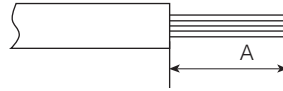


WIRE STRIPPING

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
20	.157 (4.0) - .197 (5.0)
16	.252 (6.4) - .315 (8.0)
12	.252 (6.4) - .315 (8.0)
8	.336 (8.5) - .372 (9.4)

WIRE STRIPPING AND CONTACT CRIMPING

correct crimp



incorrect crimp



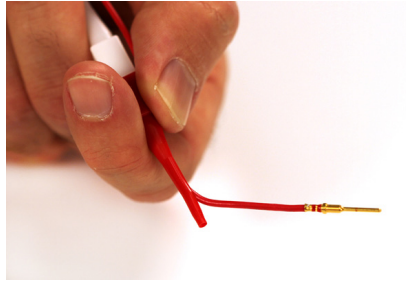
STEP 1: Insert wire into rear of contact. Wire insulation must press against rear of contact. Wire must be visible through inspection hole

STEP 2: M22520 series crimp tool and locator is recommended. → See [Contact and Tooling table on pages 20-21](#)

CONTACT SIZE	COLOR
20	Red
16	Blue
12	Yellow

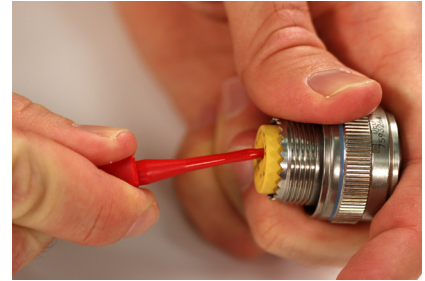
STEP 3: Insert contact into tool jaws. To crimp, squeeze handles together fully until ratchet releases and allows handles to expand; otherwise, contact may not be extracted from tool jaws. Maintain slight insertion pressure on wire while crimping contact to wire.

CONTACT INSERTION



STEP 1: Remove backshell and put wired contacts through cable opening.

STEP 2: Use colored end of plastic insertion / extraction tool for insertion. Place wire and contact into tool so that the tool rests on the rear of the contact shoulder.



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

STEP 4: 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 center cavity and working outward.

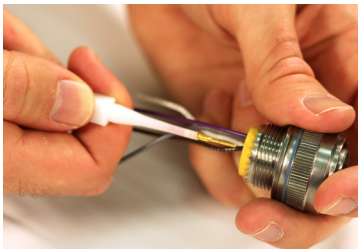
STEP 5: After all contacts are inserted, fill any empty cavities with wire sealing plugs. Re-attach backshell and tighten cable clamps.

CONTACT EXTRACTION



STEP 1: Remove backshell from connector and slide back along wire bundle.

STEP 2: Use white end of plastic insertion / extraction tool for extraction. Place tool around wire, and insert tool into contact cavity until tool tip bottoms against the contact shoulder.



STEP 4: Hold firmly onto wire and tool and extract from connector. Repeat operation for all contacts to be extracted.

STEP 5: Fill any empty cavities with wire sealing plugs. Re-attach backshell and tighten cable clamps.