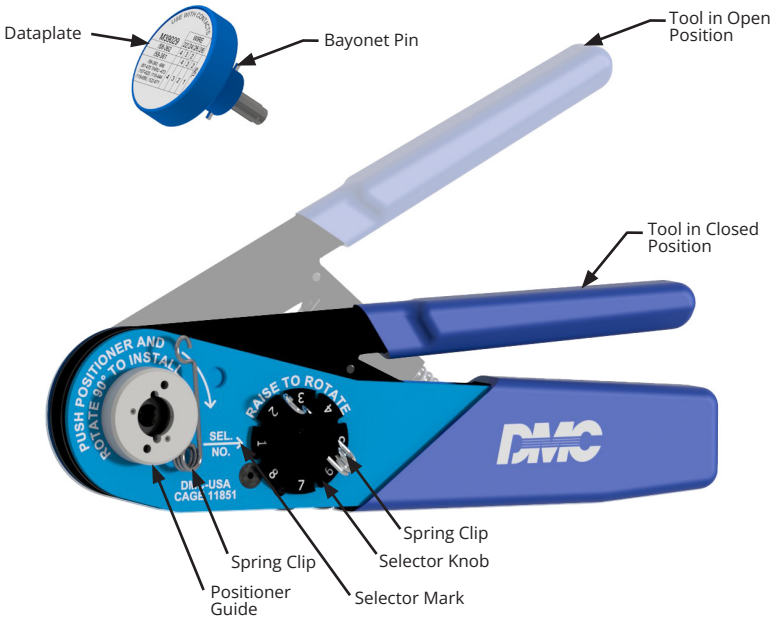
AFM8® • AFM-10
39-000 • COM8-1
Instruction Manual

DANIELS MANUFACTURING CORPORATION®

www.dmctools.com



GENERAL INFORMATION

This data sheet provides technical information for a series of manual indent crimp tools designed for precision and reliability in wire termination applications. Each tool features four symmetrically arranged precision indenters to ensure uniform crimping. A positive ratchet mechanism guarantees the completion of the full crimp cycle before the tool can be reopened, promoting consistent performance and process integrity. Selector settings allow the user to control the depth of the indenters, accommodating a range of contact and wire sizes. The tools covered in this document are suitable for use in high-reliability environments where consistent, repeatable crimps are critical.

The information in this data sheet pertains to the AFM8®, AFM8-CC, 39-000, AFM-10, and COM8-1.

Crimp Application	Machined Contacts
Power Supply	Manual
Ratchet Configuration	Full-cycle, not releasable

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TOOL SPECS

AFM8®

- 32 to 20 AWG
- MIL M22520/2-01
- K Positioners

Length	7.5”
Width	2.4”
Height	.8”
Weight	10 oz

AFM8-CC

- 32 to 20 AWG
- K Positioners

Length	7.5”
Width	2.4”
Height	1”
Weight	11 oz

AFM-10

- 32-20 AWG
- Select K Positioners

Length	7.5”
Width	2.4”
Height	.8”
Weight	10 oz

39-000

- 32 to 20 AWG
- MIL M22520/34-01
- 39 Positioners

Length	7.5”
Width	2.4”
Height	.8”
Weight	10 oz

COM8-1

- 26-16 AWG
- COMP Positioners

Length	7.5”
Width	2.4”
Height	.8”
Weight	11 oz

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INSTALLATION / REMOVAL OF ACCESSORIES

POSITIONER INSTALLATION

1. Squeeze the handles to open the tool and remove the spring clip from positioner guide. (Fig. 1)
2. Line up the bayonet pins with the slots in the positioner guide and insert the positioner. (Fig. 2)
3. Push down and rotate 90 degrees clockwise until the bayonet pins lock. Replace the clip in the positioner guide. (Fig. 3)

Fig. 1

Fig. 2

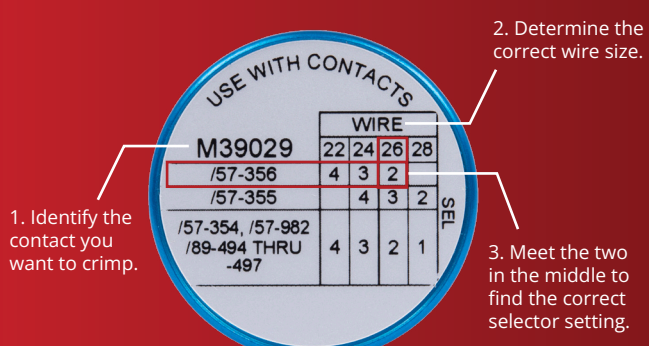
Fig. 3

POSITIONER REMOVAL

1. Squeeze the handles to open the tool and remove the spring clip.
2. Push down on positioner to release the bayonet pins from the positioner guide.
3. Rotate 90 degrees counter-clockwise and remove the positioner from tool. Replace the spring clip in the positioner guide.

