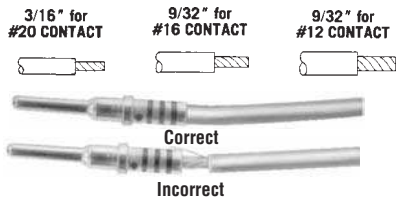
Wire Stripping and Contact Crimping



1. Strip wires. (See above for correct strip length for contact.) Insert wire into rear of contact. Wire insulation must butt against rear of contact. Wire must be visible thru inspection hole.

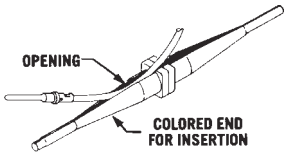
2. Use M22520/1-01 crimp tool with proper crimp location M22520/1-02.

Contact Size	Color
20	Red
16	Blue
12	Yellow

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

Contact Insertion

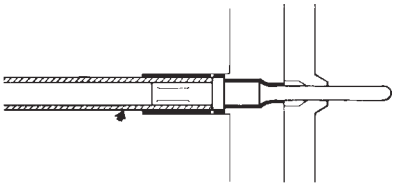
1. Remove backshell and put wired contacts thru cable clamp opening.



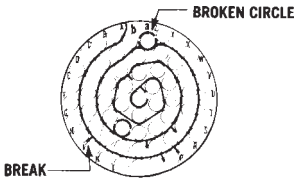
2. Use colored end of CIET tool for insertion. Place wire into tool at large opening. To facilitate contact insertion, a 6-in. min. free length of wire is recommended.

3. Slide back tool on wire while holding thumb against wire at opening. Wire will slip into tool.

4. With tool pressed against shoulder of contact, starting at the center cavity, insert wired contact and tool into properly identified cavity at rear of plug with firm, even pressure. Do not use excessive pressure.



5. When contact bottoms, a slight click can be heard as tines of metal retaining clip snap into place behind contact shoulder.



6. Check face of plug or receptacle for proper contact installation. In socket inserts with a large number of contact, cavities are identified in a spiral pattern. A projecting line from the spiral indicates omission of a letter; a broken circle around a cavity indicates transition between capitals and lower case and double letters.

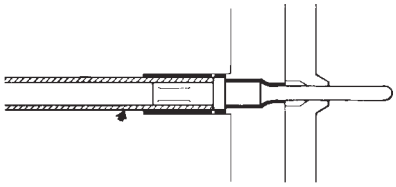
7. Withdraw tool from rear of plug. To be sure that contact is locked, pull back lightly on wire. Then remove tool from wire and proceed with other contacts.

8. After all contacts are inserted, fill unwired cavities with sealing plugs (insert head last and leave end protruding for ease of removal), assemble backshell on rear of connector.

See page 266 for endbell tightening tools.

Contact Extraction

1. Remove backshell and slide back along wires to allow access. To extract a contact, use white end of CIET tool. Place wire into tool at large opening. Slide back tool on wire while holding thumb against wire at opening. Wire will slip into tool.



2. Push tool into rear of plug until it bottoms. At this point, tool releases tines on retaining clip so that contact can be extracted.

3. While maintaining slight insertion force on tool, firmly hold wire against serrated shoulder at center of tool and extract both wired contact and tool from plug.

***Important Note:** Microsection the contact to verify crimp quality.