

FOR DETAILS ON EMERGENCY  
RATCHET RELEASE SEE  
FIGURE 1.

RECOMMENDED  
FOR R&D,  
PROTOTYPING,  
MAINTENANCE &  
REPAIR

PRECISION  
CONSTRUCTION  
OF DURABLE  
HIGH CARBON  
STEEL

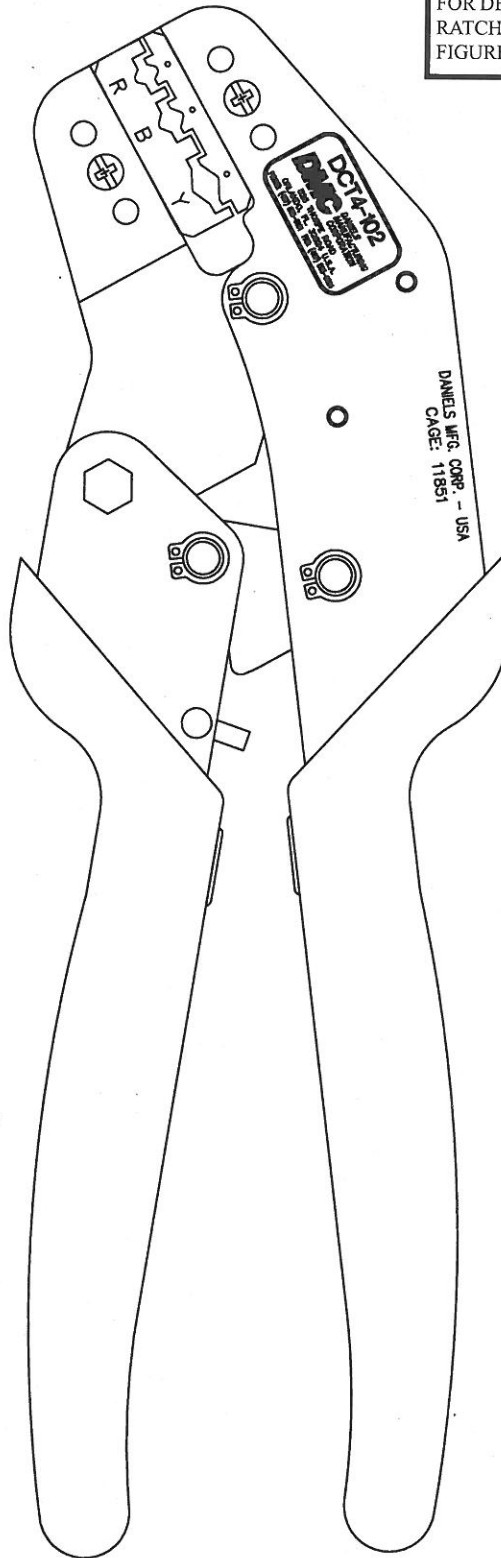
ANGLED HEAD  
FOR COMFORT-  
ABLE HAND &  
WRIST POSITION

EXTRA  
STRENGTH  
PIVOT PINS FOR  
GREATER  
DURABILITY

RATCHET CON-  
TROL ASSURES A  
COMPLETE  
CRIMPING  
CYCLE

EMERGENCY  
RATCHET  
RELEASE

INTERCHANGE-  
ABLE DIES ARE  
AVAILABLE



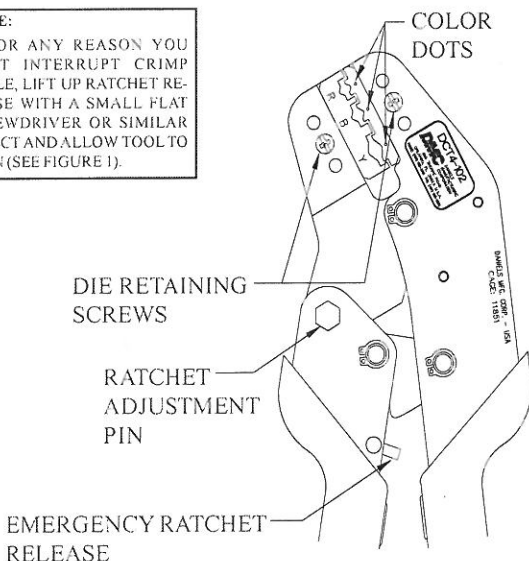
**DanComm4**  
PRECISION CRIMPING TOOL

# DCT4-102 DATA SHEET

## INTRODUCTION:

The Daniels DCT4-102 Hand Crimping Tool is designed to crimp insulated terminals and splices onto pre-stripped wire. The tool has a replaceable die assembly with three crimping areas which are color coded with red, blue and yellow dots (see Figure 2). The dot color corresponds to the insulation color of the item to be crimped in the crimping area (see Figure 1).

**NOTE:**  
IF FOR ANY REASON YOU MUST INTERRUPT CRIMP CYCLE, LIFT UP RATCHET RELEASE WITH A SMALL FLAT SCREWDRIVER OR SIMILAR OBJECT AND ALLOW TOOL TO OPEN (SEE FIGURE 1).



GENERAL STRIP LENGTH INFORMATION				
WIRE RANGE	INSULATION DIA (TYPICAL)	INSULATION COLOR	STRIP LENGTH	
			MIN	MAX
22-18 AWG	.140" (3.56mm)	RED	.203" (5.15mm)	.234" (5.95mm)
16-14 AWG	.170" (4.32mm)	BLUE	.203" (5.15mm)	.234" (5.95mm)
12-10 AWG	.250" (6.35mm)	YELLOW	.312" (7.94mm)	.344" (8.73mm)

