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DEUTSCH Common Contacts Overview

Several contacts are used interchangeably across most DEUTSCH connector product lines. This commonality improves performance, reliability, and maintainability by reducing changes in the assembly of the wire harness. The use of the same contact system helps eliminate many of the failures reported in harnesses where hundreds of different terminations are used.

CONTACT STYLES

Two styles of contacts are available: solid and stamped & formed. Both contact types use a crimp style termination, eliminating the need for solder. The variations in the contact system are those dictated by wire gauge and contact style.

Solid

The solid contacts are designed for use with larger wire size and heavy duty applications. Solid contacts are manufactured using a cold heading process with solid copper alloy wire and are available with either a nickel or gold plating finish.

Solid contacts terminate wire from 4 AWG to 20 AWG (25 - 0.5mm²) and are available in 5 sizes each of the pin and socket. The applicable contact is determined by the size of the conductor only.



Stamped & Formed

Stamped & formed contacts are designed for use where wire termination costs are of primary concern without sacrificing reliability of electrical circuits. The stamped & formed contacts are made on a precision stamping machine using flat strip stock, then a durable and corrosion proof nickel, tin, or optional gold plating is applied.

The stamped & formed style contacts terminate wire from 10 AWG to 22 AWG (6.0 - 0.35mm²) and are available in multiple sizes to accommodate a wide range of wire insulation. The specific contact is determined by the outside diameter of wire insulation and conductor size.



DEUTSCH Common Contacts

DEUTSCH CONTACT PERFORMANCE SPECIFICATIONS

Durability

No electrical or mechanical defects after 100 cycles of engagement and disengagement.

Current Rating (Contact current rating at 125° C continuous)

Contact Size	Max. Current
Size 20	7.5 amps
Size 16	13 amps
Size 12	25 amps
Size 8	60 amps
Size 4	100 amps

Contact Retention (Solid and Stamped & Formed)

Contacts withstand a minimum load of:

- 20 lbs (89 N) for size 20
- 25 lbs (111 N) for size 16
- 30 lbs (133 N) for size 12
- 35 lbs (156 N) for size 8
- 35 lbs (156 N) for size 4

Contact Millivolt Drop

Contact Size	Test Current Amps	Millivolt Drop* (Solid)	Millivolt Drop* (S&F)
20	7.5	60	100
16	13	60	100
12	25	60	100
8	60	60	-
4	100	60	-

*Less drop through wire

Crimp Tensile Strength (Solid)

Contact Size	Tensile Strength
Size 20	20 lbs
Size 16	25 lbs
Size 12	70 lbs
Size 8	90 lbs
Size 4	300 lbs

Crimp Tensile Strength (Stamped & Formed)

Contact Size	Tensile Strength
Size 20	20 lbs
Size 16	25 lbs
Size 12	70 lbs

helpful hint

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



DEUTSCH Common Contacts

SOLID CONTACT PART NUMBERS

Size	Solid Contact Part Numbers		Wire Size AWG (mm ²)	Recommended Strip Length Inches (mm)	Min. Contact Retention	Ref Crimp Tensile Lbs. (N)	Max Rated Amps at 125° C Continuous
	Pin	Socket					
20	0460-202-20**	0462-201-20**	20 (0.50)	.156-.218 (3.96-5.54)	20 (89)	20 (89)	7.5
20	0460-010-20**	0462-005-20**	16-18 (1.0-0.75)	.156-.218 (3.96-5.54)	20 (89)	20 (89)	7.5
16	0460-202-16**	0462-201-16**	16-20 (1.5-0.50)	.250-.312 (6.35-7.92)	25 (111)	35-20 (156-89)	13
16	0460-215-16**	0462-209-16**	14 (2.0)	.250-.312 (6.35-7.92)	25 (111)	70 (311)	13
12	0460-204-12**	0462-203-12**	12-14 (3.0-2.0)	.222-.284 (5.64-7.21)	30 (134)	75-70 (334-311)	25
8	0460-204-08**	0462-203-08**	8-10 (10.0-5.0)	.430-.492 (10.92-12.50)	35 (156)	125-90 (556-400)	60
4	0460-204-04**	0462-203-04**	6 (16.0-13.0)	.430-.492 (10.92-12.50)	35 (156)	300 (1334)	100
4 (C038)	5960-203-04141	5962-203-04141	4 (25.0-21.0)	.430-.492 (10.92-12.50)	35 (156)	300 (1334)	100

** = Plating codes

Solid Contact Plating Codes

Part Number Suffix	Plating Material
31	Gold
90	Nickel (size 4 pin only)
141	Nickel

Note

See information drawing
0425-015-0000.



