**INSERTING WIRES**

Grasp wire with the crimped contact just behind the contact barrel.

Holding the connector with rear seal facing you, insert the contact into rear of the connector. Push until a click is felt. A slight tug will confirm that it is properly locked in place.

On DTP series connectors, insert the wedgelock (use needle nose pliers if necessary), pressing firmly until it clicks into place.

DTHD series connectors have no wedgelock retaining system.

**REMOVING WIRES**

On DTP series connectors, use a pair of needle nose pliers to remove the wedgelock. DTHD series connectors don’t have a wedgelock, so skip this step.

With the rear of the connector towards you, snap the appropriate size extractor tool over wire of the contact to be removed.

Slide the tool along the insert cavity until it engages the contact and resistance is felt.

Grasp the wire and extraction tool and gently pull both straight out of the connector. Don’t rotate the tool while it’s in the connector. You may damage the locking tangs.
CRIMPING WIRES

with the Deutsch HDT-48-00 Crimper

This high quality, precision tool creates a weatherproof 8 point crimp on any 12, 16, 20 contact size pin or socket. The crimper is fully adjustable and the ratcheting release system ensures a perfect crimp every time.

Strip ¼” (6.3 mm) insulation from wire.

Raise selector knob and rotate until arrow is aligned with wire size to be crimped.

Loosen lock nut, turn adjusting screw in until it stops.

Insert contact with barrel up. Turn adjusting screw counter clockwise until contact is flush with indenter cover. Tighten lock nut.

Insert wire into contact. Contact must be centered between indicators. Close handles until crimp cycle is completed.

Release handles and remove crimped contact. Inspect terminal to insure that all strands are in crimp barrel.

Why Deutsch?

Common Contact System
A single contact system terminates all Deutsch connectors by utilizing common tooling.

High Performance Molded Shells
All molded Deutsch connector components are made from flame retardant, high grade thermoplastics.

Silicone Wire Seals
Deutsch wire seals are an integral component of the connector which eliminates the need to assemble seals on wire leads.

CRIMPING WIRES

with the Deutsch HDT-04-08 Crimper

This heavy duty, high leverage crimping tool produces perfect 2 point deep crimps on Deutsch size 4 and 8 solid contacts. The jaws and dies are made from hardened steel for a lifetime of use.

Select the proper die
To replace the die on the crimper, loosen and remove the 5/16” nuts on the retaining bolts in die assembly. Remove the lock washers and slide the retaining bolts out of the crimper. Slide the dies up and off the crimper head, line up retaining bolt holes on crimper head and insert retaining bolts from rear of crimper. Replace the lock washers and tighten nuts.

Strip about 7/16” (11mm) insulation from wire.

Open tool handles to open jaws. Place the contact into the appropriate size die with the crimp barrel in the jaws of the crimper.

Partially close the tool until the contact is held in place.

Insert the stripped wire into the crimp barrel of the contact.

Completely close the handles of the tool until the handles stop and the tool makes one complete cycle.

Remove and inspect the crimped contact for:
- No damaged wire strands
- No missing wire strands
- Wire inserted to the proper depth of the contact (wire should be visible through the inspection hole in the contact)

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