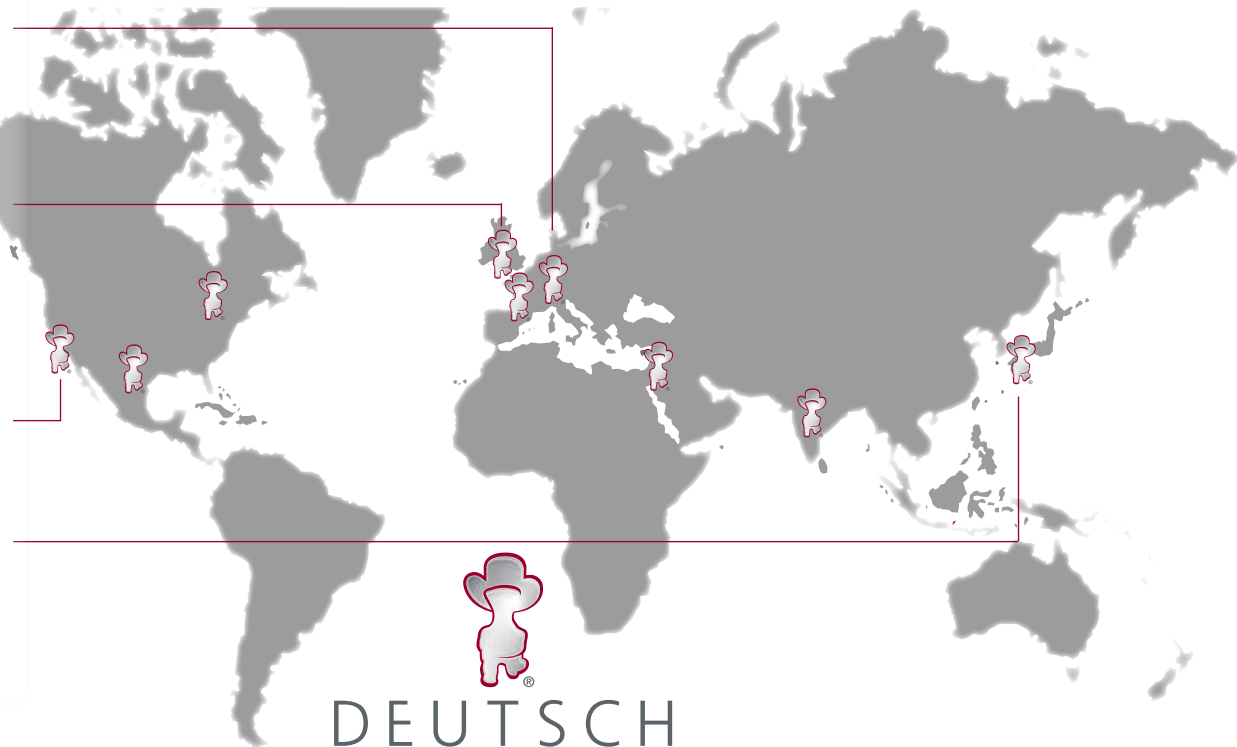


Deutsch Industrial Europe
Fraunhoferstrabe 11
82152 Martinsried
Germany
Ph. +49 (0) 89 899157-0
Fax +49 (0) 89 857 4684
info.eu@deutsch.net

Deutsch Industrial UK
Stanier Road
St. Leonards On Sea
East Sussex TN 38 9RF
England
Ph. 44 (0) 1424 852 722
Fax 44 (0) 1424 855 979
industrialuk@deutsch.net

Deutsch Industrial US
3850 Industrial Ave.
Hemet, CA 92545
USA
Ph. +1 (951) 765-2250
Fax +1 (951) 765-2255
insidesales-ipd@deutsch.net

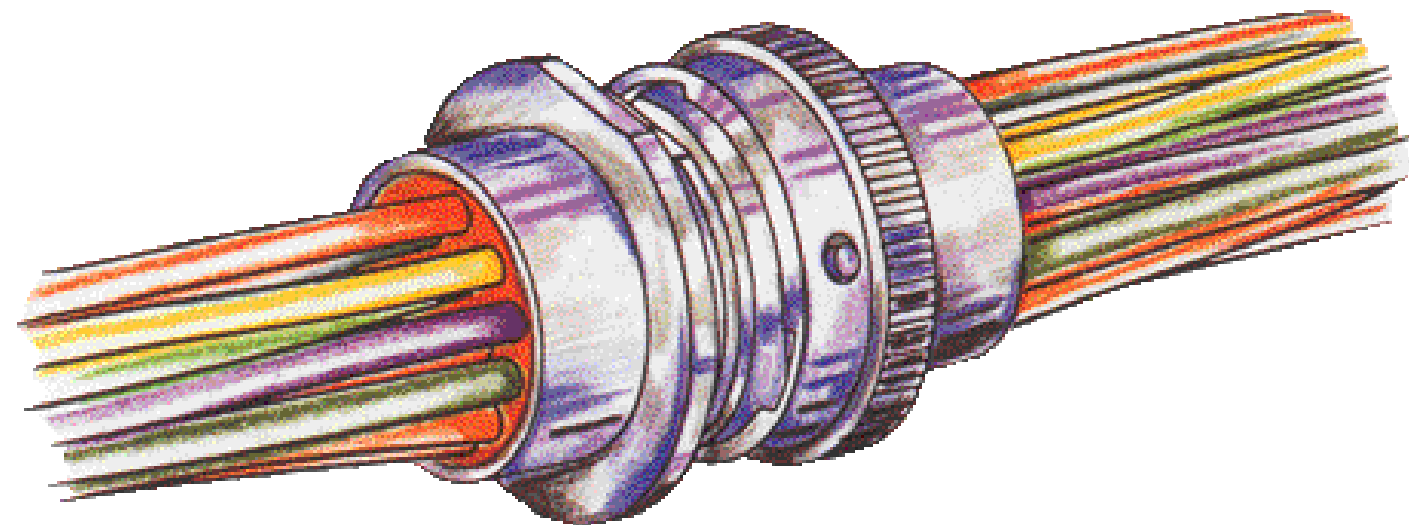
Deutsch Industrial Japan
NIHON Deutsch Ltd.
44-10, Ohyamakanai-cho
Itabashi-ku, Tokyo 173-0024
Japan
Ph. + 81-3-5995-5192
Fax + 81-305995-5193
rtakemura@nihon-deutsch.co.jp




DEUTSCH
INDUSTRIAL PRODUCTS DIVISION

3850 Industrial Avenue, Hemet, California 92545 Tel.: (951) 765-2250 - Fax: (951) 765-2255
Web : www.deutsch.net - Edition 2007


