



Wiring Assembly Instructions

5517701 Contact, ITA, High-Power, 150 Amp, 2 Awg Max, Crimp.

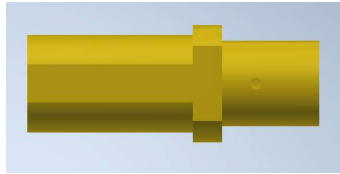


Fig. A. (Contact)

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	2 AWG	A = 1/2"	M22520/23-01	M22520/23-05 M22520/23-540	N/A	N/A	N/A

**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 1" 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 M22520/23-01)    Fig. C. (Crimp Die M22520/23-05)    Fig. D. (Positioner M22520/23-540)

**STEP 2)** Unfasten the red cover piece from the crimp tool (Fig B). Insert the Positioner (Fig D) into the Crimp Tool aligning the keyway features together. Insert the Crimp Die (Fig C) over the positioner aligning the locating dowel pin and hole. Fasten the red cover piece over the Crimp Die and Positioner onto the 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**.



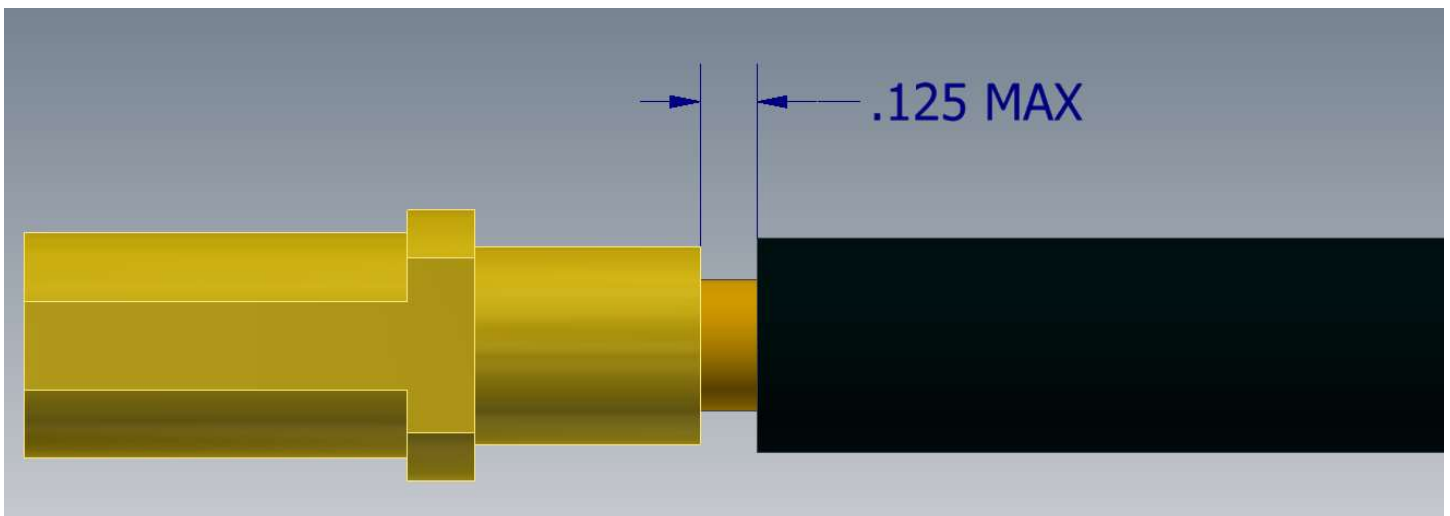
**Fig. E.**

**STEP 4)** Insert contact with wire inserted into rear cavity into the Crimp Tool until the contact is seated on the Positioner. Activate the Crimp Tool and allow it to fully cycle through the crimping process until it releases the contact. Remove the contact. Do not apply heat shrink.



**Fig. F. (Contact and wire in Crimp Tool)**

**STEP 5)** 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. G.** below.



**Fig. G.**