

RECOMMENDED
FOR R&D,
PROTOTYPING,
MAINTENANCE &
REPAIR

PRECISION
CONSTRUCTION
OF DURABLE
HIGH CARBON
STEEL

ANGLED HEAD
FOR COMFORT-
ABLE HAND &
WRIST POSITION

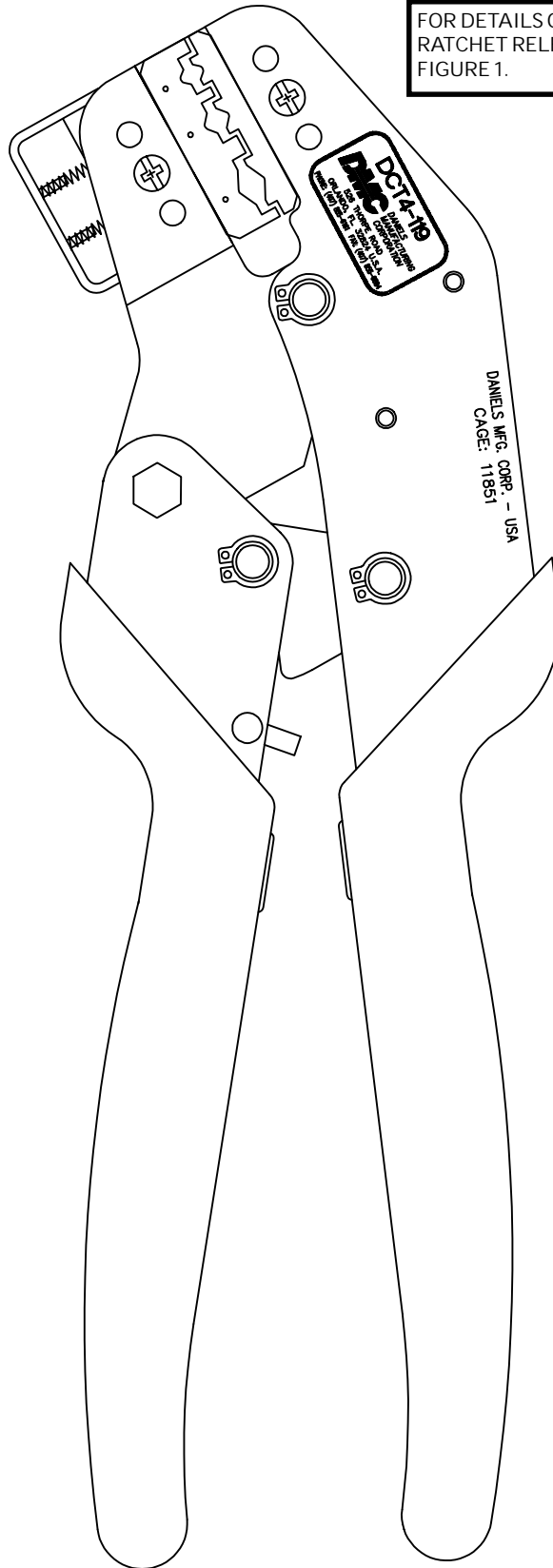
EXTRA
STRENGTH
PIVOT PINS FOR
GREATER
DURABILITY

RATCHET CON-
TROL ASSURES A
COMPLETE
CRIMPING
CYCLE

EMERGENCY
RATCHET
RELEASE

INTERCHANGE-
ABLE DIES ARE
AVAILABLE

FOR DETAILS ON EMERGENCY
RATCHET RELEASE SEE
FIGURE 1.



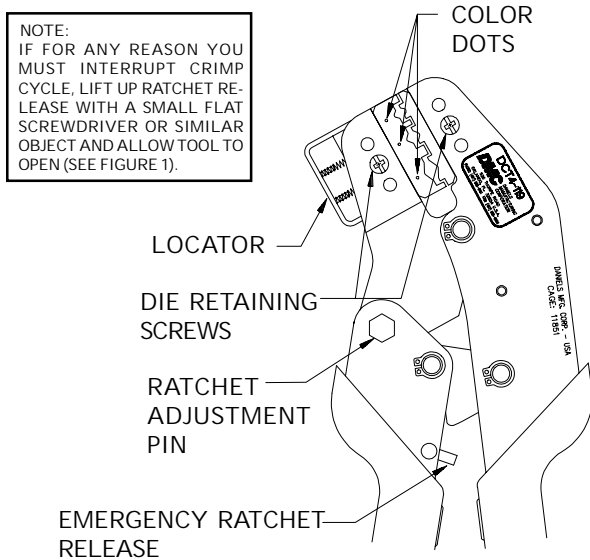
DaniComm 4

PRECISION CRIMPING TOOL

DANIELS MANUFACTURING CORP., 526 THORPE ROAD, ORLANDO, FL 32824, USA
PHONE (407) 855-6161 • FAX (407) 855-6884 • WWW.DMCTOOLS.COM • E-MAIL: DMC@DMCTOOLS.COM

INTRODUCTION:

The Daniels DCT4-119 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 white, red and blue dots (see Figure 2). The dot color corresponds to the insulation color of the item to be crimped in the crimping area (see Figure1).



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)
24-20 AWG	.050 (1.27mm)	WHITE	.187 - .213	.218 - .250

FIGURE1

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 insulation 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 butts against locator slide (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 ratchet releases.

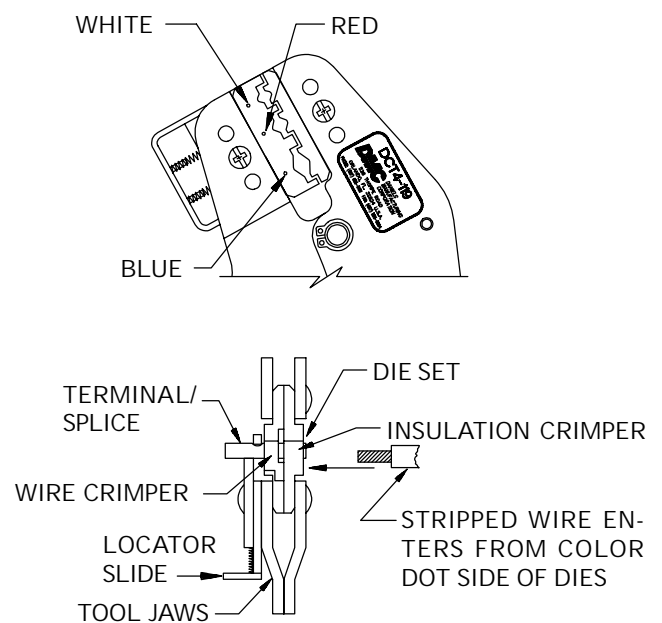


FIGURE2

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:

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 ratchet releases 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

LIMITATION OF LIABILITY / LIMITED WARRANTY*

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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