PRODUCT MANUAL

HD-2612 SERIES

DEUTSCH CRIMPING TOOLS

FOR DEUSTCH DTM, DT, DTP SERIES

MANUFACTURER:

ZHEJIANG IWISS ELECTRIC CO.,LTD
(IWISS TOOLS CO.,LTD)

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Rebrand Notice

Both IWISS® and iCrimp® brands are known as members of Zhejiang IWISS Electric Co.,Ltd. We're pleased to inform you that the company is now taking the opportunity to consolidate two brands into one(iCrimp) in order to better communicate the breadth of expertise that the company represents.

Behind the new look we are still the same company and team dedicated to providing you the best possible quality and solution.

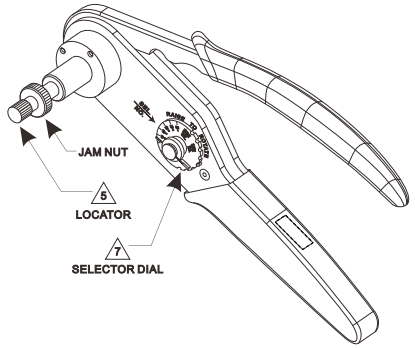
iCrimp

FOCUS ON CABLE & PIPE TOOLS

GENERAL INFORMATION

FEATURE

- Designation of HD-2612 to a basic tool with positioner.
- Wire crimp range 26 to 12 AWG.
- The tool has a double action ratchet and cannot be opened without completing the cycle.
- For DT, DTM, DTP, AMPSEAL series.



Part #	Contanct Type	Wire Gauge	Contact Size	Positioner
HD-2612	Solid Contact	26-12 AWG	12, 16, 20	Turret
HD-2612D				Fixed

USER'S INSTRUCTIONS

TOOL ADJUSTMENT

1. Cycle tool to open handles.
2. Remove lock clip.
3. Raise and rotate dial to select wire size. The Dial Position is NORMALLY the SAME as WIRE SIZE.
4. Replace lock clip.
5. Adjust locator to produce crimps as shown Figure 1 by performing test crimps.

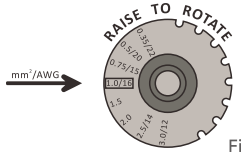


Figure 2

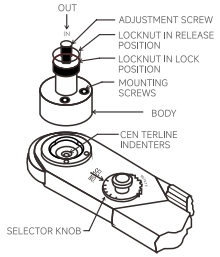
Contact Size	Contact PN	Wire Range AWG Wire Range(mm²)	Strip Dim Insh Strip Dim (mm)
20 Pin 20 Socket	0460-202-20** 0462-201-20**	20 [0.50]	156-218 [3.96-5.54]
16 Pin 16 Socket	0460-202-16** 0462-201-16**	16, 18, 20 [1.5/1.0/0.75/0.50]	250-312 [6.35-7.92]
16 Pin 16 Socket	0460-215-16** 0462-209-16**	14(1) [2.0]	250-312 [6.35-7.92]
12 Pin 12 Socket	0460-204-12** 0462-203-12**	12, 14 [3.0/2.5/2.0]	222-284 [5.64-7.21]

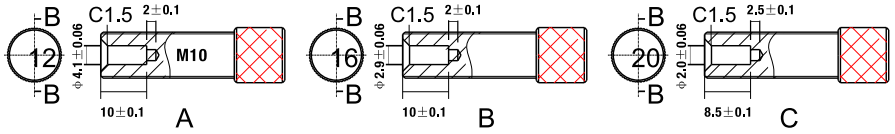
Figure 1

** Cont act Plating Code (31=Gold, 141=Nickle)
** Use 1.5 dial position for these contacts on 14 AWG

POSITIONER

1. With Universal Positioner over crimp tool, align socket head mounting screws with topped holes in tool. Tighten mounting screws.
2. Raise and rotate selector knob until desired wire size, indicated on selector knob, is in line with SEL NO. index on tool body.
3. With lock nut in release position, turn adjustment screw IN until it stops. Insert contact through indenter opening into positioner and adjust screw OUT until indenters ore centered between inspection hole and barrel end of contact. When contact contains insulation cup, center between inspection hole and bottom of insulation cup.
4. Tighten lock nut to body. Tool is now ready for crimping operation.



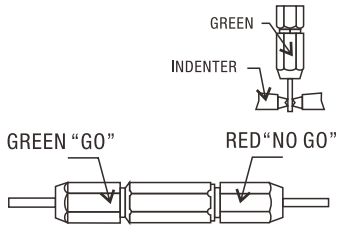


Positioner is composed of a mounting locator and pin holder. Refer to below dimensions to decide on which pin holder to choose.

GAGING

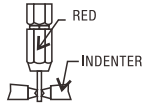
"GO" GAGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.



"NO-GO" GAGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Try to insert the "NO-GO" gage end as shown. The "NO-GO" gage may partially enter the end as shown. The "NO-GO" gage may partially enter the indenter opening, but must not pass completely through.



CAUTION

DO NOT CRIMP GAGE!!

Periodic gaging is recommended to insure accurate calibration. Thiscan be done easily by setting the tool selector knob to different positions, and checking indenter closure with gaging tools accordingly.

WIRE PREPARATION

Wire Preparation Strip the wire to the appropriate length as shown in Figure 1. Check for missing or nicked / damaged strands after wire is stripped. Before crimpings verify sufficient wire length by checking that all wire strands are INSIDE crimp barrel and visible at the inspection hole.

Strands should be visible through inspection hole.

.025-.100" GAP [0.63-2.54] between contact and insulation.

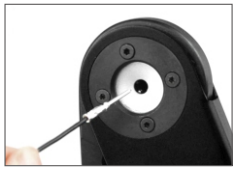
Crimp must be CENTERED between end of wire barrel and inspection hole.

OPERATION GUIDANCE

1. Open the tool by squeezing the tool handles until the ratchet releases (allowing the tool handles to fully open). Place the contact into the tool.

2. Insert the stripped wire into the contact.

3. While holding the wire in place, squeeze the tool handles together until the ratchet releases, then allow the tool handles to fully open.



4. Remove the crimped contact from the tool.

LIMITED WARRANTY

iCrimp warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. This warranty shall not cover any damage to any products which, in the option of iCrimp, was caused by normal wear, misuse, improper operation, tampering, neglect or accident.

Warranty Period: 12 months since sales date.