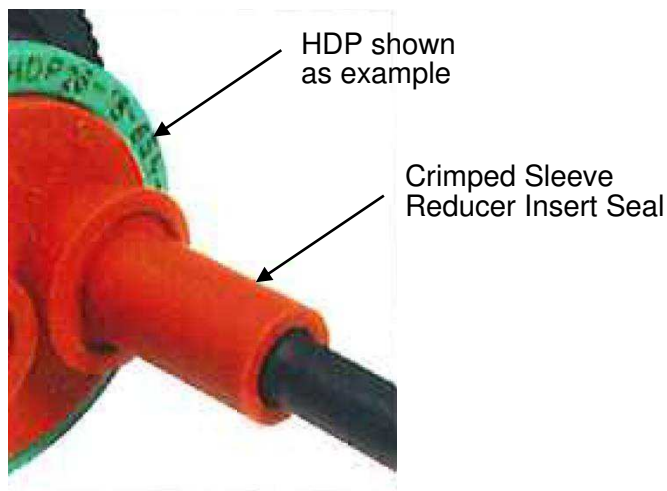






### 1. CRIMP SLEEVE REDUCER

A crimp sleeve reducer allows DEUTSCH size 4 solid contacts to accept 8-10 AWG wire. When populating a connector using a contact with a reducer sleeve, be sure the insert seal penetrates the rear grommet. The use of the crimp sleeve reducer requires no extra crimp tools and provides an easy transition and increased flexibility. Used on DEUTSCH products with size 4 contact cavity, such as HD10, HD30, HDP, DTHD, DRB.



Part Number	Description	Material	Image
0410-241-0406	Insert Seal	VMQ Red-Orange	
0421-203-04141	Crimp Sleeve Reducer	Copper Alloy Nickel	
0460-204-04141	Size 4 Pin 6 AWG [13.0-16.0 mm <sup>2</sup> ]	Copper Alloy Nickel	
0462-203-04141	Size 4 Pin 6 AWG [13.0-16.0 mm <sup>2</sup> ]	Copper Alloy Nickel	

## 2. INSTALLATION

Step 1. Place crimp sleeve reducer into contact crimp barrel.

Step 2. Slide insert seal onto 8-10 AWG [8.0-5.0mm<sup>2</sup>] wire stopping at the stripped insulation.

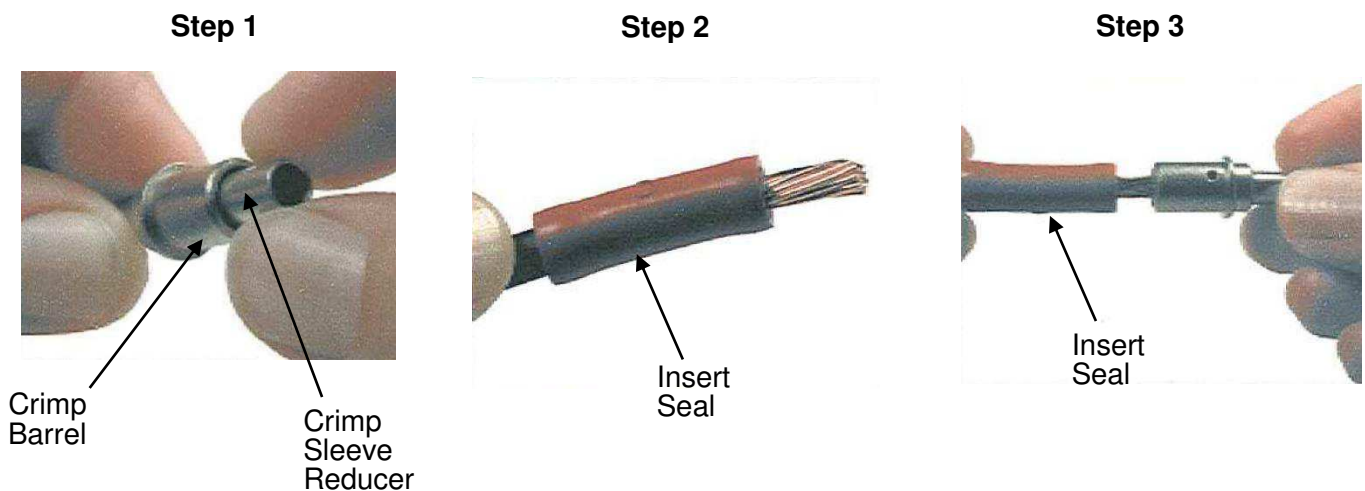
Step 3. Insert wire into crimp barrel of contact and crimp using either [HDP-400 \(0425-034-0000\)](#) power press or [HDT-04-08 \(408-32124\)](#) hand tool. See below table for crimping information.



*Note*

*Thin wire insulation, such as TXL (SAE J1128) with 10 AWG is not recommended because it may not provide an environmental seal against the insert seal.*

Step 4. Insert the wired crimped sleeve reducer contact into the connector cavity. Verify the insert seal penetrates the rear grommet. A slight tug on the wire will confirm it is locked in place.



## 3. HDP-400 CRIMPING INFORMATION (0425-034-0000)

Insulation Strip Length: 10.92-12.50 [.430-.492]

Crimp Die Part Number	Locator Part Number	Calibration Gage Part Number	Calibration Gage Description
400-414DA-4SPEC	400-4301-4S	450GA-4SPEC	4.32 [.170] GO 4.50 [.177] NO-GO

## 4. HDT-04-08 CRIMPING INFORMATION (408-32124)

Insulation Strip Length: 10.92-12.50 [.430-.492]

Contact Part Number	½ Die Set (1) Part Number
0460-204-04141	0434-205-0400
0462-203-04141	(2217968-3)



*Note*

1. Need quantity 2

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**5. REVISION SUMMARY**

<b>Revision</b>	<b>Brief Description of Change</b>	<b>Date</b>	<b>Approver</b>
A	Initial Release	2019-12-13	D. Meyer
B	Page 1. Deleted 5960-203-04141 & 5962-203-04141 Page 2. Sec 4 Deleted 5960-203-04141 & 5962-203-04141	2021-06-14	IG