TECHNICAL NOTE

Title: HDAS – Contact insertion/extraction instruction Technical note n°: PCB-ER-018-Ext Revision : B, February 2025	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

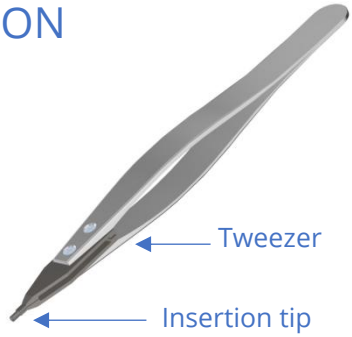
Table of contents

1. SIGNAL CONTACT INSERTION & EXTRACTION

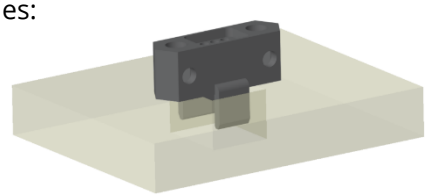
1.1. SIGNAL CONTACT INSERTION

1.1.1. TOOL & PREPARATION

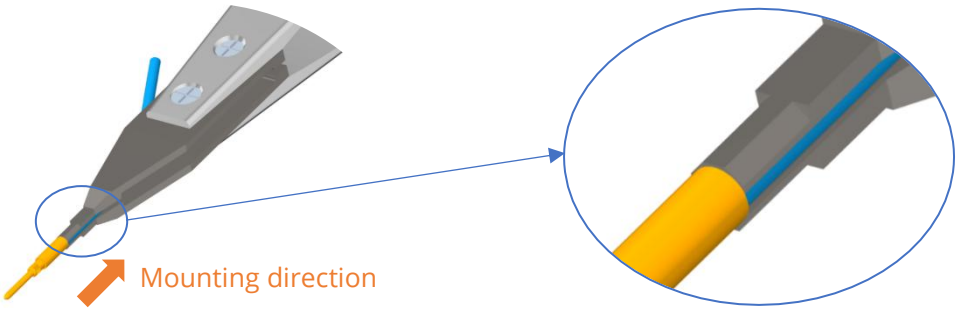
✓ Use specific HDAS crimp contact insertion tool HDAS ODI C:



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

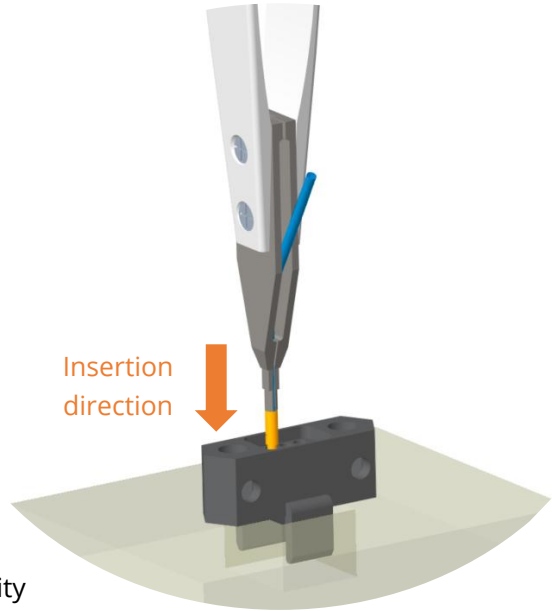


✓ Place the wire into the insertion tip and push the contact barrel against the tool:



