



Wiring Assembly Instructions

0884012R-01 Contact, Receiver, Signal, Crimp 5 Amp.



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	20	A) 1/4"	452500	452501	N/A	6	N/A
	22	A) 1/4"			N/A	5	
	24	A) 3/16"			N/A	4	

Pull Test Values	
20 Awg	13lbs
22 Awg	8lbs
24 Awg	5lbs



(Values based on M22759/11xx)

(Example of Equipment)

NOTE 1: Refer to **IPC/WHMA-A-620B (Class 2)** standard (Ch. 11.1) for cable lengths, measurements and tolerance.

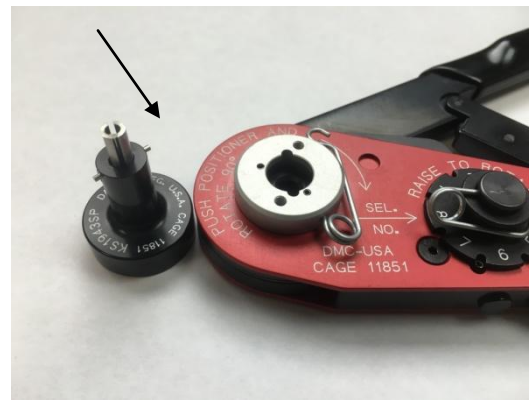
NOTE 2: Overall length of cable should be less 3/8" to compensate for the contact attachment.

STEP 1) From the "Contact Crimp Information" Table, use the crimp tool and Positioner set listed.

ECN#3720	Changed tools from 452400 and 452401 to 452500 and 452501 respectively	1/19/2016
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Fig. B. (Crimp Tool 452500)



Detail A. (Positioner and Crimp Tool 452501)

STEP 2) Insert the Positioner into the Crimp Tool by aligning the guide pins and guide holes in the "Tool Set" as shown in Fig. C. and D. below. Twist the Positioner clockwise to lock into place.



Fig. C. (Positioner)



Fig. D. (Positioner inserted into Crimp Tool)

STEP 3) Strip wire to dimensions in "Contact Crimp Information" Table using a ruler/calipers along with a wire stripper as shown in Fig. E.



Fig. E.

STEP 4) Turn the Selector Knob to suit the size of wire to be crimped.

NOTE: Crimp Tool Settings are based on Military Specifications, M22759/11xx Wire Standard. Adjust settings to suit other Specifications.

STEP 5) Align Tangs to slots in Positioner and install contact. Insert Stripped end of wire into Contact and crimp as in Fig. F. and G below.

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Fig. F

Fig. G

STEP 6) Inspect crimped assembly for extruding strands of wire to prevent shorts and also check for retention by a Pull and Return Test per **IPC/WHMA-A-620B (Class 2)** standard (Ch. 19.7.2).

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respectively

1/19/2016