# HDT-48-00 Crimping Instructions

## How to Strip a Wire for use with the HDT-48-00 Crimp Tool

1. Choose the correct AWG for the contact being used. (See chart)

2. Measure from the end of the wire **(Pic. A)** the recommended strip length according to the contact size. (See chart)

Pic. A

3. Place the wire into the stripping tool at the recommended strip length. Strip the wire according to stripping tool instructions.

4. After stripping, a small piece of the insulation should come off. **(Pic. B)**

Pic. B

5. Check for any broken strands or for a dent in the wire. If either exist, the wire is damaged and should be cut and stripped again.

6. Measure the exposed strands to be sure the crimp length is correct. **(Pic. C)**
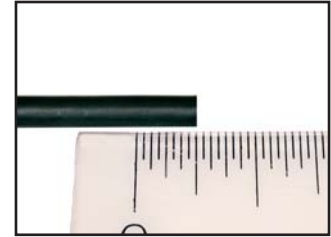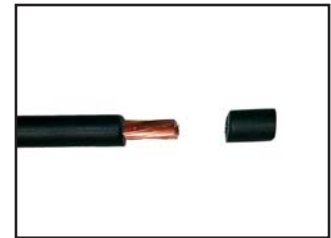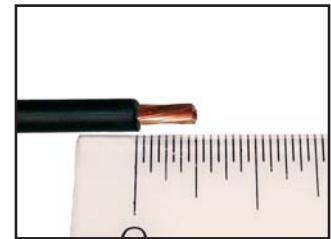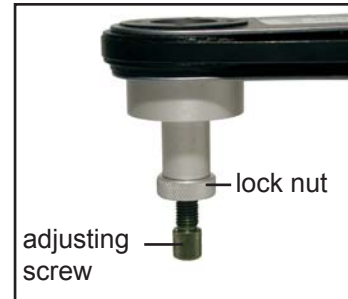

Pic. C

Contact Size	Contact Part Number	Wire Gauge Range	Recommended Strip Length
20	0460-202-20141 0462-201-20141	20 AWG (0.5mm^2) 20 AWG (0.5mm^2)	.156-.218 (3.96-5.54mm) .156-.218 (3.96-5.54mm)
16	0460-202-16141 0462-201-16141	16, 18, 20 AWG (1.0-0.5mm^2) 16, 18, 20 AWG (1.0-0.5mm^2)	.250-.312 (6.35-7.92mm) .250-.312 (6.35-7.92mm)
16	0460-215-16141 0462-209-16141	14 AWG (2.0mm^2) 14 AWG (2.0mm^2)	.250-.312 (6.35-7.92mm) .250-.312 (6.35-7.92mm)
12	0460-204-12141 0462-203-12141	12, 14 AWG (3.0-2.0mm^2) 12, 14 AWG (3.0-2.0mm^2)	.222-.284 (5.64-7.21mm) .222-.284 (5.64-7.21mm)

# How to Crimp with the HDT-48-00 Hand Tool

1.   Strip insulation from wire. Please see Page 1 for wire stripping instructions.

2.   Raise selector knob and rotate until arrow is aligned with <u>wire gauge</u> to be crimped **(Pic. A)**.

Pic. A

3.   Loosen lock nut, turn adjusting screw in until it stops. **(Pic. B)**.

4.   Insert contact **(See Pic. C for insertion point)**, turn adjusting screw clockwise out until contact is flush or a bit above flush with indentor cover. Tighten lock nut.

lock nut
adjusting screw
Pic. B

5.   Insert wire in contact **(Pic. D)**. Contact must be centered between indicators. Close handles until the handles stop.

6.   Release handles and remove crimped contact.

7.   When completed, correct assembly can be checked visually. When stripped, insulation should expose a conductor length that will pass beyond the inspection hole in the contact. There should be about .025" to .100" of conductor between the contact and the insulation on the wire.

