

Helios H4 Assembly Instructions

H4 connectors come pre-assembled as below with loose turned crimp contacts



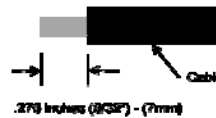
PV-10050X-F (FEMALE COUPLER)



PV-10050X-M (MALE COUPLER)

H4 Connector cable preparation and stripping

- 1.1 Strip cable 0.276 inches – 7,0mm and be careful NOT to nick conductors.



Amphenol specified strip tool (PV-670509-000) 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 1 and 2



Picture 1



Picture 2

H4 Connector contact crimping

- 1.2 Insert striped cable into contact barrel and insure all conductor strands are captured in the contact barrel and the conductors are visible in the inspection hole. See below pictures 3 and 4



Picture 3



Picture 4

Inspection hole

- 1.3 Crimp contact barrel by using the hex or 4-ident crimping die. See below pictures 5 and 6 for crimp result for hex crimp.



Picture 5



Picture 6

Amphenol specified crimp tool (PV-670508-000) can be used in this step.

Put the contact barrel with striped cable in the corresponding crimping notch and crimp the contact. See below picture 7, 8 and 9.



Picture 7



Picture 8



Picture 9

The pull-out forces requirements will have to be as following:

Cable size	Cable pull –out force requirement
2.5 mm ²	Min. 310 N (70 Lbs)
4.0 mm ²	Min. 400 N (90 Lbs)
6.0 mm ²	Min. 450 N (100 Lbs)

