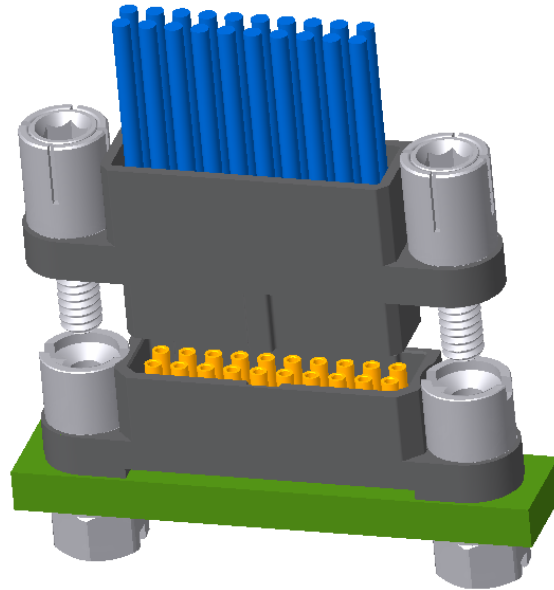




TECHNICAL NOTE

CRIMP MHDAS : INSTRUCTIONS



EXTERNAL DIFFUSION

Technical note n°: BLP-ER-015-Ext

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1. CRIMPING INSTRUCTION

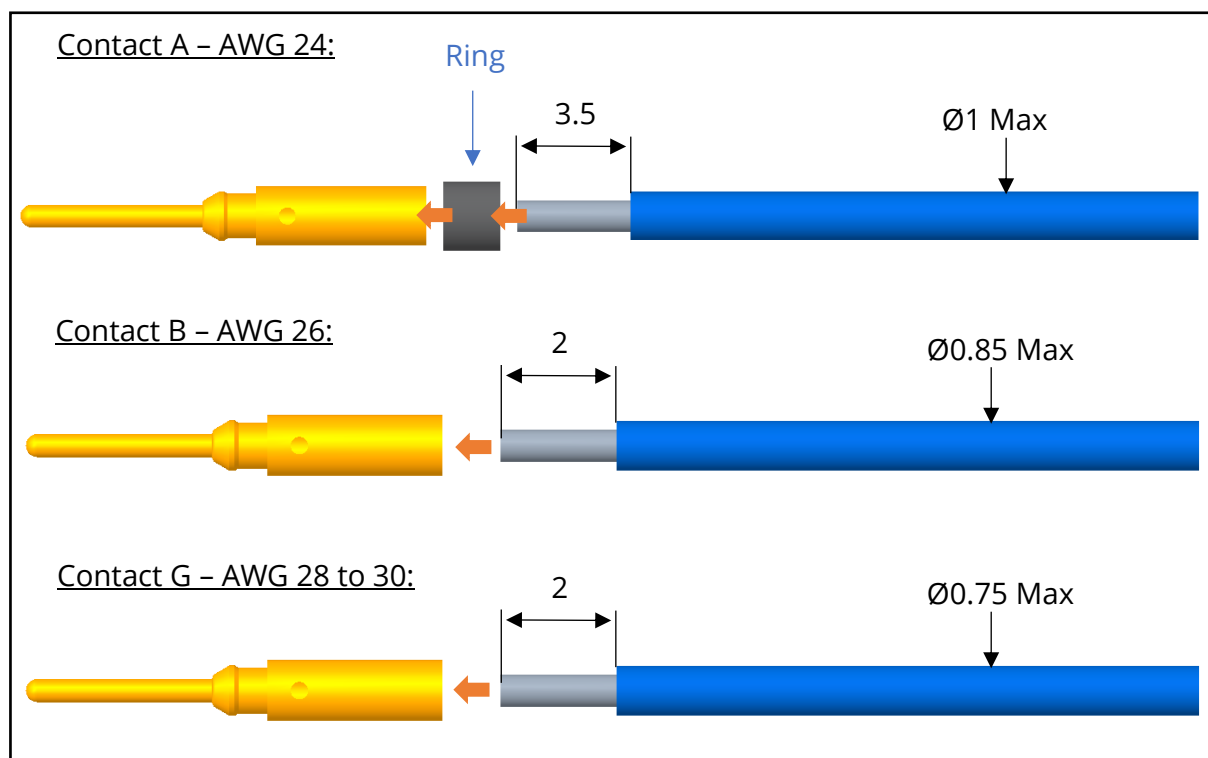
1.1.TOOLS

- ✓ Set the hand crimp tool, the positioner, and the selector number according to wire and crimp barrel size:

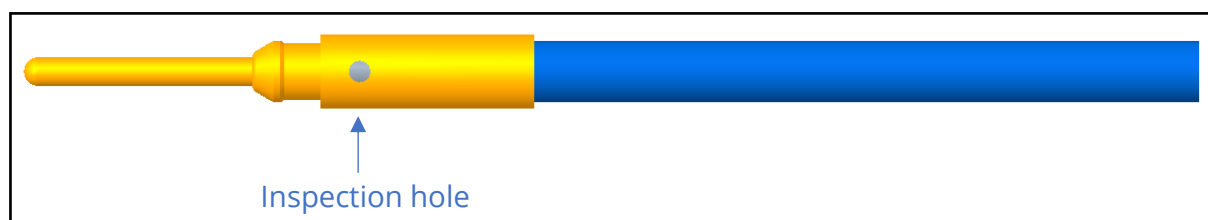
WIRE SIZE AWG	CONTACT		HAND CRIMP TOOL	POSITIONER	SELECTOR NUMBER
	TYPE	GENDER			
24	A	Male	MH800	K1692	4
		Female			
26	B	Male			
		Female			
28 30	G	Male			
		Female			

1.2.WIRE STRIPPING

- ✓ Check the wire stripping:



