



Wiring Assembly Instructions

**F01S006-02 - Contact, Receiver, Signal, Crimp, 4 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	Selecto r No.	Heat-shrink Length X Dia.
Stranded	22	A) 1/4"	452200/M	452215	N/A	5	N/A
	20	A) 1/4"				6	
	18	A) 1/4"				7	

Pull Test Values	
22 Awg	8lbs
20 Awg	13lbs
18 Awg	20lbs



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



**Fig. B.** (Crimp Tool M22520/2-01)



**Detail A.** (Positioner and Crimp Tool)

**STEP 2)** Insert the Positioner into the Crimp Tool and rotate until the two Location Pins lock in place by pushing the positioner and rotating as shown in **Fig. C.** and **D.** below.



**Fig. C. (Positioner)**



**Fig. D. (Positioner inserted into Crimp Tool)**

**STEP 3)** Strip wire to dimensions in “Contact Crimp Information” Table using a ruler along with a wire stripper as shown in **Fig. E.**

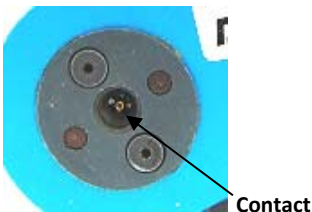


**Fig. E**

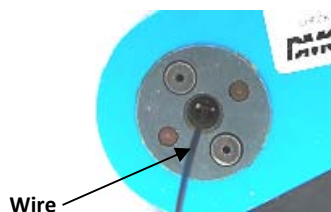
**STEP 4)** Turn the Selector Knob to suit the size of wire to be crimped in “Contact Crimp Information Table” above.

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

**STEP 5)** Place Contact into Positioner. Insert Stripped end of wire into Contact and crimp as in **Fig. F.** and **G.**



**Fig. F. (Contact in Positioner)**



**Fig. G. (Stripped Wire inserted in contact)**

**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-620A** standard (Ch. 19.7.2) **Fig. H.** below.

