

Contact Insertion

1. Tools:

Be sure that all proper assembly tools are on hand and properly calibrated (Figure 1). See previous page for complete descriptions of required tools.

2. Stripping:

Strip wire ends to 3/16" for 20-32 AWG, taking care not to nick or cut wire strands (Figure 2). Hold insulation and twist strands to eliminate any splaying.

3. Wire Insertion:

Insert wire into crimp well of contact. **Do Not Force.** Wire strands must be visible through inspection hole (Figure 3).

4. Crimping:

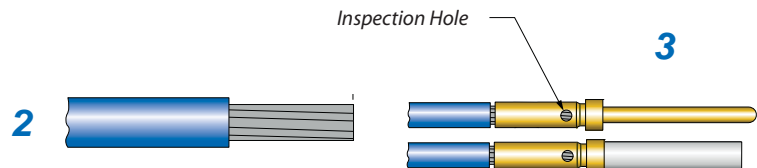
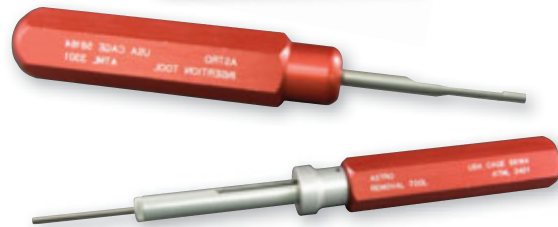
Using crimp tool and positioner noted above, insert wire and contact into locator jaws. Squeeze tool handle completely until ratchet releases. Remove wired contact from tool (Figure 4).

5. Backshell Preparation:

Slide backshell/strain relief over jacketed cable or wires in proper order for re-assembly. Consult Glenair backshell catalog or contact factory for proper jacketed cable assembly (Figure 5).

6. Contact Preparation:

Slide wired contact into insertion tool of choice so that the tip of the tool butts against the shoulder of the contact (Figure 6).



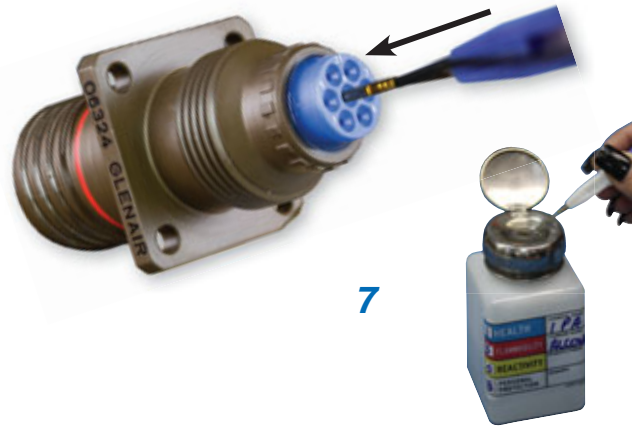
Dimensions in Inches (millimeters) are subject to change without notice.

MIL-DTL-28840 Connector Contact Insertion/Extraction Instructions



7. Insertion of Contacts:

Insert wired contacts and tool into contact cavity until contact “clicks” into retention clip (Figure 7). A straight pull on the wire will assure the contact is properly seated. Note: Isopropyl alcohol may be used as a lubricant. Use sparingly.



8. Assembly:

After all contacts are inserted, assemble backshell or strain relief according to Glenair backshell catalog instructions.

Contact Extraction

1. Contact Extraction:

Remove backshell or strain relief from connector.

2. Contact Extraction:

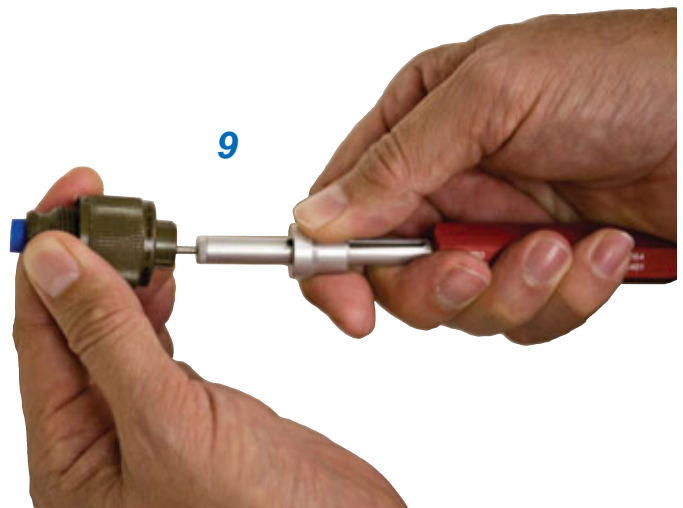
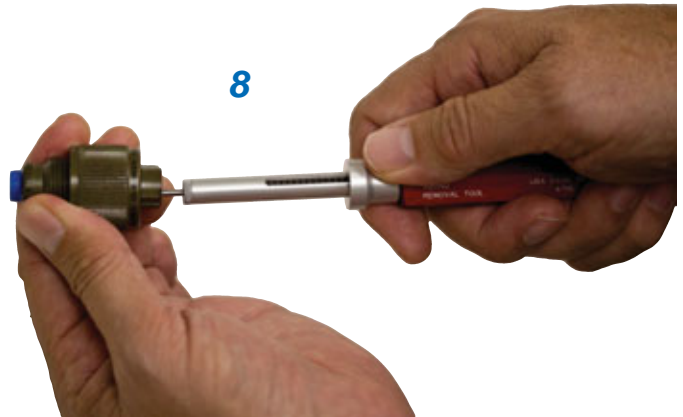
MIL-DTL-28840 connector contacts are extracted from the rear but released from the front of the connector. Using an extraction tool, slide tool tip into front of contact cavity (mating face of connector, figure 8) until tool tip engages against contact retention clip. Push plunger with minimum force to release contact (Figure 9). Note: Isopropyl alcohol may be used as a lubricant. Use sparingly.

3. Contact Extraction:

Pull wired contact from rear grommet of connector.

Contact Replacement:

After replacing contact, re-insert starting with assembly instruction number 7.



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