

TECHNICAL NOTE

<u>Title:</u> HDAS – Contact insertion/extraction instruction	<u>ISSUED BY:</u> 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
<u>Technical note n°:</u> PCB-ER-018-Ext	
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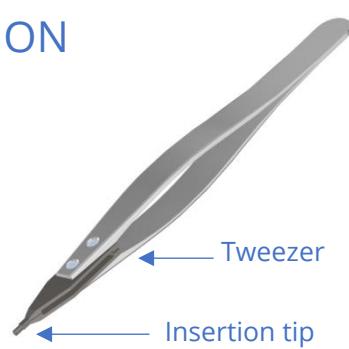
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1. SIGNAL CONTACT INSERTION & EXTRACTION

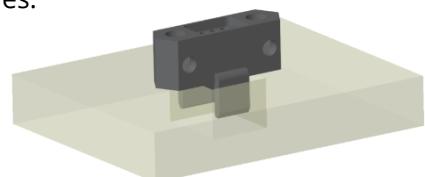
1.1. SIGNAL CONTACT INSERTION

1.1.1. TOOL & PREPARATION

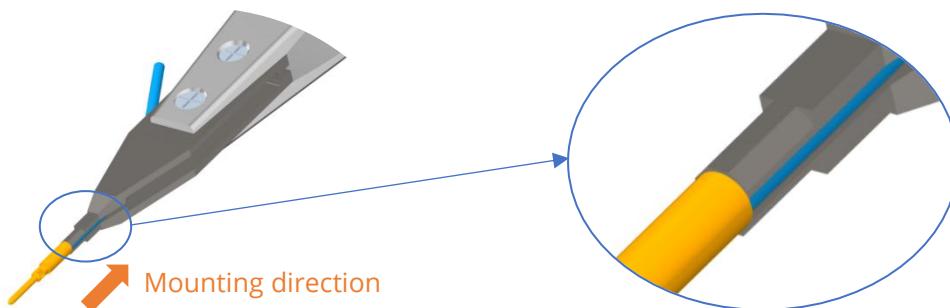
- ✓ Use specific HDAS crimp contact insertion tool HDAS ODI C:



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

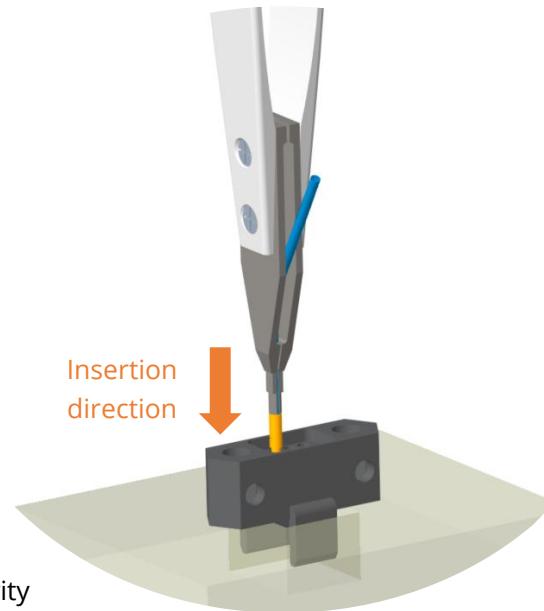


- ✓ Place the wire into the insertion tip and push the contact barrel against the tool:



