

**TERMINAL CRIMPER FOR DEUTSCH 6, 8 & 10 GAGE**  
**CLOSED BARREL TERMINALS**  
**(CONTACT SIZES 4 & 8)**

**Instructions to use:**

1. Strip wire to proper length.
2. Be sure the proper Die Set for the terminals being crimped is installed in the crimper head. The Cat. No. 18873, Die Set is for 6 gage wire (Contact Size 4) and the Cat. No. 18874, Die Set is for 8 & 10 gage wire (Contact Size 8). To change Die Sets, see below.
3. After opening the handles, position the terminal into the Die Set.
4. Slightly close the crimper until there is sufficient tension to hold the terminal in place.
5. Slide the stripped wire to the proper length into the barrel side of the terminal. Be sure all the strands are in the barrel.
6. Squeeze the handle tightly together until the crimp is completed.
7. Examine the crimped terminal to be sure the wire was inserted the proper distance into the terminal and all the strands are in good condition.

**To change Die Sets:**

The crimper comes with the Cat. No. 18873, Die Set for 6 gage wire (Contact Size 4) installed. To crimp 8 & 10 gage wire (Contact Size 8), the Cat. No. 18874, Die Set must be used. To change the Die Set, please follows these steps:

1. Unscrew the hex nuts from the bolts in the head assembly. Remove the washers, then pull the bolts out from the front side of the crimper (To remove the bolts, the handles must be in a midway position between open and closed).
2. Slide each half of the Die Set up and off from the head assembly.
3. Slide each half of the new Die Set down and onto the head assembly. The half circles must face each other and the angled corner must be on the inside.
4. Align the holes, then insert the bolts from the front side of the crimper (To insert the bolts, the handles must be in a midway position between open and closed).
5. Install the washers and tighten the hex nuts onto the bolts.