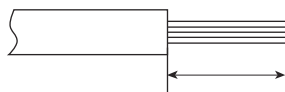


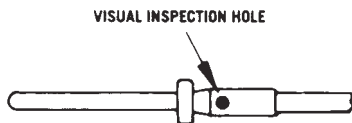
## Wire Stripping

Strip insulation from end of wire to be crimped. (See table for proper stripping dimensions.) Do not cut or damage wire strands.



Wire Size	A
22D	.125 (3.18)
20	.188 (4.77)
16	.188 (4.77)
12	.188 (4.77)

## Contact Crimping



1. Insert stripped wire into contact crimp pot. Wire must be visible thru inspection hole.



2. Using correct crimp tool and locator, cycle the tool once to be sure the indentors are open. Insert contact and wire into locator. Squeeze tool handle firmly and completely to insure a proper crimp. The tool will not release unless the crimp indentors in the tool head have been fully actuated.



3. Release crimped contact and wire from tool. Be certain the wire is visible thru inspection hole in contact.

## Contact Insertion



1. Remove hardware from plug or receptacle and slip over wire bundle in proper order for reassembly.



2. Using proper plastic or metal insertion tool for corresponding contact, position wire in tip of the tool so that the tool tip butts up against the contact shoulder.



3. Press tool against contact shoulder and, with firm and even pressure, insert wired contact and tool tip into center contact cavity. A slight click may be heard as metal retaining tines snap into place behind contact shoulder.



4. Remove tool and pull back lightly on wire to make sure contact is properly seated. Repeat operation with remainder of contacts to be inserted, beginning with the center cavity and working outward in alternating rows.



5. After all contacts are inserted, fill any empty cavities with wire sealing plugs. Reassemble plug or receptacle hardware.

## Contact Extraction



1. Remove hardware from plug or receptacle and slide hardware back along wire bundle.



2. Using plastic or metal extraction tool with proper color code corresponding to contact size, place wire in tool.



3. Insert tool into contact cavity until tool tip bottoms against the contact shoulder, expanding clip retaining tines.



4. Hold wire firmly in tool and extract wired contact and tool. Repeat operation for all contacts to be extracted.



5. Fill any empty cavities with wire sealing plugs. Reassemble plug or receptacle hardware.

Note: KJ Series shown.

For technical assistance, price or delivery info. call 1-800-523-0727 or visit [www.pei-genesis.com](http://www.pei-genesis.com) Specifications subject to change, see inside back cover.