DCT4-191
HAND CRIMP TOOL

DANIELS MANUFACTURING CORPORATION
DATASHEET

SEE PAGE THREE FOR IMPORTANT INFORMATION CONCERNING LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

RECOMMENDED FOR R&D, PROTOTYPING, MAINTENANCE & REPAIR

PRECISION CONSTRUCTION OF DURABLE HIGH CARBON STEEL

ANGLED HEAD FOR COMFORTABLE HAND & WRIST POSITION

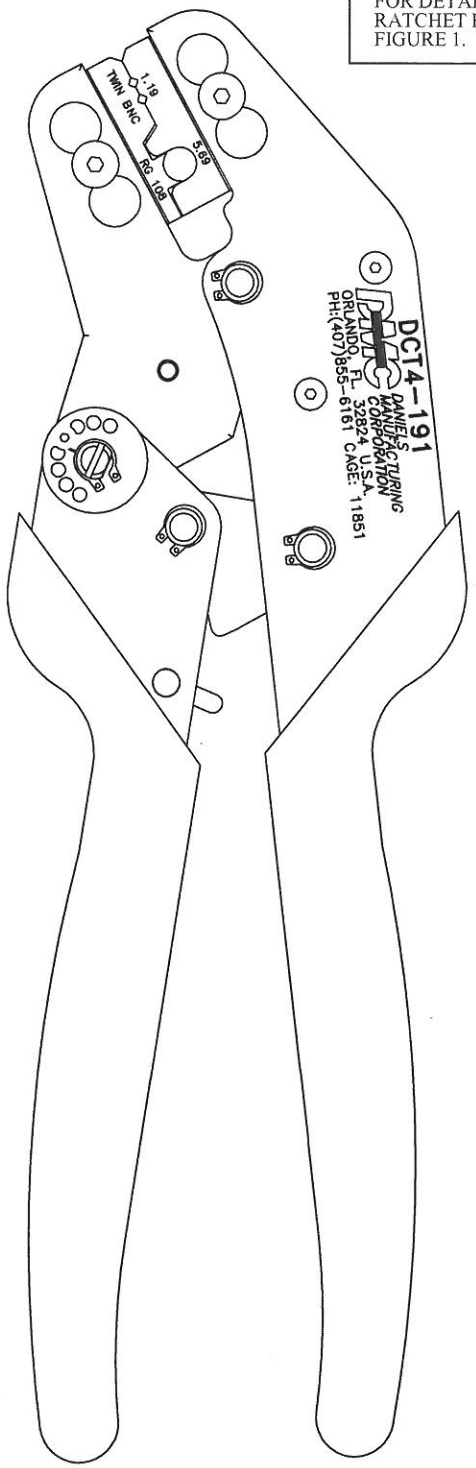
EXTRA STRENGTH PIVOT PINS FOR GREATER DURABILITY

RATCHET CONTROL ASSURES A COMPLETE CRIMPING CYCLE

EMERGENCY RATCHET RELEASE

INTERCHANGEABLE DIES ARE AVAILABLE

FOR DETAILS ON EMERGENCY RATCHET RELEASE SEE FIGURE 1.



DanCrimp 4

PRECISION CRIMPING TOOL

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INTRODUCTION:

The Daniels DCT4–191 Hand Crimp Tool is designed to crimp certain coaxial cable connector assemblies. The tool has a replaceable die assembly with 2 identical square crimp cavities and one ferrule crimping cavity (see Figure 1 below).

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).

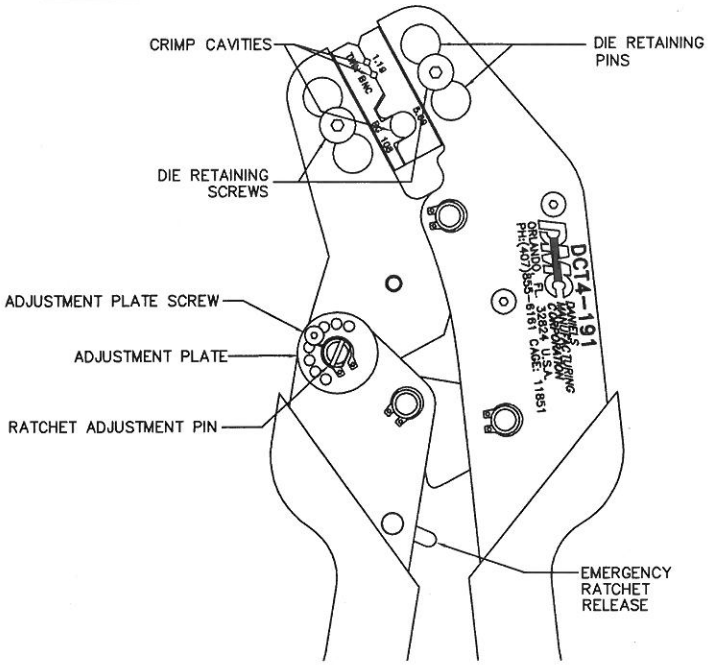

FIGURE 1

DANIELS DCT4–191 HAND CRIMP TOOL CAVITY DIMENSIONS			
GAGING	SQUARES	.047±.001 in	1.17/1.22mm
GAGING	FERRULE	.224±.004 in	5.69±.10 mm
GAGING	FERRULE	.282±.004 in	7.16±.10 mm

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 then 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.

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.

CRIMPING PROCEDURE:

NOTE: Refer to the instructions included with the connector assembly.

Crimp the center contact.

1. Close the tool handles slightly to partially close the dies.
2. Assemble the center contact onto the center conductor of the cable. Locate the center contacts into the square cavities while making sure the flanges on the center contacts butts up against the die.
3. While holding the cable, close the tool handles until the ratchet releases. Allow the tool to open fully and remove the assembly.

Crimp the ferrule.

1. Insert the crimped center contact assembly into the connector body until the cable dielectric butts against the dielectric inside the connector body or until the center contact is securely positioned within the connector.
2. Slide the ferrule over the braided shielding and onto the connector until the ferrule butts against the shoulder of the connector body.
3. Place the ferrule in the appropriate cavity while making sure the connector body butts against the edge of the die.
4. Slowly close the tool handles while holding the assembly in place. Once the assembly is held securely by the dies, release the assembly and continue to close the handles until the ratchet releases. Allow the tool to open and remove the complete assembly.

ADJUSTING RATCHET:

The ratchet adjustment is preset at the factory. If adjustment is necessary, follow these steps:

1. Remove the adjustment plate screw (see Figure 1).
2. With a screw driver, adjust the ratchet adjustment pin. For a tighter crimp, turn the pin counterclockwise. For a looser crimp, turn the pin clockwise.
3. Reassemble the adjustment plate screw.
4. Make a sample crimp and measure crimp height, tensile, and electrical properties, as required, to verify an acceptable crimp.
5. If the sample crimp is unacceptable, repeat steps 1 through 4.

DIE INSTALLATION:

Install die set into tool frame as shown in Figure 1. Install alignment pins first then install the retaining screws. Close handles and tighten die retaining screws while making sure dies are aligned.

DanComm 4™ TOOLS

DMC P/N	DESCRIPTION
DCT4–101	AMP STD & MOISTURE RESISTANT CAPS
DCT4–102	RED/BLUE/YELLOW INSULATED TERMINALS
DCT4–103	SLIDE ON RED/BLUE
DCT4–104	HEAT–N–SEAL RED/BLUE/YELLOW
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	RED/BLUE/WHITE SPLICES
DCT4–121	.039 SQ. / .195 HEX