DEUTSCH Common Contacts

STAMPED & FORMED CONTACT PART NUMBERS

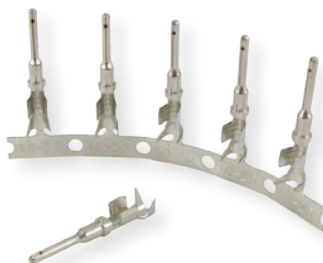
Size	S&F Contact Part Numbers		Carrier Strip	Wire Size AWG (mm ²)	Wire Insulation O.D. Range	Recommended Strip Length Inches (mm)	Min. Contact Retention	Max Rated Amps at 125° C Continuous
	Pin	Socket						
20	1060-20-01**	1062-20-01**	20-01	16-22 (1.5-0.35)	.075-.125 (1.91-3.18)	.150-.200 (3.81-5.08)	20 (89)	7.5
20	1060-20-02**	1062-20-02**	20-02	16-22 (1.5-0.35)	.051-.085 (1.30-2.16)	.150-.200 (3.81-5.08)	20 (89)	7.5
20	-	1062-20-03** sleeveless	20-03	16-22 (1.5-0.35)	.075-.125 (1.91-3.18)	.150-.200 (3.81-5.08)	20 (89)	7.5
20	1060-20-06**	1062-20-06**	20-06	14-16 (2.5-1.0)	.075-.125 (1.91-3.18)	.150-.200 (3.81-5.08)	20 (89)	7.5
16	1060-14-01**	1062-14-01**	14-16	14-18 (2.0-.75)	.095-.150 (2.41-3.81)	.150-.200 (3.81-5.08)	25 (111)	13
16	1060-14-10**	1062-14-10**	14-16	14-18 (2.0-.75)	.095-.150 (2.41-3.81)	.150-.200 (3.81-5.08)	25 (111)	13
16	1060-16-01**	1062-16-01**	16-18	14-18 (2.0-.75)	.075-.140 (1.90-3.55)	.150-.200 (3.81-5.08)	25 (111)	13
16	1060-16-06**	1062-16-06**	0.5-1.0	16-20 (1.0-.50)	.055-.100 (1.40-2.54)	.150-.200 (3.81-5.08)	25 (111)	13
16	1060-16-09**	1062-16-09**	16-18	14-18 (2.0-.75)	.075-.140 (1.90-3.55)	.150-.200 (3.81-5.08)	25 (111)	13
16	1060-16-12**	1062-16-12**	1.0-2.5	12-16 (2.5-1.0)	.075-.140 (1.90-3.55)	.175-.225 (4.45-5.72)	25 (111)	13
16	-	1062-16-14** sleeveless	14-16	12-16 (2.5-1.0)	.075-.140 (1.90-3.55)	.175-.225 (4.45-5.72)	25 (111)	13
12	1060-12-01**	1062-12-01**	12-14	12-14 (4.0-2.0)	.113-.176 (2.87-4.47)	.225-.275 (5.72-6.99)	30 (134)	25
12	1060-12-02**	1062-12-02**	10-12	10 [†] (6.0-4.0)	.140-.204 (3.56-5.18)	.225-.275 (5.72-6.99)	30 (134)	25

** = Plating codes

† = TXL wire insulation is preferred

S&F Contact Plating Codes

Part Number Suffix	Plating Material
22	Nickel
44	Gold
66	Tin/Nickel
77	Tin
88	Selective Gold



Note

See information drawing 0425-015-0000.

DEUTSCH Common Contacts

PCB PINS

Straight reduced diameter extended pins are available for installation in the DEUTSCH family of connectors. The use of removable contacts provides design flexibility and a low cost alternative to meet application needs. These solid copper alloy pins may be specified in various platings and assembled in HD30, HDP20, HD10, DRC, or DT receptacles.

Material

Copper alloy

Plating Codes

31: Gold

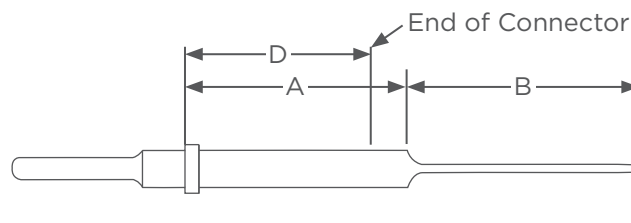
90: Tin

141: Nickel



PCB Mounting

Consult factory for PCB mounting details and pin positions.



