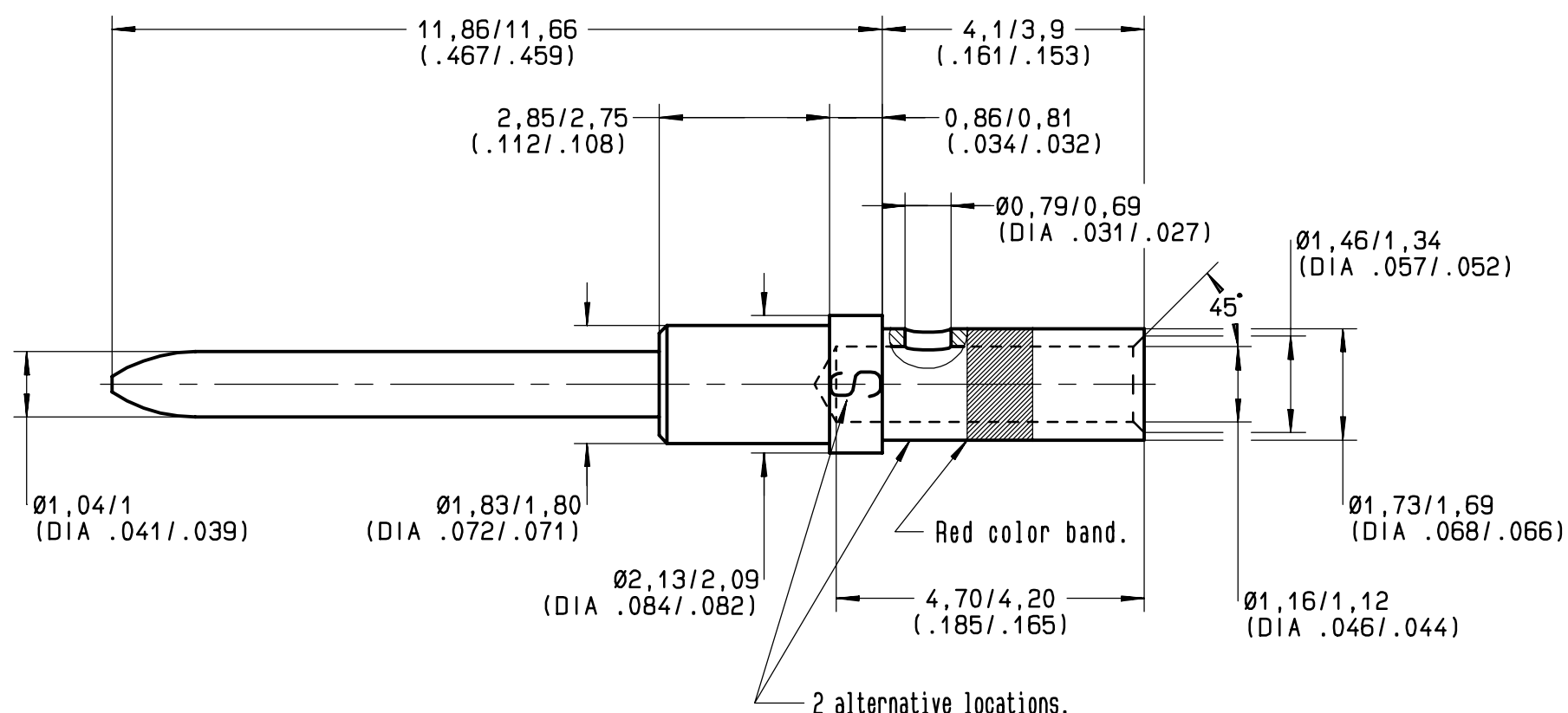




MATERIAL: COPPER ALLOY (C97) HARDNESS IN KNOOP 120 MAX (107 HV) FOR CRIMP BARREL
180 MIN (165 HV) FOR BEYOND SHOULDER

FINISH:GOLD PER MIL-G-45204 TYPE I OR II GRADE C OR D CLASS 1 50 MICROINCHES OVER NICKEL PLATE PER QQ-N-290

WIRES ACCOMODATED:AWG 20-22-24
INSULATOR DIAMETER:.071 MAX (1,80)
STRIP LENGTH:.158 (4)

CRIMP CONTACT TENSILE REQUIREMENTS USING MIL SPEC TOOLING AND WIRE SPEC

MIL-W-81381/12	20 GA.	20 LBS (9 daN)
MIL-W-22759/41	20 GA.	20 LBS (9 daN)
M22520/2-01	20 GA.	20 LBS (9 daN)

CRIMPED CONTACTS WILL SHOW NO CRACK WHEN INSPECTED PER MIL-C-22520 AT 10X

RADIAL TOOLING RECOMMENDATION
CRIMPING TOOL:M22520/2-01 (RADIAL 282 281)
SELECTOR POSITION:7 FOR AWG 20
6 FOR AWG 22
5 FOR AWG 24
POSITIONER:M22520/2-08 (RADIAL 282 971)

INSERTION/EXTRACTION TOOL:M81969/1-02 (RADIAL 282 886)
SPL RADIAL INS. 282 881 / EXT. 282 891

This information is given as an indication. In the continual goal to improve our products, we reserve the right to make any modifications judged necessary.

4112-9311

CREATION	05.13.02	"S": 2 alternative locations added.	L.Garcia	G.Motteau
PEN:	30 SEP 98	SYNTAX ERROR: CRACK WAS CREAK; UPDATED FINISH CHANGED S LOCATION; 11,86/11,66 was 11,85/11,65 $\phi_{0,79(.031)}^{0,69(.027)}$ was $\phi_{0,75(.029)}^{0,65(.026)}$; $2,85(.112)$ was $2,81(.114)$	L.GARCIA	O.VERNEAU
NOM: MACARI	01 JULY 98	UPDATED FROM THE DETAIL DRAWING	ARNAULT	O.VERNEAU
DATE: 01 NOV 86	26 MAR 98	REDRAWN	VALGRESY	L GIET
APPR.:	Issue	Revisions	Name	Approved