



Revisions			
Sym	Description	Date	Approved
NC	New Release per E.O. P21384	6/8/12	D. Meyer

1. WIRE PREPARATION

Choose wire for contact from Chart below or Envelope Drawing **PDT-48-00**.

Contact SIZE	Contact Part Number	WIRE Range AWGs WIRE Range [mm ² s]	Strip Dim INCH Strip Dim [mm]
20 PIN 20 Socket	0460-202-20** 0462-201-20**	20 [0.50]	.156-.218 [3.96-5.54]
16 PIN 16 Socket	0460-202-16** 0462-201-16**	16, 18, 20 [1.5/1.0/0.75/0.50]	.250-.312 [6.35-7.92]
16 PIN 16 Socket	0460-215-16** 0462-209-16**	14 [2.50/2.00]	.250-.312 [6.35-7.92]
12 PIN 12 Socket	0460-204-12** 0462-203-12**	12, 14 [3.0/2.5/2.0]	.222-.284 [5.64-7.21]

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



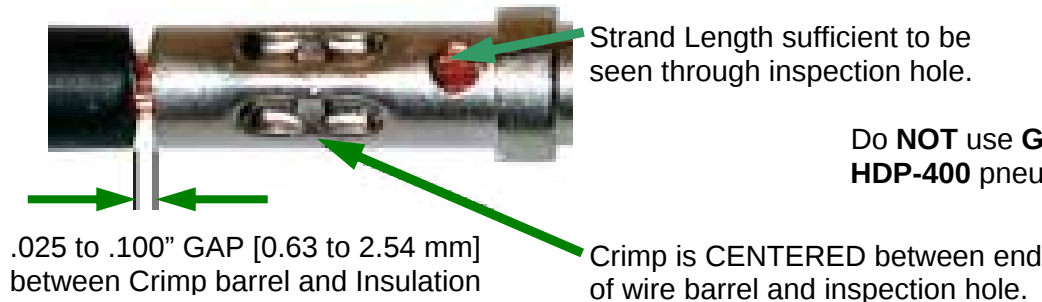
Before crimping, be sure ALL wire strands are INSIDE of the crimp barrel and visible at the inspection hole (sufficient wire length).



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

2. CONTACT CRIMPING

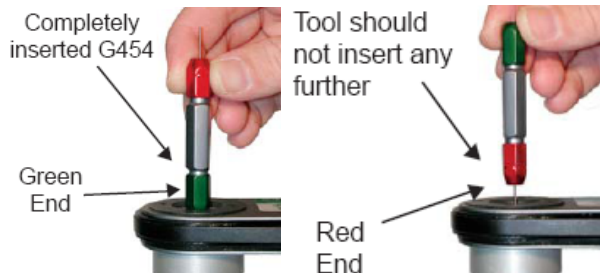
Cycle tool to open indenters. Remove lock clip. Raise and rotate dial to select wire size. Replace lock clip. Adjust locator to produce crimps as shown below:



Do NOT use G454 with a HDP-400 pneumatic tool.

Use Gage G454 in **Dial Position 16/1.0** to check wear. This is recommended on a monthly basis for normal use. Check more often if used for frequent crimping.

WARNING: NEVER close tool ON crimp gage G454. This will damage indenters and VOID the WARRANTY. Close tool FIRST and THEN insert GO or NOGO G454 Inspection Gage.

**3. MAINTENANCE**

Clean tool and remove debris regularly. Check for missing or loose hardware. Air Supply: 80 to 120 PSI (5.5 to 8.3 BAR) needs filter, dryer, and regulator. Lubricator is recommended. Check hoses and fittings for integrity and fix leaks as required.

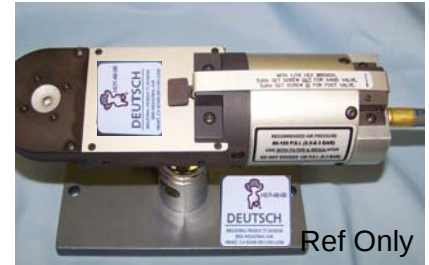


**4. CARE OF TOOL**

Do NOT immerse tool in Cleaners (vacuum or wipe clean).
Do NOT spray oil into tool to lube (use in-line Lubricator).
Do NOT open tool or make repairs (Voids your Warranty).