Note

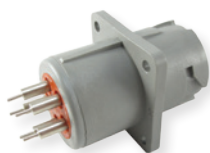
See information drawing 0425-202-0000 for full specifications.

Contact Size

Contact Size	Part Number	A	B	C	Series	D*
20	0460-208-2031	1.305 (33.15)	.248 (6.30)	.025 (.64)	HD30/HDP20	.939 (23.85)
	0460-208-2090	1.305 (33.15)	.248 (6.30)	.025 (.64)	HD10	.925 (23.50)
16	0460-208-16141	1.300 (33.02)	.248 (6.30)	.025 (.64)	DT	.777 (19.74)
	0460-208-1631	1.300 (33.02)	.248 (6.30)	.025 (.64)	DT04-2P	.677 (17.20)
	0460-229-16141	.545 (13.84)	.248 (6.30)	.025 (.64)	DT04-3P	.677 (17.20)
	0460-241-16141	1.305 (33.15)	.160 (4.06)	.040 (1.02)	DRC	1.063 (27.00)
	0460-244-16141	.976 (24.79)	.400 (10.16)	.041 (1.04)		
	0460-244-1631	.976 (24.79)	.400 (10.16)	.041 (1.04)		
12	0460-208-12141	1.305 (33.15)	.248 (6.30)	.025 (.64)		
	0460-245-1231	1.024 (26.01)	.500 (12.70)	.041 (1.04)		
	0460-245-1290	1.024 (26.01)	.500 (12.70)	.041 (1.04)		

*D is equal to the distance from the contact shoulder to the end of the connector.

Dimensions are for reference only.



HD10 Series



HDP20 Series



HD30 Series

Crimping

Crimping is defined as the act of joining a conductor to a pin or socket contact using a mechanical tool to compress and displace metal. In a good crimp joint, there is mutual flow of metal, causing a symmetrical distortion of wire strands.

CRIMPING CONFIGURATIONS

Stamped & formed contacts use a folded type of crimp (Fig. 1) while solid contacts use a 1, 2, or 4 indent crimp (Fig. 2). In both styles of crimps, the wire strands and the contact material are formed together in a solid mass creating a reduction of the wire strand area. The reduced wire strand area creates a minimum of voids allowing for excellent conductivity. Crimping may be accomplished with hand tools or power tools.

BENEFITS OF CRIMPED CONTACTS

Mechanically crimping contacts is the leading wire termination method for some very good reasons:

- With smaller wire, the crimp is as strong as the wire itself.
- The joint can be visually inspected. Viewing the wire through an inspection hole in the contact makes inspection quick and easy, both by the operator and the inspector.
- Plating thickness is not restricted, as in solder joints, so better corrosion resistance and contact reliability are achieved.
- Crimping can be done anywhere, without special preparation. Terminations are replaced or modified in the field exactly the same as in the shop, using the same tools and the same techniques, and with the same ease of operation and certainty of results.
- Total installed and maintenance costs are lower.

helpful hint

Solder should not be added to DEUTSCH terminals.



Stamped & Formed Style



Cross-Section Across Axis

Figure 1

Solid Style



Indenter Crimp
Cross-Section Across Axis

Figure 2

Note

The use of dielectric grease is not recommended.

CRIMP INSPECTION

Crimping tools provide lower total installation and maintenance costs. However, controls are required to help confirm that the proper crimp tools designed for the type and size contact are used, the pin or socket is properly inserted into the tool, the wire insulation is stripped properly, and the wire fully inserts into the contact.

When a crimp is completed, correct termination can be visually inspected. The inspector should check for:

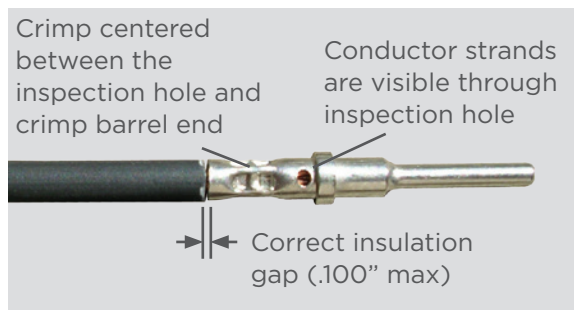
- The removed insulation should expose a conductor length that will pass beyond the inspection hole in the contact and still reveal the appropriate length of conductor between the contact and the insulation on the wire.
- Wire strands intact.
- All wire strands enter the contact barrel.
- Wire inserted to the proper depth in the contact.