DEUTSCH
INDUSTRIAL PRODUCTS DIVISION

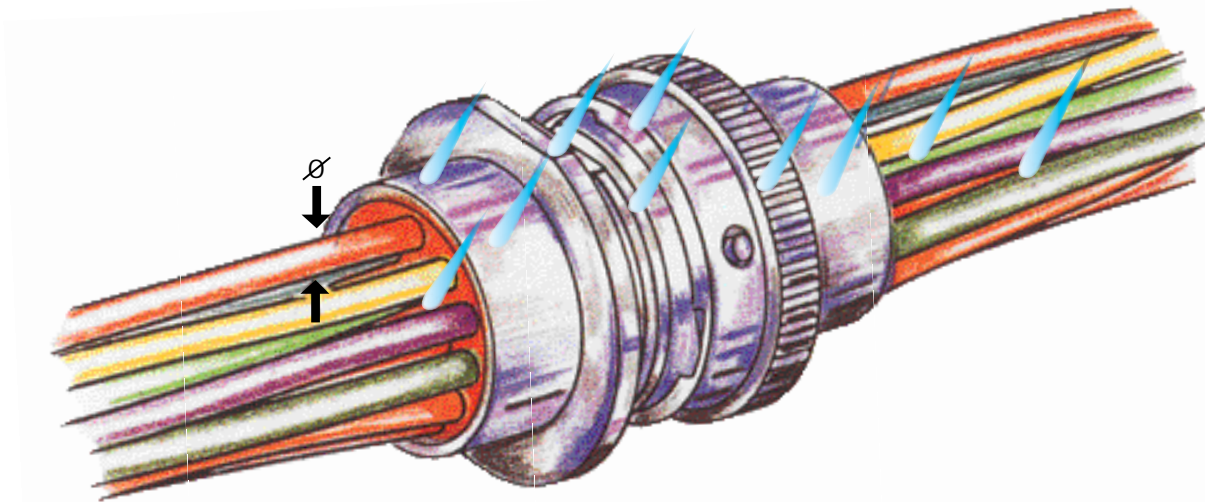


HELPFUL HINTS

A STEP AHEAD

A STEP AHEAD

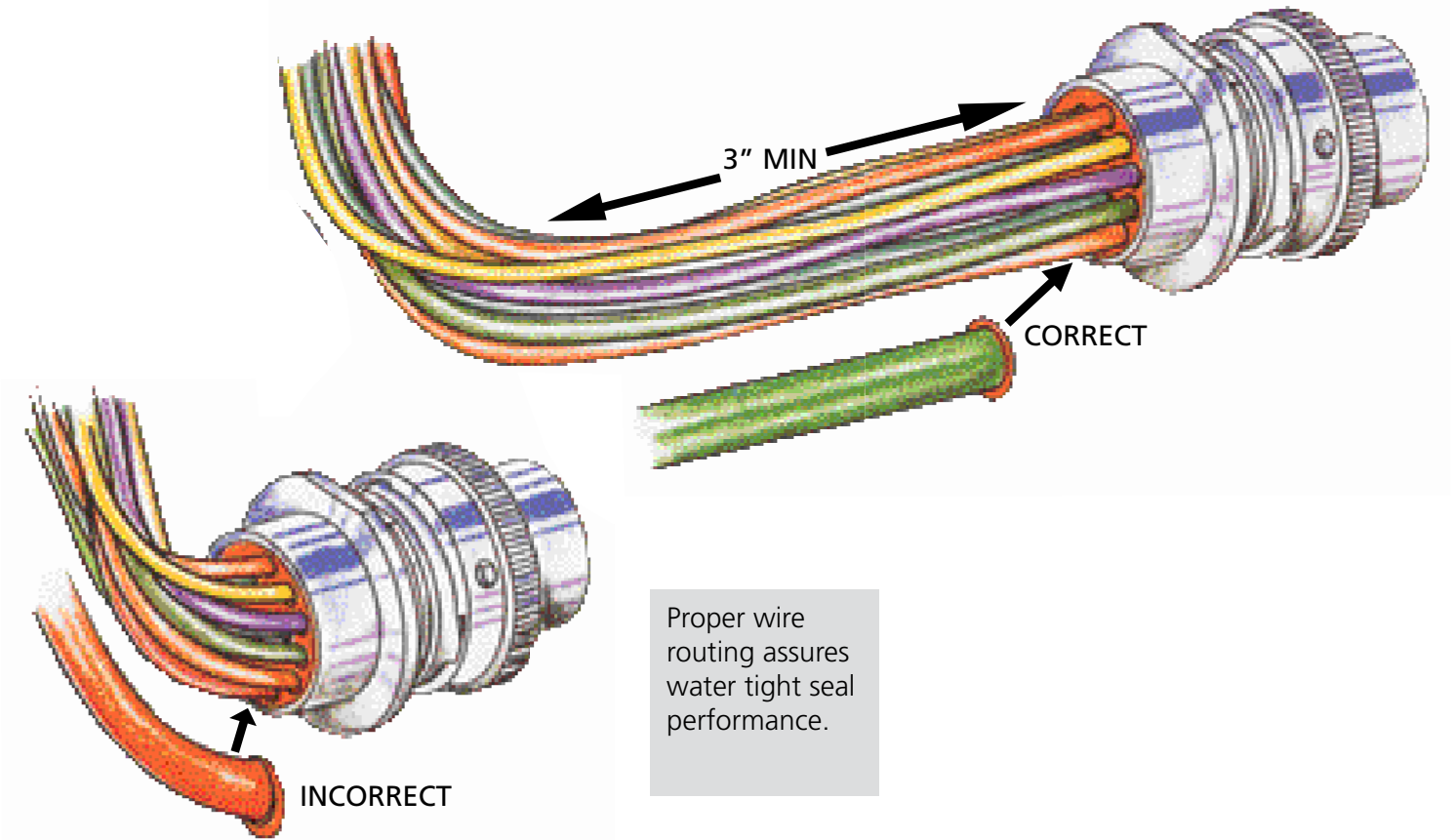
HELPFUL HINTS



Proper wire outside diameters assure water tight seals.

