



Wiring Assembly Instructions

**F01S006 - Contact, Receiver, Signal, Crimp, 4 Amps, 24–26 Awg.**



**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	26	A) 1/4"	452200/M	452215	N/A	3	N/A
	24	A) 1/4"				4	
	22	A) 1/4"				5	

Pull Test Values	
26 Awg	1.5lbs
24 Awg	5lbs
22 Awg	8lbs



**(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 452200/M)



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, Contact Crimp Information Table" above.

**NOTE:** Crimp Tool Settings, based on Military Specifications 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.

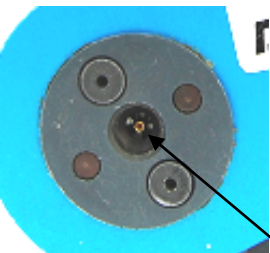


Fig. F. (Contact is Crimp Tool)

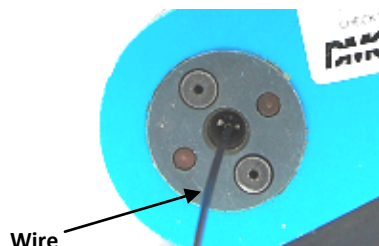


Fig. G. (Stripped wire inserted in Contact)

**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) to match Fig. G. below.



Fig.