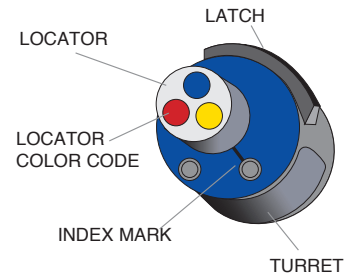
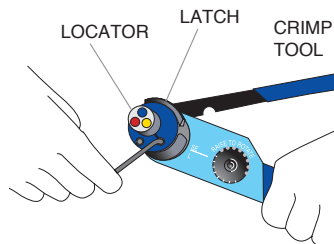


PT SOLDER CONTACTS

- STEP 1:** Slide the rear accessories over the wire bundle in the proper sequence for re-assembly: cable clamp and/or endbell first, then ferrule and, if used, coupling nut.
- STEP 2:** Insert individual wires through the proper holes in the grommet. Use isopropyl alcohol as a lubricant.
- STEP 3:** Solder wires to appropriate contacts on the rear of the connector. Information on standard soldering practices is available upon request. Please contact us.
- STEP 4:** Fixture the connector for reassembly using the endbell assembly tools on [page 146](#) or a mating connector with contacts installed.
- STEP 5:** Slide the grommet down the wires (lubricating the grommet with isopropyl alcohol will help).
- STEP 6:** Fill all unused grommet cavities with a wire hole filler to maintain the sealing integrity of the connector.
- STEP 7:** Slide coupling nut, ferrule, and endbell accessories over rear of the connector and tighten. For more information, [see page 146](#).

PTSE & PTCE CRIMP TOOL OPERATION

CONTACT SIZE	STRIP LENGTH
20	.275 (7.0)
16	.250 (6.4)
12	.250 (6.4)

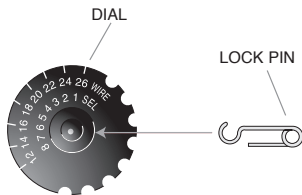


STEP 1: Strip the wires to the appropriate length.

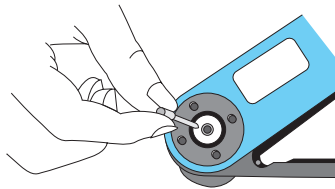
STEP 2: Open the AF8 (M22520/1-01) crimp tool by squeezing the handles. Push the latch on TH1A (M22520/1-02) to pop up the locator on the turret. Attach the turret to the AF8 crimp tool using the two captive hex bolts in the turret.

STEP 3: Select the proper locator position for your contact by rotating the locator until the proper color is aligned with the index mark. Push locator back down until it snaps into position

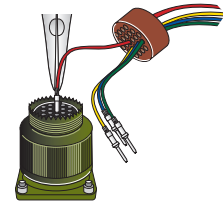
CONTACT SIZE	LOCATOR COLOR
20	Red
16	Blue
12	Yellow



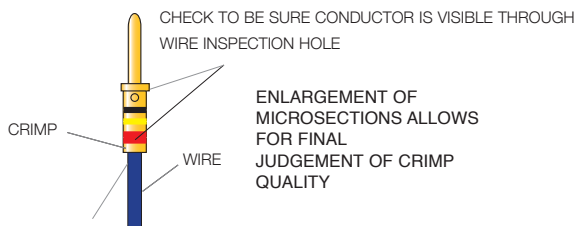
STEP 4: Adjust dial for proper wire gauge. To change the dial setting, remove the lock pin and lift center of dial. Turn to the desired wire gauge. Replace lock pin on dial.



STEP 5: Cycle the tool before inserting the contact to be sure the tool is in the open position. Drop the contact, mating end first, into the crimp cavity of the tool. Squeeze the tool handle just enough to grip the contact without actually crimping it.



STEP 6: Insert the stripped wire into the contact with a slight twisting motion. Be sure all wire strands are inside the contact. Squeeze the handle to cycle the tool. The handle will not release until the contact is completely crimped.



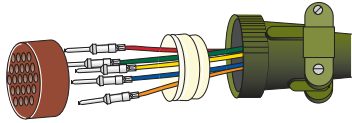
INSULATION SHOULD PRESS AGAINST THE END OF THE CONTACT.

ENLARGEMENT OF MICROSECTIONS ALLOWS FOR FINAL JUDGEMENT OF CRIMP QUALITY

STEP 7: Remove the crimped contact. Pull on the wire slightly to be sure it is properly crimped. Be sure the contact is not bent or damaged in any way. Visually inspect the crimp.

All dimensions in inches (millimeters in parenthesis)

INSERTION OF CONTACTS

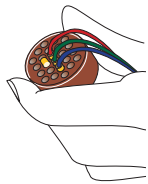


STEP 1: Slide the rear accessories over the wire bundle in the proper sequence for re-assembly: cable clamp and/or endbell first, then ferrule, and coupling nut.



STEP 2: Use the proper insertion tool from the Contact Selection Chart on [page 132](#), slide the tool over the wire side of the contact until the tool bottoms on the contact. The tool for size 16 contacts presses against the shoulder of the contact. The rear, or insulation support, of the size 20 contacts presses against an internal shoulder in the tool tip.

STEP 3: Dip the contact and tool tip in isopropyl alcohol (do not use any lubricant other than isopropyl alcohol). Hold the tool perpendicular to the rear of the connector. Beginning with the center cavity and working outwards in a circular pattern, insert the wired contact into the rear of the connector until the contact snaps into place. A light pull on the wire will ensure that the contact is locked securely.



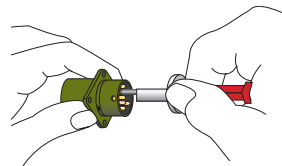
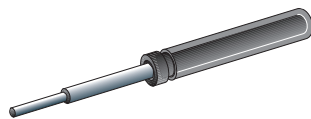
STEP 4: Fill any unused cavities with contacts. A wire hole filler must be inserted into the grommet behind the unused contacts to maintain the sealing integrity of the connector.



STEP 5: Check the mating face of the connector to ensure that all the same size contacts are on the same plane (fully inserted). If not, the contact is not fully inserted. Remove the contact using the proper extraction tool and procedure and re-insert. Do not attempt to reinsert the insertion tool to correct the problem.

STEP 6: Fixture the connector for re-assembly using the endbell assembly tools on [page 146](#) or a mating connector with contacts installed. Slide the connector accessories back down the cable over the rear of the connector and tighten. Torque as shown above.

EXTRACTION OF CONTACTS



STEP 1: Remove the endbell accessories and slide them back over the wires.

STEP 2: Use the proper extraction tool from the chart on [page 133](#).

STEP 3: On the mating face of the connector, insert the tool over the contact and into the insulator until the tool bottoms. While keeping an even pressure against the tool, push the plunger on the tool shaft forward with your thumb and index finger. This will release the contact from the retention tine and push it toward the rear of the connector.

STEP 4: Carefully remove the extraction tool from the connector. Pull the wire by hand to completely remove the contact from the rear of the connector.