

CRIMPING INSTRUCTIONS

8 AWG CONTACT WITH
8 AWG WIRE BARREL

TOOLS REQUIRED

1. AIRBORN PN CDG14569—CRIMP TOOL
2. AIRBORN PN CDG14570—POSITIONER FOR PIN AND SOCKET CONTACTS
3. AIRBORN PN CDG5418—REMOVAL TOOL

CRIMPING PROCESS

1. INSTALL POSITIONER ONTO CRIMP TOOL.
2. STRIP INSULATION OF WIRE $.510 \pm .010$
3. DROP CONTACT INTO THE NEST OF THE CRIMP TOOL, MAKING SURE THAT IT BOTTOMS OUT IN THE POSITIONER.



4. INSERT STRIPPED END OF WIRE INTO CRIMP BARREL OF CONTACT. INSULATION SHOULD EXTEND INTO INSULATION CUP.
5. CRIMP CONTACT BY DEPRESSING FOOT PEDAL
6. VISUALLY INSPECT CRIMP:
 - A. WIRE INSULATION SHOULD EXTEND INTO INSULATION CUP. THERE SHOULD NOT BE A GAP BETWEEN INSULATION AND INSULATION CUP.
 - B. THERE SHOULD BE STRANDS OF WIRE VISIBLE THRU THE INSPECTION HOLE IN THE BARREL OF THE CONTACT.

Please consult the AirBorn website for the latest revision of this document prior to beginning any design work.

CRIMPING INSTRUCTIONS CONT'D

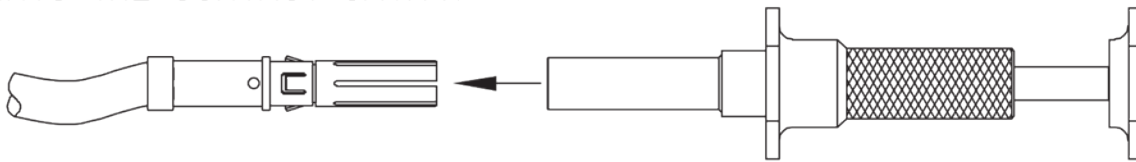
8 AWG CONTACT WITH 8 AWG WIRE BARREL

INSTALLING CONTACTS

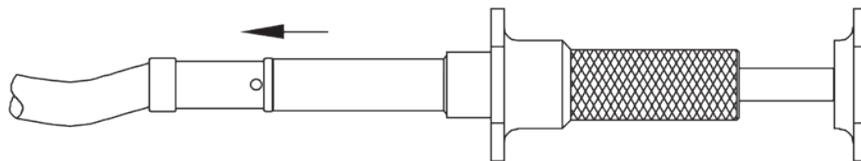
1. CHOOSE CRIMPED WIRE TO BE INSTALLED.
2. HOLD CONTACT BETWEEN THUMB AND INDEX FINGER AT THE BACK OF THE CONTACT BARREL.
3. INSERT CONTACT INTO CONTACT CAVITY FROM THE REAR OF CONNECTOR.
4. PUSH CONTACT INTO CAVITY UNTIL RETAINER IS ENGAGED.
GENTLY PULL BACK ON THE WIRE TO ENSURE SEATING.
IF CONTACT IS PROPERLY SEATED, IT WILL NOT COME OUT OF CONNECTOR WITHOUT THE AID OF THE REMOVAL TOOL.

REMOVING CONTACTS

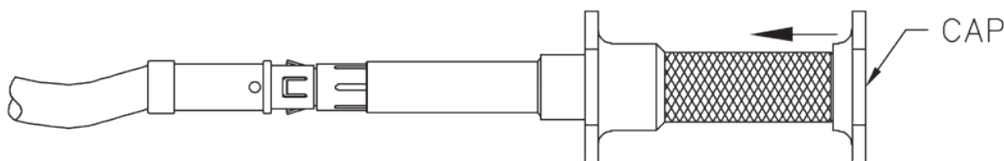
1. IN THE EVENT THAT A WIRE MUST BE EXTRACTED FROM THE CONTACT CAVITY, THE REMOVAL TOOL IS REQUIRED.
2. IN THE FRONT OF THE CONNECTOR(MATING FACE), INSERT REMOVAL TOOL INTO THE CONTACT CAVITY.



3. PRESS THE REMOVAL TOOL DOWN UNTIL THE RETAINER IS RELEASED.



4. PRESS CAP OF TOOL TO DISLODGE CONTACT FROM CAVITY.



5. PULL WIRE AND CONTACT FREE FROM BACK OF CONNECTOR.

Please consult the AirBorn website for the latest revision of this document prior to beginning any design work.