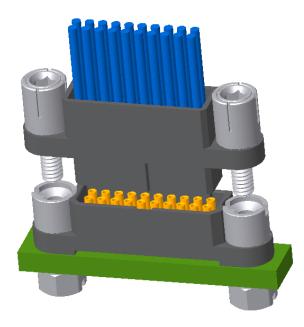
TECHNICAL NOTE MHDAS : CRIMPING INSTRUCTIONS



EXTERNAL DIFFUSION

Technical note n°: PCB-ER-020-Ext

Revision A, October 2023

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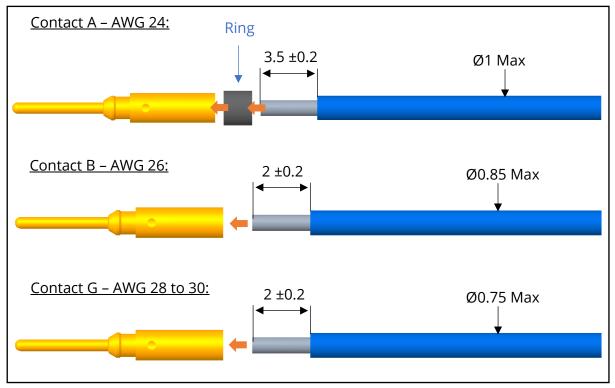
1. CRIMPING INSTRUCTION

1.1.TOOLS

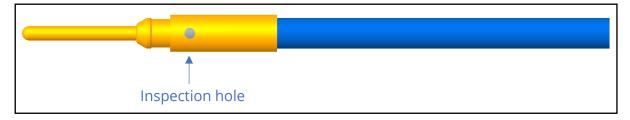
✓ Set the hand crimp tool, the positioner, and the selector number according to wire and crimp barrel size:

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

- <u>Visual</u>: 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
- ✓ <u>Retention:</u> pinch the cable and pull it gently