Interconnect Solutions & Services

Wiring Assembly Instructions

0884011-01 Contact, Receiver, Mini-Power, 50 Amps, 8 Awg Max.

Fig. A. (Contact Sub-Assembly)

Contact Crimp Information Table							
Wire Type	Wire Awg.	Strip Length In Inches	Crimp Tool	Hex Die Set/ Positioner	Indicator	Selector No.	Heat-shrink Length X Dia.
Stranded	12 10 8	A) 5/32” B) 5/32 C) 5/32	N/A	N/A	N/A	N/A	3/16 X 5/8

Pull Test Values	
12 Awg	62lbs
10 Awg	73lbs
8 Awg	85lbs

(Values based on M22759/11xx)

(Example of Equipment)

NOTE 1: Refer to **IPC/WHMA-A-620A** standard (Ch. 11.1.2) for cable lengths, measurements and tolerance.

NOTE 2: Overall length of cable should be less 3/8” to compensate for the contact attachment.

STEP 1) Strip wire to dimensions in “Contact Crimp Information” Table using a ruler along with a wire stripper as shown in **Fig. B.**

Fig. B.

STEP 2) Tin stripped wire. (This prevents wire strands from fraying) as in **Fig. C.**

Fig. C.

STEP 3) Put contact in a fixture, insert wire in contact and solder per **IPC/WHMA-A-620A** standard (Ch. 4.9.6) for Solder Connections – Cup Terminals.

NOTE: Inspect after insertion of wire into contact to make sure no strands of wire is protruding outside the Cup of the contact.

STEP 4) Remove the Contact and make sure there is no spillage of solder on outside of Contact and meets all standards set in **IPC/WHMA-A-620A** standards. **Fig. D.**

Fig. D.

STEP 5) Slide Heat-Shrink over completed Assembly for Strain Relief, **Fig. E** below,

Fig. E.

NOTE: Heat-Shrink shall not cover Inspection -Hole.