

CRIMPING INSTRUCTIONS

20 AWG CONTACT WITH
20,24–26 OR 28–30 AWG BARREL

TOOLS REQUIRED

1. AIRBORN PN CDG4601—CRIMP TOOL
2. AIRBORN PN CDG7935—POSITIONER FOR SOCKET CONTACTS
3. AIRBORN PN CDG7936—POSITIONER FOR PIN CONTACTS
4. AIRBORN PN CDG7932—REMOVAL TOOL

CRIMPING PROCESS

1. SELECT CORRECT POSITIONER FOR THE PIN OR SOCKET CONTACT.
2. INSTALL POSITIONER ONTO BACK OF CRIMP TOOL.
3. TO DETERMINE WHICH "SELECTION NUMBER" TO CHOOSE ON THE CRIMP TOOL, BEGIN BY DETERMINING THE TENSILE STRENGTH OF THE WIRE TO BE USED.

FOR EXAMPLE, IF USING 20 AWG WIRE BEGIN BY TURNING "SELECTION NUMBER" TO 6. CRIMP TEST CONTACTS(3–5 PIECES). PERFORM TENSILE TEST. TENSILE TEST RESULTS ARE INVALID IF (1)ANY STRANDS OF WIRE ARE NOT CAPTURED IN BARREL, (2)STRANDS ARE NICKED OR CUT BEFORE TEST, (3) WIRE BROKE AT SHARP EDGE OF TEST FIXTURE, OR (4)WIRE PULLED OUT OF BARREL WITHOUT BREAKING STRANDS.

IF TENSILE STRENGTH VALUES ARE NOT 75% (MINIMUM) OF TENSILE STRENGTH OF WIRE, CHANGE "SELECTION NUMBER". CRIMP ANOTHER GROUP OF TEST CONTACTS(3–5 PIECES) AND PERFORM TENSILE TEST AGAIN.

CONTINUE THIS PROCESS UNTIL TENSILE STRENGTH OF CRIMP MEETS OR EXCEEDS 75% OF TENSILE STRENGTH OF WIRE.

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4. STRIP LENGTH OF INSULATION:
24–26 AND 28–30 AWG: $.145 \pm .005$
20 AWG: $.190 \pm .005$
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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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 CONNECTOR UNTIL A DEFINITE "CLICK" IS HEARD. GENTLY PULL BACK ON THE WIRE TO CONFIRM 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. OPEN REMOVAL TOOL AND PLACE TIP AROUND THE WIRE INSULATION.
3. MOVE THE TOOL SO THAT THE TIP GOES DOWN INTO THE CONTACT CAVITY.
4. WHILE PRESSING THE TOOL DOWN, ROTATE THE HANDLE BACK AND FORTH.
5. WHEN THE TIP OF THE HANDLE IS DOWN AS FAR AS IT WILL GO, THE CONTACT IS READY TO BE REMOVED.
6. MAKING SURE TO KEEP THE TIP OF THE TOOL PERPENDICULAR TO THE CONNECTOR, PULL TOOL FREE OF THE CONTACT CAVITY.
7. OPEN REMOVAL TOOL AND REMOVE THE EXTRACTED WIRE.

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