

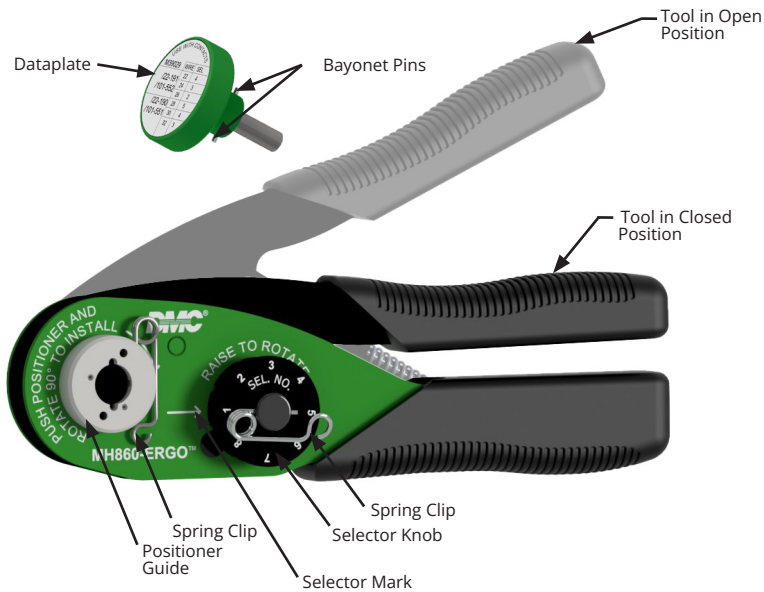
MH860-ERGO™

Instruction Manual



DMC **DANIELS**®
MANUFACTURING
CORPORATION

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GENERAL INFORMATION

This instruction manual provides technical information for the MH860-ERGO™ (M22520/7-01) which is a manual indent crimp tool designed for precision and reliability in wire termination applications. Built on the legacy of the original MH860®, the MH860-ERGO introduces ergonomic enhancements to reduce fatigue while optimizing mechanical efficiency. The MH860-ERGO contains four symmetrically arranged precision indenters to ensure uniform crimping. A positive ratchet mechanism guarantees the completion of the full crimp cycle before the tool can be reopened, promoting consistent performance and process integrity. Selector settings allow the user to control the depth of the indenters, accommodating a range of contact and wire sizes. The MH860-ERGO is suitable for use in high-reliability environments where consistent, repeatable crimps are critical.

Crimp Application	Machined Contacts
Crimp Range	32 to 16 AWG
Power Supply	Manual
Ratchet Configuration	Full-cycle, not releasable
Positioner Type	86 Positioners
Dimensions L X W X H	7.5" x 2.4" x .8"
Weight	10 oz

INSTALLATION / REMOVAL OF ACCESSORIES

POSITIONER INSTALLATION

1. Squeeze the handles to open the tool and remove the spring clip from the positioner guide. (Fig. 1)
2. Line up the bayonet pins with the slots in the positioner guide and insert the positioner. (Fig. 2)
3. Push down and rotate 90 degrees clockwise until the bayonet pins lock. Replace the clip in the positioner guide. (Fig. 3)



Fig. 1



Fig. 2



Fig. 3

POSITIONER REMOVAL

1. Squeeze the handles to open the tool and remove the spring clip.
2. Push down on the positioner to release the bayonet pins from the positioner guide.
3. Rotate 90 degrees counter-clockwise and remove the positioner from tool. Replace the spring clip in the positioner guide.

HOW TO READ A POSITIONER

Technicians must take into consideration contact part number and wire size when crimping contacts in order to determine the correct selector setting. Smaller selector settings create a tighter crimp.

1. Identify the contact you want to crimp.

USE WITH CONTACTS

	WIRE				SEL
	22	24	26	28	
M39029					
/58-362	3	2	1		
/58-361		3	2	1	
/58-360					
/87-470 THRU -473					
/107-620, /118-644	3	2	1	1	
/118-650, /122-671					

2. Determine the correct wire size.

3. Meet the two in the middle to find the correct selector setting.

CRIMPING INSTRUCTIONS

1. Reference the dataplate on the positioner to select the correct number on the selector knob that correlates with the wire size. (Fig. 4)
2. Remove the spring clip, then raise and rotate the selector knob to the appropriate setting. Reinsert the spring clip. (Fig. 5)



Fig. 4



Fig. 5

3. Insert the contact and prepared wire through the indenter opening into the positioner. (Fig. 6)
4. Squeeze the handles together until the ratchet releases. The handle will return to the open position once fully crimped. (Fig. 7)



Fig. 6



Fig. 7

GAUGING INSTRUCTIONS

It is recommended to verify tool calibration using a GO/NO-GO gage. This can be achieved by adjusting the selector setting and inserting the specified gage listed on the following page.



GO

1. Actuate the tool to the fully closed position.
2. With firm hand pressure on the tool handles, insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.



DO NOT crimp the gage.



NO-GO

1. Actuate the tool to the fully closed position.
2. With firm hand pressure on the tool handles, try to insert the "NO-GO" gage end as shown. The "NO-GO" gage may partially enter the indenter opening, but must not pass completely through.



DO NOT crimp the gage.

GAUGING SETTINGS

Use the chart below to pair the recommended GO/NO-GO gage with the indenter gauging limits.

Tool	Selector Setting	Gauging Limits	GO/NO-GO Gage
 MH860-ERGO M22520/7-01	1	.0160-.0210	G228
	2	.0190-.0240	G229
	3	.0220-.0270	G230
	4	.0250-.0300	G231
	5	.0290-.0340	G232
	6	.0330-.0380	G233
	7	.0370-.0420	G234
	8	.0410-.0460	G145

TOOL CARE

Virtually no maintenance is required for this tool; however, it's good practice to keep indenter tips free of residual deposits and other debris by using a small wire brush.

We strongly recommend that you:

- ☐ DO NOT immerse tools in cleaning solution.
- ☐ DO NOT spray oil into tool to lubricate.
- ☐ DO NOT attempt to disassemble tool or make repairs.
- ☒ Only use tools for their intended purposes.

CALIBRATION & REPAIR

We offer comprehensive calibration and repair services. Our technicians will inspect the tool, replace worn components, and ensure it meets factory specifications.

To begin the calibration or repair process, scan the QR code. U.S. Customers will be directed to the appropriate forms to initiate service through DMC. Customers outside of the U.S. may contact authorized repair centers near them.

<https://qrco.de/Calibrate>



SAFETY

Safety is essential in the use and maintenance of DMC tools and equipment. This manual and any markings on the tool provide information for avoiding hazards and unsafe practices related to the use of these tools. Observe all of the safety information provided below:



Use proper connector and cable combinations. Improper combinations can result in an incomplete crimp. Failure to observe this warning could result in severe injury or death.



Inspect tool before use. If any parts are worn or damaged, send the tool for repair.



Avoid use of any powered “press” as defined by OSHA CFR 1910.211 (46).



Ensure the tool is in the open position whenever the positioner is being installed or removed.

Limitation of Liability

DANIELS MANUFACTURING CORPORATION (DMC) IS NOT LIABLE FOR CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY NATURE OR KIND RESULTING FROM THE USE, 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

Daniels Manufacturing Corporation (DMC) 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 products 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 DMC other than those herein set forth.



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