HOW TO READ A POSITIONER

Technicians must take into consideration contact part number and wire size when crimping contacts in order to determine the correct insert and selector setting. Smaller selector settings create a tighter crimp.



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CRIMPING INSTRUCTIONS

1. Reference the dataplate on the positioner to select the correct number on the selector knob that correlates with the wire size. (Fig. 4)
2. Remove the spring clip, then raise and rotate the selector knob to the appropriate setting. Reinsert the spring clip. (Fig. 5)

Fig. 4

Fig. 5

3. Insert the contact and prepared wire through the indenter opening into the positioner. (Fig. 6)
4. Squeeze the handles together until the ratchet releases. The handle will return to the open position once fully crimped. (Fig. 7)

Fig. 6

Fig. 7

SCAN FOR A VIDEO TUTORIAL.
https://qrco.de/afm8

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GAUGING INSTRUCTIONS

It is recommended to verify tool calibration using a GO/NO-GO gage. This can be achieved by adjusting the selector setting and inserting the specified gage listed on the following page.

GO

1. Actuate the tool to the fully closed position.
2. With firm hand pressure on the tool handles, insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.

⚠ DO NOT crimp the gage.

NO-GO

1. Actuate the tool to the fully closed position.
2. With 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 indenter opening, but must not pass completely through.

⚠ DO NOT crimp the gage.

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GAUGING LIMITS

Use the chart below to pair the recommended GO/NO-GO gage with the indenter gauging limits.

Tool	Selector Setting	Gauging Limits	GO/NO-GO Gage
AFM8®	1	.0130-.0180	G213
	2	.0160-.0210	G214
	3	.0190-.0240	G215
	4	.0220-.0270	G216
AFM8-CC	5	.0260-.0310	G217
	6	.0300-.0350	G218
	7	.0340-.0390	G219
	8	.0390-.0440	G125
AFM-10	1	.0150-.0180	
	2	.0180-.0210	
	3	.0210-.0240	
	4	.0240-.0270	G871
	5	.0270-.0300	G1387
	6	.0300-.0330	
	7	.0330-.0360	
	8	.0360-.0390	

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Tool	Selector Setting	Gauging Limits	GO/NO-GO Gage
39-000	5	.0260-.0310	G626
	6	.0300-.0350	G345
	7	.0340-.0390	G1045
	8	.0390-.0440	G310
COM8-1	1	.0220-.0270	G472
	2	.0240-.0290	G268
	3	.0280-.0330	G438
	4	.0320-.0370	G427
	5	.0360-.0410	G506
	6	.0410-.0460	G551
	7	.0470-.0520	G538
	8	.0530-.0580	G687

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TOOL ENHANCEMENTS

Enhance your tool's functionality with the added benefit of a cycle counter. This feature provides a reliable method for monitoring tool usage, scheduling preventative maintenance, and conducting calibration verification.

AFM8-CC

TOOL CARE

Virtually no maintenance is required for this tool; however, it's good practice to keep indenter tips free of residual deposits and other debris by using a small wire brush. We strongly recommend that you:

- DO NOT immerse tools in cleaning solution.
- DO NOT spray oil into tool to lubricate.
- DO NOT attempt to disassemble tool or make repairs.
- Only use tools for their intended purposes.

CALIBRATION & REPAIR

We offer comprehensive calibration and repair services. Our technicians will inspect the tool, replace worn components, and ensure it meets factory specifications.

To begin the calibration or repair process, scan the QR code. U.S. Customers will be directed to the appropriate forms to initiate service through DMC. Customers outside of the U.S. may contact authorized repair centers near them.

https://qrco.de/Calibrate

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SAFETY

Safety is essential in the use and maintenance of DMC tools and equipment. This manual and any markings on the tool provide information for avoiding hazards and unsafe practices related to the use of these tools. Observe all of the safety information provided below:

Use proper connector and cable combinations. Improper combinations can result in an incomplete crimp. Failure to observe this warning could result in severe injury or death.

Inspect tool before use. If any parts are worn or damaged, send the tool for repair.

Avoid use of any powered “press” as defined by OSHA CFR 1910.211 (46)

Ensure the tool is in the open position whenever the turret positioner is being installed, removed, or released.

Limitation of Liability

DANIELS MANUFACTURING CORPORATION (DMC) IS NOT LIABLE FOR CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY NATURE OR KIND RESULTING FROM THE USE, MISUSE, 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.

Limited Warranty

Daniels Manufacturing Corporation (DMC) warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. DMC’s obligation under this warranty is limited to the free correction or, at DMC’s option, the refund of the purchase price of any such product which proves defective in normal service within ninety (90) days after delivery to the first user, provided that the product is returned to DMC with all transportation charges prepaid and which shall appear to DMC’s satisfaction, after DMC’s inspection, to have been defective in material or workmanship, it being understood that DMC products are not consumer products. This warranty shall not cover any damage to any products which, in the opinion of DMC, was caused by normal wear, misuse, improper operation, tampering, neglect 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 DMC other than those herein set forth.

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Rev A