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# DEUTSCH\* Field Service Crimp Tool

## HDT-1561

### Crimping Instructions

This ratcheting crimp tool is designed to crimp Deutsch solid pin and socket contacts as listed on **Chart A** below:

**Chart A**

Contact Size	Contact Type	Deutsch Part Number	Wire AWG Range	Crimp Nest	Recommended Strip Length
20	Pin	0460-202-20141	20	Front	.156"-.218"
20	Socket	0462-201-20141	20	Front	.156"-.218"
16	Pin	0460-202-16141	16-18	Middle	.250"-.312"
16	Socket	0462-201-16141	16-18	Middle	.250"-.312"
16	Pin	0460-215-16141	14	Middle	.250"-.312"
16	Socket	0462-209-16141	14	Middle	.250"-.312"
12	Pin	0460-204-12141	12-14	Rear	.222"-.284"
12	Socket	0462-203-12141	12-14	Rear	.222"-.284"

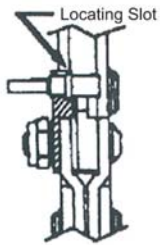
**Illustration A**



**Assembly Instructions:**

1. Cycle the tool to open position by completely closing handle grips.
2. Refer to **Chart A** to select the appropriate crimp nest.
3. Grasp crimp barrel end of contact (short end with bleed hole). Place contact through front of tool (**Illustration A**). Align contact shoulder with locating slot (**Illustration B**). Close tool slightly, holding contact in place.
4. Insert properly stripped wire (refer to **Chart A**) into the crimp barrel of contact. Hold wire in place while completely closing handle grips.
5. Remove crimped contact. Inspect for quality; a) copper strands should be visible in bleed hole of crimp and b) no copper strands should be loose outside the crimp barrel.

**Illustration B (Locating Slot)**



**Chart B (Crimp Height/Width)**

Nominal Cavity Sizes			
	20	16	12
H	.037 REF.	.054 REF.	.086 REF.
W	.072 REF.	.098 REF.	.154 REF.

**Chart C (Current Ratings)**

Size	Wire AWG Range	Maximum Current Rating	Crimp Tensile Strength
20	20	7.5 amps	20 lbs.
16	16-18	13 amps	25 lbs.
16	14	13 amps	25 lbs.
12	12-14	25 amps	70 lbs.