

Contact Crimping and Assembly Procedures:

- A. Push cable through connector components, i.e. backshell, grommet, sleeve, and coupling ring.
- B. Wire preparation: Strip cable to dimensions shown. Make all cuts square and sharp being careful not to nick wires when cutting. To prevent stranded wires from fraying it is recommended that ends be tightly twisted and not solder dripped.

Conductor Strip Lengths

CON-X	MIL-E-QUAL
#20 -3/16	#16 -9/32
#16 -7/32	#12 -7/32
#12 -7/32	



Cable Stripping

- C. Contact crimping tools, use as follows:
 - ☐ Assemble contact locator to tool.
 - ☐ Check tool setting for wire gage to be crimped.
 - ☐ Drop contacts, mating end first into locator so that it rests fully on bottom. Insert stripped lead into contact barrel until it stops.
 - ☐ Close tool handles completely in one stroke. (The ratchet will not release jaws until tool has completed cycle.)
 - ☐ Inspect crimp to be sure there are no loose strands outside the contact which may short out to an adjacent contact.
- D. Contact insertion tools. Place wired contact into proper connectors cavity. Guide tip of the insertion tool so that it starts at the contact and slides down against the stop. Apply a steady force perpendicular to the contact until it snaps into position.