

## 1. INTRODUCTION

Cable-applied NettWarrior OCH contacts consist of a pin (2226913-1), ground pin (222913-2), and socket (2226923-1). These contacts accept discrete wire conductor sizes 22 & 24 AWG (max insulation diameter 1.27mm [.05"])



### NOTE

Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets] and have a tolerance of  $\pm 0.1$  mm [ $\pm .004$  in.]. Figures are not drawn to scale.

## 2. DESCRIPTION

Each connector consists of an outer shell, a dielectric insert assembly with metal contact retention clips, and interfacial and wire seals, plus 6 or 7 signal and ground contacts

## 3. ASSEMBLY

### 3.1. Connector Cable Preparation

- Strip the cable jacket and individual wires' insulation, then roll the cable EMI braid back to the lengths shown in Figure 1. Refer to Detail A for Plug dimensions and Detail B for Receptacle dimensions.



### CAUTION

Reasonable care must be taken not to nick, scrape, or cut any wire conductors during the stripping operation.

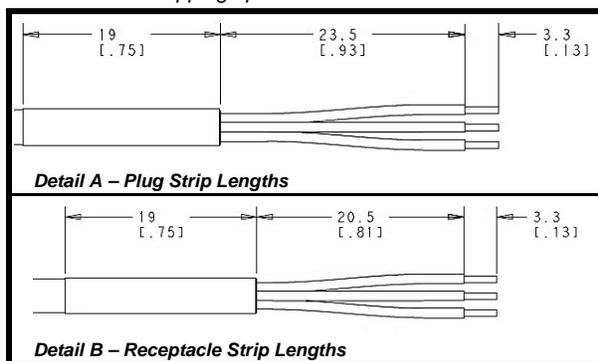


Figure 1

- Terminate appropriate contacts onto individual wires using crimping tool M22520/2-01, Use positioner K1461 for contacts 2226913-1 and 2226923-1. Use positioner K2062 for contact 2226913-2. See Figures 2 and 3.

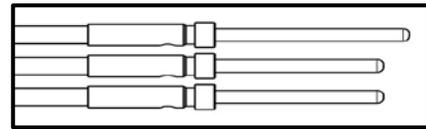


Figure 2 – Terminated Pin Contacts

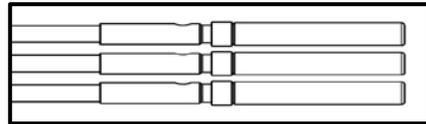


Figure 3 – Terminated Socket Contacts

- Insert crimped contacts into designated cavities from the rear of the connector using Daniels insertion tool, DAK225-22, one contact at a time. See Figure 4 for spacing between cable EMI braid and rear of shell. (If needed, use extraction tool 809-088 (D163088)).

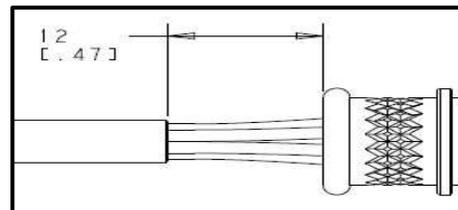


Figure 4 – Distance between Braid and Shell



### CAUTION

Perform a hand pull check to be sure that contacts are locked into cavities and will not pull out before moving to next step.

- Fill back end of plug with S1125, TE p/n 878462-000, epoxy and cure (1 hour @ 85°C).
- Using TE's Band Strap Adapter, BND0812S, terminate the cable braid to the rear of the shell in the knurled area.



### NOTE

For more information on applying band straps and the suggested tooling, refer to ELE-3COP375, which is available on the product specification documentation section of the band strap product page (<http://www.te.com/usa/en/product-CX6566-000.html>).

- Apply heat shrink tubing or overmold boot to complete connector/harness assembly.

