

MIL-DTL-38999 Series I Type Crimp contact termination instructions

HOW TO TERMINATE, INSTALL, AND REMOVE CRIMP CONTACTS

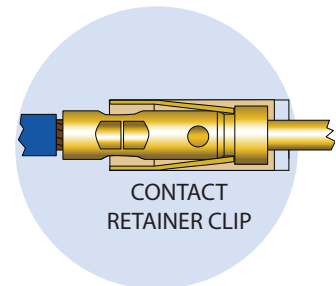
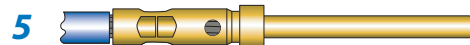
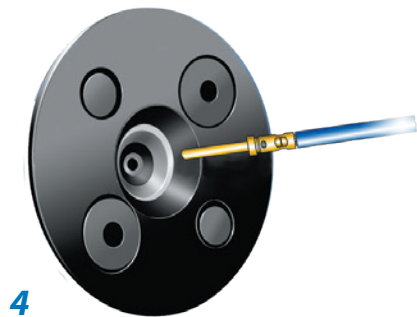
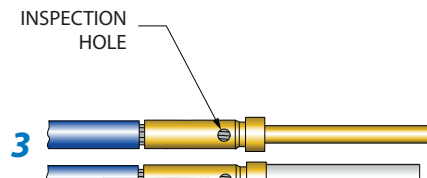
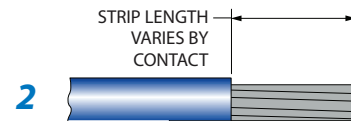
1 Set Up Crimp Tool. Install proper positioner into crimp tool. The label on the positioner shows the proper tool setting for each wire size. Turn the adjustment wheel to the correct setting.

2 Strip Wire. Remove wire insulation, taking care to avoid nicking or cutting wire strands. Strip wire to proper length so wire is visible thru inspection hole.

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

4 Insert 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.

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



Insertion/Extraction Tool



6 Install contact into connector. Push the contact through the rear grommet until the contact locks into place. This can usually be done by hand without the need for a tool. If the wire gage is #26 or smaller, a tool is helpful. There are two techniques for installing contacts with a tool. One method is to push the contact in by hand, then use the tool to finish the insertion. The other method is to position the insertion tip against the contact shoulder, then insert the contact. Use insertion/extraction tool 809-088 to install contacts. Slide the wire into the groove on the blue end of the tool. Slide the tool tip up the contact until it touches the contact shoulder. **USE CARE TO AVOID DAMAGING THE CONNECTOR.**

7 Contact Extraction. Use tool M81969/14-01. The white end is used for contact extraction. First, push the wire into the groove of the metal tip. Slide the tip of the tool into the connector. Push the tool into the connector cavity until the tip bottoms in the connector. Avoid wiggling or rocking the tip. This may damage the cavity. A straight push is best. Pinch the wire between your finger and the white plastic grip and slide the tool and contact out of the connector. **Wire insulation diameter greater than 0.045 inches (1.14mm) is too large to work properly with the extraction tool. Connector damage is possible.**

