



Wiring Assembly Instructions

0884013R-01 Contact, Receiver, High Density Signal/Power, 10 Amps 14-18 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	18	A) 1/4"	452400	452402	Blue	3	N/A
	16	A) 1/4"			Blue	5	
	14	A) 1/4"			Blue	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-620B (Class 2)** standard (Ch. 11.1) 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.

ECN#3056	Removed Heat-Shrink and updated to IPC/WHMA-A-620B (Class 2)	3/17/2014
ECN#3464	Changed Selector NO From 5 To 3, For 18 ga Wire	3/12/2015
ECN#3785	CHANGED STRIP LENGTH TO 1/4"	3/30/2016
ECN#4689	CHANGE POSITIONER TOOL	9/19/2019



Fig. B. (Crimp Tool 452400)



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) Align Tangs to slots in Positioner and install contact. Insert Stripped end of wire into Contact and crimp as in Fig. F. and G below.

ECN#3056	Removed Heat-Shrink and updated to IPC/WHMA-A-620B (Class 2)	3/17/2014
ECN#3464	Changed Selector NO From 5 To 3, For 18 ga Wire	3/12/2015
ECN#3785	CHANGED STRIP LENGTH TO ¼”	3/30/2016
ECN#4689	CHANGE POSITIONER TOOL	9/19/2019

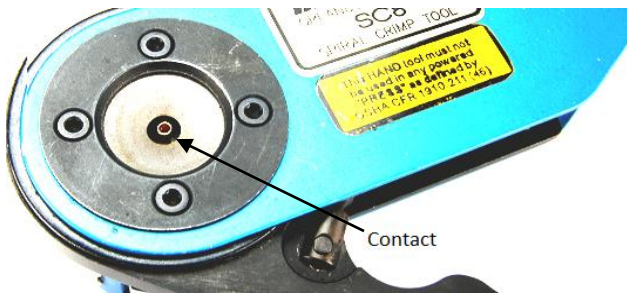


Fig. F.



Fig. G.

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-620B (Class 2)** standard (Ch. 19.7.2).

ECN#3056	Removed Heat-Shrink and updated to IPC/WHMA-A-620B (Class 2)	3/17/2014
ECN#3464	Changed Selector NO From 5 To 3, For 18 ga Wire	3/12/2015
ECN#3785	CHANGED STRIP LENGTH TO ¼"	3/30/2016
ECN#4689	CHANGE POSITIONER TOOL	9/19/2019