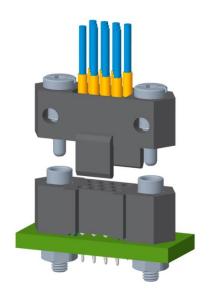
## **Amphenol SOCAPEX**

### **TECHNICAL NOTE**

# HDAS: CRIMP CONTACT INSERTION/EXTRACTION INSTRUCTION



#### **EXTERNAL DIFFUSION**

Technical note n°: PCB-ER-018-Ext

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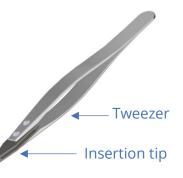
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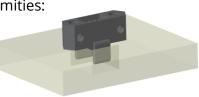
#### 1. CRIMP CONTACT INSERTION INSTRUCTION

#### 1.1.TOOL & PREPARATION

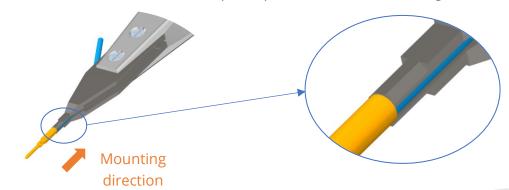
✓ Use specific HDAS crimp contact insertion tool HDAS ODI C:



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

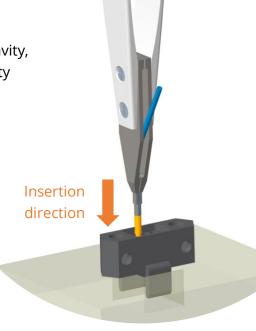


✓ Place the wire into the insertion tip and push the contact barrel against the tool:



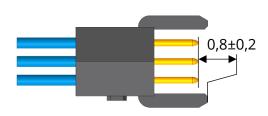
#### 1.2. INSERTION

- ✓ Push on the tool to insert the contact into the insulator cavity, make sure you stay in the axis of the contact and the cavity
  - ► Push the contact to the bottom of the cavity



#### **1.3. CHECK**

- ✓ <u>Visual</u>: the insulator must not have any cracks
- ✓ Retention: pinch the cable and pull it gently
- ✓ <u>Insertion</u>: measure the correct position of the contact in the cavity





#### 2. CRIMP CONTACT EXTRACTION INSTRUCTION

#### 2.1.TOOL & PREPARATION

✓ Use specific HDAS crimp contact extraction tool HDAS ODE C:

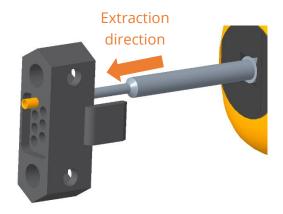


✓ Place the tool over the contact and make sure first tool diameter is inside the insulator cavity:



#### 2.2. EXTRACTION

- ✓ Push on the tool to extract the contact out the insulator cavity, make sure you stay in the axis of the contact and the cavity
  - ► Push the contact to the top of the cavity



#### **2.3. CHECK**

- ✓ <u>Visual:</u> the insulator must not have any cracks
- ✓ Retention: no retention of contact, it can be removed easily