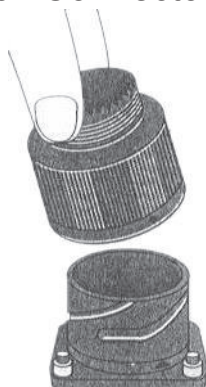


CRIMPED CONTACT INSERTION

Disassemble the connector and slide the rear accessories over the wire bundle in proper sequence (For reassembly, see Figures 17 & 18). Use the insertion tool to place the crimped contacts into the insert pursuant to Tables A (page 2) & B (page 3).

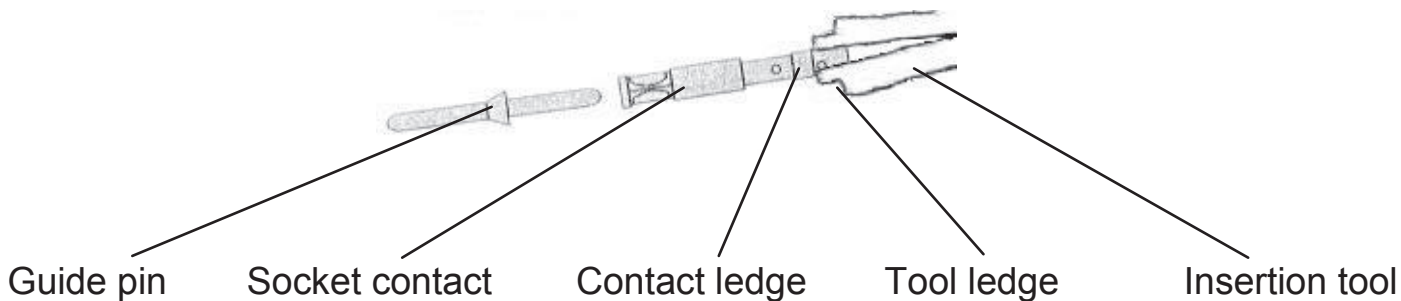
- 1) Attach the connector to its mate in a fixed position to facilitate the insertion process.

Figure 10: Attach Connector to Its Mate



- 2) Place the contact in the insertion tool, resting the crimping tool on the crimping edge for a stronger hold. To insert the female contact, it is necessary to use the guide pin (See Table B, page 3) to facilitate the insertion and to avoid shaving the shoulders of the insert. At the end of the operation, the guide pin is removed from the connector.

Figure 11/a: Contact Insertion



NOTE: it is recommended that the operation be facilitated using small quantities of isopropyl alcohol. It is necessary to dry the connector immediately so that insulating resistance is not reduced. All contacts, including unused contacts (or suitable sealing plugs), should be inserted into the connector.

- 3) Insert the contact from the back side of the connector employing a slow but constant force until the contact snaps into position in the proper cavity. Start at the center of the pattern and work toward outside edges.

Figure 11/b: Contact Insertion

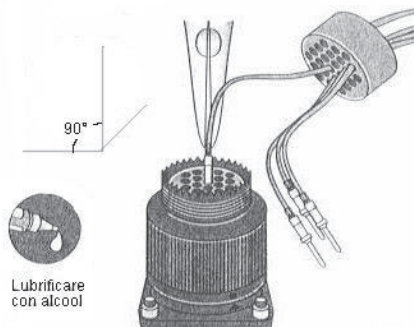
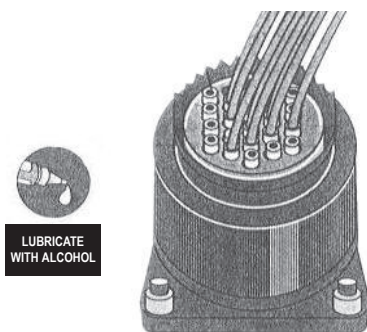


Figure 11/C: Contact Insertion



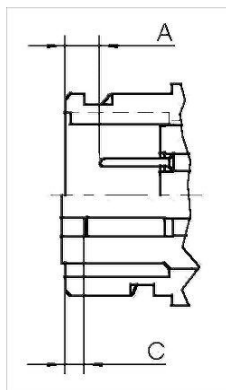
When all contacts have been inserted, check positioning from the front side of the connector to verify correct alignment.

Figure 11: Final Result



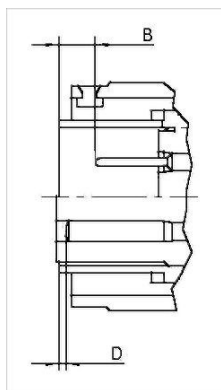
Use Tables 5 and 6 (below) to verify the correct positioning of the contacts.

TABLE 5: SEATING DIMENSIONS FOR RECEPTACLES

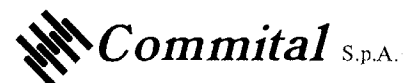


Size	A ±1 Male Contacts							C ±1 Female Contacts						
	Contact Size							Contact Size						
	16S	16	12	8	4	0	4/0	16S	16	12	8	4	0	4/0
10SL	3.5							2.8						
14S	3.0							2.8						
16S	3.0							2.8						
16		7.3	2.5	2.5	2.5				2.5	2.5	2.5	2.5		
18		7.3	2.5	2.5					2.5	2.5	2.5	2.5		
20		7.3	2.5	2.5		2.9			2.5	2.5	2.5	2.5		
22		7.3	2.5	2.5		2.5			2.5	2.5	2.5	2.5	2.7	
24		7.0	2.2	2.5	2.5				2.5	2.5	2.5	2.5		
28		7.0	2.2	2.5	2.5	2.5			2.8	2.8	2.8	2.8		
32		7.0	2.2	2.5	2.5	2.5			2.2	2.2	2.2	2.2	2.3	
36		7.0	2.2	2.5	2.5	2.5	2.5		2.2	2.2	2.2	2.2	2.3	2,3
40		7.0	2.2	2.5	2.5	2.5			2.2	2.2	2.2	2.2	2.3	
110			5,6			6,3	6,3			7,4			7,6	7,6

TABLE 6: SEATING DIMENSIONS FOR PLUGS



Size	B ±1 Male Contacts							D ±1 Female Contacts						
	Contact Size							Contact Size						
	16S	16	12	8	4	0	4/0	16S	16	12	8	4	0	4/0
10SL	2.6							2.6						
14S	2.8							2.8						
16S	2.9							2.8						
16		7.3	2.5	2.5	2.5				2.5	2.5	2.5	2.5		
18		7.3	2.5	2.5					2.5	2.5	2.5			
20		7.3	2.5	2.5		2.9			2.5	2.5	2.5		2.7	
22		7.3	2.5	2.7		2.5			2.5	2.5	2.5		2.7	
24		7.1	2.4	2.4	2.4				2.5	2.5	2.5	2.5		
28		7.1	2.4	2.4	2.4	2.4			2.5	2.5	2.5	2.5	2.3	
32		7.1	2.4	2.4	2.4	2.4			2.4	2.4	2.4	2.4	2.3	
36		7.1	2.4	2.4	2.4	2.4			2.4	2.4	2.4	2.4	2.3	
40		7.1	2.4	2.4	2.4	2.4			2.4	2.4	2.4	2.4	2.3	
110			5,6			6,3	6,3			7,0			7,0	6,0



If some contacts have been inserted too deeply, a slight pull in the opposite direction might help place them into the proper position.

- 4) To extract the contact from the insert use the extraction tools pursuant to Tables A (page 2) and B (page 3). Exercise a slow but constant force on the contact from the front side of the insert until the contact comes out the rear of the connector.

Figure 13: Contact Extraction

