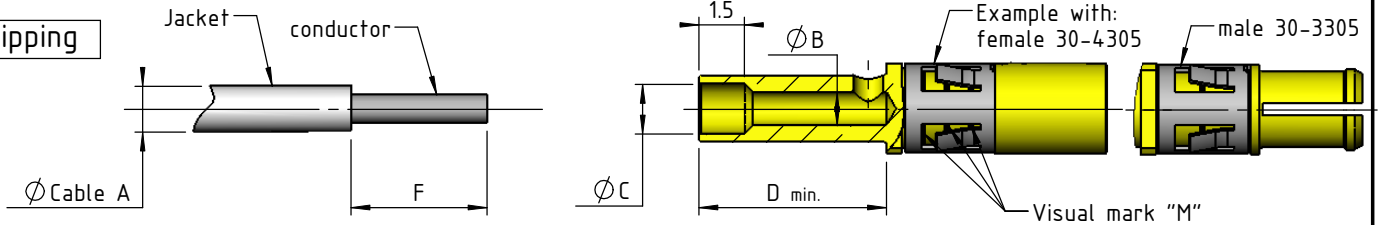


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Stripping



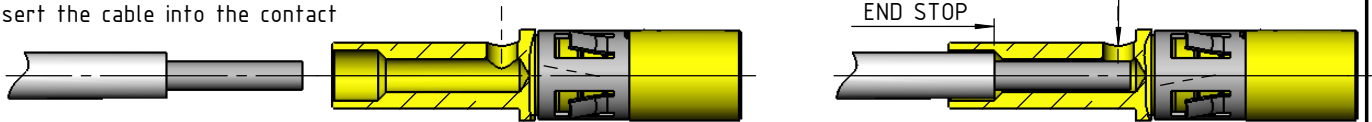
Loaded	Unloaded	Cable A					ØB	ØC	Length F conductor	Length D hole	M	Solder	Crimp by AF8 Tool / Positioner	Crimp tool setting - Number selector				
		AWG20	AWG18	AWG16	AWG14	AWG12								AWG20	AWG18	AWG16	AWG14	AWG12
3305	30-3305	X		NA			1.1 mm	1.65 mm	4.5 mm	6.2 mm	x3	16459 / C16460	3			NA		
3308	30-3308	NA	X		NA	1.35 mm	1.85 mm				x2				NA	4		
3310	30-3310		X			1.7 mm	NA	6 mm		x1	OK		4	4	5		NA	
3315	30-3315			X	NA	2 mm					NA							6
3320	30-3320		NA		X	2.6 mm		5.3 mm	5.5 mm								NA	8

Loaded	Unloaded	Cable A					ØB	ØC	Length F conductor	Length D hole	M	Solder	Crimp by AF8 Tool / Positioner	Crimp tool setting - Number selector				
		AWG20	AWG18	AWG16	AWG14	AWG12								AWG20	AWG18	AWG16	AWG14	AWG12
4305	30-4305	X		NA			1.1 mm	1.65 mm	4.5 mm	6.2 mm	x3	16459 / C16460	3			NA		
4308	30-4308	NA	X		NA	1.35 mm	1.85 mm				x2				NA	4		
4310	30-4310		X			1.7 mm	NA	6 mm		x1	OK		4	4	5		NA	
4315	30-4315			X	NA	2 mm					NA							6
4320	30-4320		NA		X	2.6 mm		5.3 mm	5.5 mm								NA	8

NA : Not Applicable

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

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 selector with the selector knob (see crimp tool setting).
2.2 - Put the positioner C16460 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 end 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

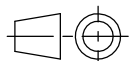


5 - Check it is firmly crimped by pulling gently

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

b	07/09/10	Modif. Toolsetting for 30-X320	C.G.	A.V.	E.M.
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 30

Ref : IC30HP02

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