

CRIMPING INSTRUCTIONS

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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CRIMPING INSTRUCTIONS CONT'D

24 AWG CONTACT WITH
24, 26, 28 AND 30 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 CONNECTOR UNTIL A DEFINITE "CLICK" IS HEARD. GENTLY PULL BACK ON THE WIRE TO INSURE 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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CRIMPING INSTRUCTIONS

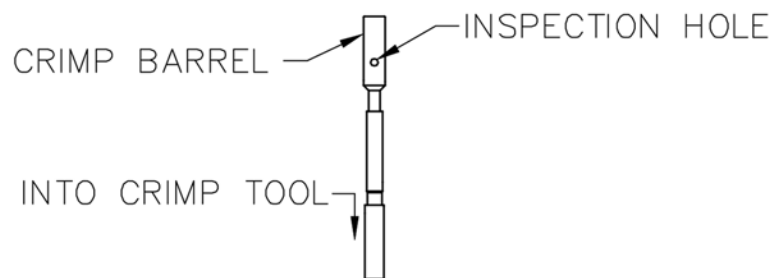
24 AWG CONTACT WITH
22 AND 20 AWG WIRE BARREL

TOOLS REQUIRED

1. AIRBORN PN CDG4601—CRIMP TOOL
2. AIRBORN PN CDG4603—POSITIONER FOR SOCKET CONTACTS
3. AIRBORN PN CDG8161—REMOVAL TOOL

CRIMPING PROCESS

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



5. INSERT STRIPPED END OF WIRE INTO BARREL OF CONTACT. INSULATION SHOULD BE FLUSH WITH BACK OF CONTACT BARREL.
6. CRIMP CONTACT BY SQUEEZING HANDLES TOGETHER. CRIMP IS COMPLETE WHEN THE HANDLES RELEASE TO ORIGINAL POSITION.
7. 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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CRIMPING INSTRUCTIONS CONT'D

24 AWG CONTACT WITH 22 AND 20 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 CONNECTOR UNTIL A DEFINITE "CLICK" IS HEARD. GENTLY PULL BACK ON THE WIRE TO INSURE 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. THE WIRE BARREL MUST BE CUT OFF BEFORE USING REMOVAL TOOL.
3. OPEN REMOVAL TOOL AND PLACE TIP AROUND THE WIRE INSULATION.
4. MOVE THE TOOL SO THAT THE TIP GOES DOWN INTO THE CONTACT CAVITY.
5. CONTINUE TO LIGHTLY PRESS DOWN. IF RESISTANCE IS MET, ROTATE FORTH IF TOOL MEETS ANY RESISTANCE.
6. WHEN THE TIP OF THE HANDLE IS DOWN AS FAR AS IT WILL GO, THE CONTACT IS READY TO BE REMOVED.
7. MAKING SURE TO KEEP THE TIP OF THE TOOL PERPENDICULAR TO THE CONNECTOR, PULL TOOL FREE OF THE CONTACT CAVITY.
8. OPEN REMOVAL TOOL AND REMOVE THE EXTRACTED WIRE.

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