When the correct crimp tool and process are used, a good termination results.

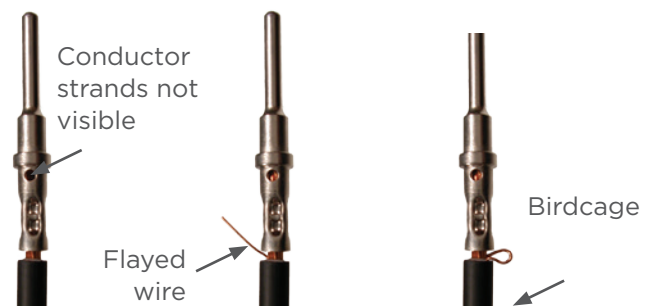
Note

For more detailed crimp dimensions please request a drawing.

SOLID CONTACT CRIMP

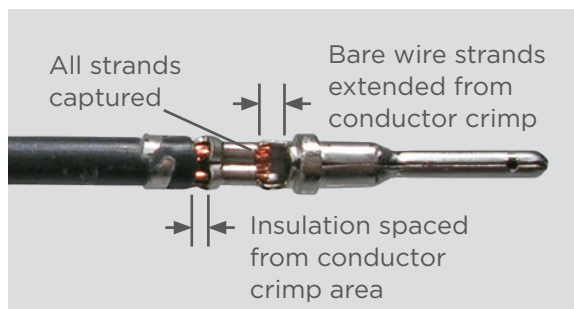


Acceptable Crimp

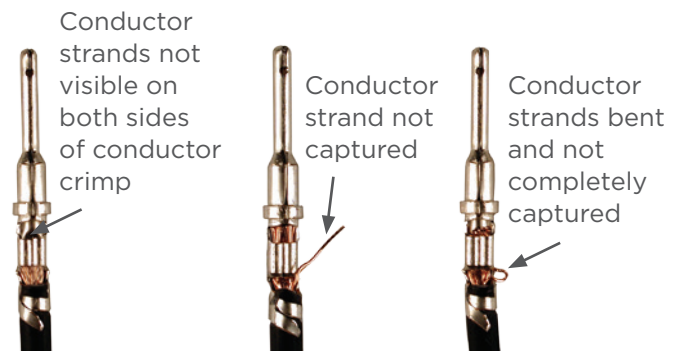


Unacceptable Crimps

STAMPED & FORMED CONTACT CRIMP



Acceptable Crimp



Unacceptable Crimps

DEUTSCH Common Contacts

Accessories

Additional accessories are available to aid in the design flexibility and sealing requirements of applications. Accessory items such as sealing plugs and keying pins help to maintain an environmental seal and prevent mis-mating.

KEYING PINS

Keying pins are solid plastic rods used to help prevent mis-mating of like connectors in close proximity. Applicable DEUTSCH product lines include HD10, HD30, HDP20, DT, and DTM series.

Keying pins are inserted into the retention fingers of an empty socket cavity. Once installed, the keying pin blocks a mating contact pin from being inserted. The contact pin will be blocked before the coupling device mates the connectors, helping to prevent the mis-mating of like connectors. Proper usage requires that the corresponding mating pin be omitted and a sealing plug inserted in the rear cavity of the mating connector. Individual applications will vary, and testing should be done to determine the best pattern arrangement to help prevent improper connector mating.



Part Number	Contact Size	Color
0413-216-2005	20	Red
0413-215-1605	16	White
0413-214-1205	12	Yellow

Note

Multiple keying pins may be required to help prevent unintentional forced mating.

CONTACT CRIMP SLEEVE REDUCER

A crimp sleeve reducer is available to allow DEUTSCH size 4 solid contacts to accept 8-10 AWG wire. When populating a connector using a contact with a reducer sleeve, be sure the insert seal penetrates the rear grommet. The use of the crimp sleeve reducer requires no extra crimp tools and provides an easy transition and increased flexibility.



Insert Seal
0410-241-0406



Crimp Sleeve
0421-203-04141

Note

TXL wire insulation with 10 AWG is not recommended because it may not provide an environmental seal against the insert seal.

