1- Insert the cable into 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

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.

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.

---

### Cable instruction of HP 22-3305

<table>
<thead>
<tr>
<th>Component</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jacket</td>
<td>AWG22</td>
</tr>
<tr>
<td>Conductor</td>
<td>AWG22</td>
</tr>
<tr>
<td>Visual mark</td>
<td>“M”</td>
</tr>
<tr>
<td>Male Contact HP</td>
<td>22-3305</td>
</tr>
<tr>
<td>AWG22</td>
<td>6.2 min.</td>
</tr>
</tbody>
</table>

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### Crimp parameter table

<table>
<thead>
<tr>
<th>Loaded/Unloaded</th>
<th>Cable A ØB</th>
<th>Cable A ØC</th>
<th>Length F conductor M</th>
<th>Solder Tool/Positioner</th>
<th>Crimp tool setting - Number selector</th>
</tr>
</thead>
<tbody>
<tr>
<td>22-3305</td>
<td>1.1 mm</td>
<td>1.65 mm</td>
<td>4.5 mm</td>
<td>x5 OK</td>
<td>16459 / C16461</td>
</tr>
</tbody>
</table>

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

**Ref:** ICC17891