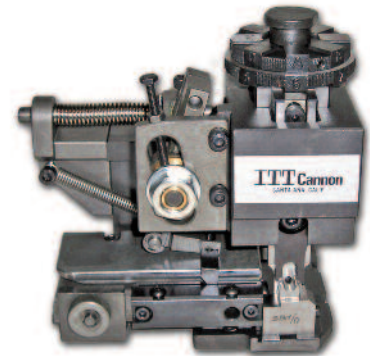


A key feature of the Cannon DL connector series is easy contact termination, both in the field and in high-volume production. An ergonomically designed hand crimp tool is available for the low volume (loose contact) applications and will accommodate two different crimp contact sizes. To reduce overall costs, the crimp jaws are replaceable.

Automatic crimp and strip/crimp machines are available for high volume applications requiring a large number of crimps (50,000 crimps per year or more). These machines are leased to customers to eliminate the need for heavy investment. They also improve productivity for large pin count applications.

DL Crimp contacts are designed to be hand installed into the connector, no tooling is needed for the insertion process. Extraction tools are available for the removal of Crimp contacts for easy repair even in field applications. Extraction tools are also available for the Buss contacts, as well as the factory installed Square Post contacts.



## Hand Crimp Tool



Hand Crimp Tool with Replaceable Jaw Set

| Hand Tool | Description | Part Number |
|-----------|-------------|-------------|
| 1         | CHDLT 28-32 | 112108-0002 |
| 2         | CHDLT 20-26 | 112108-0001 |
| 3         | CHDLT 18-20 | 112108-0000 |

## Crimp Tensile Strength

Crimp tensile strength is a measure of how hard a wire can be pulled without breaking or separating from the contact. This is the best way to verify that the wire is properly terminated to the contact. Periodic crimp tensile measurements are recommended to insure the integrity of the crimp. The table below contains the appropriate values for DL crimp contacts.

Wire Trim Dimension



| Wire Size (AWG)         | 32          | 30          | 28          | 26          | 24          | 22          | 20          | 18          |
|-------------------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Tensile Min. (lbs)      | 1           | 1.5         | 3           | 7           | 10          | 15          | 19          | 30          |
| Wire Trim Dimension "A" | 3,30 (.130) | 3,30 (.130) | 3,30 (.130) | 3,30 (.130) | 3,30 (.130) | 3,30 (.130) | 4,06 (.160) | 4,06 (.160) |
| Insulation Dia. Max     | 1,35 (.053) | 1,35 (.053) | 1,35 (.053) | 1,65 (.065) | 1,65 (.065) | 1,88 (.074) | 1,88 (.074) | 1,88 (.074) |

### Extraction Tool - Buss Contacts



#### Extraction Tool for Buss Contact

| Description | Contacts | Part Number         |
|-------------|----------|---------------------|
| CET-DL3     | 1 pair   | <b>274-7029-003</b> |
| CET-DL4     | 2 pair   | <b>274-7029-004</b> |
| CET-DL4     | 3 pair   | <b>274-7029-004</b> |
| CET-DL5     | 4 pair   | <b>274-7029-005</b> |
| CET-DL6     | 5 pair   | <b>274-7029-006</b> |
| CET-DL6     | 6 pair   | <b>274-7029-006</b> |

### Extraction Tool - Crimp, Square Post, PC/RC Contacts

CET-DL10

CET-ECP

CET-ECP-1



| Description | Part Number         | Contact Type | PC Tail Extension |
|-------------|---------------------|--------------|-------------------|
| CET-DL10    | <b>274-7029-007</b> | Crimp        | -                 |
| CET-ECP     | <b>274-7045-000</b> | Wrap Post    | 15,37 (.605)      |
| CET-ECP-1   | <b>274-7045-001</b> | Square Post  | 7,11 (.280)       |

### Assembly Instructions for Crimp Contacts

#### Contact Insertion:

All crimp contacts inserted by hand. No tooling is required for either the plug or receptacle.