The conductor must be visible through the inspection hole of the contact:



1.3. CRIMPING

- ✓ Insert the contact and wire assembly in the positioner mounted in the hand crimp tool.
- ✓ Ensure that the contact is well positioned in the positioner, keep the wire in position.
- ✓ Crimp the contact and wire assembly – 1 crimping operation is enough.

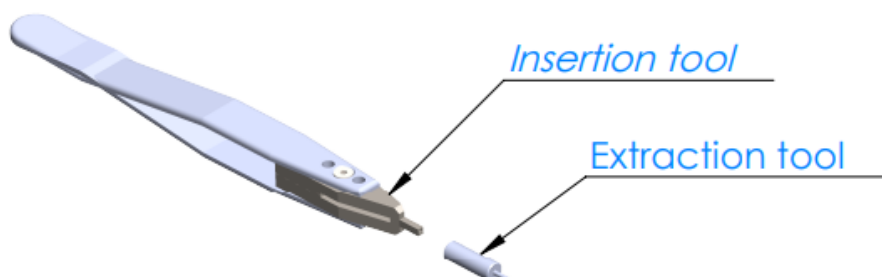
1.4. CHECK

- ✓ Visual: The conductor is visible in the inspection hole, crimping is centered between the inspection hole and the barrel entrance, the contact must not have any cracks, plating detachment
- ✓ Retention: pinch the cable and pull it gently

