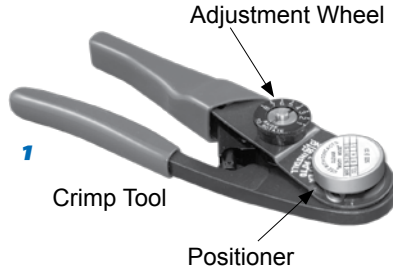


# Crimp Contact Termination Instructions



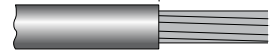
## How To Terminate, Install and Remove Crimp Contacts

**1 Set Up Series M22520 Crimp Tool.** See pin and socket contact selection guide for correct tools based on contact part numbers and tool codes. Install proper positioner into crimp tool. The label on the positioner shows the proper tool setting for each wire size. Turn the adjustment wheel to the correct setting.



For Wire Sizes 22, 22M, 22D

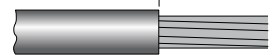
1/8" - 5/32"  
(3.2 - 3.9)



2

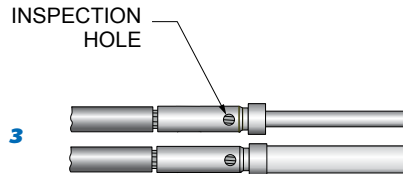
For Wire Sizes 10, 12, 16, 20

7/32" - 1/4"  
(5.6 - 6.4)



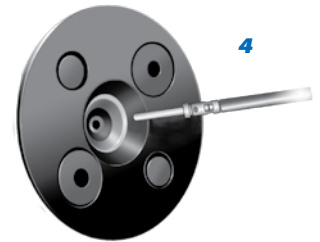
**2 Strip Wire.** Remove wire insulation, taking care to avoid nicking or cutting wire strands. Strip wire to length shown. Holding wire by insulation, twist strands together to form a neat bundle.

**3 Insert wire** into contact. The wire should be visible in the inspection hole.



3

**4** Insert wire and contact into crimp tool as shown. Make sure that the contact is fully inserted into the tool. Squeeze handle completely. The ratchet mechanism will not allow a partial crimp. Release handle and remove contact.



4

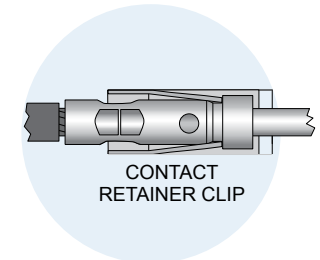
**5 Inspect crimped contact.** Wire should be fully inserted and the crimp should be uniform in appearance.



5

**6 Install contact into connector.** Slide colored end of insertion/extraction tool over wire insulation and slide the tool forward until it bottoms against the contact shoulder. Insert tool/contact/wire into contact cavity, being careful to avoid damage by properly aligning the contact with the cavity. Push forward until contact retention clip snaps into position. Remove tool. Gently pull on wire to confirm contact retention. Fill unused contact cavities with uncrimped contacts followed by the proper MS27488 sealing plug. For potted cable applications, install crimped-wire contacts in all unused cavities and terminate tail-end to a SAE-AS25274 cap.

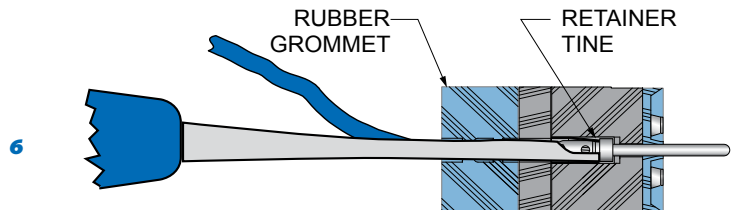
Contact Size	Wire Diameters (Inches)*	
	Min	Max
10	0.135	0.016
12	0.097	0.142
16	0.065	0.109
20	0.040	0.077
22	0.034	0.060
22M, 22D	0.030	0.060



CONTACT RETAINER CLIP

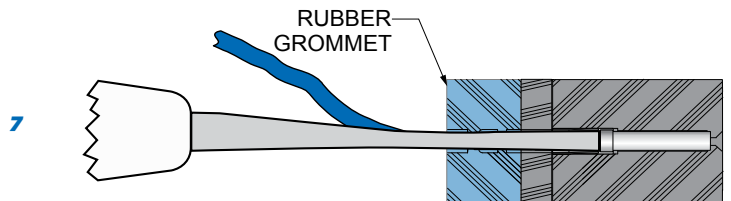
\*The min diameters are to ensure proper sealing. The max diameters are to allow the use of removal tools.

Contact Size	Seal Plug	Cap
10	AS84049/81-10	AS25474-4
12	MS27488-12	AS25474-4
16	MS27488-16	AS25474-3
20	MS27488-20	AS25474-2
22, 22M, 22D	MS27488-22	N/A



6

**7 Contact Extraction.** Use the white end of appropriate insertion/extraction tool. First, push the wire into the groove of the extraction tool's tip. Slide the tip of the tool over the jacketed wire into the connector cavity. Push the tool until the tip bottoms in the connector. A straight push is best. Avoid wiggling or rocking the tip, as this may damage the cavity. Pinch the wire between your thumb and the white plastic grip and slide the tool and contact out of the connector.



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