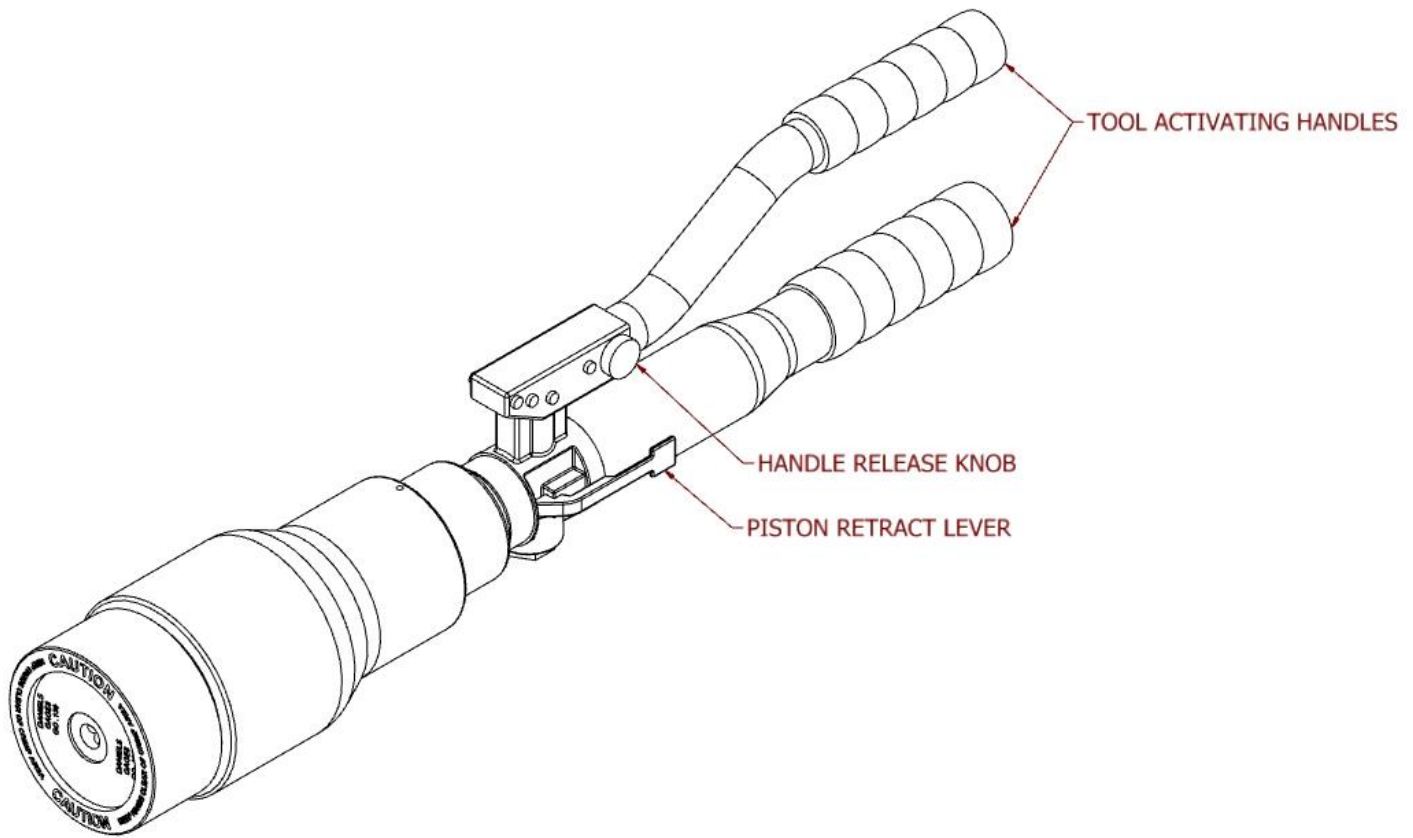


HD23

HEAVY DUTY HYDRAULIC CRIMP TOOL

DATASHEET



SEE PAGE 5 FOR IMPORTANT
INFORMATION REGARDING
LIMITED WARRANTY AND
LIMITATION OF LIABILITY

GENERAL INFORMATION

1. The DMC HD23 is a heavy duty hand operated hydraulic crimp tool, designed to produce four indent crimps on M39029 and similar contacts, sizes 8 thru 4/0 AWG. Various sizes and types of contacts are accommodated by changing indenter die assemblies and locators.
2. This tool is a hand operated hydraulic equivalent to DMC tool part number WA23 (M22520/23-01) Heavy Duty Pneumatic Crimp Tool. It accepts all die assemblies and locators designed for WA23. However this tool is **NOT** Mil Qualified at the time of this writing.
3. The tool's hydraulic pump is filled with biodegradable hydraulic fluid at the factory and does not need to be bled or primed.

