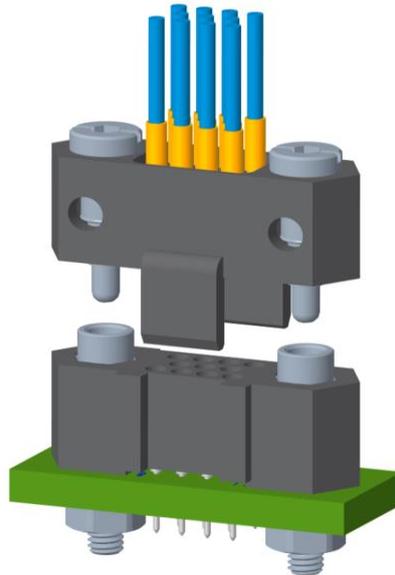




TECHNICAL NOTE

HDAS : CRIMPING INSTRUCTION



EXTERNAL DIFFUSION

Technical note n°: PCB-ER-017-Ext

Revision A, October 2023

Prepared by: Matthieu GERVAIS
Business Division Avionics R&D Engineer / Amphenol Socapex

Approved by: Thomas CARLIER
Business Division Avionics Product Manager / Amphenol Socapex

ISSUED BY:

Amphenol Socapex
948, Promenade de l'Arve – B.P. 29
74311 Thyez Cedex - France
Tél. : +33 (0) 4 50 89 28 00
www.amphenol-socapex.com

1. CRIMPING INSTRUCTION

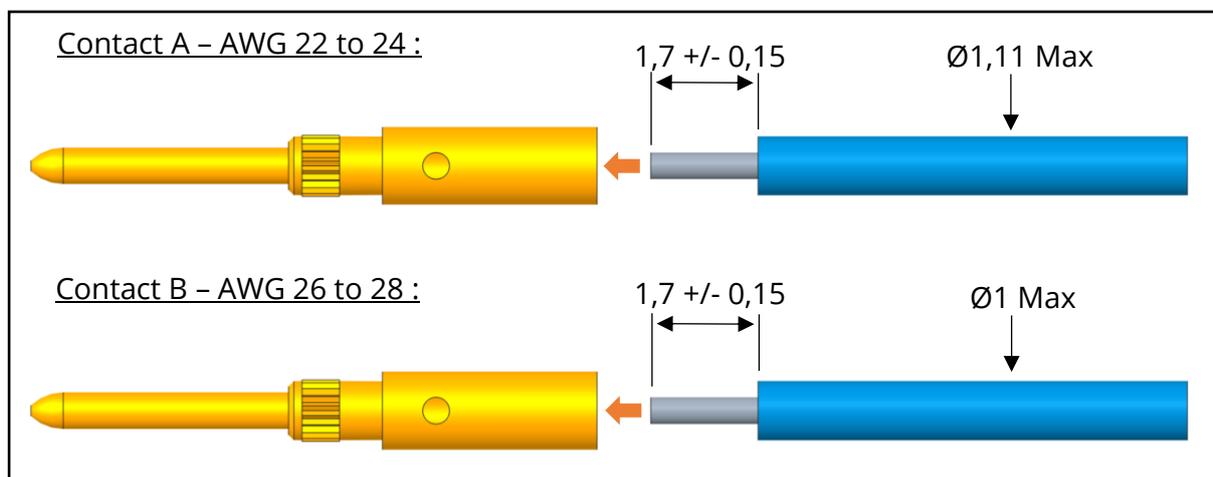
1.1. TOOLS

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

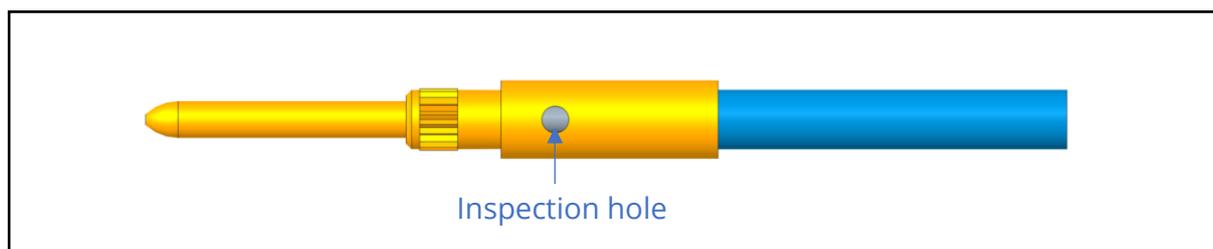
WIRE SIZE AWG	CONTACT		HAND CRIMP TOOL	POSITIONER	SELECTOR NUMBER
	TYPE	REFERENCE			
22	A	612375	M22520/2-01	K2092	3
24					
26	B	612376			
28					

1.2. WIRE STRIPPING

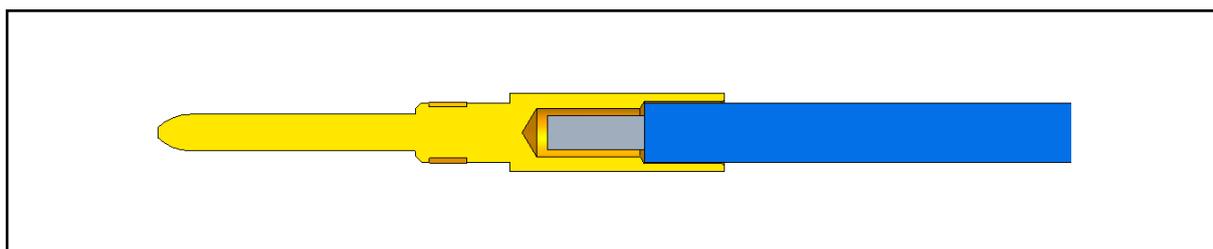
- ✓ Check the wire stripping length = 1,7 +/- 0,15 mm:



- ✓ 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