**Caution:** Do not force contacts into contact cavities. If contact encounters excessive resistance during installation remove and re-insert using a slight up and down motion. This will assure positive cavity alignment. *Do not* install contact if plug is in the *closed* or *actuated* position.

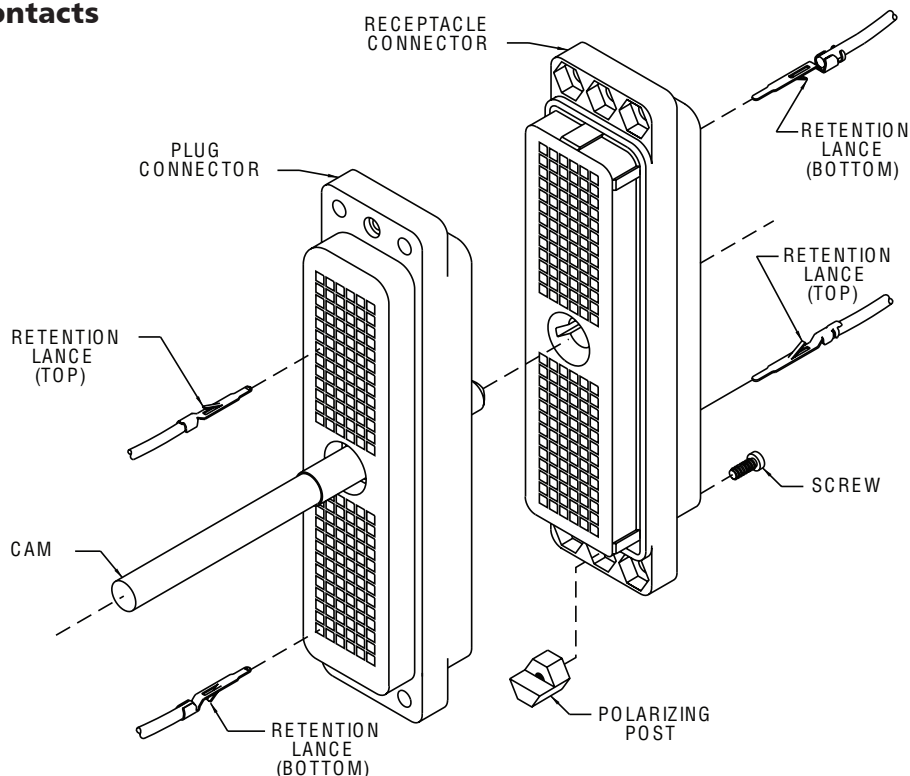
#### Plug:

Step 1. Prior to inserting contacts, turn the shaft counter-clockwise to its maximum *open* position.

Step 2. With the retention lance positioned away from the shaft, insert contacts from the rear of the contact plug.

#### Receptacle:

Step 1. With the retention lance positioned toward the shaft hole, insert contacts from the rear of the receptacle.