SAFETY

1. Safety is essential in the use and maintenance of DMC tools and equipment. This datasheet and markings on the tool provide information for avoiding hazards and unsafe practices related to the use of this tool. Observe all of the safety information provided.

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SPECIFICATIONS

Crimping Tool

Length	22.9" (581.7mm)
Width	4.0" (101.6mm)
Mass/Weight	13.9lb (6.3kg)
Hydraulic Oil	.1pt (50ml) Biodegradable Hydraulic Fluid

Crimping Capacities

Crimping Range	8 to 4/0
Pump Force Output	4.5 tons (40.03kN)

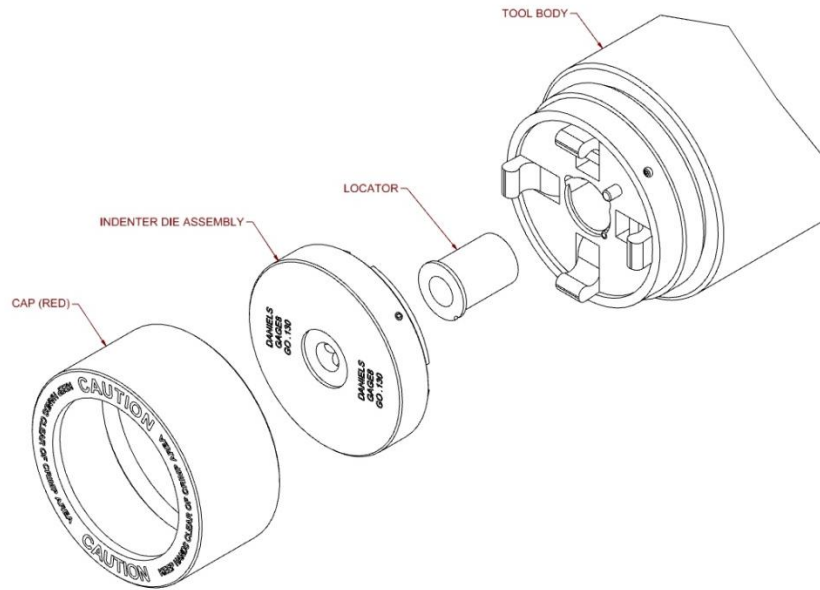


Figure 1

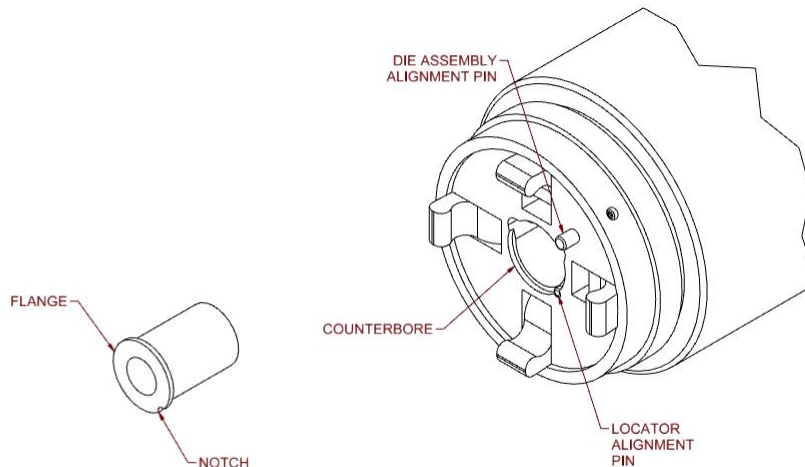


Figure 2

Figure3

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OPERATION

INSTALLATION OF LOCATOR

1. Unscrew the red cap and remove die assembly, if installed. Insert the locator in the center hole, See Figure 1.
2. Verify that the flange on the locator is seated in the counterbore, and the notch on the flange, See Figure 2, is aligned with the locator alignment pin, See Figure 3.

