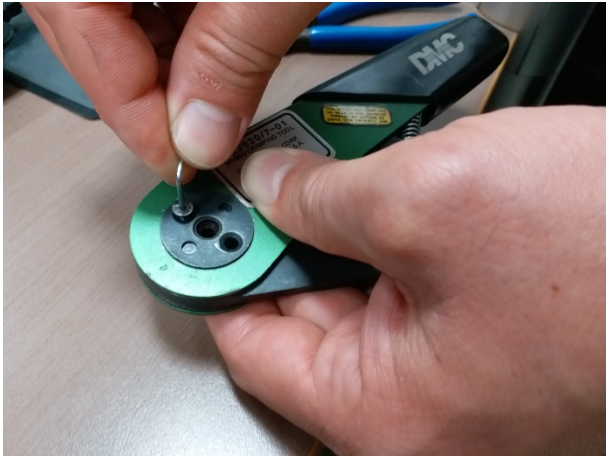


Crimping terminals

Step 1: Un-screw DMC MH860's positioner frame



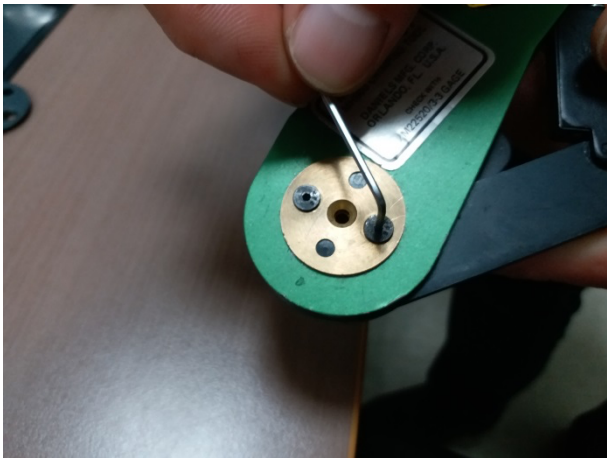
Step 2: take the DMC MH860's positioner frame out



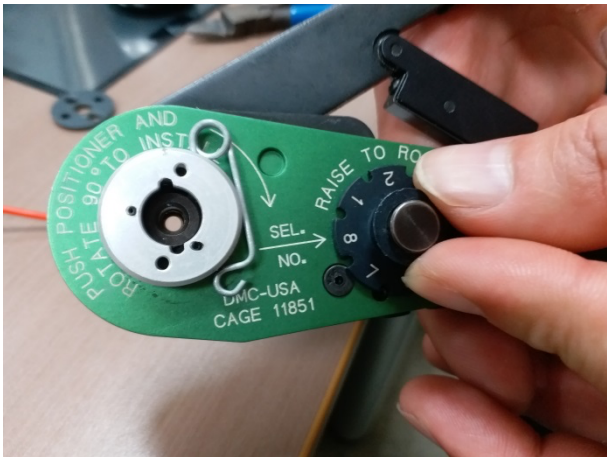
Step 3. Replace DMC MH860's positioner frame with GTC custom positioner



Step 4. Install the screws of the positioner



Step 5. Adjust the rotary dial per below chart



Crimping chart

	Wires (AWG)	Terminals pull force (KGF)	Rotary dial	DMC model
58000-X2001	28	1 · 25—2 · 5	2	MH860
	26	2 · 5—3 · 5	2	MH860
	24	3 · 5—5 · 0	3	MH860
58000-X2002	24	3 · 5—5 · 0	3	MH860
	22	5 · 0—8 · 0	3 or 4	MH860
	20	8 · 0—12 · 0	4	MH860
	18	12 · 0—20 · 0	5	MH860
58000-X2003	18	12 · 0—20 · 0	5	MH860

Step 6. Insert the bare wires to terminals



Step 7. Insert terminals with wires into crimping tool and engage

