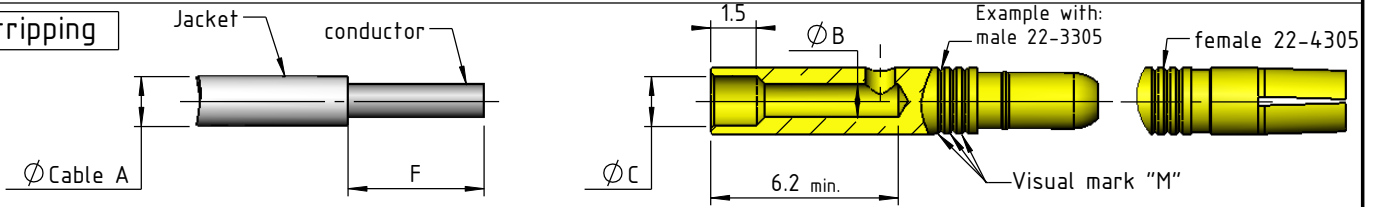


Stripping



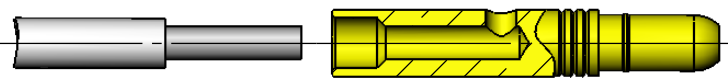
Loaded	Unloaded	Cable A			\varnothing B	\varnothing C	Length F conductor	M	Solder	Crimp by AF8 Tool / Positioner	Crimp tool setting - Number selector		
		AWG20	AWG18	AWG16							AWG20	AWG18	AWG16
3305	22-3305	X	NA		1.1 mm	1.65 mm	4.5 mm	x3	OK	16459 / C16461	4	NA	
3308	22-3308	NA	X	NA	1.35 mm	1.85 mm		x2			NA	5	NA
3310	22-3310		X		1.7 mm	NA	6 mm	x1			4	5	6

Loaded	Unloaded	Cable A			\varnothing B	\varnothing C	Length F conductor	M	Solder	Crimp by AF8 Tool / Positioner	Crimp tool setting - Number selector		
		AWG20	AWG18	AWG16							AWG20	AWG18	AWG16
4305	22-4305	X	NA		1.1 mm	1.65 mm	4.5 mm	x3	OK	16459 / C16461	4	NA	
4308	22-4308	NA	X	NA	1.35 mm	1.85 mm		x2			NA	5	NA
4310	22-4310		X		1.7 mm	NA	6 mm	x1			4	5	6

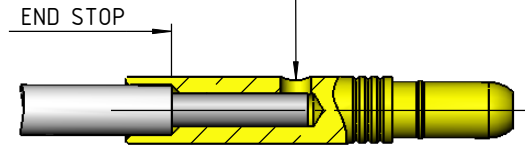
NA : Not Applicable

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

1 - Insert the cable into the contact



END STOP



END STOP only for 22-X310

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

- 2.1 - Select the number selector with the selector knob (see crimp tool setting).
- 2.2 - Put the positioner C16461 on the hand crimp tool 16459.

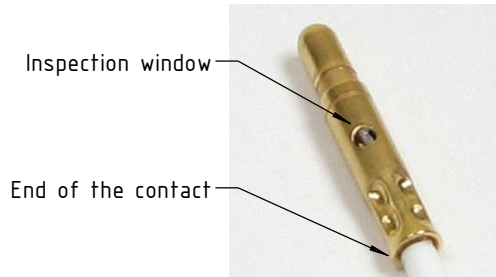


3 - Insert the contact and wire assembly in the crimp guide of the hand crimp tool.

- 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.

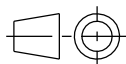


5 - Check it is firmly crimped by pulling gently

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



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Echelle/Scale
4:1

a	21/07/10	Edition originale	C.G.	A.V.	E.M.
Ind.	Date	Modification	Drawn	Checked	Approved

Folder : X:\Méthodes\Documentations\Instruction de cablage\

Item : Cable instruction of HP contact series 22

Ref : IC22HP02

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