

WIRE STRIPPING

Strip wires to dimension "A" shown in table at right. Avoid cutting or nicking wire strands.



CONTACT SIZE	WIRE SIZE	SEALING RANGE WIRE O.D.	STRIPPING LENGTH DIMENSION "A"
		MAX.	
22	20-24-26-28 AWG	0.054 (1.37)	.156 – .125
20	20-22-24 AWG	0.083 (2.11)	.185 – .155
16	16-18-20 AWG	0.103 (2.61)	.260 – .230
8	8-10 AWG	0.255 (6.48)	.395 – .365

All dimensions in inches (millimeters in parenthesis)

CONTACT CRIMPING



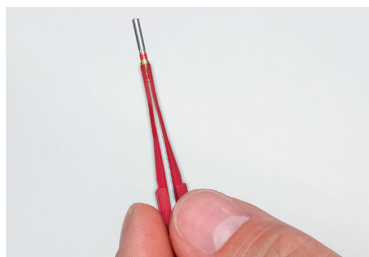
STEP 1: Fully insert wire into contact crimp pocket. Wire must be visible through wire inspection hole.



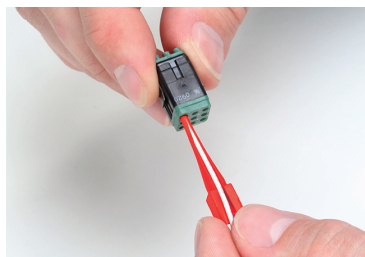
STEP 2: Insert contact into tool (use proper crimping tool as listed on preceding page). Crimp contact to wire. Tool will not open if contact is not fully crimped.

STEP 3: After crimping, wire should be visible through wire inspection hole.

CONTACT INSERTION

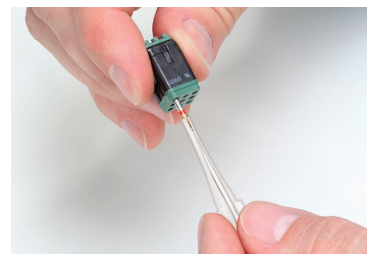


STEP 1: Using proper insertion/removal tool as listed on previous page, slip wire into insertion end (colored end), placing crimp end of contact inside the slotted portion and contact shoulder against end of tool.



STEP 2: Align contact with the cavity at the rear face of the module. Carefully push the contact into the full depth of the cavity. Withdraw tool. A slight axial pull on the wire will confirm contact is locked in proper position.

CONTACT REMOVAL

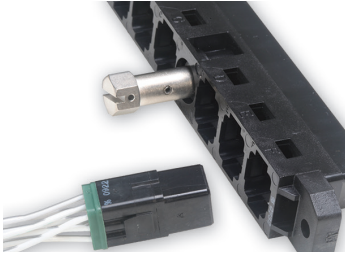


STEP 1: Snap the extraction end (white end) of the tool over the wire of the contact selected for removal. Carefully push the tool into the full depth of the contact cavity releasing the contact retaining collet. Hold the wire against the serrations on the tool, and withdraw the tool and the wired contact from the module.

MODULE INSERTION/REMOVAL & USE OF STRAIN RELIEF

Pin or socket modules, wired or unwired, can be inserted or intermixed in plug or receptacle housings. The next instructions illustrate the proper method of insertion and removal of modules within the LMD connector.

MODULE INSERTION

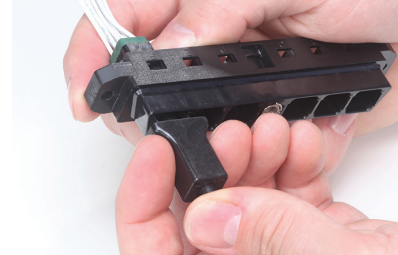


STEP 1: Align the module with the proper cavity at the rear of the housing. The module keyway must be positioned to accept key in housing cavity. Carefully insert the module straight in to the cavity until fully seated and locked in place. A slight axial push on the front of the module or a pull on the cable bundle will confirm module is locked in proper position.

MODULE REMOVAL



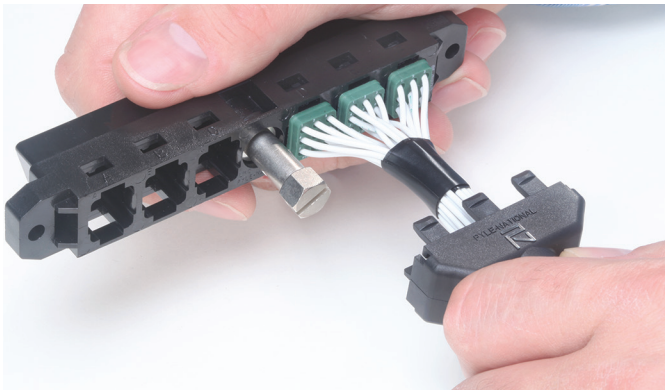
STEP 1: Insert contact into tool (use proper crimping tool as listed on preceding page). Crimp contact to wire. Tool will not open if contact is not fully crimped.



STEP 2: After crimping, wire should be visible through wire inspection hole.

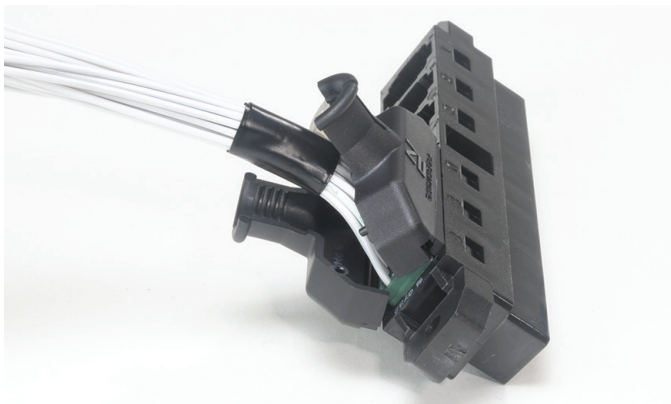
ASSEMBLY OF INTERNAL STRAIN RELIEF

Strain reliefs, if required, may be assembled to plug or receptacle connectors which have a full complement of modules installed. The following is instruction for assembling the internal attachment strain relief, part number LMD-5300-10A.



STEP 1: Tape wire bundle in area of cable clamp, and build up diameter to approx. 3/8 inches, if required. Align self-locking tines of the strain relief housing with the cavities adjacent to each module. Push the strain relief housing into place until the self-locking tines snap and lock strain relief into position. Assemble opposite half of strain relief housing to connector and tighten tie-strap to provide clamping force on the wire bundle.

OPENING STRAIN RELIEF TO SERVICE MODULES AND CONTACTS



STEP 1: Internal attachment strain reliefs may be opened to provide module and/or contact accessibility. To service connectors, first cut and discard tie-strap on strain relief. Open strain relief halves approx. 45° each by bending along integral flexible hinge. After servicing, close strain relief halves and install and tighten new tie-strap. To completely remove strain relief from the housing in order to provide module access; first remove tie-strap, open strain relief halves 45° each, then remove module, then remove strain relief.