

CRIMPING INSTRUCTIONS

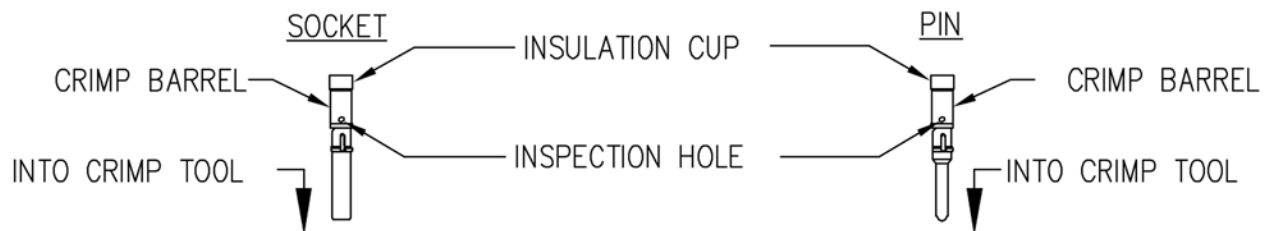
16 AWG CONTACT WITH
16 AWG WIRE BARREL

TOOLS REQUIRED

1. AIRBORN PART NUMBER CDG14571—CRIMP TOOL (MIL-C-22520/1-01)
2. AIRBORN PART NUMBER CDG14572—TURRET FOR PINS AND SOCKETS (MIL-C-22520/1-03)
3. AIRBORN PART NUMBER CDG4492—INSERTION TOOL
4. AIRBORN PART NUMBER CDG4493—REMOVAL TOOL

CRIMPING PROCESS

1. STRIP INSULATION OF WIRE $.200 \pm .010$.
2. INSTALL TURRET ONTO CRIMP TOOL.
3. SELECT THE BLUE/RED BUTTON ON THE TURRET
4. TURN DIAL ON BACK OF CRIMP TOOL TO SETTING 7.
THIS IS A BASELINE SETTING. SEE "GUIDELINES FOR ESTABLISHING TENSILE VALUE FOR CRIMP".
5. DROP CONTACT INTO THE NEST OF THE CRIMP TOOL, MAKING SURE THAT IT BOTTOMS OUT IN THE TURRET.



6. INSERT STRIPPED END OF WIRE INTO CRIMP BARREL OF CONTACT.
INSULATION SHOULD EXTEND INTO INSULATION CUP.
7. CRIMP CONTACT BY SQUEEZING HANDLES TOGETHER. CRIMP IS COMPLETE WHEN HANDLES RELEASE TO ORIGINAL POSITION.
8. VISUALLY INSPECT CRIMP:
 - A. THERE SHOULD BE NO GAP BETWEEN INSULATION AND CRIMP BARREL.
 - B. THERE SHOULD BE STRANDS OF WIRE VISIBLE THRU THE INSPECTION HOLE IN THE CRIMP BARREL.
 - C. THERE SHOULD BE NO STRANDS OF WIRE OUTSIDE THE CRIMP BARREL.

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**GUIDELINES FOR ESTABLISHING
TENSILE VALUE FOR CRIMP**

EQUIPMENT REQUIRED:

FORCE GAGE
WIRE—FROM LOT TO BE USED FOR PRODUCT
CONTACT—FROM LOT TO BE USED FOR PRODUCT
CRIMP TOOL
TURRET

PROCEDURE TO ESTABLISH TENSILE VALUE OF WIRE:

1. CUT 10 PIECES OF WIRE (ABOUT 2–3 INCHES LONG)
2. REMOVE INSULATOR FROM ENTIRE LENGTH OF WIRE
3. TIN APPROXIMATELY 1.00" ON BOTH ENDS
4. PERFORM TENSILE TEST ON FORCE GAGE
5. DETERMINE AVERAGE TENSILE VALUE OF WIRE