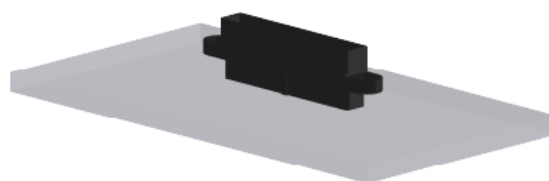
2. CRIMP CONTACT INSERTION INSTRUCTION

2.1. TOOL & PREPARATION

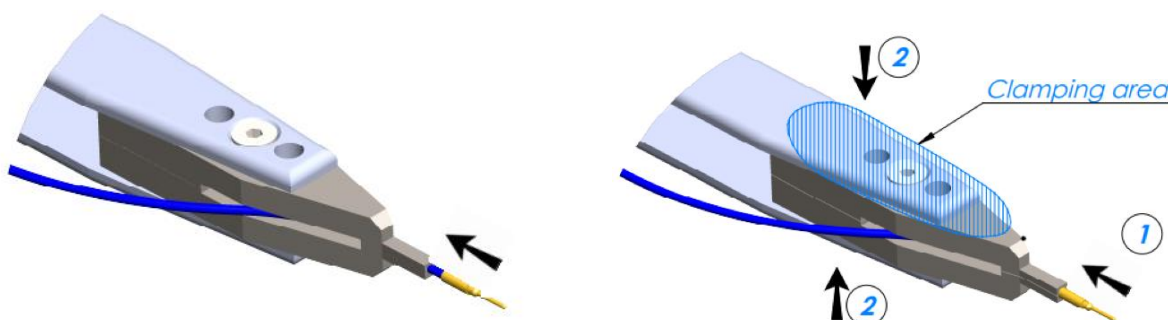
- ✓ Use specific MHDAS crimp contact insertion tool **MHDASODIEC**:



- ✓ Place the insulator on a flat surface, pressing on both extremities:

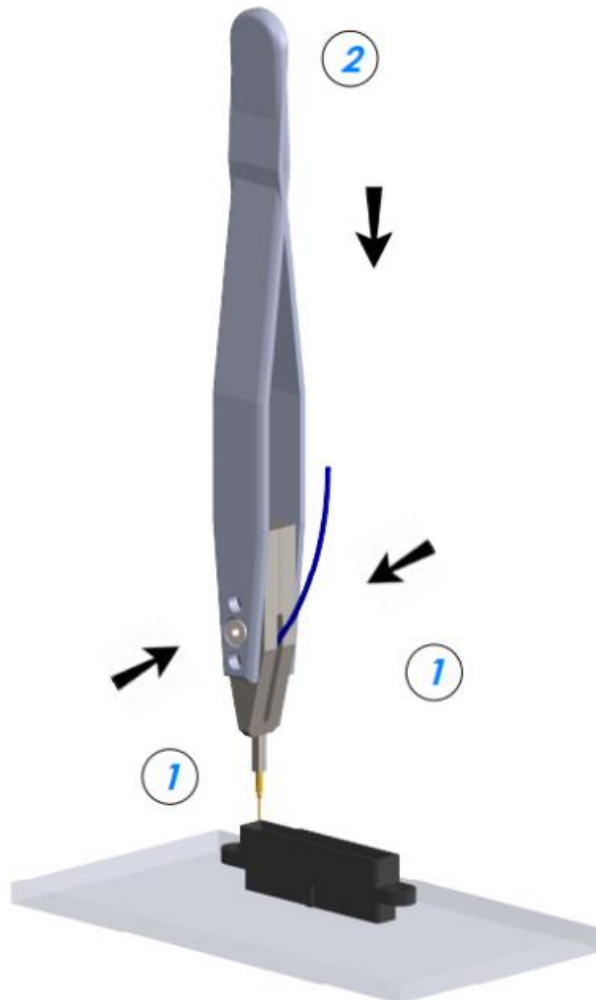


- ✓ Place the wire into the insertion tip, push the contact barrel against the tool (1) and grip the tool with your fingers (2):



2.2. INSERTION

- ✓ Keep the tool closed (1)
- ✓ Push on the tool to insert the contact into the insulator cavity (2), make sure you stay in the axis of the contact and the cavity.
 - ▶ Push the contact to the bottom of the cavity



2.3. CHECK

- ✓ Visual: Contact must have clearance with the housing, contact can rotate freely inside the housing
- ✓ Retention: pinch the cable and pull it gently

3. BACKPOTTING INFORMATION

We recommend the use of *Skycast 2651MM* and *Catalyst 9 (10%)* for enhanced protection.