REV B IN 562023



Wiring Assembly Instructions

562023 - Contact, Micro-Power, Solder.



Fig. A. (Contact Sub-Assembly)

Contact Crimp Information Table							
Wire	Wire	Strip Length In	Crimp Tool	Hex Die Set/	Indicator	Selector	Heat-shrink
Type	Awg.	Inches		Positioner		No.	Length X Dia.
Stranded	18	A) 5/32"	N/A	N/A	N/A	N/A	3/8 X 1/4
	16	B) 5/32					
	14	C) 5/32					

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) Strip wire to dimensions in "Contact Crimp Information" Table using a ruler along with a wire stripper as shown in **Fig. B.**



Fig. B.

STEP 2) Tin stripped wire, (This prevents wire strands from fraying) as in Fig. C.

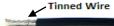


Fig. C

STEP 3) Put contact in a fixture, insert wire in contact and solder per **IPC/WHMA-A-620A** standard (Ch. 4.9.6) for Solder Connections – Cup Terminals.

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NOTE: Inspect after insertion of wire into contact to make sure no strands of wire are protruding outside the Cup of the contact.

STEP 4) Remove and inspect Contact, making sure there is no spillage of solder on the outside of Contact and meets all standards set in **IPC/WHMA-A-620A** standards. **Fig. D.**



Fig. D.