

DEUTSCH TERMINALS & TOOLS

Both our Deutsch type crimp tools are ideal for production, workshop and field repair work. The selector chart below, provides an easy lookup table to match every terminal in the Deutsch range to the correct cable size and tooling. Using the information provided on this page assures correct results - every time.



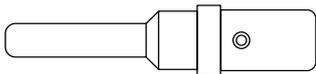
27000
Precision crimp tool.
Crimp range: 24 to 12AWG
2 to 5mm auto



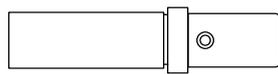
27005
Generic crimp tool
Crimp range: 20AWG
2 to 2.5mm auto

27004
Generic crimp tool
Crimp range: 18 to 14AWG
3 to 4mm auto

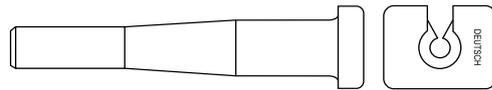
27007
Generic crimp tool
Crimp range: 12AWG
5mm auto



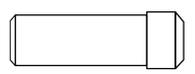
Pin terminal



Socket terminal



Terminal removal tool

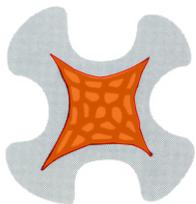


Cavity plug

TERMINAL, CAVITY PLUG, REMOVAL TOOL, CRIMPING TOOL SELECTOR

Cable Auto	Cable AWG	Pin Standard	Socket Standard	Pin Gold	Socket Gold	Cavity plug	Removal Tool	Removal Tool Colour	Crimping Tool
2mm	24-20	27021	27020	27023	27022	27026	27025	Red	27000, 27005
3mm	16-18	27031	27030	27033	27032	27046	27035	Dark blue	27000, 27004
4mm	14-16	27041	27040	27043	27042	27046	27045	Light blue	27000, 27004
5mm	12	27051	27050	27053	27052	27046	27055	Yellow	27000, 27007
8B&S	8	27081	27080	-	-	27086	27085	Green	16120
4B&S	4	27091	27090	-	-	27096	27095	White	16120

Hints for correct crimping:



Compression crimp cross-section

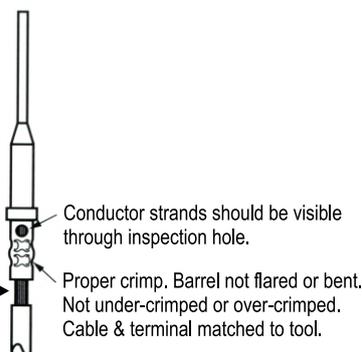
Why crimp?

Because of the new environments to which electrical connectors are subjected, and the environmental and occupational health issues associated with lead, there has been a drastic change in thinking relating to the use of precision crimp joints in preference over solder joints.

Crimping tools can be more expensive than soldering tools, but this is more than offset by lower installation and maintenance costs together with more repeatable and reliable outcomes. To realise these advantages it is imperative that the operator understands how to crimp properly by matching cable to terminal size coupled with correct tool use. Below are examples of the good and the bad.

The Good

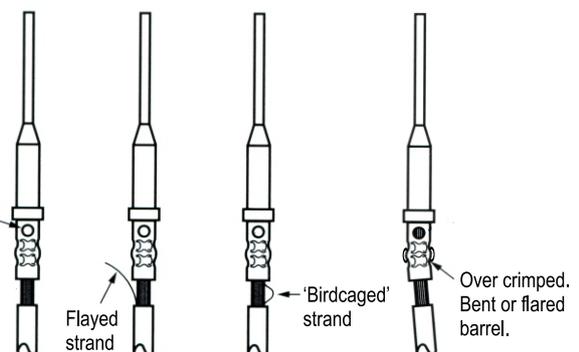
Where the cable is subjected to vibration or regular handling, leaving an insulation gap reduces point stress at the terminal which could lead to broken strands.



Conductor strands should be visible through inspection hole.
Proper crimp. Barrel not flared or bent. Not under-crimped or over-crimped. Cable & terminal matched to tool.

The Bad

Conductor not visible. Not fully inserted.

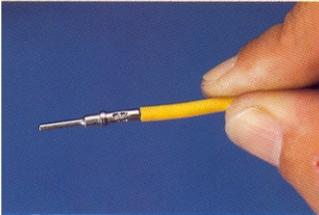


Flayed strand
'Birdcaged' strand
Over crimped. Bent or flared barrel.