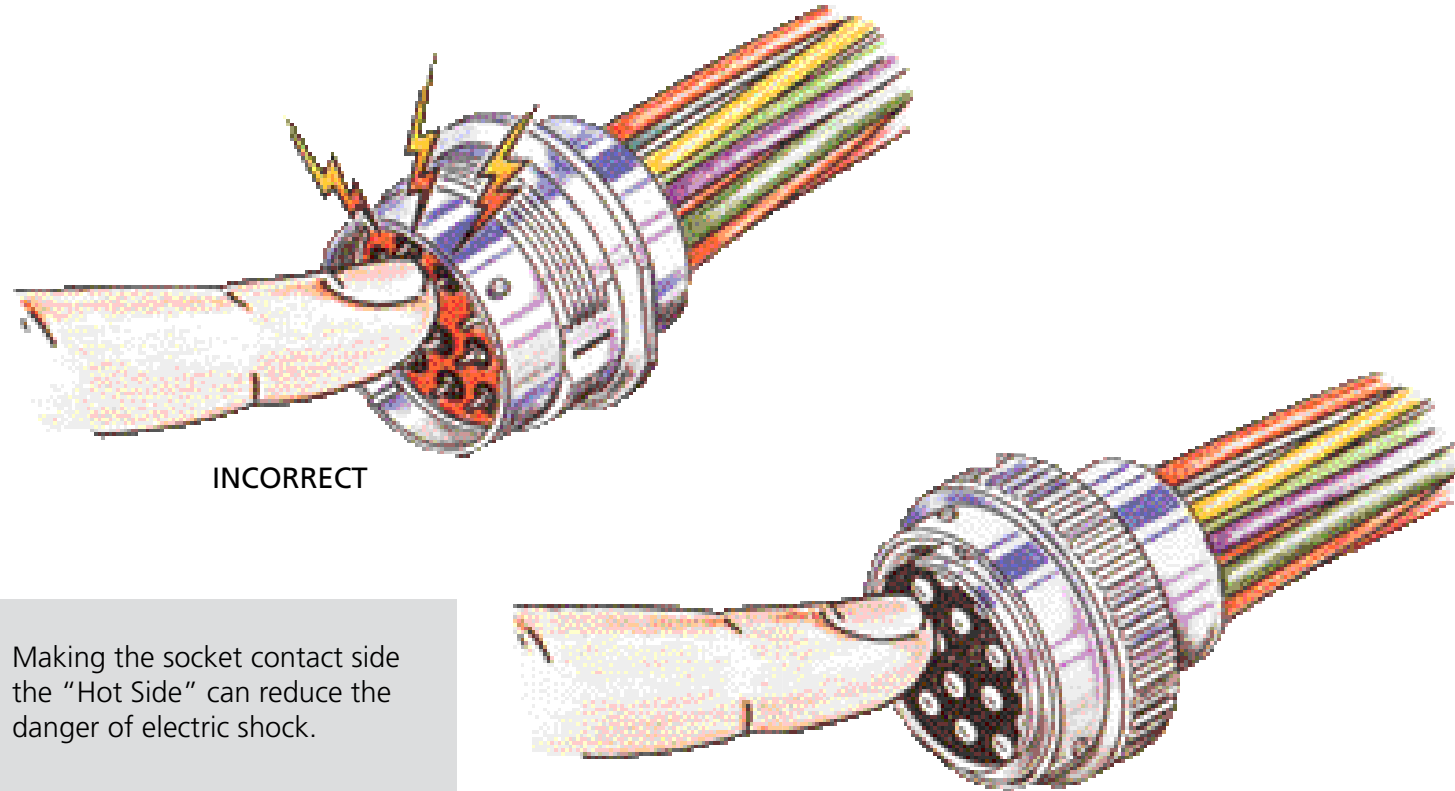
CORRECT SIZE	4 MIN/MAX	8 MIN/MAX	12 MIN/MAX	16 MIN/MAX	20 MIN/MAX
HD 10	—	—	—	.100/.150	—
DT	—	—	—	.088/.150	—
ALL OTHERS	.280/.292	.190/.240	.134/.170	.100/.135	.040/.095

HELPFUL HINTS



Proper wire routing assures water tight seal performance.

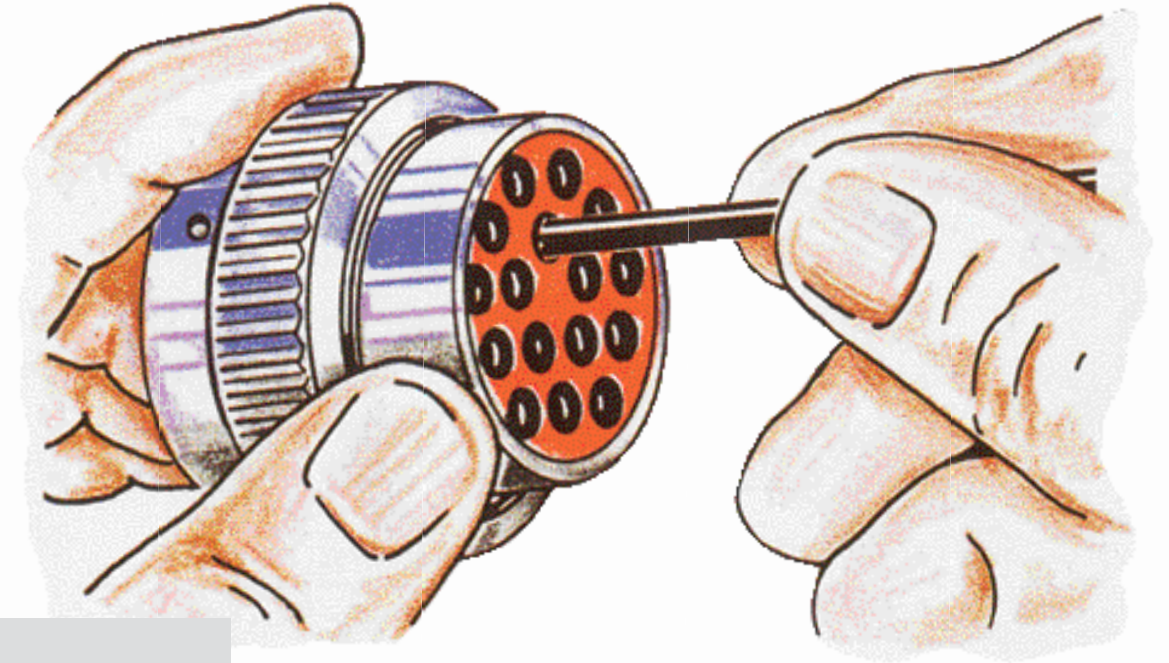
HELPFUL HINTS



INCORRECT

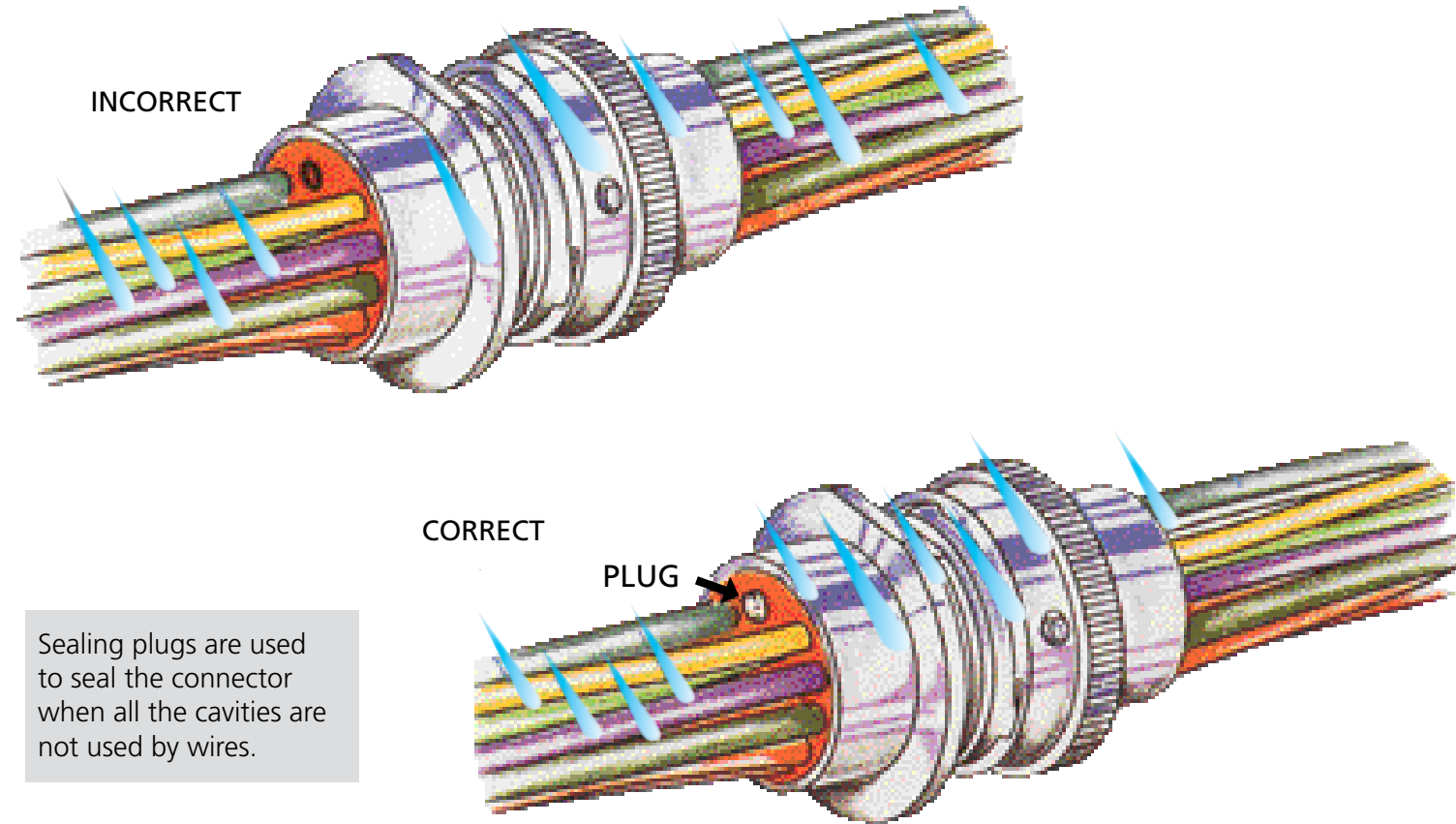
Making the socket contact side the "Hot Side" can reduce the danger of electric shock.