PROCEDURE TO ESTABLISH TENSILE VALUE OF CRIMP

1. CUT 10 PIECES OF WIRE (ABOUT 2–3 INCHES LONG)
2. STRIP WIRE .200±.010" ON ONE END AND 1.00" ON OTHER END
3. TIN END OF WIRE THAT IS STRIPPED 1.00"
4. TURN DIAL ON BACK OF CRIMP TOOL TO SETTING 7
5. CRIMP CONTACT ON .200" STRIPPED END
6. PERFORM TENSILE TEST ON FORCE GAGE
7. RECORD ALL 10 READINGS.
8. DETERMINE AVERAGE TENSILE VALUE OF CRIMP
9. TENSILE VALUE OF CRIMP SHOULD BE 75% OF TENSILE VALUE OF WIRE
10. UNDER MAGNIFICATION, EXAMINE CRIMP.
PREFERRED CRIMP FAILURE IS BREAKAGE OF THE WIRE STRANDS OUTSIDE THE CRIMP BARREL.
A CRIMP IS CONSIDERED UNACCEPTABLE IF THE WIRE PULLS OUT OF THE WIRE BARREL WITHOUT BREAKING THE WIRE STRANDS.
11. IF WIRE PULLS OUT OF THE WIRE BARREL WITHOUT BREAKING THE WIRE STRANDS, SELECT THE NEXT LOWER SETTING NUMBER ON THE CRIMP TOOL AND REPEAT PROCEDURE TO ESTABLISH TENSILE VALUE OF CRIMP.
THE LOWER THE SETTING NUMBER ON THE CRIMP TOOL, THE TIGHTER THE CRIMP.

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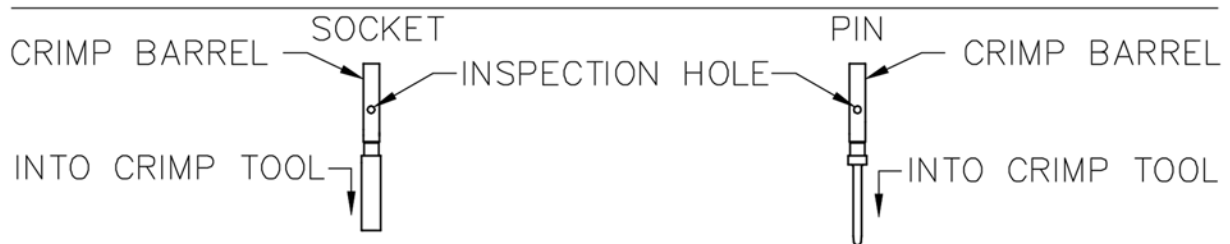
24 AWG CONTACT WITH
24, 26, 28 AND 30 AWG WIRE BARREL

TOOLS REQUIRED

1. AIRBORN PN CDG4601—CRIMP TOOL
2. AIRBORN PN CDG4602—POSITIONER FOR SOCKET CONTACTS
3. AIRBORN PN CDG5598—POSITIONER FOR PIN CONTACTS
4. AIRBORN PN CDG8161—REMOVAL TOOL

CRIMPING PROCESS

1. SELECT CORRECT POSITIONER FOR THE PIN OR SOCKET CONTACT.
2. INSTALL POSITIONER ONTO BACK OF CRIMP TOOL.
3. CHOOSE "SELECTION NUMBER" FROM POSITIONER FOR THE WIRE AWG THAT HAS BEEN SELECTED FOR YOUR APPLICATION. SET CRIMP TOOL TO THAT SELECTION NUMBER.
4. STRIP INSULATION OF WIRE $.145 \pm .005$
5. DROP CONTACT INTO THE NEST OF THE CRIMP TOOL, MAKING SURE THAT IT BOTTOMS OUT ON THE POSITIONER.



6. INSERT STRIPPED END OF WIRE INTO BARREL OF CONTACT. INSULATION SHOULD BE FLUSH WITH BACK OF CONTACT BARREL.
7. CRIMP CONTACT BY SQUEEZING HANDLES TOGETHER. CRIMP IS COMPLETE WHEN THE HANDLES RELEASE TO ORIGINAL POSITION.
8. VISUALLY INSPECT CRIMP:
THERE SHOULD BE NO GAP MIN./ONE WIRE DIA MAX. BETWEEN INSULATION AND BARREL OF CONTACT.
THERE SHOULD BE STRANDS OF WIRE VISIBLE THRU THE INSPECTION HOLE IN THE BARREL OF THE CONTACT.

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