



RJ45 AND USB 2.0 Contacts, Tools, and Accessories

Size #22 Crimp Contact Instructions



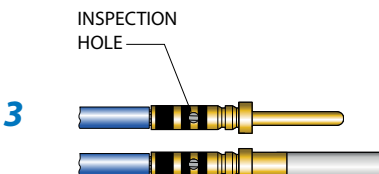
HOW TO TERMINATE, INSTALL AND REMOVE SIZE #22 CONTACTS

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.



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.

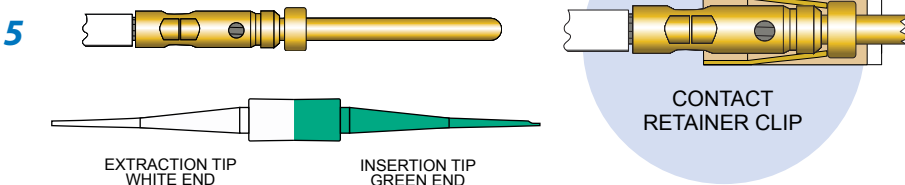
3 Insert wire into contact. The wire should be visible in the inspection hole.



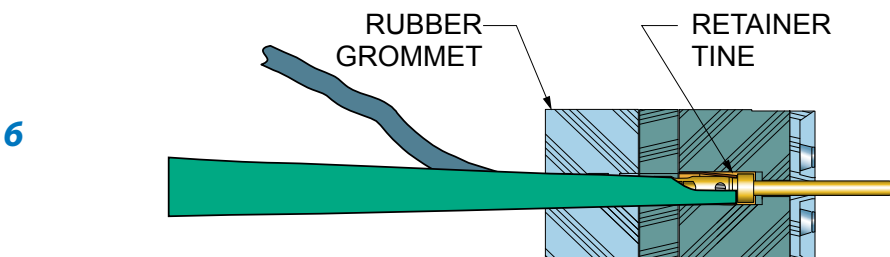
4 Insert wire and contact into crimp tool as shown. Make sure that the contact is fully inserted into the tool. Squeeze handle completely. The ratchet mechanism will not allow a partial crimp. Release handle and remove contact.



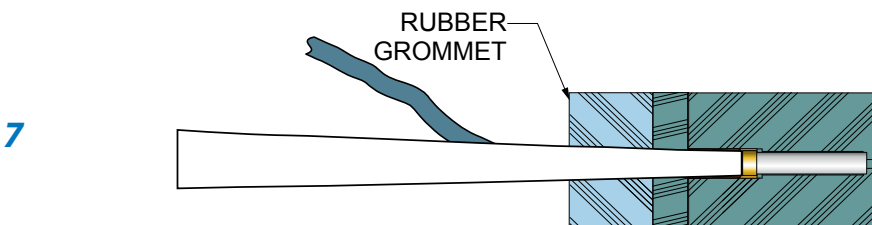
5 Inspect crimped contact. Wire should be fully inserted and the crimp should be uniform in appearance.



6 Install contact into connector. Slide green 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.



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.



Contact Size	Seal Plug
22, 22M, 22D	MS27488-22