#### 4. ADDITIONAL FIGURES

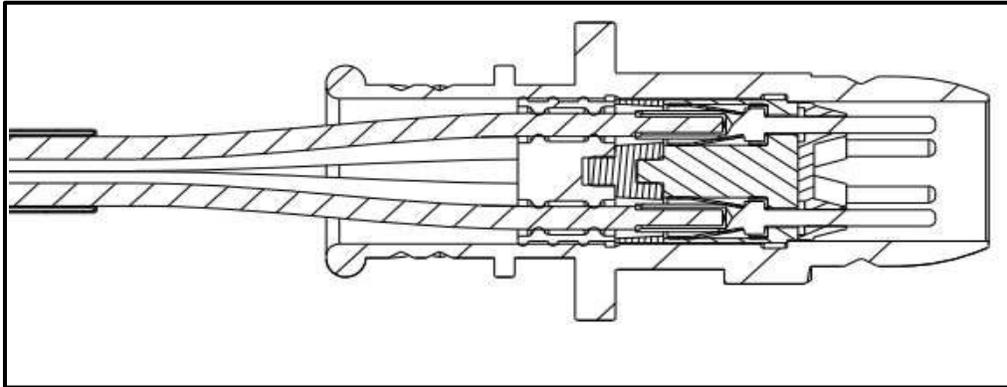


Figure 5 - Cross Section of Plug Connector with Pins Installed

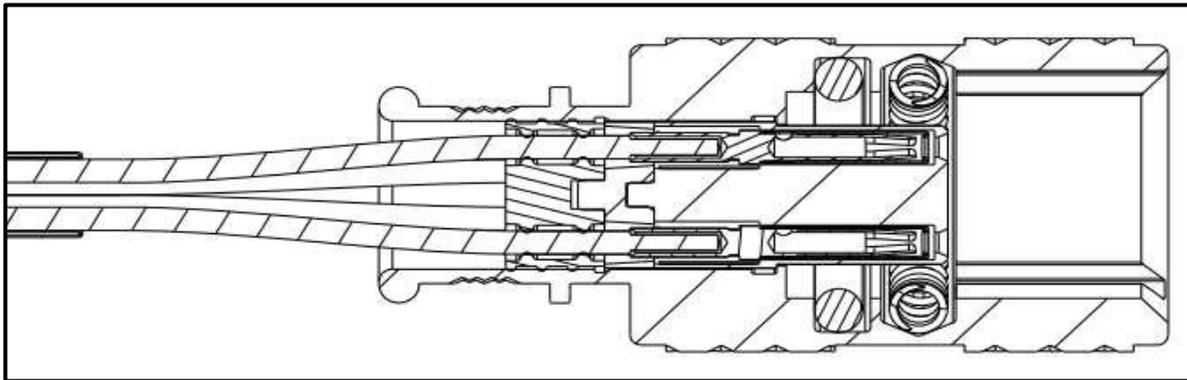


Figure 6 - Cross Section of Receptacle Connector with Sockets Installed

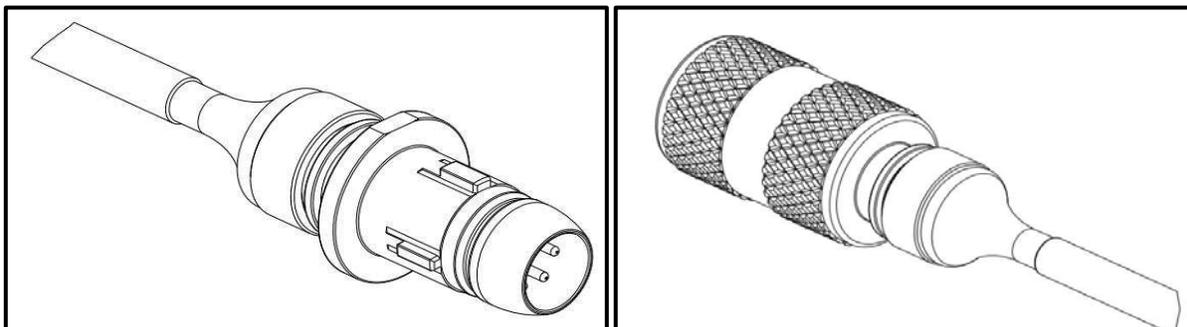


Figure 7 Completed NettWarrior Plug and Receptacle Assemblies with Braid Terminated using Band Strap.

#### 5. REVISION SUMMARY

Rev A: October 18, 2017 – Document Created – NPR

Rev B: May 1, 2019 – Added Extraction Tool Part Number – NPR

Rev C: September 25, 2019 – Added contact P/Ns, crimp positioner and max wire info – NPR