

# CIRCULAR INDENT HAND CRIMP TOOL GS100-1

**DMC** DANIELS  
MANUFACTURING  
CORPORATION

## DATASHEET

THIS HAND TOOL MUST NOT BE USED IN ANY POWERED "PRESS" AS DEFINED BY OSHA CFR 1910.211 (46)

SEE REVERSE SIDE FOR IMPORTANT INFORMATION CONCERNING LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

### HOW TO USE THE DANIELS GS100-1 HAND CRIMP TOOL & POSITIONER

#### GENERAL INFORMATION

1. Designation GS100-1 (M22520/4-01) refers to the hand crimp tool only. It is used with GP295 (M22520/4-02) Positioner.
2. The tool has a double acting ratchet. Note that the tool cannot be opened without completing the cycle.
3. The GS100-1 has a single die closure which produces a circular crimp on the outer ferrules of M2430B/14 and /15 shielded contacts, as well as many MIL-C-38999 and proprietary contacts.

#### INSTALLATION OF POSITIONER

1. Tool must be in open position.
2. Place Positioner onto retainer ring with socket head screws lined up with tapped holes.
3. After Positioner is seated against retainer ring, tighten socket head screws with 9/64 inch socket head screw key.

#### CRIMPING INSTRUCTIONS

1. Insert contact and prepared wire through the indenter opening into Positioner.
2. Squeeze handles together until ratchet releases. Handle will return to open position. Rotate crimped contact 45° and crimp again. Remove crimped assembly.

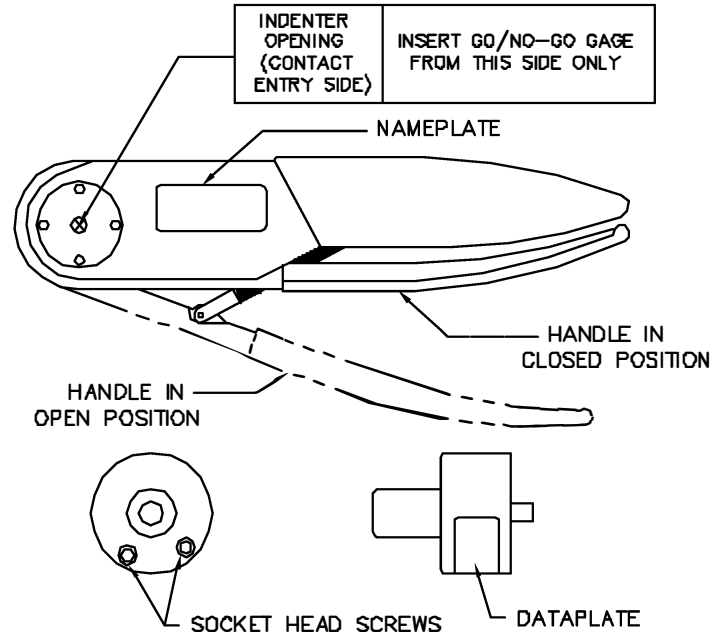
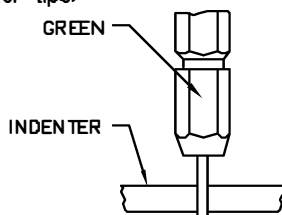
#### REMOVING POSITIONER

1. Loosen socket head screws until threads are disengaged from positioner guide and remove with a straight lifting motion.

#### GAGING INSTRUCTIONS

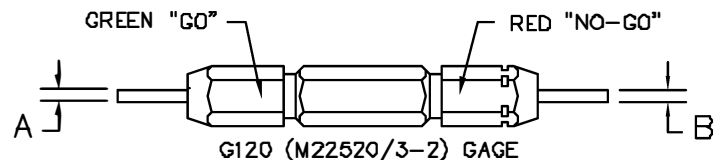
##### "GO" GAGING

Operate tool to fully closed position. Maintain firm hand pressure on the tool handles. Insert "GO" gage end as shown. Gage must pass freely between indenter tips.



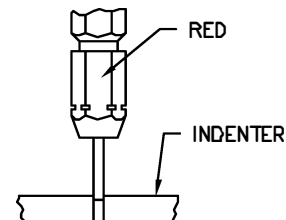
DANIELS CATALOG NUMBERS		
DESCRIPTION	MILITARY P/N	DANIELS P/N
CRIMP TOOL	M22520/4-01	GS100-1
POSITIONER ONLY	M22520/4-02	GP295
INSPECTION GAGE	M22520/3-2	G120

GAGE PART NO.	A GO DIA	B NO-GO DIA	CRIMP TOOL
G120	.0960	.1000	GS100-1



##### "NO-GO" GAGING

Operate tool to fully closed position. Maintain firm hand pressure on the tool handles. Insert "NO-GO" gage end as shown. The "NO-GO" gage may partially enter the indenter opening, but must not pass completely through the opening.



**CAUTION!**  
DO NOT CRIMP GAGE!

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### CARE OF TOOL

There is virtually no maintenance required. However, it is a good practice to keep indenter tips free of residual color band deposits and other debris. A small wire brush may be used for this purpose.

We strongly recommend that you:

1. DO NOT immerse tools in cleaning solution.
2. DO NOT spray oil into tool to lubricate.
3. DO NOT attempt to disassemble tool or make repairs.

This is a precision hand crimping tool and should be handled as such.

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 or 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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