HELPFUL HINTS



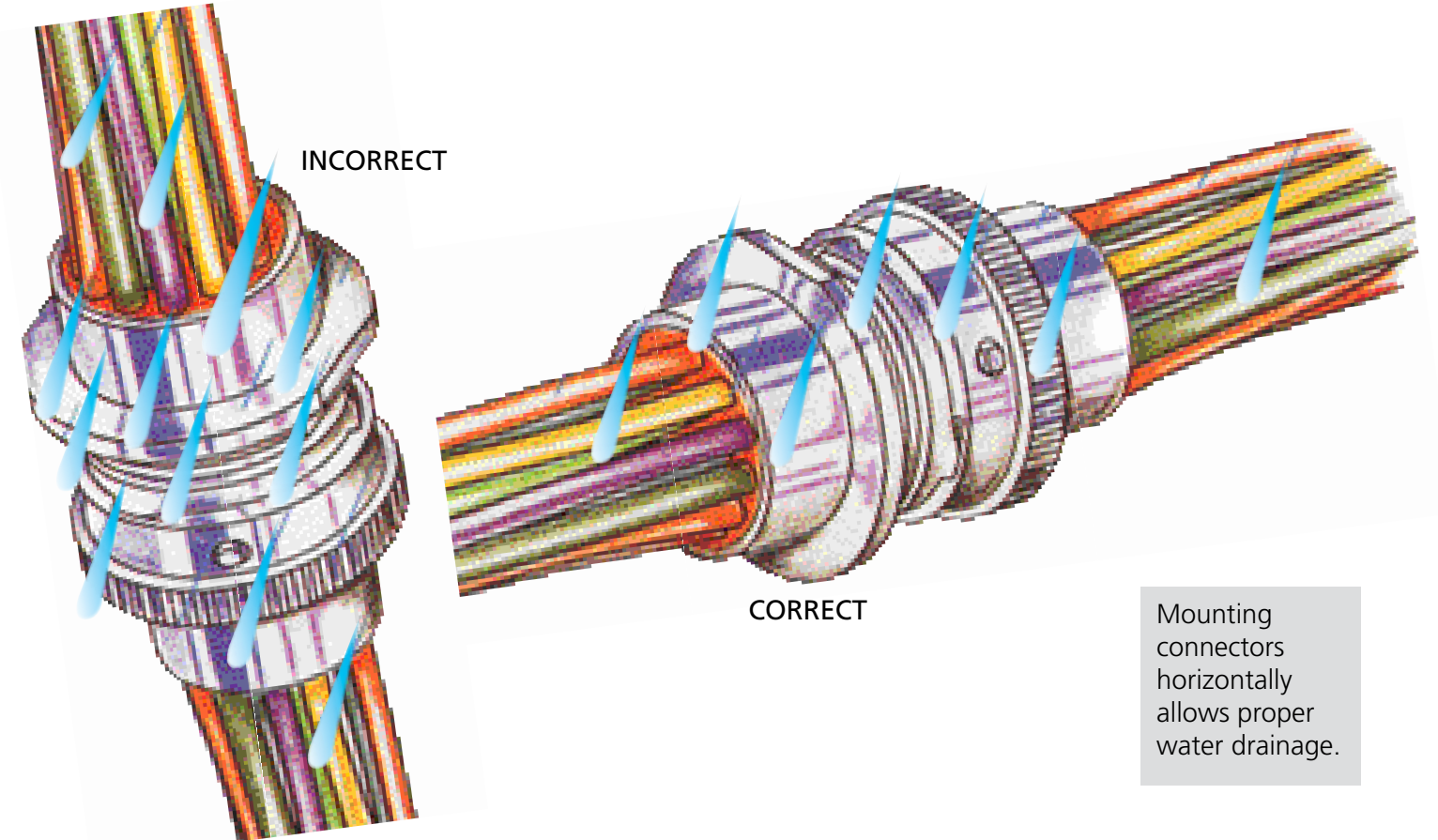
Pulling lightly on the wire after it is snapped in place will assure the contact is locked.

