

## TECHNICAL NOTE

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| <b>Title:</b> HDAS - Crimping instruction<br><br><b>Technical note n°:</b> PCB-ER-017-Ext<br><br><b>Revision :</b> B, February 2025 | <b>ISSUED BY:</b><br><b>Amphenol Socapex</b><br><b>948, Promenade de l'Arve – B.P. 29</b><br><b>74311 Thyez Cedex - France</b><br><b>Tél. : +33 (0) 4 50 89 28 00</b><br><b>www.amphenol-socapex.com</b> |
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### 1.1. TOOLS

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

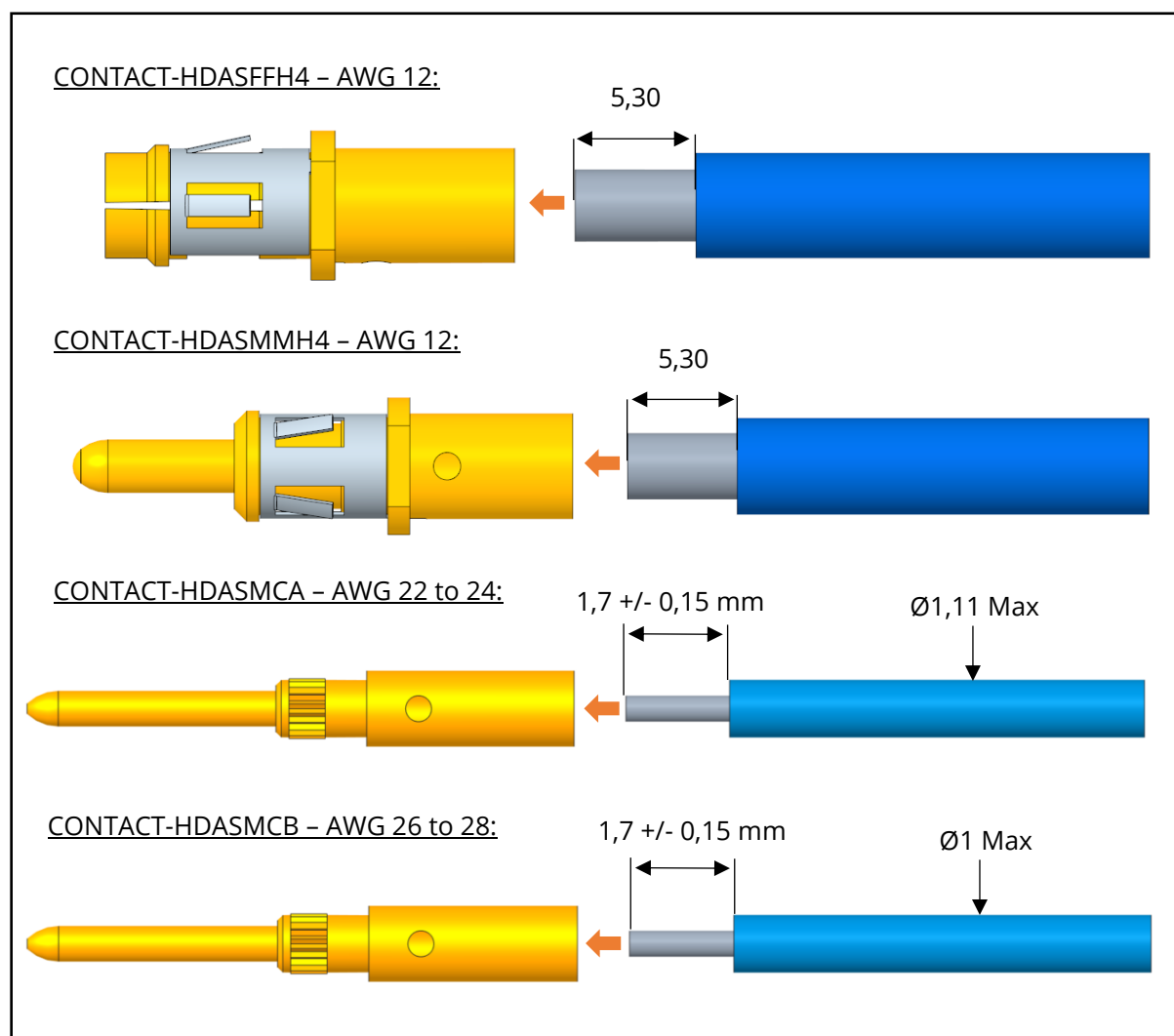
| WIRE SIZE   | CONTACT |                  |        | CRIMPING TOOL   | POSITIONER  | SELECTOR NUMBER OR JAW |
|-------------|---------|------------------|--------|---|---|------------------------|
| AWG         | Type    | Reference        | Gender |   |   |                        |
| 12          | FH4     | CONTACT-HDASFFH4 | Female | M22520/1-01   | WA27F   | -                      |
| 12          | MH4     | CONTACT-HDASMMH4 | Male   | M22520/1-01   | WA27F   | -                      |
| 22          | CA      | CONTACT-HDASMCA  | Male   | M22520/2-01   | K2092   | 3                      |
| 24          |         |                  |        |   |   |                        |
| 26          | CB      | CONTACT-HDASMCB  | Male   |   |   |                        |
| 28          |         |                  |        |   |   |                        |
| Coaxial 50Ω | TBD     | 612103           | Female | M22520/2-01 for center contact<br>M22520/5-01 for outer contact | M22520/2-34 for center contact<br>M22520/5-03 for outer contact | -                      |
| Coaxial 50Ω | TBD     | 612097           | Male   | M22520/2-01 for center contact<br>M22520/5-01 for outer contact | M22520/2-34 for center contact<br>M22520/5-03 for outer contact | -                      |

