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CONTACT to CONDUCTOR CRIMP TRAINING

(mo/yr)

Revisions		Rev:	Orig
Letter	E.O. Number - Description	Date	
Used On	Contract#:	Your Co Name	
Prepared By:			
Your Dept:			
Your Dept:		Your Procedure Name	
Your Dept:		Your #	
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Your Logo

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1.0 Scope

This procedure implements NASA-STD-8739.4, Workmanship Standard for Crimping, Interconnecting Cables, Harnesses, and Wiring. This procedure is based upon a nationally recognized standard and is considered certified due to (Your Co's) conformity with the standard. Deviation from the standards referenced herein must be based upon [REDACTED]

[REDACTED] This procedure is subject to Customer review and acceptance.

2.0 References

Unless otherwise specified herein, compliance to the following documents is mandatory for training and production crimping. In the event of conflict between this document and any referenced document, the provisions of this document shall take precedence.

- 2.1 Crimp Log, (Your #)
- 2.3 NASA-STD-8739.4, Workmanship Standard for Crimping, Interconnecting Cables, Harnesses, and Wiring.
- 2.4 Procedure for Wire Crimp and Installation of Crimp Contacts in Connector, (Your #)
- 2.5 Training Certification Card, (Your #)
- 2.6 Training Log, (Your #)
- 2.7 Vision Acuity Record, (Your #)

3.0 Equipment, compliant with NASA-STD-8739.4

- 3.1 [REDACTED]
- 3.2 [REDACTED]
- 3.3 [REDACTED]
- 3.4 [REDACTED]
- 3.5 [REDACTED]
- 3.6 [REDACTED]

4.0 Materials

- 4.1 [REDACTED]
- 4.2 [REDACTED]
- 4.3 [REDACTED]

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5.0 Operator/Inspector Qualification

5.1 Prerequisites

Prior to the start of crimp training each student must complete [REDACTED]

5.2 Personnel Certification

Personnel responsible for producing, inspecting and testing wire crimps shall comply with NASA-STD-8739.4. They shall be certified to perform [REDACTED]

[REDACTED] Personnel will be recertified [REDACTED]

5.3 Training Requirements

Students are required to fabricate, inspect and test wire crimps to the extent necessary to support production designs and to attain knowledge sufficient to pass an exam derived from [REDACTED]

5.3.1 Training Material

The training program shall comply with requirements of NASA-STD-8739.4 and [REDACTED]

5.3.2 Wire Crimp Test Requirements

Acceptance criteria for wire crimp assemblies are stated in NASA-STD-8739.4

5.4 Qualification and Certification Records

The instructor shall maintain the following written records of student qualification:

- 1) [REDACTED]
- 2) [REDACTED]
- 3) [REDACTED]

The instructor shall issue a Certificate of Achievement [REDACTED]

[REDACTED] shall identify

Also, a [REDACTED]

The Certificate of Achievement or [REDACTED] is not required to be [REDACTED]

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6.0 Process and Equipment Controls

6.1 Environmental Conditions

The assembly area shall comply with [REDACTED]

6.2 Insulation Stripping Tool

Insulation stripping tools shall [REDACTED]

not

If thermal stripping tool is

Periodic verification shall [REDACTED]

6.3 Crimp Tool

Crimp tools shall be examined and verified as follows:

- 1) [REDACTED]
- 2) [REDACTED]
- 3) [REDACTED]
- 4) [REDACTED]
- 5) [REDACTED]
- 6) [REDACTED]
- 7) [REDACTED]

7.0 Procedure for Producing and Testing Crimp Assemblies

7.1 Insulation Stripping

Insulation shall be removed [REDACTED]

between the [REDACTED]

as follows:

- 1) [REDACTED]
- 2) [REDACTED]

7.1.1 Insulation Removal Inspection

After removal of insulation, the remaining insulation shall [REDACTED]

according to NASA-STD-

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8739.4.

Slight discoloration [redacted] Conductors with damaged [redacted]

7.1.2 Conductor Inspection after Insulation Removal

The conductor (now exposed) shall not [redacted] provided the base [redacted] Conductors that have been [redacted] shall not be used. The lay of the wire strands shall [redacted]

7.2 Contact Inspection

Contacts shall be inspected using [redacted] to ensure the following anomalies do not exist.

- 1) [redacted]
- 2) [redacted]
- 3) [redacted]
- 4) [redacted]

7.3 Cleaning, Insertion and Crimping of Contact-Conductor Combinations

7.3.1 Cleaning

Using a small nylon brush [redacted] the contact and conductor shall [redacted] If the wire lay is [redacted]

7.3.2 Contact-Conductor Combinations Required

Allowable contact-conductor combinations are stated in NASA-STD-8739.4, manufacturer's recommendations.

7.3.3 Insertion and Crimping

Place contact into crimp opening. Fully insert [redacted] Squeeze crimp [redacted] Verify clearance is as stated in [redacted]

7.4 Testing Contact-Conductor Combinations

7.4.1 Test Requirements

A tensile-testing device, appropriate fixtures and sufficient force shall [redacted] The tensile-tester shall be set up as follows:

- 1) [redacted]

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2)

7.4.2 Test Sample Quantity and Frequency Requirement

A minimum of [redacted] samples shall [redacted]

whichever is shorter. Each test sample shall [redacted]

A sample that [redacted] shall [redacted]

7.4.2.1 Tensile-Tester Set-up and Procedure

Verify tensile-tester is ready for testing samples.

- 1)
- 2)
- 3)
- 4)
- 5)
- 6)
- 7)
- 8)

7.4.2.2 Tensile Strength Requirements

Crimp tensile strength shall meet requirements stated in NASA-STD-8739.4, Table [redacted]

7.4.2.3 Visual Acceptance of Tested Samples

Each test sample shall [redacted]

[redacted] Crimp joint tensile failures will [redacted]

The crimp tool setting that produces the maximum number of fray breaks and breaks outside the contact shall [redacted]

7.4.2.4 Data Recorded

The following data is to be recorded on the Crimp Test Log (Your #):

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- 1) [REDACTED]
- 2) [REDACTED]
- 3) [REDACTED]
- 4) [REDACTED]
- 5) [REDACTED]
- 6) [REDACTED]
- 7) [REDACTED]
- 8) [REDACTED]
- 9) [REDACTED]
- 10) [REDACTED]
- 11) [REDACTED]

8.0 WORKMANSHIP

Adherence to [REDACTED]
[REDACTED] are mandatory.

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