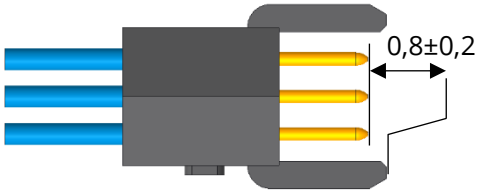
1.1.2. INSERTION

✓ 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

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

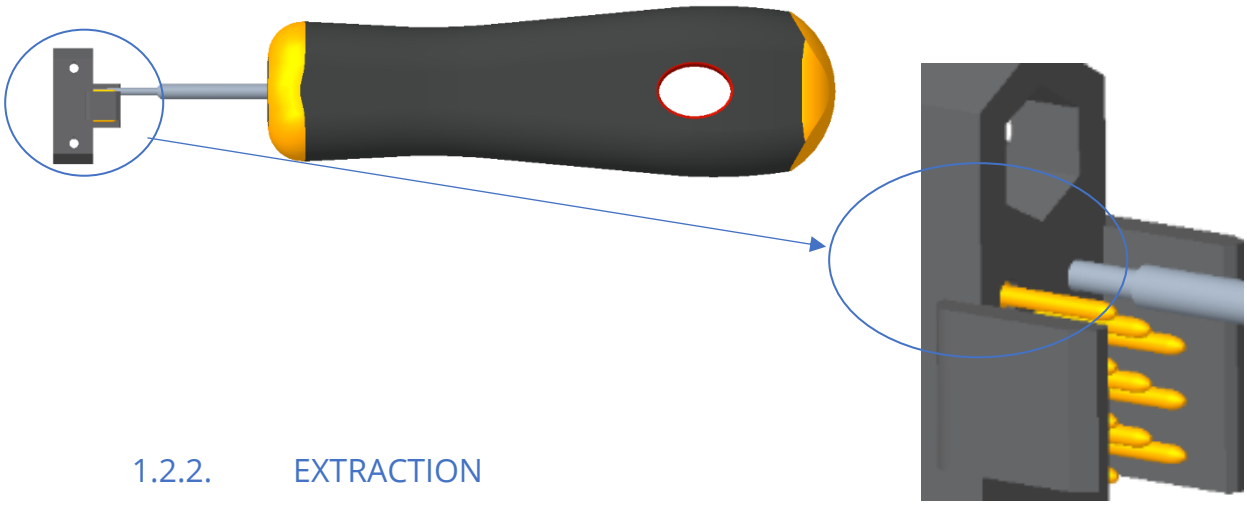


1.2. SIGNAL CONTACT EXTRACTION

1.2.1. TOOL & PREPARATION

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

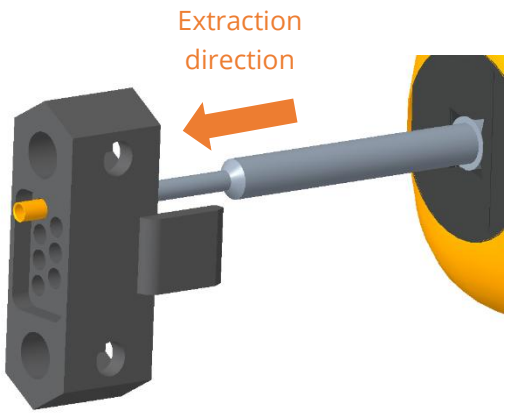
✓ Place the tool over the contact and make sure first tool diameter is inside the insulator cavity



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

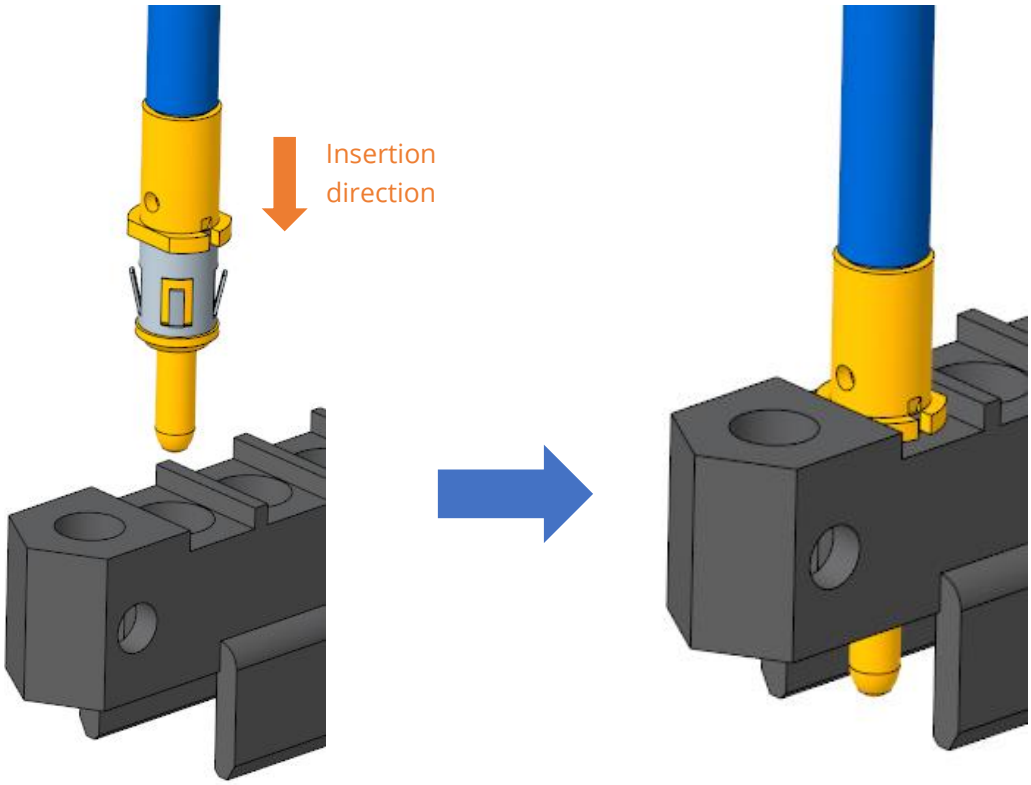


2. 20A POWER CONTACT INSERTION & EXTRACTION

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

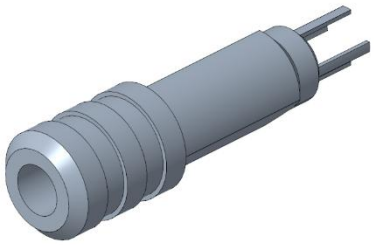


2.1.2. CHECK

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

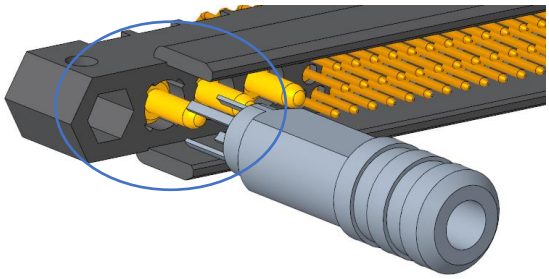
2.2. 20A POWER CONTACT EXTRACTION

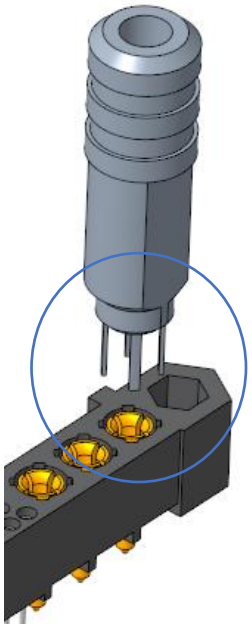
2.2.1. TOOL & PREPARATION



✓ 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