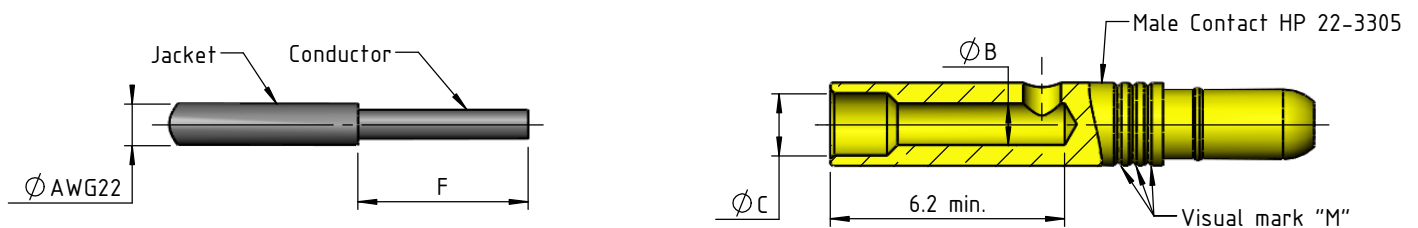


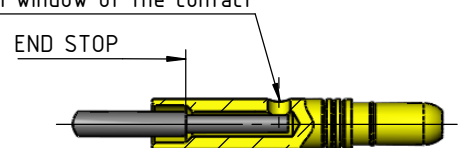
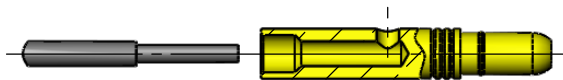
Stripping



Loaded	Unloaded	Cable A	ØB	ØC	Length F conductor	M	Solder	Crimp by AF8 Tool / Positioner	Crimp tool setting - Number selector
		AWG22							AWG22
3305	22-3305	X	1.1 mm	1.65 mm	4.5 mm	x3	OK	16459 / C16461	Position 3

1- Insert the cable into the contact

The conductor must be visible through the inspection window of the contact



2- Set the hand crimp tool according to crimp barrel accommodation table above.

2.1- Select the number "Position 3"

2.2- Put the positioner C16461 on the hand crimp tool 16459

Hand crimp tool in a closed position.



3- Insert the contact and wire assembly

in the guide of the hand crimp tool
3.1 - In the crimp guide, the contact and wire assembly must be in the ends stop position.

3.2 - During crimping, keep the wire in position.

3.3 - Just one crimping operation is allowed per contact and wire assembly.

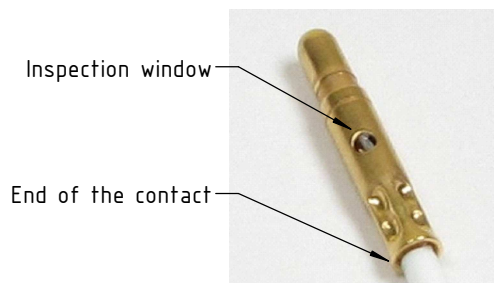
4 - Visually check crimping

4.1 - Crimping must not deform the inspection window.

4.2 - Contact must not have visible fractures or cracks.

4.3 - Contact barrel must not be deformed or bent.

4.4 - Crimping must not deform the end of the contact.



Hand crimp tool in an open position.

Crimp guide.

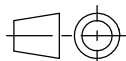


5 - Check it is firmly crimped by pulling gently

5.1 - For that purpose two (2) fingers are enough : pinch the wire and pull smoothly along the axis of the crimped contact



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Echelle/Scale

4:1

a	06/10/14	Edition originale	V.G.		C.F.
Ind.	Date	Modification	Drawn	Checked	Approved

Folder : X:\Méthodes\23 - Connectique spécifique\07 - Connecteurs spécifiques\C17891\

Item : Cable instruction of HP 22-3305 compatible with AWG22

Ref : ICC17891

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