



ASSEMBLY INSTRUCTION

opticalCON® DRAGONFLY | Contact Crimping

1 Wire preparation

(A)



(A)

Strip the isolation to 5 mm for all wires.

Use following AWG Sizes:

- POWER - AWG 16
- SENSE - AWG 24

2 Required Crimp Tools

(A)



(A)

DMC MH860 Crimp Tool

(B)



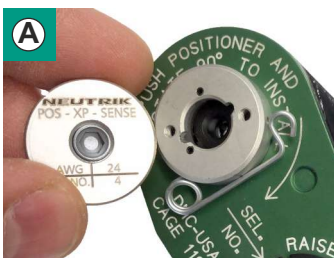
(B)

Crimp DIE

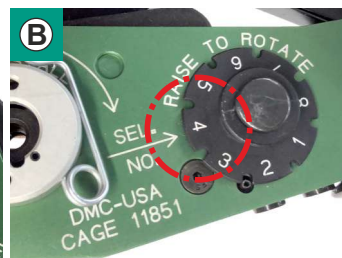
- POS-XP-POWER
- POS-XP-SENSE

3 Crimp Tool Setup

(A)



(B)



(A)

Use the correct Crimp DIE. Therefore check the labeling on the DIE.

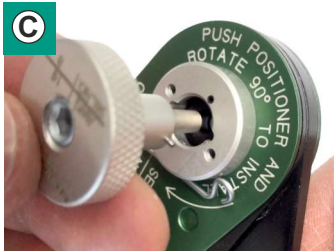
(B)

Set the sel. No as noted on the Crimp DIE.

(C)

Insert the DIE.

(C)



(D)

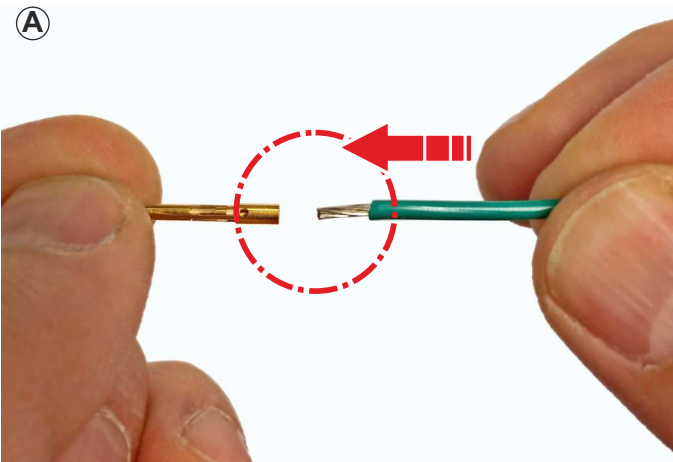


(D)

Rotate 90° to lock the DIE.



4 Contact Crimping

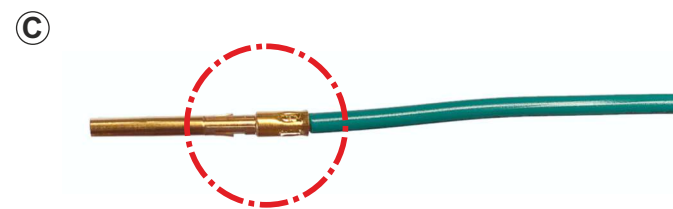


A Attach the contact to the wire.



B Insert the contact from the backside into the crimp tool.

When totally seated, crimp the contact.



C Contact is now crimped and can be inserted in the chassis.



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