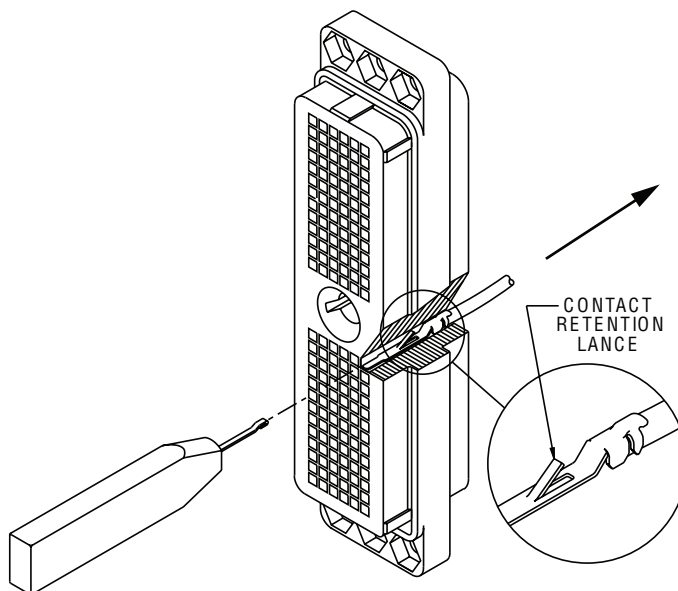


### Contact Removal for Crimp Contacts

#### Tool: CET-DL10



Release retention lance by inserting tip of extraction tool into cavity until it bottoms on insulator shoulder. Gently pull wire in direction of arrow, see illustration, to remove contact from insulator.



### Assembly Instructions for Buss Contacts

#### Contact Insertion:

All buss contacts are inserted by hand. No tooling is required for either the plug or receptacle.

**Caution:** Do not force contacts into contact cavities. If contact encounters excessive resistance during installation remove and re-insert using a slight up and down motion. This will assure positive cavity alignment. *Do not* install contact if plug is in the *closed* or actuated position.

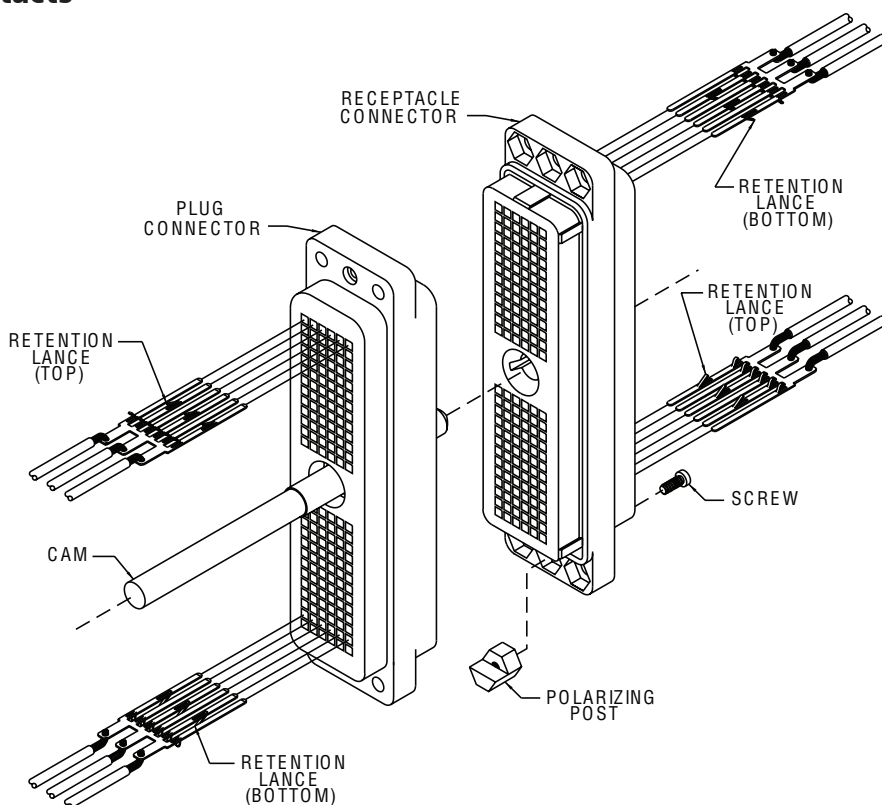
#### Plug:

Step 1. Prior to inserting contacts, turn the shaft counter-clockwise to its maximum *open* position.

Step 2. With the retention lance positioned away from the shaft, insert contacts from the rear of the contact plug.

#### Receptacle:

Step 1. With the retention lance positioned toward the shaft hole, insert contacts from the rear of the receptacle.



### Contact Removal for Buss Contacts

**Tool:** CET-DL3/4/5/6



Release retention lance by inserting tip of extraction tool into cavity until it bottoms on insulator shoulder. Gently remove buss contact in direction of arrow, see illustration, to remove contact from insulator.

