

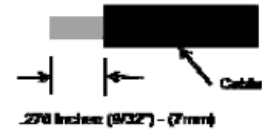
### Cable preparation and stripping process

Strip cable 0.276 inches (7.0 mm) and be careful NOT to nick conductors.

Amphenol specified strip tool (H4TS0000) can be used in this step.

Adjust the stripper stopper and put the cable in corresponding notch to strip the length of 7mm.

See below pictures.



Cable against stopper



Stripped cable

### Crimp process solid contacts

When you insert striped cable into contact barrel, always insure all conductor strands are captured in the contact barrel and the conductors are visible in the inspection hole. See below pictures.



Pin solid contact



Socket solid contact

Inspection hole

Insert the contact into the corresponding crimping notch or locator (male or female) taking into account the cable size used.

Press the pliers gently together until the crimp lugs are properly located within the crimping die. Insert the stripped cable end until the insulation comes up against the crimp insert. Completely close the crimping pliers.

See below pictures.

Amphenol specified crimp tool (H4TC0001) should be used in this step.



Positioner



Crimper with die

See below pictures for crimp result solid contacts.



Crimped solid pin



Crimped Solid socket

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**Crimp process stamped and formed contacts:**

Insert the contact into the corresponding crimping notch or locator (male or female) taking into account the cable size used.



Open barrel socket S&F contact



Open barrel pin S&F contact

Press the pliers gently together until the crimp lugs are properly located within the crimping die. Insert the stripped cable end until the insulation comes up against the crimp insert. Completely close the crimping pliers.

See below pictures of crimp result

Amphenol specified crimp tool (H4TC0002) should be used in this step



Closed barrel socket S&F contact



Closed barrel pin S&F contact

The cable pull-out forces requirement will have to be the following:

Cable size	Cable pull –out force requirement
2.5 mm <sup>2</sup>	Min. 230 N (~50 Lbs)
4.0 mm <sup>2</sup>	Min.310 N (~70 Lbs)
6.0 mm <sup>2</sup>	Min. 360.0 N (~80 Lbs)

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**Assembly process connector:**

Insert contact cable assembly into back of male and female connector. A “click” should be heard or felt when the contact cable assembly is seated in correct position. Contacts cannot be removed once seated.

See below pictures.

**Connector cable female**



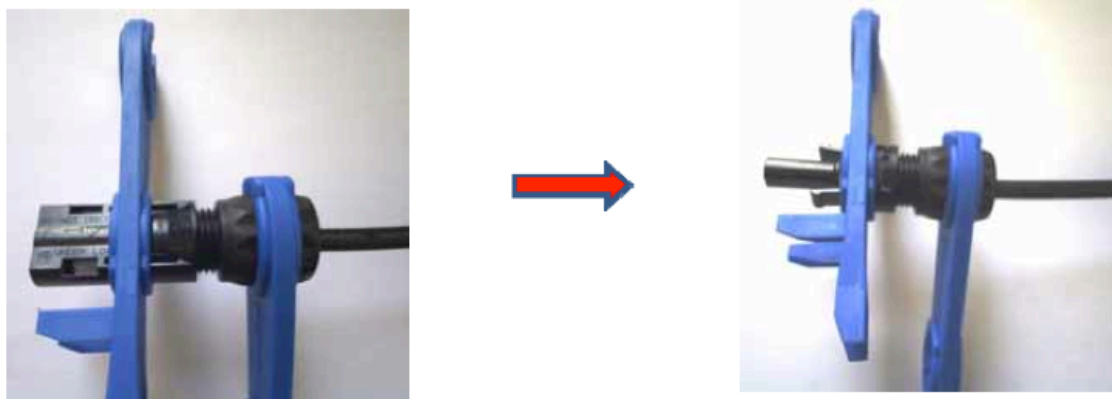
**Connector cable male**



Back cap must be closed using a torque between 2.6 and 2,9NM.

Amphenol specified hand wrench tool (H4TW0001) can be used in this step or electric torque controlled wrench tool with as well the Amphenol open-end back cap spanner (H4TE0000) or socket wrench (H4TF000). See below picture for hand wrench.

Note: Pneumatic wrench tools are NOT recommended since torque control is very difficult.



**Double spanner cap closing operation**

**Connector mating and un-mating:**

For mating align the 2 half connectors and mate them together by hand until a “click” is heard and/or felt.

For un-mating, since the Amphenol H4 connector complies with the NEC 2008 690.33, a tool is required to disconnect the connector once mated.

Amphenol specified wrench tool (H4TW0001) or Universal tool (H4TU0000) should be used in this step.

See below pictures.

WRENCH TOOL DISCONNECT



UNIVERSAL TOOL DISCONNECT

