

MAC-PANEL

Interconnect Solutions & Services

Wiring Assembly Instructions

563700 - Contact, ITA, Signal, Crimp, 20 – 24 Awg, 1MM.



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	24	A) 3/16"	452200-MSP	452207	N/A	4	N/A
	22	A) 3/16"				6	
	20	A) 3/16"				7	

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



(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-MSP)



Detail A. (Positioner and Crimp Tool)

STEP 2) Insert the Positioner into the Crimp Tool and tighten in place with the two screws in the positioner by aligning the guide pin and guide hole in the “Tool Set” 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/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) Insert contact into Positioner and squeeze handle slowly to grip and hold Contact in place. Insert Stripped end of wire into Contact and crimp as in **Fig. F.** and **G** below.

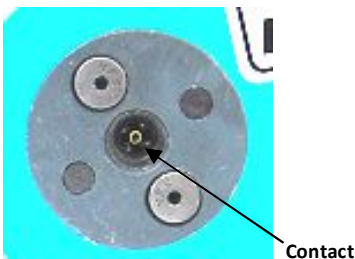


Fig. F. (Contact in Positioner)

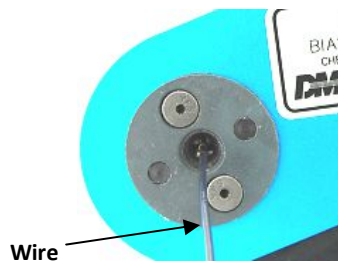


Fig. G. (Wire inserted in Contact)

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. H.** below.



Fig. H.