insertion point
Pic. C
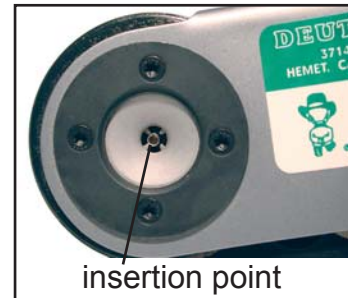
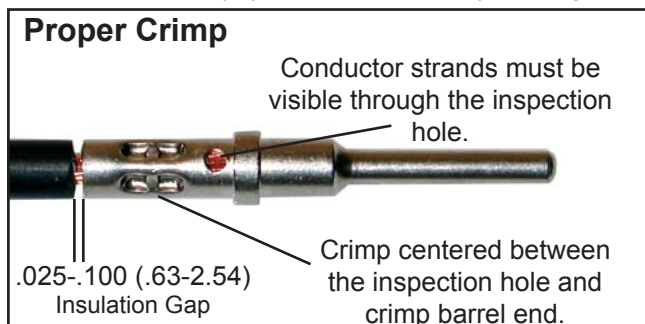*After crimping, check for:*
1.   Damaged wire strands.
2.   Missing wire strands.
3.   Wire strands not entering the contact barrel or splayed wires.
4.   Wire not inserted to the proper depth in the contact, not visible through inspection hole.

If any of the above conditions exist. Please discard the contact, re-cut and strip the wire, and start the crimping process over.

Pic. D

For more detailed crimp specifications see envelope drawing for HDT-48-00.

Proper Crimp

Conductor strands must be visible through the inspection hole.

.025-.100 (.63-2.54) Insulation Gap

Crimp centered between the inspection hole and crimp barrel end.

G454 Go No-Go Directions for the HDT-48-00

Set Up

1. Use the Go No-Go testing tool, p/n G454. **(Pic. A)**

2. The HDT-48-00 hand crimp tool <u>MUST</u> be set on #20 wire size, Sel. No. 4. **(Pic. B)** Testing for all wire sizes should be tested at #20 wire size, Sel. No. 4, this ensures proper calibration for all settings. Further testing is not needed for the other selections.
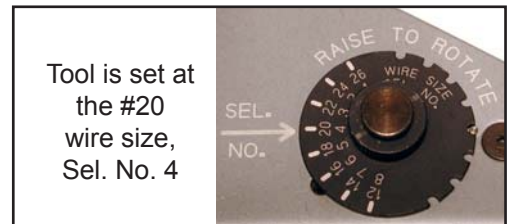
Testing Procedure

1. Squeeze the handles of the HDT-48-00 crimp tool together completely. **(Pic. C)**

2. Insert the Go End (green) of the G454 into the HDT-48-00 with handles completely closed. **(Pic. C)** The G454 (green end) should insert easily **(Pic. D)**. If the **G454 (green end) *will not*** insert, the calibration of the HDT-48-00 is incorrect.

3. Insert the No-Go End (red) of the G454 into the HDT-48-00 while handles are still completely closed. **(Pic. C)** The G454 (red end) should <u>NOT</u> insert **(Pic. E)**. If the **G454 (red end) *will*** insert, the calibration of the HDT-48-00 is incorrect.

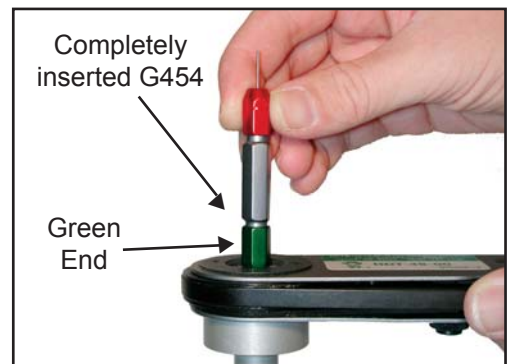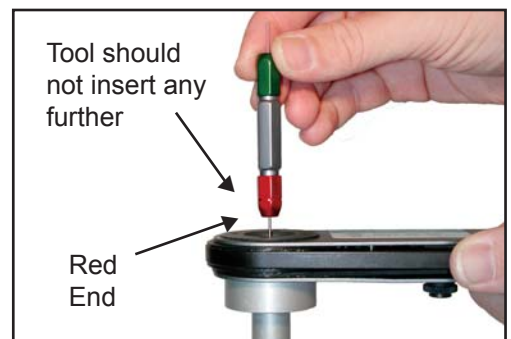Caution: Do not close HDT-48-00 on Go No-Go tool. Close HDT-48-00 first and then insert Go No-Go tool.

The G454 Testing Tool can only be used to test the HDT-48-00 Hand Crimp Tool. **DO NOT USE WITH THE HDP-400 POWER UNIT**.

Pic. A

Tool is set at the #20 wire size, Sel. No. 4

Pic. B

Insertion point

Pic. C

Completely inserted G454

Green End

Pic. D

Tool should not insert any further

Red End

Pic. E