INSTALLATION OF THE DIE ASSEMBLY

1. Place the indenter die assembly, as shown in Figure 1, onto the tool body. The die assembly alignment pin, See Figure 3, must fit into the corresponding hole in the die assembly. Place the red cap over the die assembly, See Figure 1, and tighten fully to hold the assembly flush with the tool body.
2. Apply pressure to the tool activating handles, closing them towards each other. While holding pressure, turn the handle release knob 180° CW (See Page 1). The moving handle will come up under spring pressure when handle pressure is released.
3. Repeatedly cycle the tool activating handles until the die assembly's indenters come in fully, the tool reaches full pressure and the pressure release trips. (Approximately 15 – 16 cycles with no contact loaded in die assembly)
4. When the tools internal pressure release trips the indenters will retract automatically. Confirm that the indenters move freely.
5. The activating handles can be re-locked by holding them closed fully, then rotating the handle release knob 180° CW (See Page 1).

CRIMPING A CONTACT

1. Verify that the proper locator and die assembly are installed for the contact to be crimped.
2. Assemble the contact and wire to be crimped, and insert them into the tool.
3. Push the contact in until it bottoms out in the locator.
4. Release the moving handle, if locked, and cycle repeatedly as previously described. (Approximately 20-25 cycles with contact loaded in die assembly)
5. Remove the crimped contact assembly. Visually inspect the crimp to verify crimp quality and location.

WARNING: DURING THE CRIMP CYCLE, KEEP FINGERS AWAY FROM THE DIE OPENING AREA

GAGING THE DIE ASSEMBLY

1. The GO and NO-GO dimensions are marked on the face of each die assembly. The appropriate gage pins are available from DMC.
2. To check the die closure of the installed die assembly, release the moving handle, and cycle repeatedly, until the tool brings the indenters to the full travel (Closed) position. **STOP** cycling tool handles, and indenters will stay in place.
3. Insert the GO gage pin between the closed indenters. The gage must pass between the indenter tips.

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4. With the indenters still closed, insert the NO-GO gage pin between the closed indenters. The gage can begin to enter, but must not pass through the indenter tips. Manually retract indenters by pressing the piston retract lever.

CAUTION: DO NOT CRIMP GAGE PIN. THIS WILL DAMAGE THE TOOL AND VOID WARRANTY

AS22520/23 TOOL, DIE, ASSEMBLY, AND LOCATOR LIST

Military P/N	Description	DMC P/N	Contact Size*	"GO" Dim	"NO-GO" Dim	Gage P/N
M2250/23-01	Crimp Tool	WA23				
M22520/23-02	Die Assembly 8	WA23-2	8	.130	.136	G693
M22520/23-03	Die Assembly 6	WA23-3	6	.171	.178	G694
M22520/23-04	Die Assembly 4	WA23-4	4	.195	.202	G695
M22520/23-08	Die Assembly 1	WA23-8	1	.255	.265	G1299
M22520/23-05	Die Assembly 1/0	WA23-5	1/0	.325	.332	G696
M22520/23-06	Die Assembly 2/0	WA23-6	2/0	.351	.358	G697
M22520/23-07	Die Assembly 4/0	WA23-7	4/0	.425	.432	G698
M22520/23-09	Locator 8	WA23-9	8			
M22520/23-10	Locator 6, 6N, 6G	WA23-10	6, 6N, 6`G			
M22520/23-11	Locator 4	WA23-11	4			
M22520/23-12	Locator 4, 4N, 4G	WA23-12	4, 4N, 4G			
M22520/23-13	Locator 1/0	WA23-13	1/0			
M22520/23-14	Locator 1/0, 1/0N	WA23-14	1/0, 1/0N			
M22520/23-15	Locator 2/0, 2/0N	WA23-15	2/0, 2/0N			
M22520/23-16	Locator 4/0, 4/0N	WA23-16	4/0, 4/0N			

*Smaller wire gage may require the use of M39029/112-XX contact bushings.

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DMC offers complete refurbishing and recalibration services.

DMC specially engineers and manufactures complete tool kits to satisfy individual customer requirements, such as total aircraft support general shop maintenance or production, on board ship and vehicle service, etc.

Limitation of Liability

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

DMC (Daniels Manufacturing Corporation) 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 and workmanship, it being understood that DMC products are not consumer products. This warranty shall not cover any damage to any product 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 Daniels Manufacturing Corporation other than those herein set forth.

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