



## Assembly Instructions

### Contact Crimping



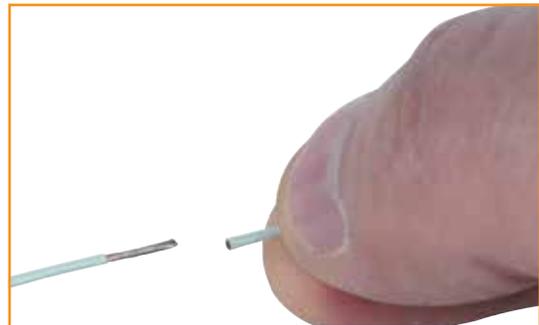
**1** Burn through the insulation with a hot wire stripper or use other approved stripping method. Do not remove the insulation at this point. This will help protect the wire strands from splaying. Refer to contact information sheet for proper wire insulation strip length.



**2** Set the dial of the crimp to the proper setting for wire gage and contact as noted on the contact information sheet or on the tool. Be sure that the proper locator is used. See contact information sheet for proper locator.



**3** Drop the contact into the crimping tool with the contact crimp barrel facing up.



**4** Remove the small piece of insulation from the wire. Do not pinch the insulation with the fingernails during this procedure. The wire is now ready to be crimped to the contact.



**5** Insert the bare wire into the open end of the contact and squeeze the handles of the tool together. The crimping tool will not release until the full crimping cycle has been performed. Remove the crimped contact and wire from the tool.

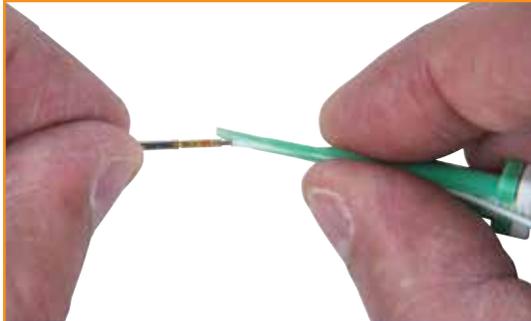


**6** Two series of 4 indents grip the wire and secure the contact to the wire. Visibility of the wire in the contact inspection hole (arrow) indicates that the wire is crimped into the contact at the proper depth. Inspect to make sure there are no loose or nicked strands.



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### Contact Insertion



**1** Hold the insertion half of the tool between the thumb and forefinger and lay the wire against the slot of the tool, then snap the wire into the slot.



**2** After the wire snaps into the tool, seat the retention shoulder against the tip of the tool.



**3** Holding the connector with the rear grommet facing you, slowly push the contact straight into the grommet cavity. Do not twist the tool. Note: Some wire constructions may not require the use of an insertion tool.



**4** A firm stop will be evident when the contact positively seats in the connector. Remove the tool by sliding it back on the wire. The contact will now be securely locked in place.



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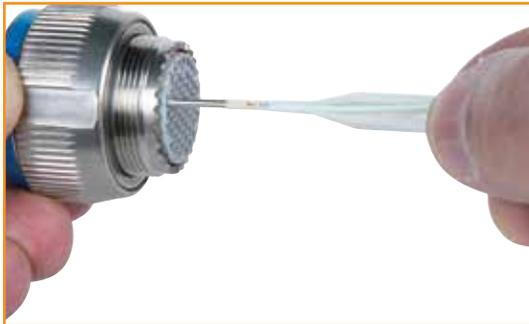
### Contact Removal



**1** With the rear of the connector facing you, lay the wire of the contact along the slot of the tool, leaving about 1/2" from the end of the tool to the rear of the connector. Squeeze the wire firmly into the tool between the thumb and forefinger about 1/2" from the tip and quickly pull the tool away from the connector.



**2** The wire will now have snapped into place. Slide the tool down along the wire and into the rear cavity and slowly into the connector until a positive resistance is felt. At this time, the contact retaining mechanism is in the unlocked position.



**3** Press the wire of the contact against the serrations of the plastic tool and pull both the tool and the contact/wire assembly out of the connector.

**Caution:** When using minimum diameter wire, the tool may have a tendency to stop against the rear of the contact crimp barrel. If this should occur, careful manipulation of the tool will help permit it to ride over the crimp barrel and into the proper position to unlock the contact.