HELPFUL HINTS



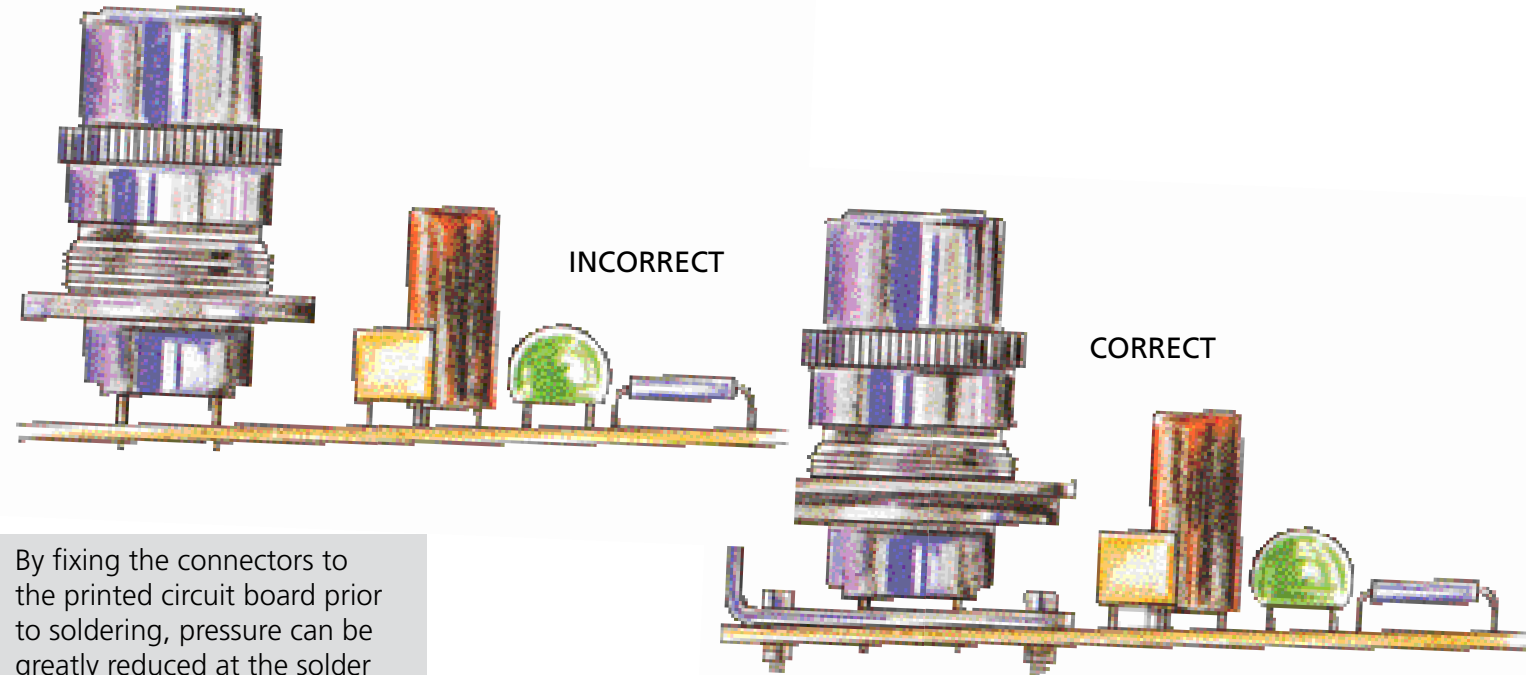
Sealing plugs are used to seal the connector when all the cavities are not used by wires.

HELPFUL HINTS



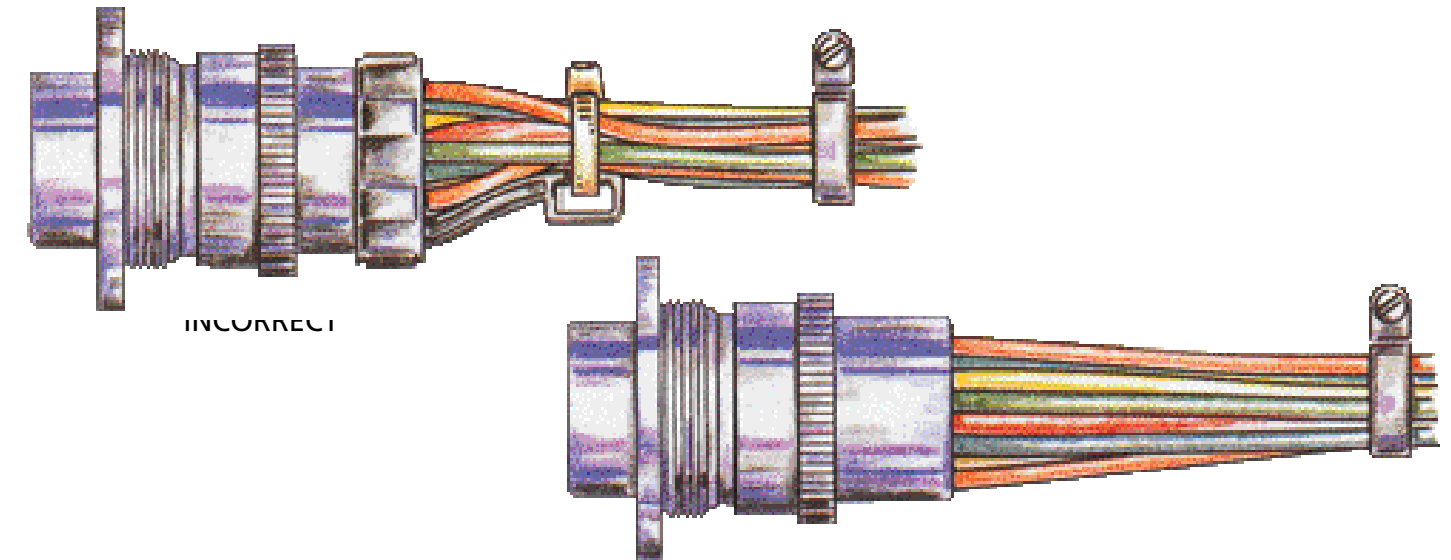
Mounting connectors horizontally allows proper water drainage.

HELPFUL HINTS



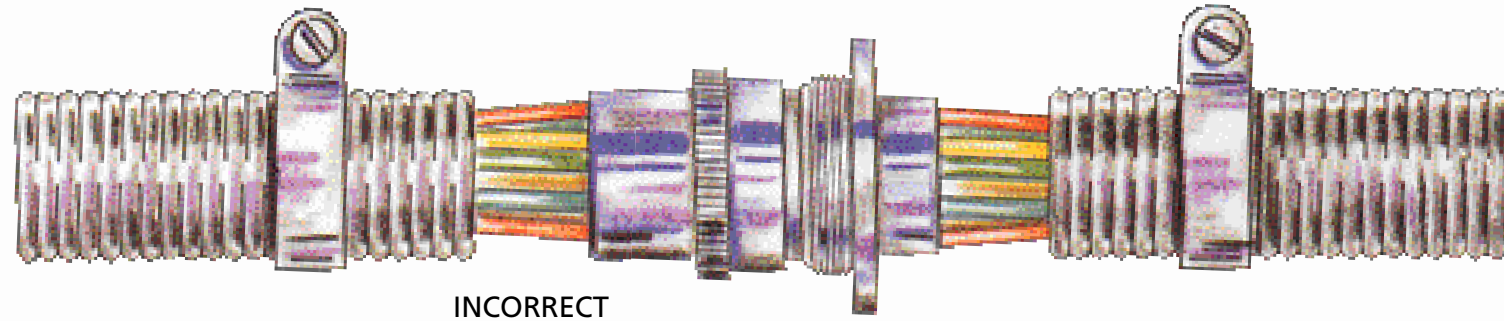
By fixing the connectors to the printed circuit board prior to soldering, pressure can be greatly reduced at the solder joint.