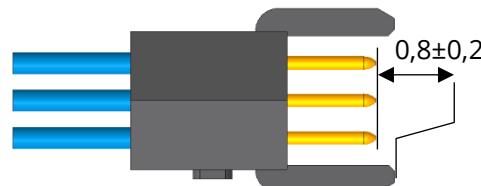
1.1.2. INSERTION

- ✓ 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



1.1.3. CHECK

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



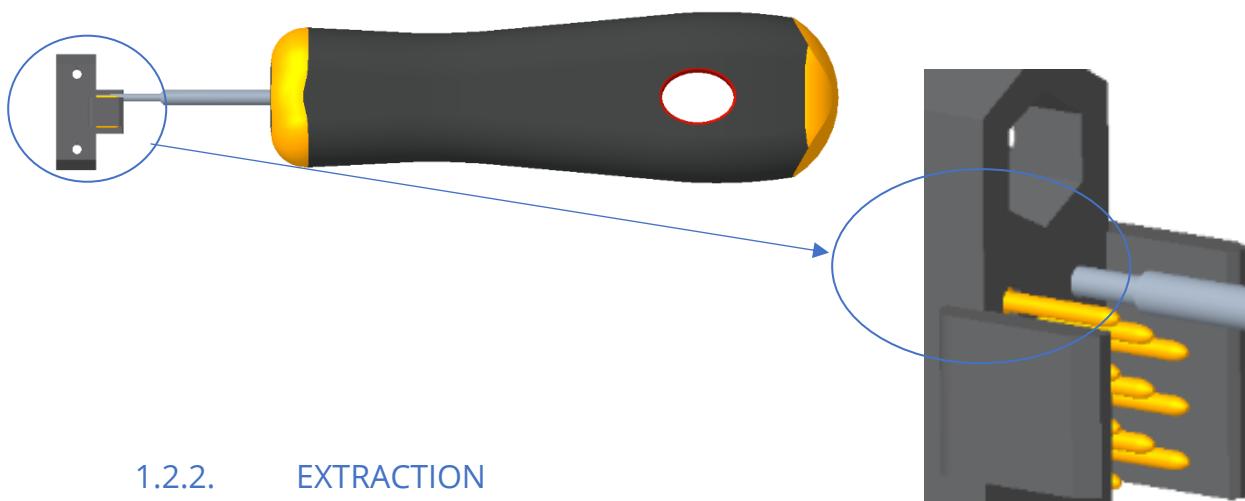
1.2. SIGNAL CONTACT EXTRACTION

1.2.1. TOOL & PREPARATION

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

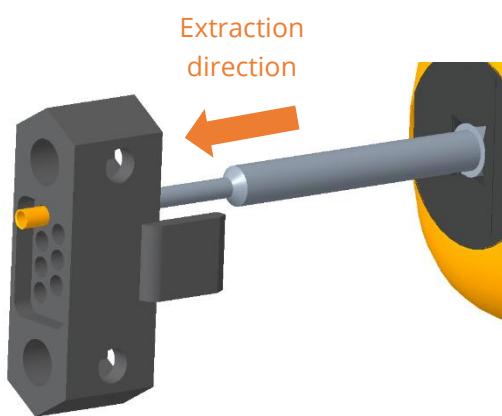


- ✓ Place the tool over the contact and make sure first tool diameter is inside the insulator cavity



1.2.2. 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

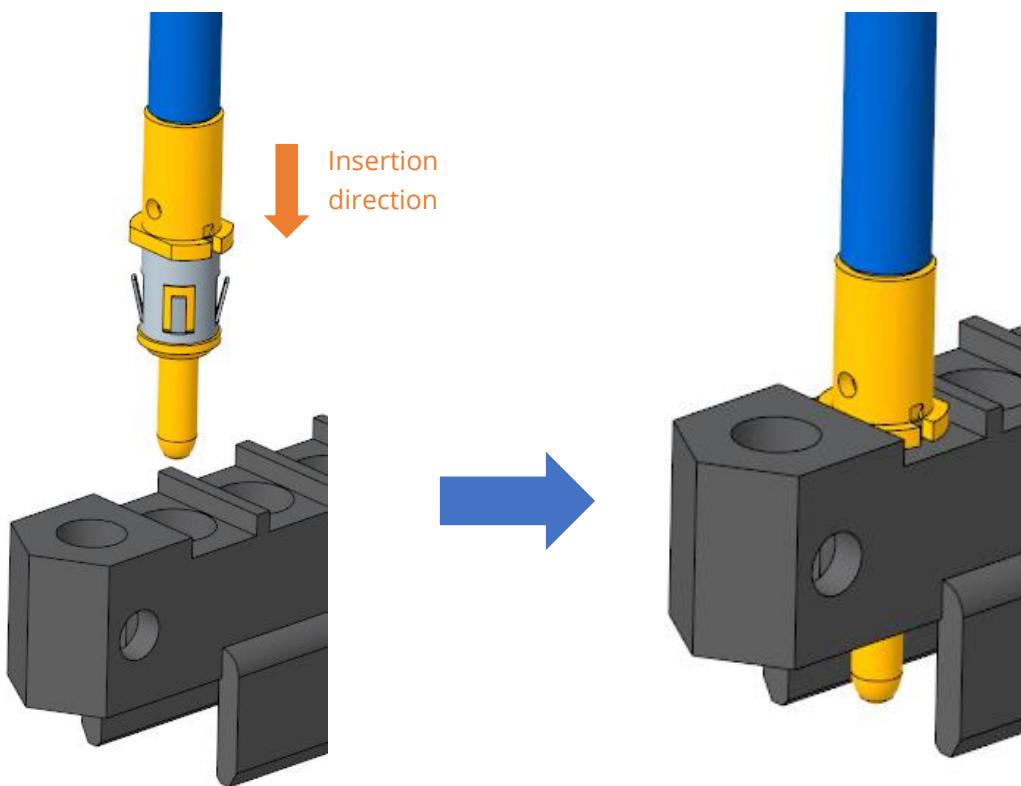


2. 20A POWER CONTACT INSERTION & EXTRACTION

2.1. 20A POWER CONTACT INSERTION

2.1.1. Insertion

- ✓ Push on the crimp contact while handling the cable and contact
 - Push the contact to the bottom of the cavity



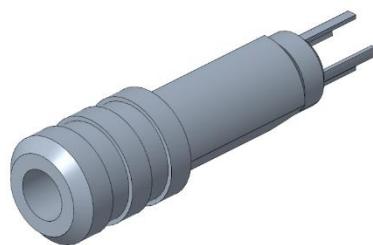
2.1.2. CHECK

- ✓ Visual : the insulator must not have any cracks
- ✓ Retention : pinch the cable and pull it gently

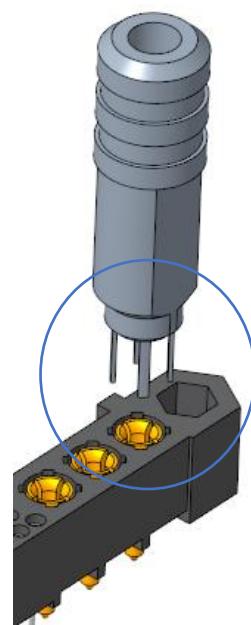
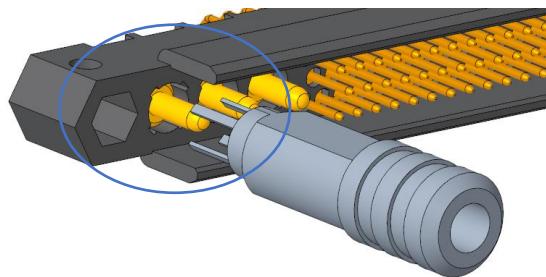
2.2. 20A POWER CONTACT EXTRACTION

2.2.1. TOOL & PREPARATION

- ✓ Use specific HDAS 20A crimp contact extraction tool 23550:



- ✓ Align tool with contact and make sure tool tabs are in front of insulator slots



2.2.2. EXTRACTION

- ✓ Push on the tool to close contact tabs (extraction direction)
 - Push/pull the contact to the top of the cavity

