



Wiring Assembly Instructions

M02S006M-02 Contact, ITA, Signal, Crimp 4 Amp 20-26 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	20 18	A) 3/16" A) 3/16"	452200/M	452218	N/A	7 6	N/A

Pull Test Values	
20 Awg	13lbs
18 Awg	25lbs



(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 hex die 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, (per "Contact Crimp Information Table" above).

NOTE: Crimp Tool Settings are based on Military Specifications Wire M22759/11xx 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.**

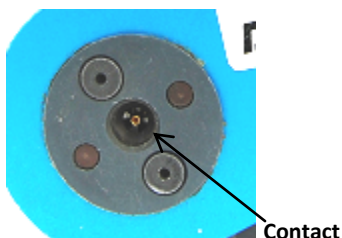


Fig. F. (Contact in Positioner)

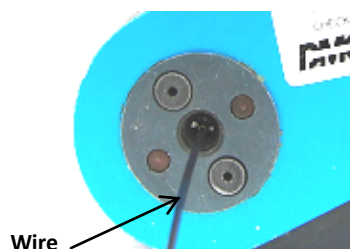


Fig. G. (Wire in inserted in Contact)

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. G.