HELPFUL HINTS

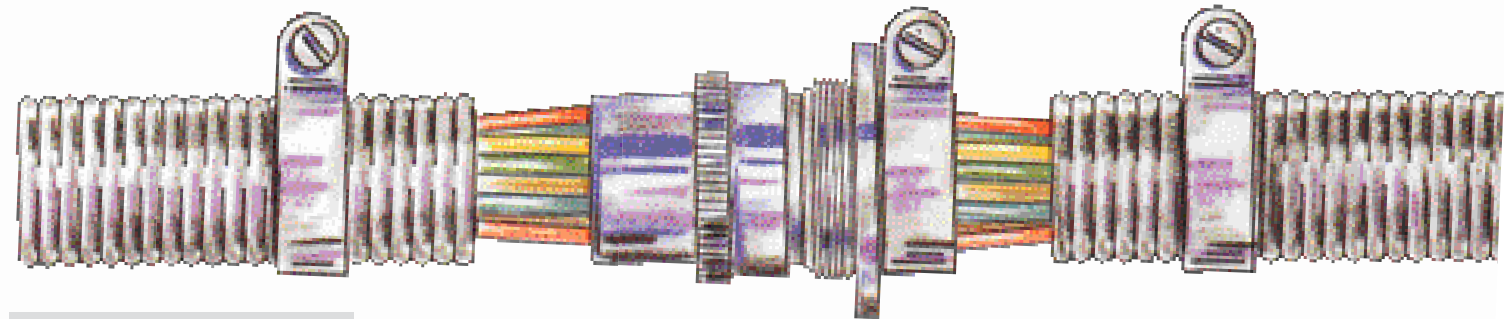


Planned wire routing and clamp points can reduce harness cost by eliminating strain reliefs.

HELPFUL HINTS



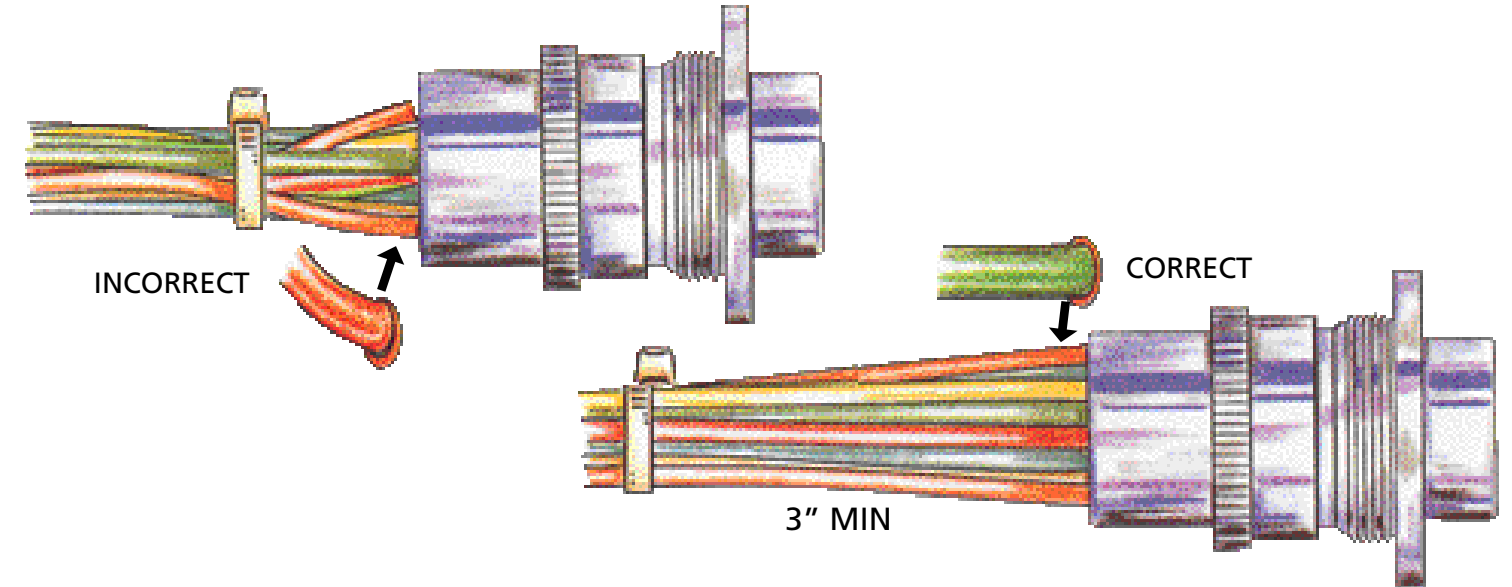
INCORRECT



CORRECT

Attaching the connector to a structure eliminates straining the electrical system in service.

HELPFUL HINTS



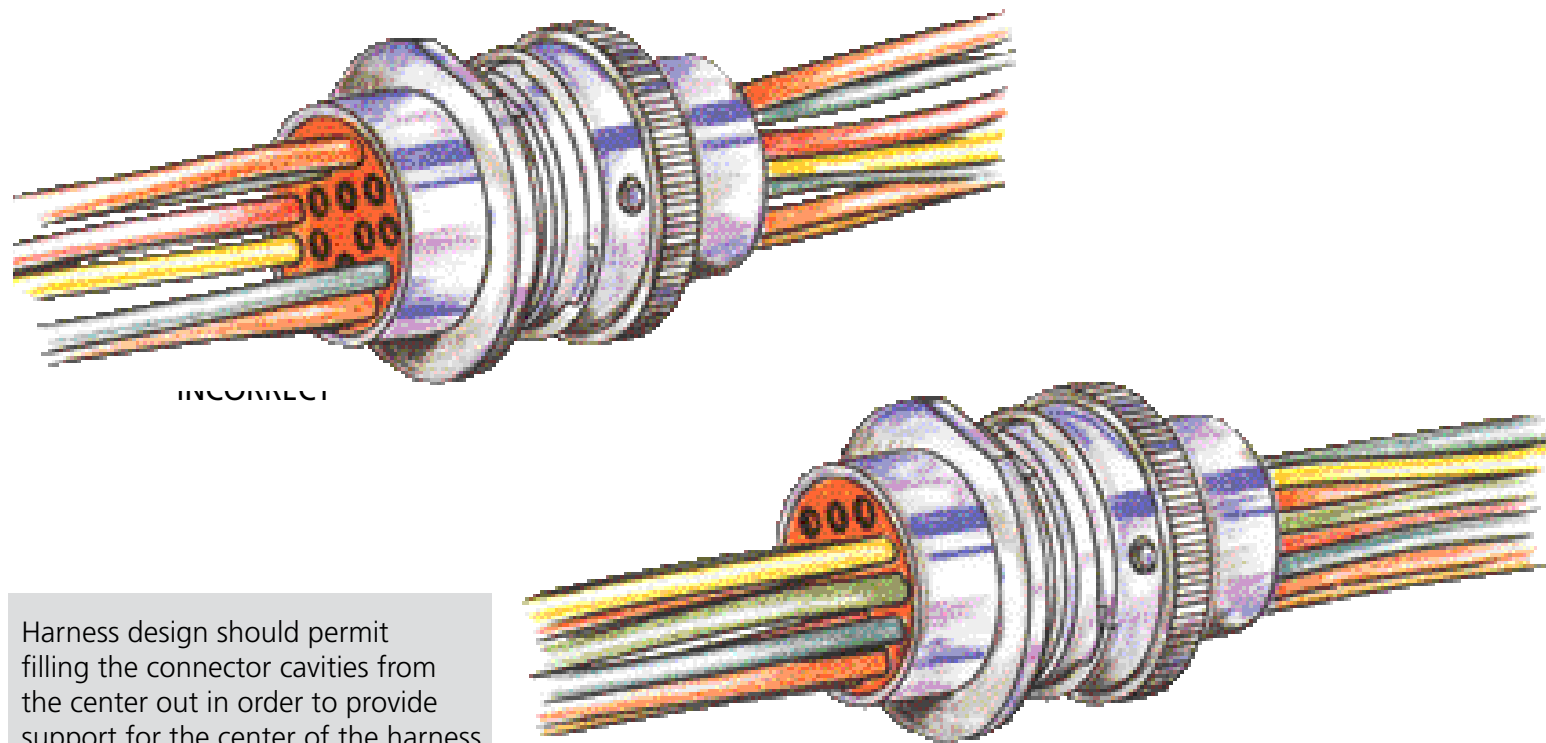
INCORRECT

CORRECT

3" MIN

Tie wraps and tape away from the rear of the connector will allow the wire to be sealed properly.

