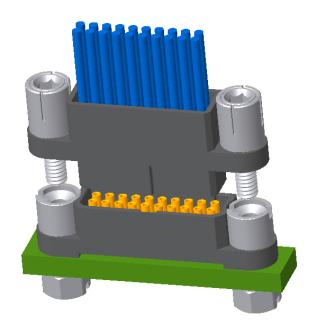
Amphenol SOCAPEX

TECHNICAL NOTE

MHDAS: CRIMPING INSTRUCTIONS



EXTERNAL DIFFUSION

Technical note n°: PCB-ER-020-Ext

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1. CRIMPING INSTRUCTION

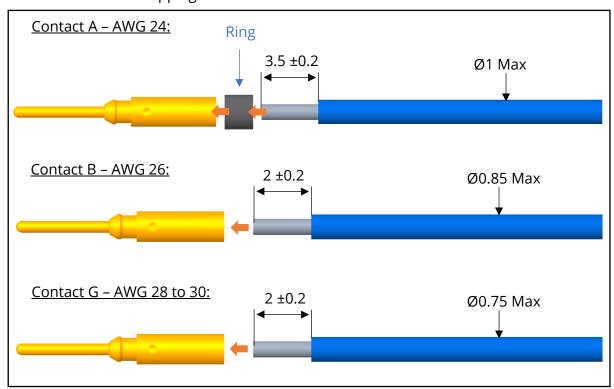
1.1.TOOLS

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

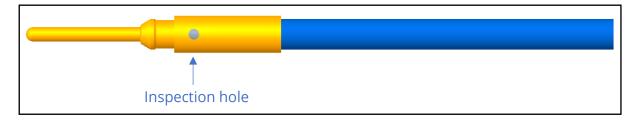
WIRE SIZE	CONTACT		HAND CRIMP TOOL	POSITIONER	SELECTOR NUMBER
AWG	TYPE	GENDER	CRIMP TOOL		NOWIDER
24	Α	Male	MH800	K2024	4
		Female			
26	В	Male			
		Female			
28	G	Male			
30		Female			

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
- ✓ Retention: pinch the cable and pull it gently