No view is shown for coaxial contacts.

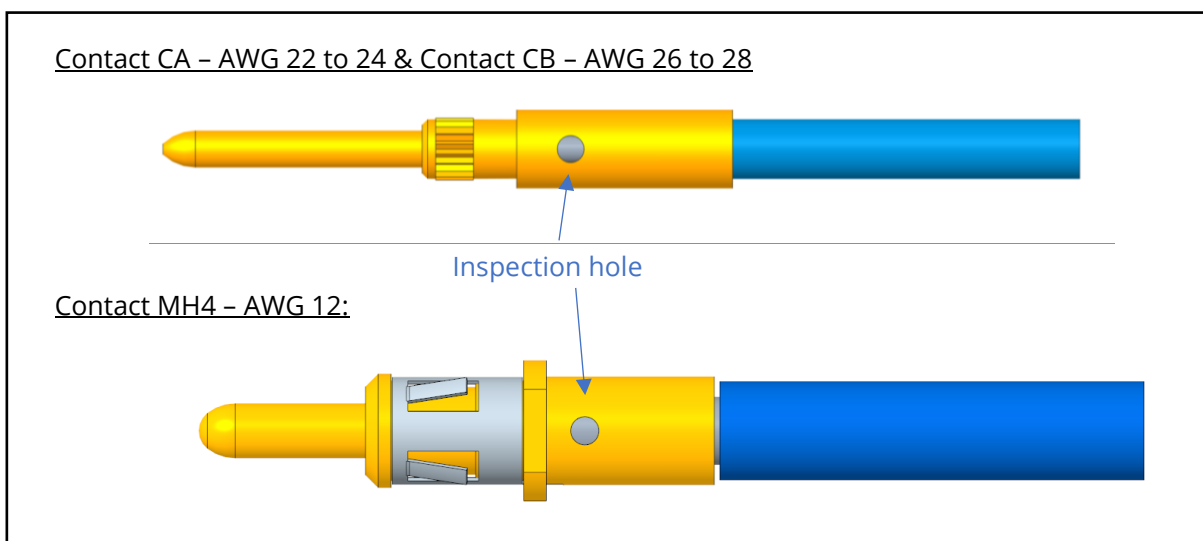
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The communication of Technical Note is punctual on internal decision or after request from customer.

## WIRE STRIPPING

- ✓ Check the wire stripping:

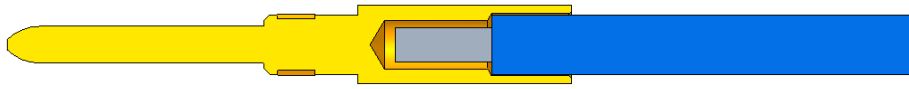


- ✓ The conductor must be visible through the inspection hole of the contact:

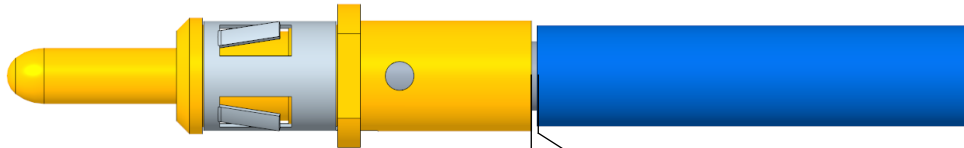


- ✓ Ensure that the wire is fully insert, with all strands in place:

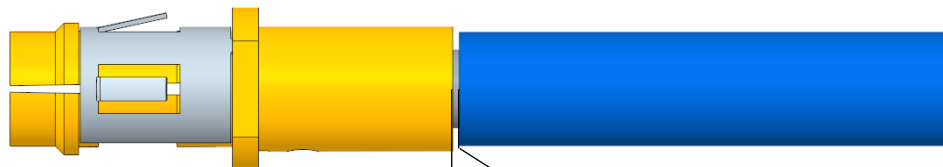
Contact CA – AWG 22 to 24 & Contact CB – AWG 26 to 28



Contact MH4 – AWG 12:



Contact FH4 – AWG 12:



0mm to one wire diameter  
Following IPC/WHMA-A-620, Class 3.

0mm to one wire diameter  
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## 1.2. 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

## 1.3. 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