SEALING PLUGS

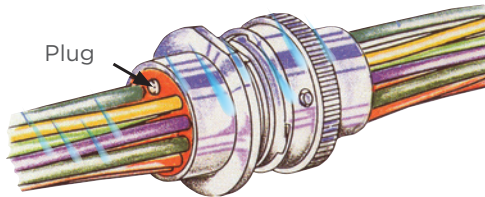
Open cavities provide pathways for contaminants to enter the connectors. To maintain seal integrity, any unused cavity must be filled with the appropriate size sealing plug.



Part Number	Contact Size	Description
114019	Size 4	Silicone rubber
114018	Size 8	Thermoplastic
114017	Size 12, 16	Thermoplastic
0413-217-1605 (locking sealing plug)	Size 16	Thermoplastic, retained by locking fingers
0413-003-1605	Size 16	Thermoplastic, used with STRIKE series
0413-204-2005	Size 20	Thermoplastic

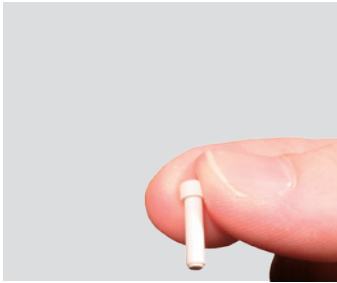
helpful hint

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



How To Instructions

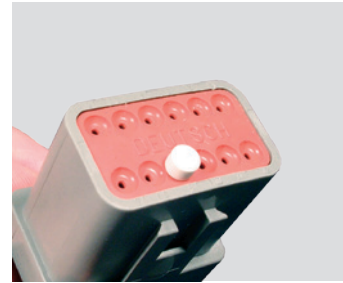
SEALING PLUG INSTALLATION



Step 1:
Holding the sealing plug with large diameter end away from the connector, gently apply downward pressure to force the sealing plug into the cavity.

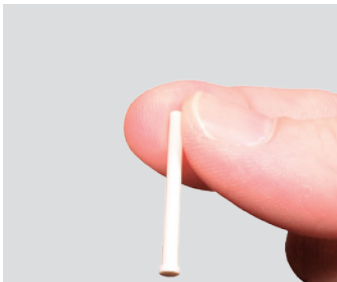


Step 2:
With perpendicular motion, apply downward pressure to the large diameter end of the sealing plug.

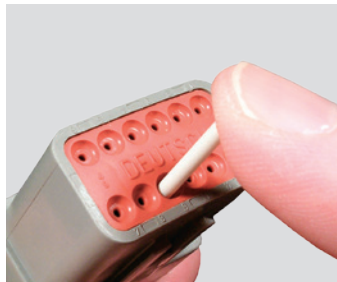


Step 3:
Apply pressure until sealing plug is forced to stop by contact with rear grommet. Visually inspect the sealing plug to confirm it is flush with cavity opening.

LOCKING SEALING PLUG INSTALLATION



Step 1:
Holding the sealing plug with large diameter end towards the connector, gently apply downward pressure to force the sealing plug into the cavity.



Step 2:
With perpendicular motion, apply downward pressure to the small diameter end of the sealing plug.

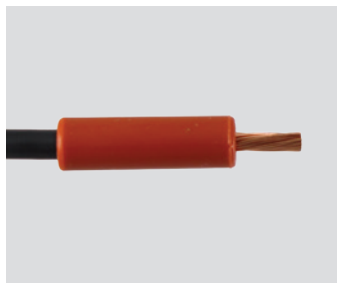


Step 3:
Apply pressure until sealing plug locks into place. A slight tug on the sealing plug will confirm it is locked into place.

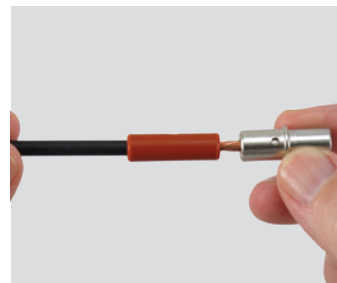
CONTACT CRIMP SLEEVE REDUCER ASSEMBLY



Step 1:
Place crimp sleeve reducer into contact barrel.



Step 2:
Slide insert seal onto 8-10 AWG wire stopping just at the edge of the stripped insulation.



Step 3:
Insert wire into barrel of contact and crimp using designated tooling.



Step 4:
Confirm seal is not distorted.