

# Crimping Circular Solid Pin and Socket Contacts

## Crimper # 3107 DTCT

### Crimping Instructions:

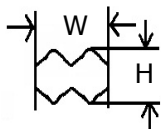
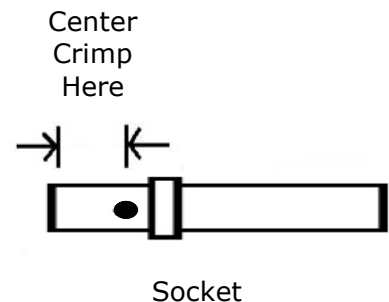
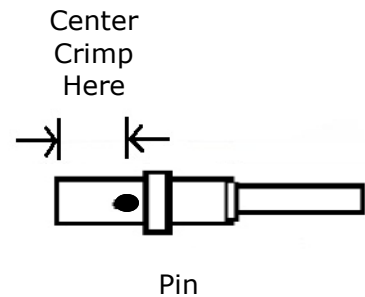
**1** Close tool completely to release ratchet and open jaws.

**2** Refer to the chart below to select appropriate crimp nest.

**3** Place short end of contact (with bleed hole) into nest centering it on the jaws between the hole and end of contact. Slowly close tool slightly to hold contact in place.

**4** Insert properly stripped wire (refer to chart) into the crimp barrel of the contact. Hold wire in place while completely closing the tool until the ratchet releases.

**5** Remove crimped contact. Inspect for quality:  
 a. copper stands should be visible in the bleed hole of crimp and  
 b. no copper strands should be loose outside the crimp barrel.



Nominal Cavity Sizes

	20	16	12
H	.037 REF.	.054 REF.	.086 REF.
W	.072 REF.	.098 REF.	.154 REF.

Current Ratings

Size	Wire AWG Range	Recommended Strip Length	Maximum current Rating	Crimp Tensile Strength
20	20	.156"-.218"	7.5 amps	20 lbs.
16	16-18	.250"-.312"	13 amps	25 lbs.
16	14	.250"-.312"	13 amps	25 lbs.
12	12-14	.222"-.284"	25 amps	70 lbs.

**These instructions show only the minimum required information based on general use and production conditions.**

**Use these instructions for reference only.**

**Form #3107DTCTINS**