5. COMPRESSED AIR FITTINGS

Inlet port has a ¼" NPT fitting. Apply thread sealing tape or compound to avoid leakage or damage. Adjust 1/16" hex set screw OUT for Hand Valve or IN for Foot Switch.

**6. WIRE RANGE**

Minimum **22 AWG** [0.35 mm²] (wire Selector Knob is on side opposite crimp cavity).
Maximum **12 AWG** [3.00 mm²] Tool must be "open" prior to selecting wire range.

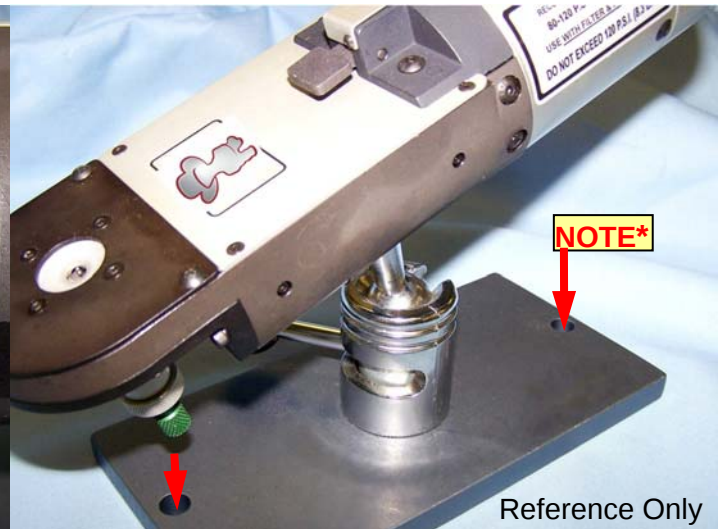
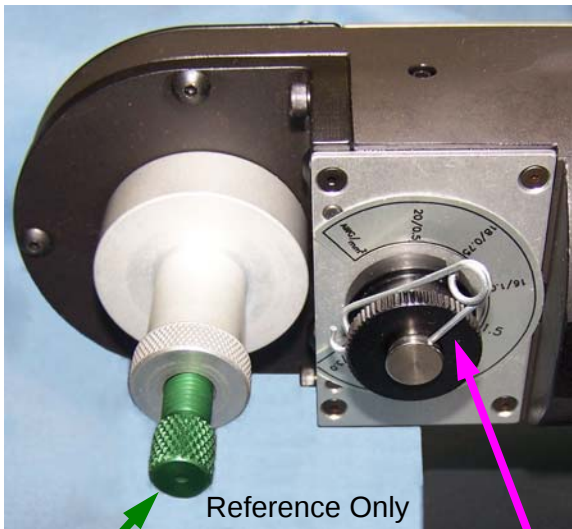
7. RELATED PRODUCT

PDT-48-00 is a **Pneumatic Deutsch Tool** version of the **HDT-48-00 (Hand Deutsch Tool)**.
PDT-48-00 is for **PRODUCTION** crimps; and **HDT-48-00** is for **FIELD REPAIRS ONLY**.

8. BENCH MOUNT

Adjust Bench Mount for efficiency and ergonomics. Loosen by rotating knob lever. Move tool to desired position. Lock ball mount by rotating knob lever.

CAUTION: It is recommended that **BASE** of Bench Mount be **ATTACHED** with hardware.
This will reduce the **RISK** of damage from tool falling onto Operator or floor surface.



Ergonomics Adjustment Bench Mount
Remove Clip and Raise Dial to Rotate

with Locking Arm to Select Tool Angle

GREEN threaded rod is contact DEPTH locator.
Loosen knurled lock ring and adjust depth to position contact as shown in section 2.

NOTE*: Mounting Base should be **ATTACHED** with hardware.