**FIGURE 1**

## PROPER USE GUIDELINES:

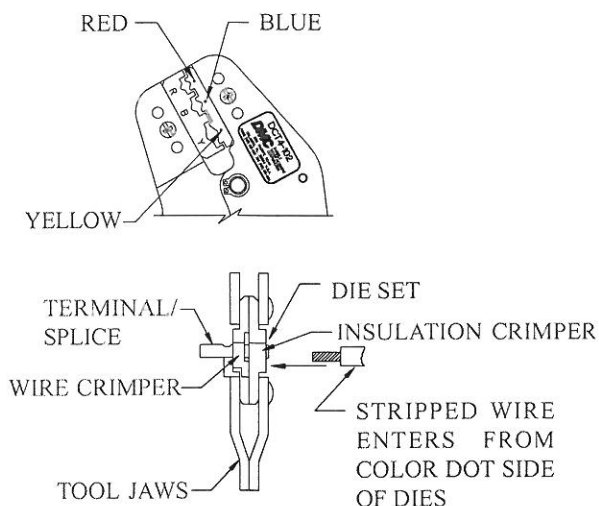
Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Daniels hand tools are intended for occasional use and low volume applications. Daniels offers a wide selection of powered application equipment for extended-use, production operations.

## CRIMPING PROCEDURE:

1. Strip the wire to the proper length (see table in Figure 1).
2. Choose the desired terminal/splice and match the in-

sulation color to the crimping area color dot.

3. Place the terminal/splice in the crimping area so that the edge of the terminal/splice insulation aligns with the edge of the wire crimper (see Figure 2). Terminal/splice should be positioned in the tool so that the wire enters from the color dot side of the die.
4. Close the tool handles until the terminal/splice is held in the dies without deforming the wire barrel.
5. Place the stripped wire in the terminal/splice wire barrel and squeeze the handles until the handles are fully closed.



**FIGURE 2**

A .25 (6.35mm) diameter lead rod or 50/50 solid solder can be used to check crimp height of the yellow cavity. A .125 (3.18mm) diameter lead rod or 50/50 solid solder can be used to check the crimp height of the blue and red cavities. Crimp a rod in each of the crimping areas should result in the following dimensions. NOTE: The G931 Go/No-Go Gage can be used for checking the die cavities.

