

## Crimp Connector Assembly Work Order

Project: \_\_\_\_\_ Page: \_\_\_\_\_ of: \_\_\_\_\_

Assembly Name:	Drawing Number:	Build To Rev.	Assembly Serial Number:
J#/P#	Connector	Contact	
Prepared By:	R&QA	Project	

Step No.	Type	Description	Perf By:	Date
1	A	PREPARE WIRES AND CRIMP CONTACTS PER NASA SPEC NHB 5300.4(3H)		
2	A	PREPARE WIRES FOR CRIMPING		
		-STRIP WIRES WITH MECHANICAL STRIPPER LABELLED PER WIRE GAUGE WIRE STRIPPER SET #		
		-CLEAN WIRES USING WIPES AND ISOPROPANOL		
3	A	PREPARE CONTACTS FOR CRIMPING		
		-BLOW OUT CONTACT BARREL USING COMPRESSED AIR		
		-VISUALLY INSPECT CRIMP CONTACTS INSURING NO DEBRIS IN CONTACT BARREL		
4	A	CRIMP TOOL QUALIFICATION		
		-CRIMP TOOLS USED		
		-TOOL: M22520/2-01 RECALIBRATION DATE		
		- TURRET: M22520/2-		
5	A/I	TEST		
		-GO/NO GO TEST WITH TOOL M22520/3-01		
		-VERIFY PULL TEST PERFORMED PER "TENSILE TEST DAILY LOG"		
6	A/I	CRIMP PINS/SOCKETS FOR CONNECTOR J#/P# PER SCHEMATIC DRAWING 64- REV		
		-CONNECTOR TYPE PER PARTS LIST 64-		
		-CONTACT TYPE		
		-USE TOOL SPECIFIED IN STEP 4		
		-CRIMP TOOL SETTING WIRE TYPE #1		
		-CRIMP TOOL SETTING WIRE TYPE #2		
		-CRIMP TOOL SETTING WIRE TYPE #3		
		-VISUAL INSPECTION M.I.T. Q.A.		
7	A	INSERT CONTACTS IN CONNECTOR PER ATTACHED WIRING LIST		
		-LABEL CONTACT PIN #'S ON WIRES		
8	A/I	VERFIY PIN RETENTION M.I.T. Q.A.		
9	A	CLEAN, BAG, AND TAG HARNESS; INSTALL CONN COVERS		
10	A	STORE IN FLIGHT ASSEMBLY AREA FOR NEXT LEVEL OF ASSEMBLY		

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