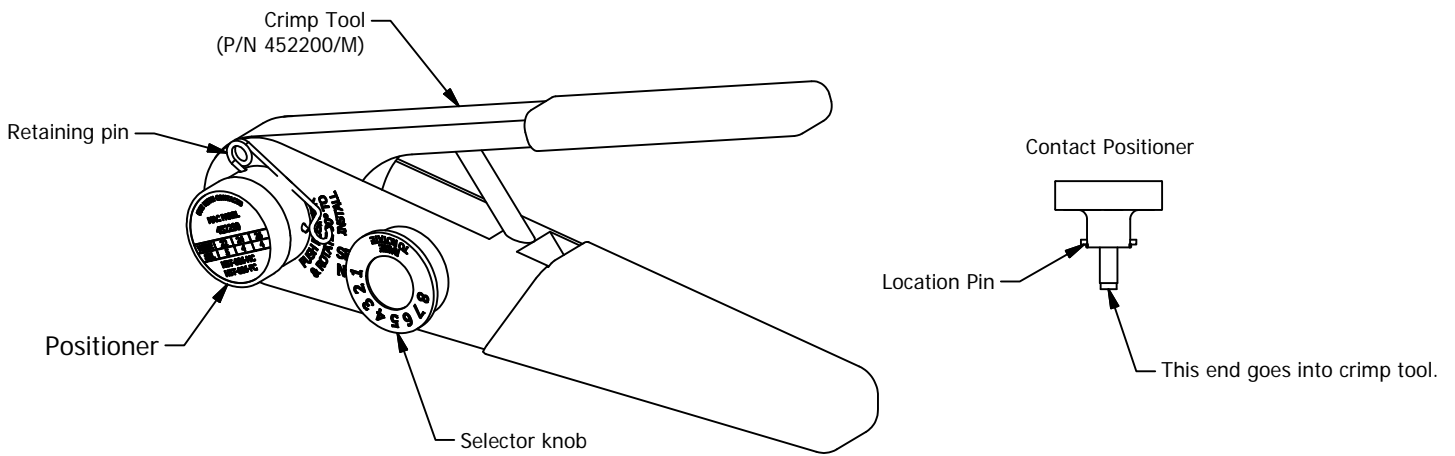# Wiring Assembly Instructions

Crimp Tool Assembly.

Step1) Select the correct Crimp tool and positioner for the contact you are using from the "Crimp Information" table below.
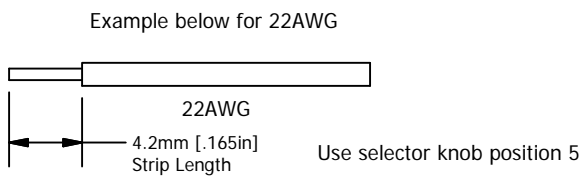
Crimp Information		
Contact P/N	Crimp Tool	Positioner
HST-806-MC	452200/M	452299
HST-806-FC	452200/M	452299

Step 2) Install positioner into crimp tool :

a) Remove retaining pin from crimp tool
b) Insert positioner into crimp tool, depress and rotate until two location pins clip into place.
c) Replace retaining pin.

Crimp Tool (P/N 452200/M)

Retaining pin

Positioner

Selector knob

Contact Positioner

Location Pin

This end goes into crimp tool.

Step 3) Turn the selector knob to suit the size of wire you are using, strip one end of the wire
Details for both of these can be found in the "Wire Information" table.

Example below for 22AWG

22AWG

4.2mm [.165in]
Strip Length

Use selector knob position 5

Wire Information		
Wire AWG	Selector position	Wire strip length
22	5	4.2mm [.165in]
24	4	4.2mm [.165in]
26	4	4.2mm [.165in]

** Crimp tool settings based on Mil Spec wire standards.
Adjust settings to suit other specifiactions ***

Step 4) Place contact into the positioner through the hole in the back of crimp tool, insert stripped end of wire into contact.
Close handles of crimp tool, handles will automatically release when crimp is completed.

Contact

Through hole

Crimp tool

Positioner