



Wiring Assembly Instructions

40-220003-01 Contact, ITA, Micro Power, Crimp, 23Amps, 14Awg 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 | 452220 | 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 is Crimp Tool)



Fig. F. (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. H. below.



Fig. G.

