



Wiring Assembly Instructions

40-120003-01 Contact, Receiver, Micro Power, Crimp, 23 Amp, 14 Awg Max.



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	18	A) 1/4"	452200	452221	Yellow	4	N/A
	16	A) 1/4"			Yellow	5	
	14	A) 1/4"			Yellow	5	

Pull Test Values	
18 Awg	32lbs
16 Awg	39lbs
14 Awg	48lbs



(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)



Detail A. (Positioner and Crimp Tool)

STEP 2) Insert the Positioner into the Crimp Tool as shown in **Fig. C.** below.



Fig. C. (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. D.**



Fig. D.

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



Fig. E. (Contact in Crimp Tool)

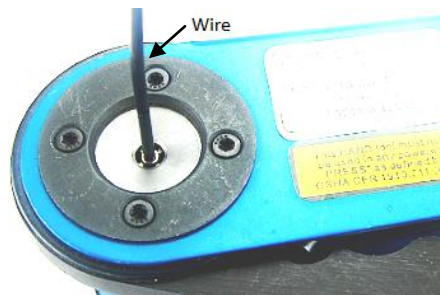


Fig. F. (Striped wire inserted in Contact)

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. G.