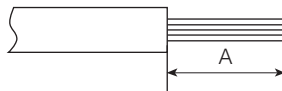


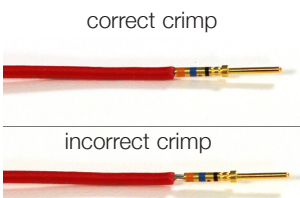
WIRE STRIPPING

Strip insulation from end of wire to be crimped. (See table for proper stripping dimensions.) Do not cut or damage wire strands.



WIRE SIZE	A
22, 22M, 22D	.125 (3.18)
20	.188 (4.77)
16	.188 (4.77)
12	.188 (4.77)
10	.335 (8.51)
8 (power)	.470 (11.99)

CONTACT CRIMPING

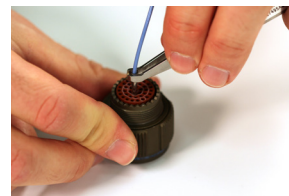
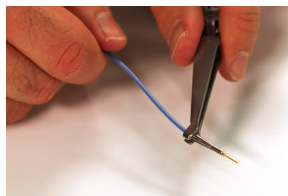
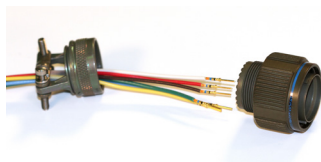


STEP 1: Strip wires. See above for correct strip length for contact. Insert wire into rear of contact. Wire insulation must push against rear of contact. Wire must be visible through inspection hole.

STEP 2: M22520 series crimp tool and locator is recommended. → See page 68 here for choice of turret head and selection setting according to correct size, part number and wire gauge size.

STEP 3: Insert contact and wire into tool jaws. To crimp, squeeze handles together fully until ratchet releases and allows handles to expand; otherwise, contact cannot be extracted from tool jaws. Maintain slight insertion pressure on wire while crimping contact to wire.*

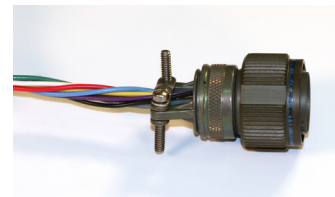
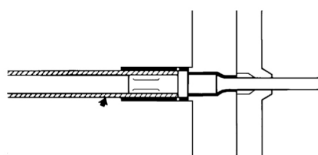
CONTACT INSERTION



STEP 1: Remove hardware from plug or receptacle and slip over wire bundle in proper order for reassembly.

STEP 2: Using proper plastic or metal insertion tool for corresponding contact, position wire in tip of the tool so that the tool tip presses against the contact shoulder.

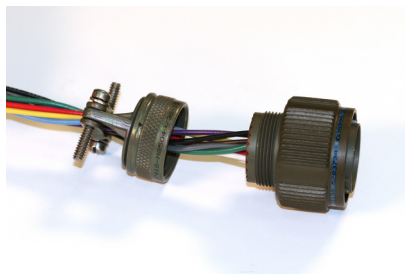
STEP 3: Press tool against contact shoulder and, with firm and even pressure, insert wired contact and tool tip into center contact cavity.



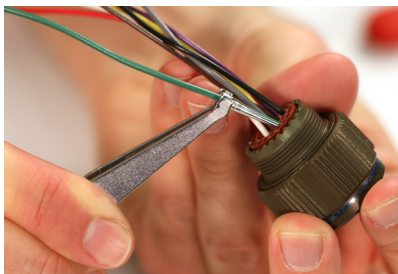
STEP 4: When contact bottoms, a slight "click" can be heard as tines of metal retaining clip snap into place behind contact shoulder.

STEP 5: Remove tool and pull back lightly on wire to make sure contact is properly seated. Repeat operation with remainder of contacts to be inserted, beginning with the center cavity and working outward in alternating rows.

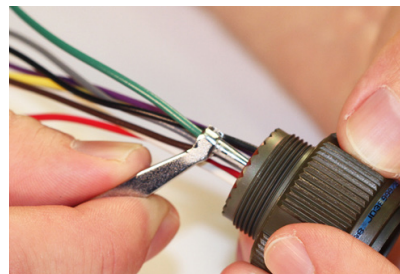
STEP 6: After all contacts are inserted, fill any empty cavities with wire sealing plugs. Reassemble plug or receptacle hardware.



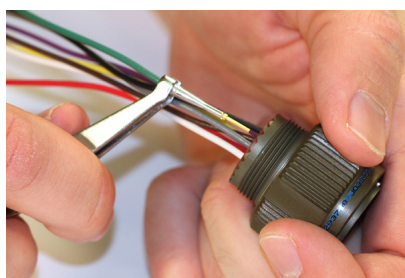
STEP 1: Remove hardware from plug or receptacle and slide hardware back along wire bundle.



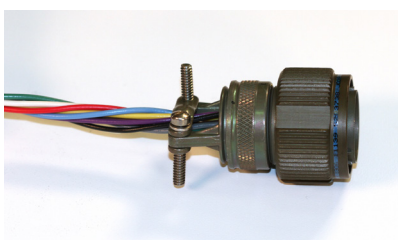
STEP 2: Using plastic or metal extraction tool with proper color code corresponding to contact size, place wire in tool.



STEP 3: Insert tool into contact cavity until tool tip bottoms against the contact shoulder, expanding clip retaining tines.



STEP 4: Hold wire firmly in tool and extract wired contact and tool. Repeat operation for all contacts to be extracted.



STEP 5: Fill any empty cavities with wire sealing plugs. Reassemble plug or receptacle hardware.

Note: DTS series shown.