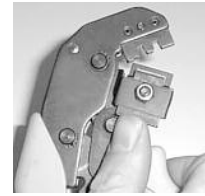


CRIMPING



STEP 1: Squeeze handles until tool has gone through a complete cycle and opens easily.

STEP 2: Select the proper cavity for the wire size to be crimped.

STEP 3: Using your thumb or forefinger, raise the spring-loaded locator on the back of the lower jaw by pushing up.

STEP 4: While the locator is in the up position, place the contact into the front of the crimp tool (crimp side up) in the proper crimp cavity (16 AWG or 20 AWG).



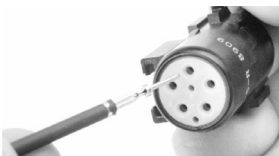
STEP 5: Release the locator. The locator should rest comfortably in the indent in the contact just above the crimp area.

STEP 6: Insert the stripped wire into the crimp area until it bottoms.

STEP 7: Firmly squeeze the handle; crimp jaw and ratchet will release.

STEP 8: Using your thumb or forefinger, raise the spring-loaded locator and remove the crimped contact and wire.

INSERTION



STEP 1: Move to the rear of the connector so that the contact cavities can be identified.

STEP 2: Insert a crimp-terminated assembly into a selected cavity.

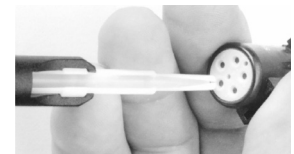
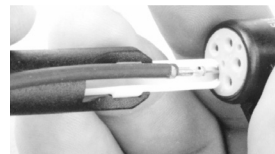
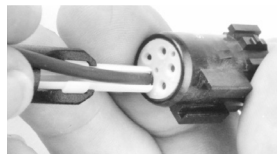
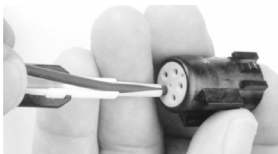
STEP 3: Continue the forward movement until an audible snap can be felt and heard. A slight pull in the opposite direction will confirm complete insertion.

CRIMP INSPECTION



STEP 1: Note that there are no unterminated wire strands and that some strand ends can be seen at the forward edge of the crimp. Also note the insulation is gripped by the smaller secondary crimp. Distortion is at a minimum, both axially and laterally – no sharp edges. Enlargement of micro section allows for final judgment of crimp quality. This test is recommended whenever new tools or new types of wire are used.

EXTRACTION WITHOUT TPA



STEP 1: Open the CET – SLC extraction tool and place it over the insulation of the wire.

STEP 2: Using a straight motion forward, insert the tool along the wire until it bottoms against the connector. Do not use a screwing motion - damage will result.

STEP 3: While the CET - SLC is bottomed, simply pull the wire/contact assembly out.

STEP 4: Remove the CET - SLC. Extraction is complete.