



Revisions			
Sym	Description	Date	Approved
B	Revised per E.O. P19919	6/27/08	R D R

**1. WIRE PREPATION:** Use Envelope Drawing HDT-48-00 for ALL wire and contact combinations (this chart simplifies popular sizes). Strip wire as specified. Inspect for damaged/missing strands. The Dial Position is NORMALLY the SAME as WIRE Size (see Envelope Drawing for exceptions).

Contact SIZE	Contact Part Number	WIRE Range AWGs WIRE Range [mm <sup>2</sup> s]	Strip Dim INCH Strip Dim [mm]
20 PIN	0460-202-20**	20	.156-.218
20 Socket	0462-201-20**	[0.50]	[3.96-5.54]
16 PIN	0460-202-16**	16, 18, 20	.250-.312
16 Socket	0462-201-16**	[1.5/1.0/0.75/0.50]	[6.35-7.92]
16 PIN	0460-215-16**	14 *	.250-.312
16 Socket	0462-209-16**	[2.0]	[6.35-7.92]
12 PIN	0460-204-12**	12, 14	.222-.284
12 Socket	0462-203-12**	[3.0/2.5/2.0]	[5.64-7.21]

NOTE: Check for missing or nicked strands after wire is stripped.

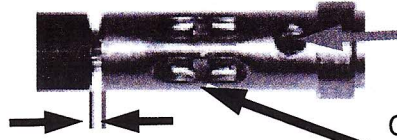


Before crimping, be sure ALL wire strands are INSIDE of the crimp barrel and visible at the inspection hole (sufficient wire length).

\*\* Plating codes: \*\* = 31 is "Gold" \*\* = 141 is "Nickel"

\* NOTE: Use 1.5 dial position for these contacts on 14 AWG.

**2. CONTACT CRIMPING:** Cycle tool to open handles. Remove lock clip. Raise and rotate dial to select wire size. Replace lock clip. Adjust locator to produce crimps as shown below:



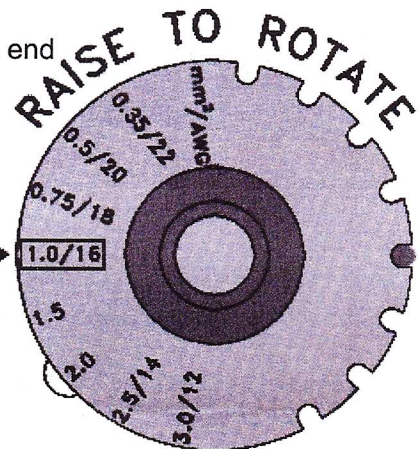
Strands should be visible through inspection hole.

.025-.100" GAP [0.63-2.54] between Contact & Insulation

Crimp must be CENTERED between end of wire barrel and inspection hole.

**NOTE: NEVER close tool ON GAGE G454.**  
Close tool **FIRST**, THEN insert **GAGE G454**.  
Do **NOT** use **GAGE G454** with the **HDP-400**.

mm<sup>2</sup> / AWG  
**GAGE G454**



Use **GAGE G454** in Dial Position **1.0/16** to check wear annually under normal conditions. Check more often with high volume use.

**CAUTION:** To avoid DAMAGE, ALWAYS check Dial Position BEFORE Crimping. (crimping LARGE wire at a small setting may permanently harm the tool).

**3. MAINTENANCE:** Clean tool and remove debris regularly. Inspect for loose or missing hardware. To prevent rust or environmental damage, never leave HDT-48-00 tool outdoors.