
RECOMMENDED
FOR R&D
PROTOTYPING
MAINTENANCE &
REPAIR

PRECISION
CONSTRUCTION
OF DURABLE HIGH
CARBON STEEL

ANGLED HEAD
FOR COMFORT-
ABLE HAND &
WRIST POSITION

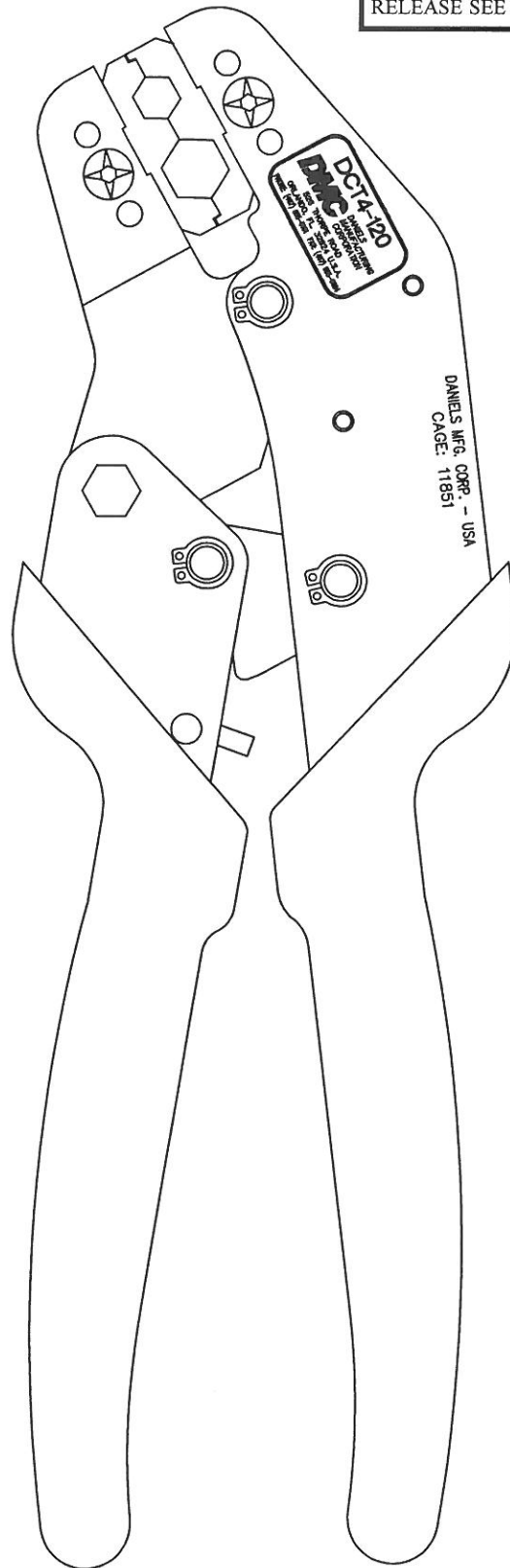
EXTRA
STRENGTH
PIVOT PINS FOR
GREATER
DURABILITY

RATCHET CON-
TROL ASSURES
COMPLETE
CRIMPING
CYCLE

EMERGENCY
RATCHET
RELEASE

INTERCHANGEABLE
DIES ARE AVAILABLE

FOR DETAILS ON EMERGENCY RATCHET
RELEASE SEE REVERSE SIDE FIGURE 1.



DanComm

PRECISION CRIMPING TOOL

DCT4-120 DATA SHEET



INTRODUCTION:

The Daniels DCT4-120 Hand Crimping tool is designed to crimp 50 ohm commercial BNC and TNC connectors onto RG58/U, RG59/U and RG62/U coaxial cable. The tool has a replaceable die assembly with two crimping areas listed in Figure 1.

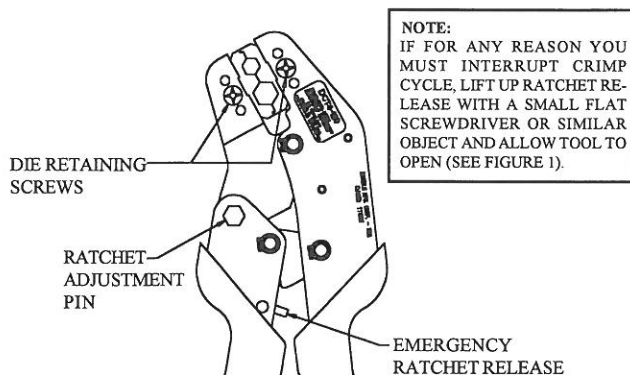


FIGURE 1

DANIELS DCT4-120 HAND CRIMP TOOL CAVITY DIMENSIONS		
CAVITY ONE	.359 INCH HEX	9.12 mm
CAVITY TWO	.255 INCH HEX	6.48 mm

PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Daniels hand tools are intended for occasional use and low volume applications. Daniels offers a wide selection of powered application equipment for extended-use, production operations.

CRIMPING PROCEDURE:

1. Prepare coaxial cable per connector manufacturer's instructions. Avoid nicks on braid, dielectric and center conductor.
2. Slide outer ferrule over cable as shown in Figure 2.
3. Flare slightly end of cable braid, and install cable assembly into body assembly so inner portion slides under braid. Push cable assembly forward until contact snaps into place in insulator.
4. Slide outer ferrule over braid and up against connector body. Crimp outer ferrule with specified hex size die cavity.

NOTE:

Instructions given above are intended as general guidelines for assembly of coaxial connectors. Specific directions of connector manufacturer should take precedence.

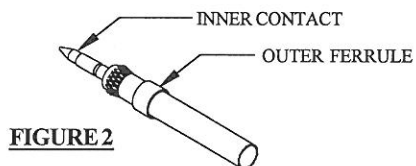


FIGURE 2

MAINTENANCE AND INSPECTION:

Daily maintenance:

Daniels recommends that operators of the tool be made aware of, and 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.

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. Remove all lubrication and accumulated film by immersing the tool (handles partially closed) in a suitable commercial degreaser that will not affect paint or plastic material.
2. Make certain that all retaining pins are in place and secured with retaining rings.
3. 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.
4. 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.
5. Check the crimping dies occasionally to make sure dies are not broken or chipped.

ADJUSTING RATCHET:

The ratchet adjustment is preset at the factory. If adjustment is necessary, contact the factory for instructions.

DIE INSTALLATION:

Install die set into tool frame as shown in Figure 1. Install and tighten retaining screws making sure dies are aligned and fully seated against tool frame.

DanComm 4™ TOOLS

DMC P/N	DESCRIPTION
DCT4-101	AMP STD & MOISTURE RESISTANT CAPS
DCT4-102	R/B/Y INSULATED TERMINALS
DCT4-103	SLIDE ON R/B
DCT4-104	HEAT-N-SEAL R/B/Y
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	R/B/C SPLICES
DCT4-120	.255 HEX / .359 HEX
DCT4-121	.039 SQ / .195 HEX

CONSULT FACTORY FOR OTHER DIE CONFIGURATIONS

LIMITATION OF LIABILITY / LIMITED WARRANTY*

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

*as defined by PL93-637

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