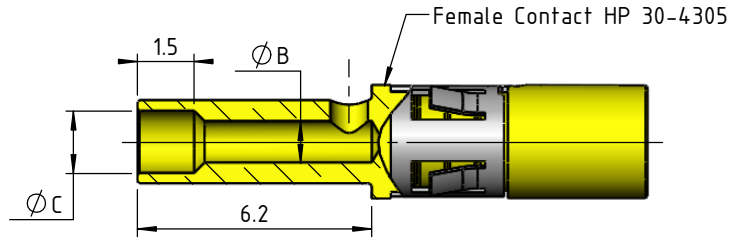
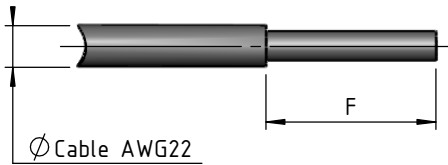


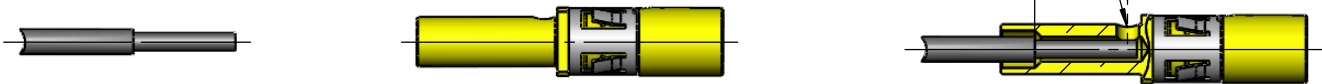
Stripping



Loaded	Unloaded	Cable A AWG22	ØB	ØC	Length F conductor	M	Solder	Crimp by AF8 Tool / Positioner	Crimp tool setting - Number selector	
									AWG22	
4305	30-4305	X	1.1 mm	1.65 mm	4.5 mm	x3	OK	16459 / C16460	Position 3	

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 "Position 3"

2.2- Put the positioner C16460 on the hand crimp tool 16459

Hand crimp tool in a closed position.



"non contractual picture"

Positioner C16460 Selector knob.

3- Insert the contact and wire assembly

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.

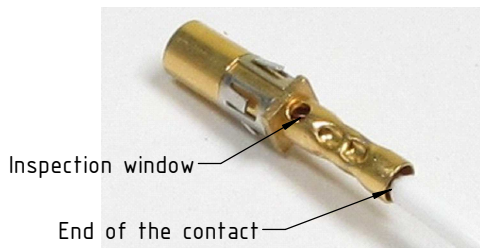
4 - Visually check crimping

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.



Inspection window

End of the contact

Hand crimp tool in an open position.

Crimp guide.

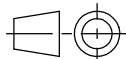


5 - Check it is firmly crimped by pulling gently

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\C17939\

Item : Cable instruction of HP 30-4-305 compatible with AWG22

Ref : ICC17939

Page 1/1

A4