COLOR DOT	CRIMP HEIGHT
YELLOW	.132" ± .006 (3.35 ± 0.15mm)
BLUE	.096" ± .006 (2.44 ± 0.15mm)
RED	.082" ± .006 (2.08 ± 0.15mm)

## MAINTENANCE AND INSPECTION:

### Daily Maintenance:

Daniels recommends that operators of the tool be made aware of, and be responsible for the following steps of daily maintenance:

# DCT4-102 DATA SHEET



1. Remove dust, moisture, and any other contaminants from the tool with a clean, soft brush, or a clean, soft, lint-free cloth. **DO NOT** use hand or abrasive objects that could damage the tool.
2. Make certain the tool retaining pins are in place and that they are secured with retaining rings.
3. All pins, pivot points, and bearing surfaces should be protected with a thin coat of any good SAE No. 20 motor oil. Do not oil excessively.
4. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping jaw. Store the tool in a clean, dry area.

## Periodic Inspection:

Regular inspections of the tool should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to supervisory personnel responsible for the tool. Inspection frequency should be based upon the amount of use, working conditions, operator training and skill, and established company standards.

## Visual Inspection:

1. Make certain that all retaining pins are in place and secured with retaining rings.
2. Close tool handles until fully closed and allow them to open freely. If they do not open quickly and fully, the spring is defective and must be replaced.
3. Inspect the tool frame for wear or damage, paying particular attention to the tool jaws and pivot points. If tool is acceptable, lubricate and return to service.

4. Check the crimping dies occasionally to make sure dies are not broken or chipped.

## ADJUSTING RATCHET:

The ratchet adjustment is preset at the factory. If adjustment is necessary, contact the factory for instructions.

## DIE INSTALLATION:

Install die set into tool frame as shown in Figure 1. Install and tighten retaining screws making sure dies are aligned and fully seated against tool frame.

## DanComm 4™ TOOLS

DMC P/N	DESCRIPTION
DCT4-101	AMP STD. & MOISTURE RESISTANT CAPS
DCT4-102	R/B/Y INSULATED TERMINALS
DCT4-103	SLIDE ON R/B
DCT4-104	HEAT-N-SEAL R/B/Y
DCT4-105	UNINSULATED TERMINALS
DCT4-106	.052 SQ/.128 HEX/.178 HEX
DCT4-107	.068 HEX/.178 HEX/.324 HEX
DCT4-108	.068 HEX/.213 HEX/.255 HEX
DCT4-119	R/B/W SPLICES
DCT4-121	.039 SQ/.195 HEX

## CONSULT FACTORY FOR OTHER DIE CONFIGURATIONS

Daniels Manufacturing Corp. offers complete refurbishing and recalibration services. DMC specially engineers and manufactures complete tool kits to satisfy individual customer requirements, such as total aircraft support, general shop maintenance or production, on board ship and vehicle service, etc.

## LIMITATION OF LIABILITY / LIMITED WARRANTY\*

DANIELS MANUFACTURING CORPORATION IS NOT LIABLE FOR CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY NATURE OR KIND RESULTING FROM THE USE OF ANY OF ITS PRODUCTS. OWNERS AND USERS OF DMC PRODUCTS ASSUME FULL RESPONSIBILITY FOR INSTRUCTING THEIR EMPLOYEES IN THE PROPER AND SAFE USE OF SUCH PRODUCTS.

Daniels Manufacturing Corporation warrants each new unit sold by it to be free from defects in material and workmanship under normal use and service. Its obligation under this warranty is limited to the free correction or, at its option, the refund of the purchase price of any such unit which proves defective within ninety (90) days after delivery to the first user, provided that the unit is returned to it with all transportation charges prepaid, and which shall appear to its satisfaction, upon inspection by it, to have been defective in material or workmanship. This warranty shall not cover any damage to such products, which in the opinion of Daniels Manufacturing Corporation, was caused by normal wear, misuse, improper operation or accident. This warranty is in lieu of all other warranties express or implied. No warranty, express or implied, is made or authorized to be made or assumed with respect to products of Daniels Manufacturing Corporation, other than that herein set forth.

\*as defined by PL93-637