
RECOMMENDED
FOR R&D,
PROTOTYPING,
MAINTENANCE &
REPAIR

PRECISION
CONSTRUCTION
OF DURABLE
HIGH CARBON
STEEL

ANGLED HEAD FOR
COMFORTABLE
HAND & WRIST
POSITION

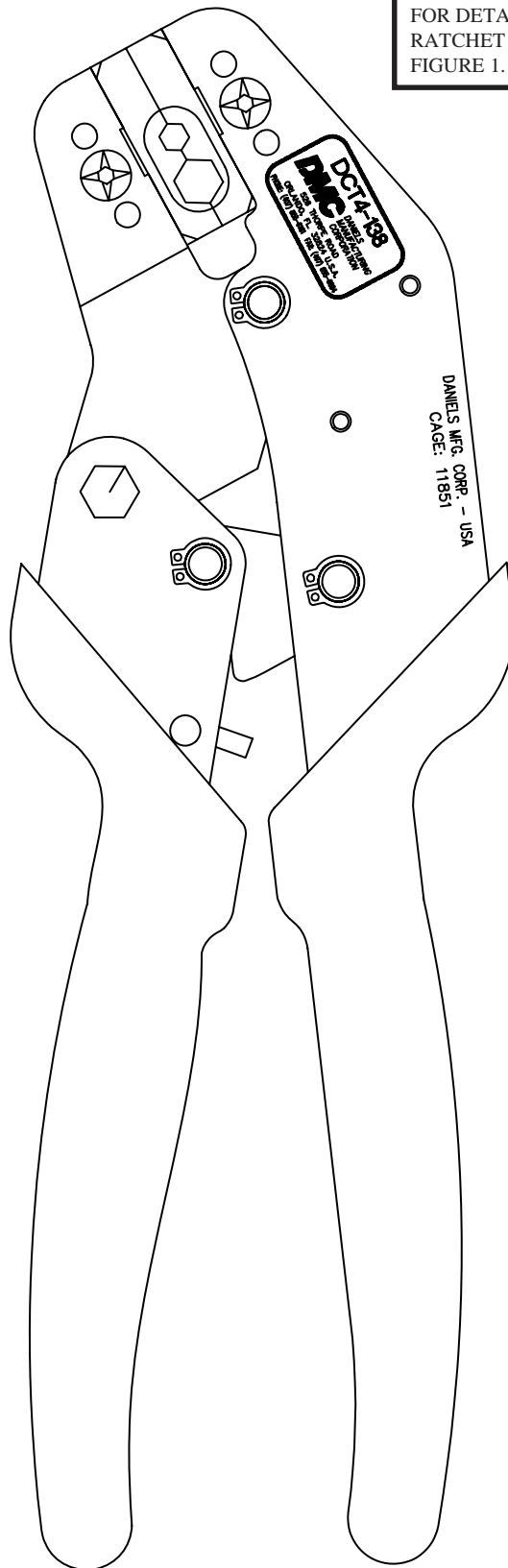
EXTRA
STRENGTH
PIVOT PINS FOR
GREATER
DURABILITY

RATCHET CONTROL
ASSURES A
COMPLETE
CRIMPING CYCLE

EMERGENCY
RATCHET RELEASE

INTERCHANGEABLE
DIES ARE
AVAILABLE

FOR DETAILS ON EMERGENCY
RATCHET RELEASE SEE
FIGURE 1.



DANIELS PRECISION CRIMPING TOOL 4

DCT4-138 DATA SHEET



INTRODUCTION:

The Daniels DCT4-138 Hand Crimp Tool is designed to provide a .264 inch (6.71 mm) hex crimp and a .161 inch (4.09 mm) hex crimp for coaxial crimping applications. The tool has a replaceable die assembly with two crimping cavities (see Figure 1).

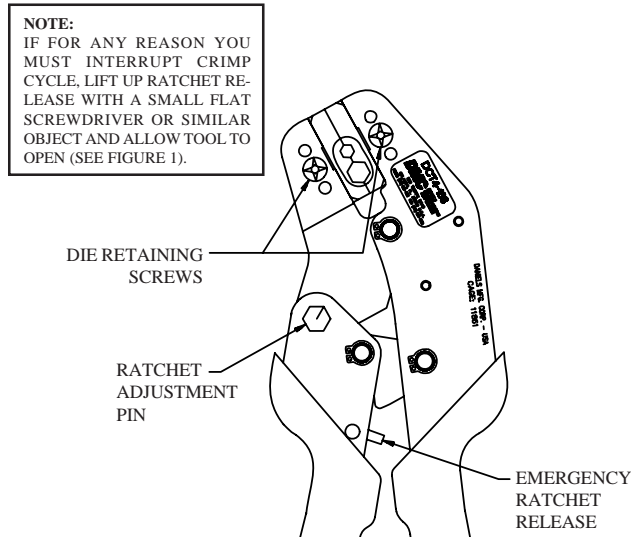


FIGURE 1

DANIELS DCT4-138 HAND CRIMP TOOL CAVITY DIMENSIONS		
CAVITY ONE	.264 INCH HEX	6.71 mm
CAVITY TWO	.161 INCH HEX	4.09 mm

CRIMPING PROCEDURE:

- Place the center contact or connector ferrule to be crimped into the appropriate crimp cavity. Be sure that the crimp area is fully enclosed within the cavity.
- Close the handles until the ratchet releases.
- Allow the handles to open fully and remove the connector from the cavity.

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:

- 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.
- Make certain the tool retaining pins are in place and that they are secured with retaining rings.
- 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.
- 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:

- Make certain that all retaining pins are in place and secured with retaining rings.
- Close tool handles until ratchet releases and then allow them to open freely. If they do not open quickly and fully, the spring is defective and must be replaced.
- 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.
- 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	.042 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/C 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