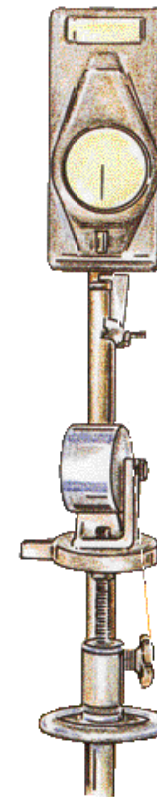
HELPFUL HINTS



INCORRECT

Harness design should permit filling the connector cavities from the center out in order to provide support for the center of the harness and to allow easier connector assembly.

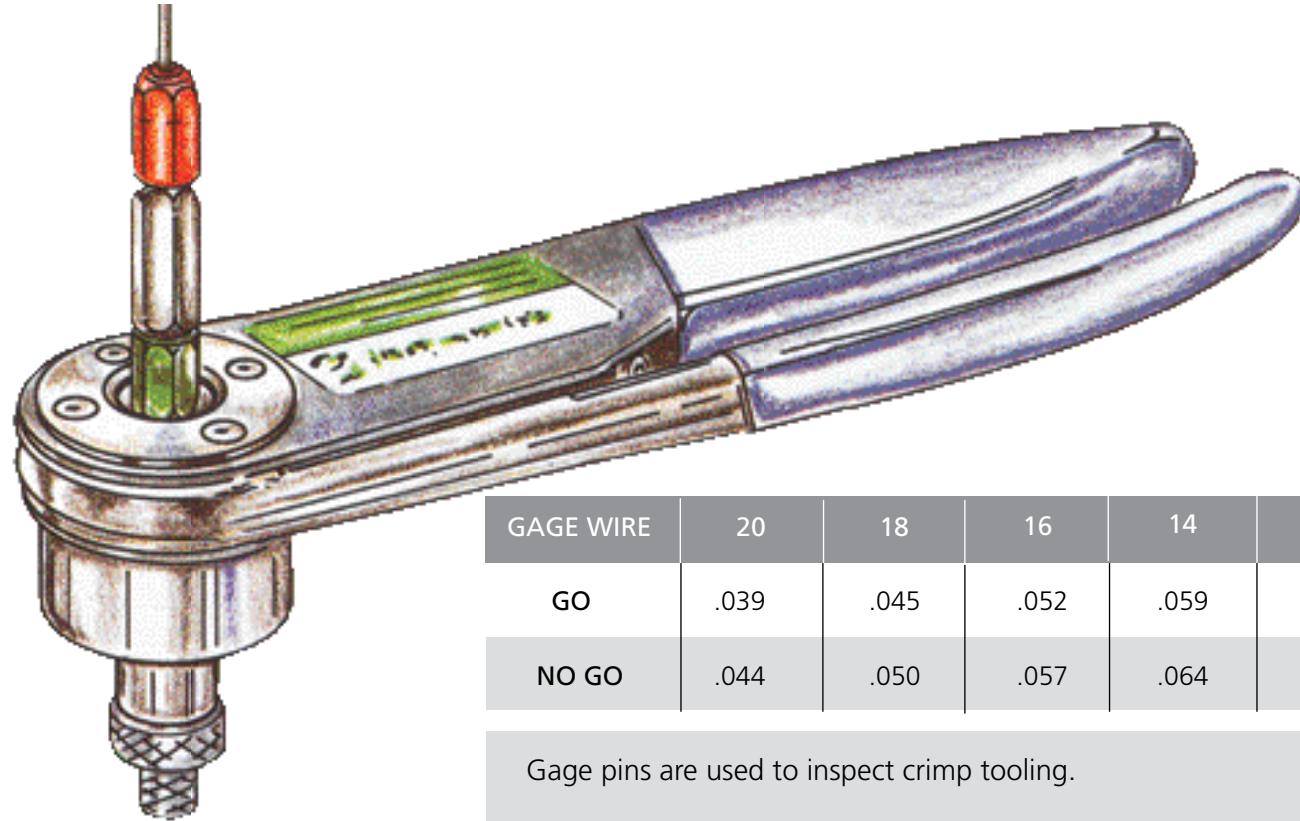
HELPFUL HINTS



CORRECT SIZE	WIRE SIZE	MINIMUM TENSILE (lbs.)	TYPICAL TENSILE (lbs.)
20	20	20	25
16	18	25	32
16	16	25	50
16	14	25	58
12	14	70	100
12	12	70	125

A crimp tensile test easily and rapidly identifies a proper crimp.

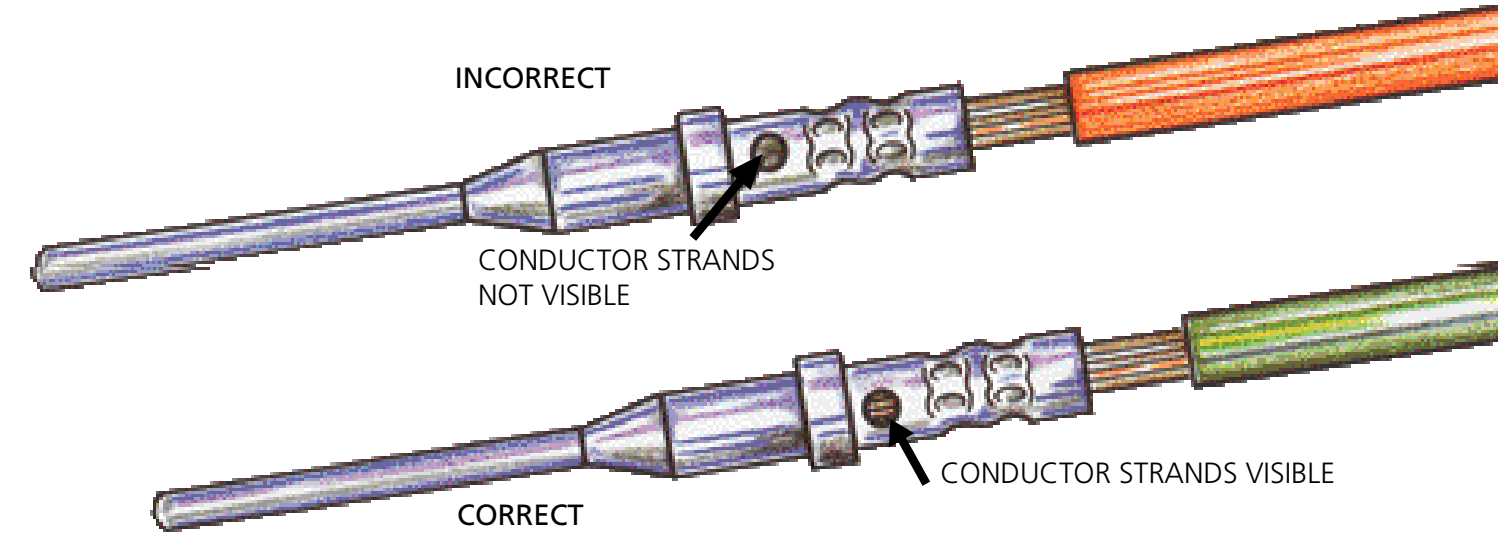
HELPFUL HINTS



GAGE WIRE	20	18	16	14	12
GO	.039	.045	.052	.059	.068
NO GO	.044	.050	.057	.064	.073

Gage pins are used to inspect crimp tooling.