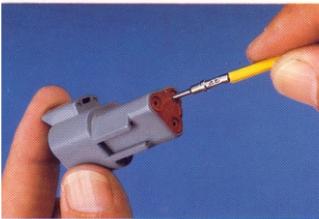
USING DEUTSCH CONNECTORS

Understanding how to assemble Deutsch connectors is the key to Deutsch's performance and reliability. Common terminals across the entire range ensure easy upgrade and expansion plus interfacing with the huge range of manufactured equipment now fitted with Deutsch connectors as standard. Using the information provided on this page assures correct operation - every time.

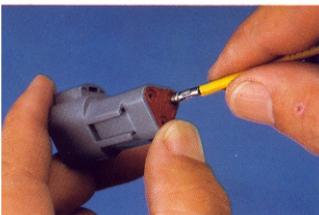
Assembly for: DT, DTM & DTP series



Male housings use socket terminals and female housings use pin terminals. Grip crimped terminal approx. 25mm behind barrel



All Deutsch connectors accept terminals from the housing's rear. Identify terminal cavity to insert terminal into.



Push terminal straight into connector seal until a click is felt. A slight tug will confirm that it is locked into place



Once all terminals are in place, insert the retention wedge. Checking orientation will assure correct alignment. Unused cavities can be sealed off using cavity plugs. Plug heads should sit proud of the seal to allow easy removal and can be installed with or without the wedge in place.

Disassembly for: DT, DTM & DTP series



Remove the wedge using a hooked tool such as a strong seal pick. Be careful not to pull towards yourself so as not to cause injury. 3 circuit female housing wedges will require pointy-nose pliers, as illustrated.



To remove terminals, using a small blade screwdriver release the locking finger away from the terminal whilst at the same time gently pulling the cable rearwards until it is released.

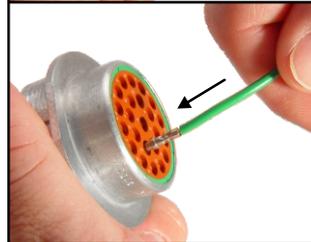


Once the terminal is released, and while holding the seal in place with your thumb, pull the cable out fully. The crimped terminal can be re-inserted.

Assembly for: HD10 & HD30 series

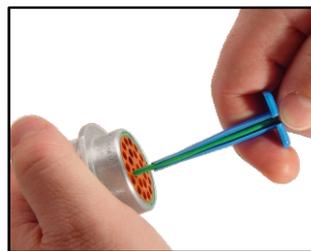


HD30 series connectors are available in reverse gender. It is recommended that panel sockets use pin terminals and plugs use socket terminals to reduce the chance of user damage to terminals. Grip crimped terminal approx. 25mm behind barrel

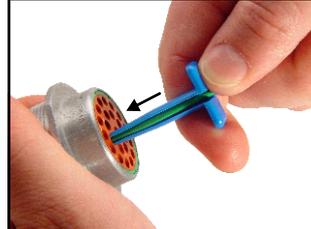


Identify terminal cavity to insert terminal into. Push terminal straight into connector seal until a click is felt. A slight tug will confirm that it is locked into place. Once all terminals are in place seal off any unused cavities with cavity plugs. The plug head should sit proud of the seal to allow easy removal.

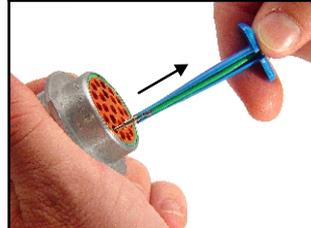
Disassembly for: HD10 & HD30 series



Grip the housing as shown if the panel socket is not already mounted. Using the correct removal tool for the terminal to be removed, slide the tool over the cable as shown.



Slide the removal tool into the cavity until it engages the terminal retention fingers and resistance is felt. Do not bend or twist the tool as it is designed to break rather than damage the retention fingers and rendering the housing useless. The removal tool is many times cheaper than the housing. Never use metal removal tools for this reason alone.



Once the removal tool engages, gently pull the cable back through the tool to release it and then withdraw both from the housing. If the terminal won't disengage, re-insert the removal tool at a different angle around the cable to try and engage the terminal locking fingers. Once removed it can be re-inserted.

A CD-ROM is available with the full line of Deutsch connectors plus more handy hints on using Deutsch

