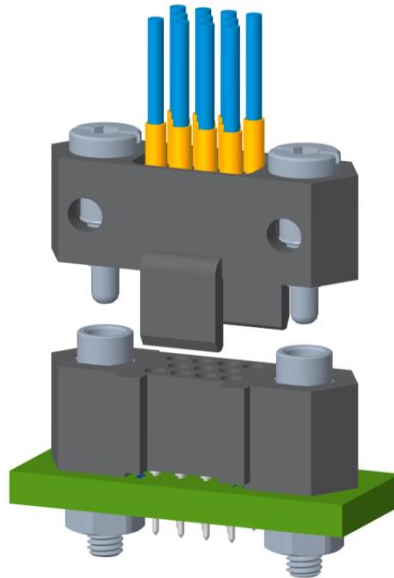


## TECHNICAL NOTE

### HDAS : CRIMPING INSTRUCTION



#### EXTERNAL DIFFUSION

Technical note n°: PCB-ER-017-Ext

Revision A, October 2023

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## 1. CRIMPING INSTRUCTION

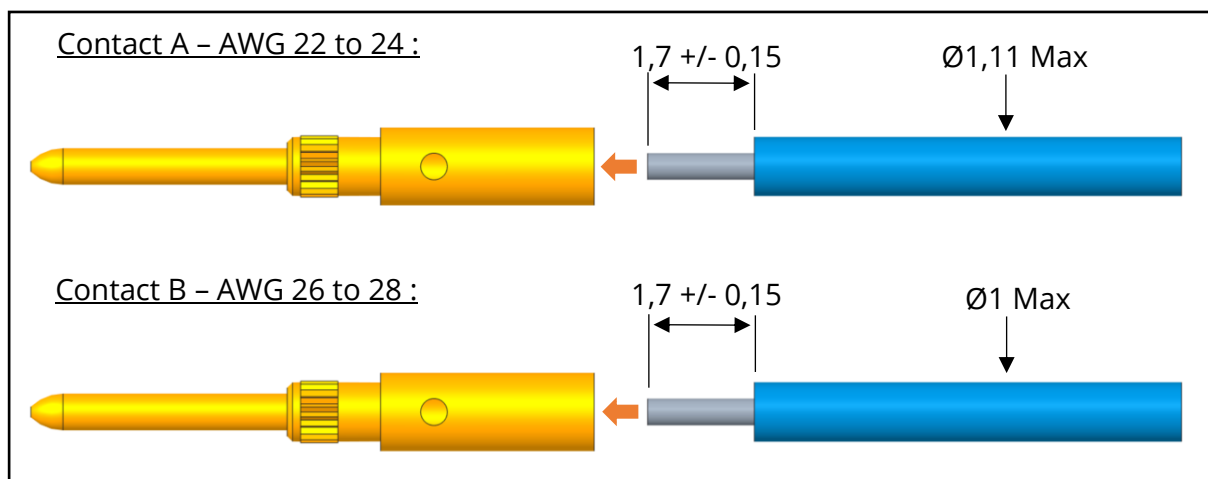
### 1.1.TOOLS

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

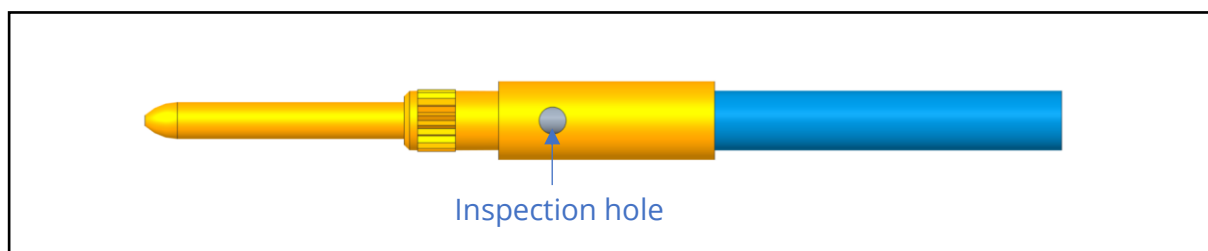
| WIRE SIZE | CONTACT |           | HAND CRIMP<br>TOOL | POSITIONER | SELECTOR<br>NUMBER |
|-----------|---------|-----------|--------------------|------------|--------------------|
| AWG       | TYPE    | REFERENCE |                    |            |                    |
| 22        | A       | 612375    | M22520/2-01        | K2092      | 3                  |
| 24        |         |           |                    |            |                    |
| 26        | B       | 612376    |                    |            |                    |
| 28        |         |           |                    |            |                    |

### 1.2.WIRE STRIPPING

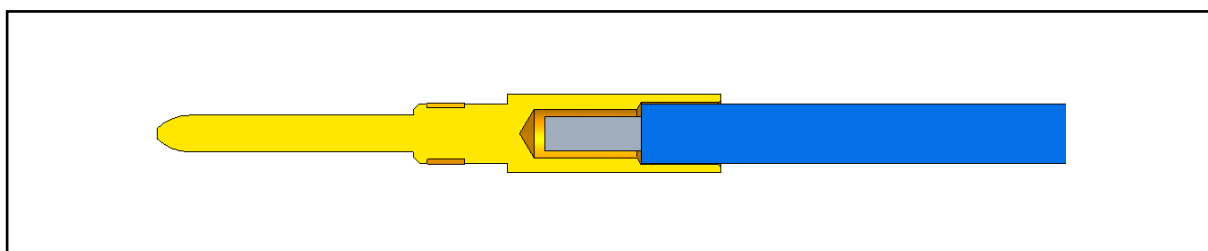
- ✓ Check the wire stripping length = 1,7 +/- 0,15 mm:



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



- ✓ Ensure that the wire is fully insert, with all strands in place:



### 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: all strands must be in the barrel, the contact must not have any cracks, plating detachment, or non-symmetrical barrel swelling
- ✓ Retention: pinch the cable and pull it gently