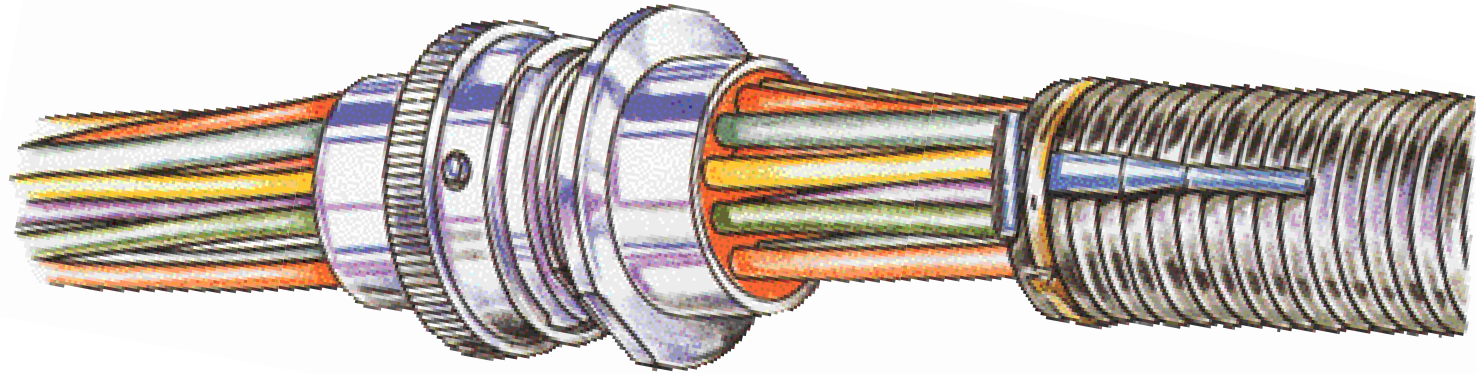
HELPFUL HINTS



An inspection hole is provided to inspect proper strip length.

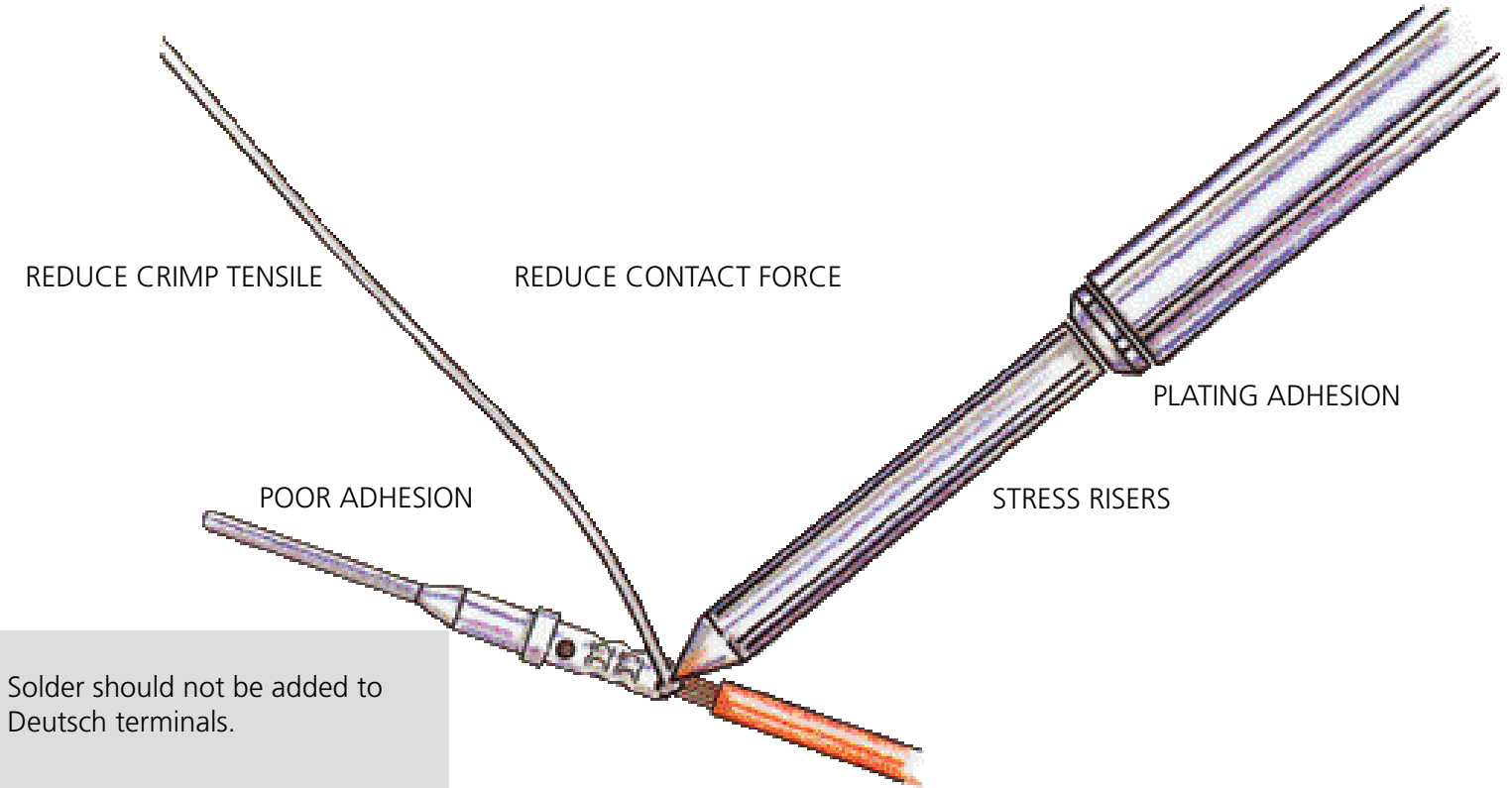
		STRIP LENGTH				
CONTACT SIZE		4	8	12	16	20
MIN		.430	.430	.222	.250	.156
MAX		.492	.492	.284	.312	.218

HELPFUL HINTS



A contact removal tool taped or tie wrapped to the harness will make it easily available should repairs be needed.

HELPFUL HINTS



Solder should not be added to Deutsch terminals.