

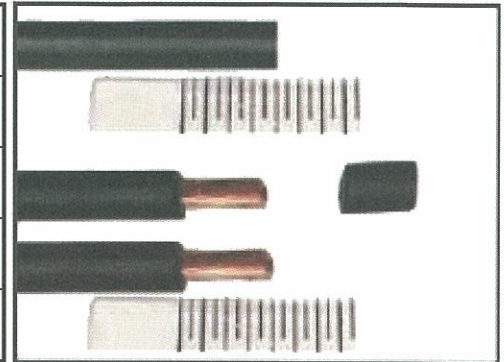


Revisions			
Sym	Description	Date	Approved
NC	New Release per E.O. P19466	3/26/07	David Meyer

### 1. WIRE PREPARATION

Choose wire for contact from Chart below. See Envelope Drawing HDT-48-00 for more contact selections. Strip wire to specified length. Inspect for damaged or missing strands.

Contact SIZE	Contact Part Number	WIRE Range AWGs WIRE Range [mm <sup>2</sup> s]	Strip Dim. INCH Strip Dim. [mm]
<b>20 PIN</b> <b>20 Socket</b>	0460-202-20** 0462-201-20**	<b>20</b> [0.50]	<b>.156-.218</b> [3.96-5.54]
<b>16 PIN</b> <b>16 Socket</b>	0460-202-16** 0462-201-16**	<b>16, 18, 20</b> [1.5/1.0/0.75/0.50]	<b>.250-.312</b> [6.35-7.92]
<b>16 PIN</b> <b>16 Socket</b>	0460-215-16** 0462-209-16**	<b>14</b> [2.50/2.00]	<b>.250-.312</b> [6.35-7.92]
<b>12 PIN</b> <b>12 Socket</b>	0460-204-12** 0462-203-12**	<b>12, 14</b> [4.0/3.0/2.5/2.0]	<b>.222-.284</b> [5.64-7.21]

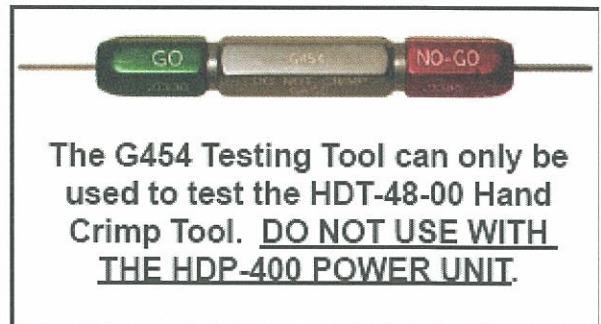
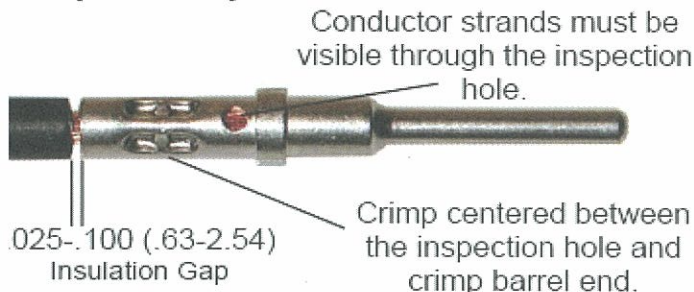


(\*\* PIN and Socket Plating Codes: \*\* = 31 is "Gold" \*\* = 141 is "Nickel")

### 2. CONTACT CRIMPING

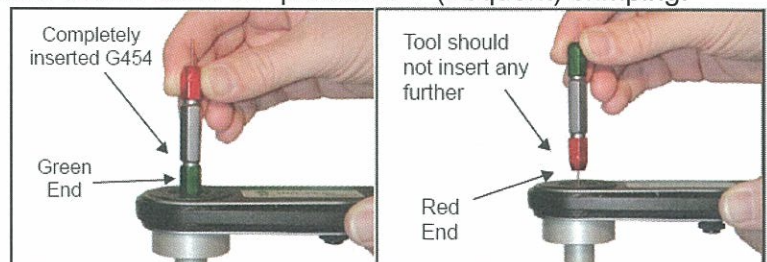
Cycle tool to open handles. Remove lock clip. Raise and rotate dial to select wire size. Replace lock clip. Adjust locator to produce "Proper Crimp".

#### Proper Crimp



Use Gage G454 in Dial Position 16/1.0 to check for wear of indenters. This is recommended on an annual basis for "normal" use. Check more often if used for "production" (frequent) crimping.

**WARNING:** Never close tool on crimp gage. This will damage the indenters and VOID WARRANTY. Close tool first and THEN insert GO or NOGO Inspection Gage.



### 3. MAINTENANCE

Clean tool and remove debris on a regular basis. Inspect for loose or missing hardware.