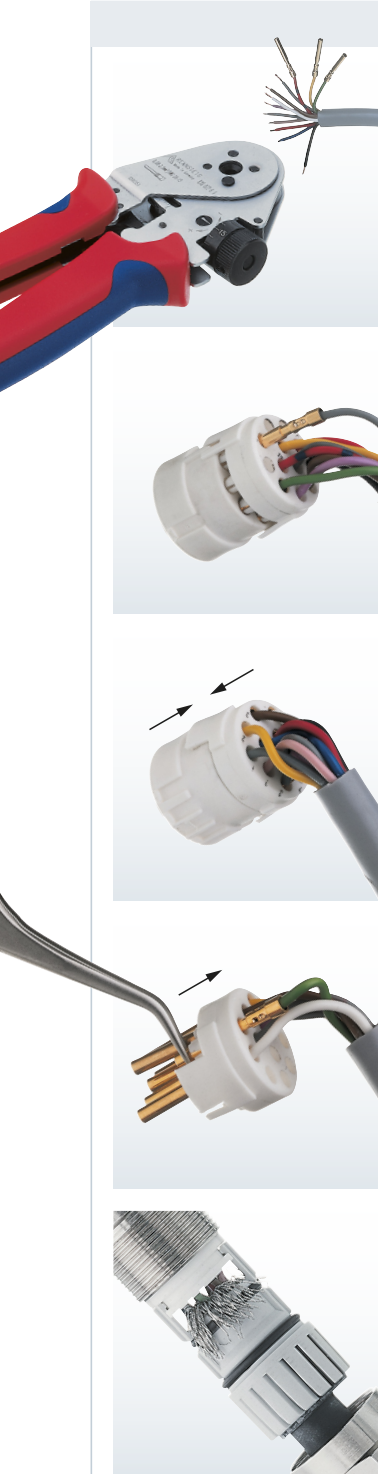


## Crimping, Assembly and Disassembly of Contacts



### Crimping

- // Remove conductor insulation 4 mm (.16") max.
- // Select appropriate Crimp tool setting
- // Insert Crimp contact into the positioner of the tool
- // Insert stripped end of conductor into the crimp opening of the contact
- // Squeeze handles of crimp tool together

### Assembly

- // Open crimping jaws and remove contact
- // Pry open upper and lower insert approx. 3 mm (1/8") apart as shown
- // Insert the contact and conductor assembly into the desired location
- // Press upper and lower insert parts together

### Interlock Contacts

- // press the upper and lower part of the insulator together

### Disassembly

No special tools are needed to remove the crimp contacts from the insert.

- // Remove upper part of insert
- // With a pair of needle nose pliers, wiggle the contact and push it back through the lower part of insert
- // Insert contacts into new location and push until it snaps in position
- // Align the nose and groove of the upper and lower part of insert and press together

### Shielding

- // Assemble strain relief insert with insert
- // Fold stranding of the shield back over the first O-Ring of the strain relief insert
- // Cut back the overextending braid



The stranding of the shield is not allowed to touch the second O-Ring. Otherwise the assembly may not be proof.