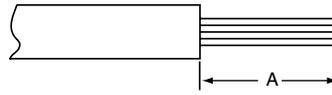


# Assembly Instructions

## Military (MS3476), Commercial (MB16)

### WIRE STRIPPING

- Strip wire to required length. (See Figure at right). When using hot wire stripping do not wipe melted insulation material on wire strands; with mechanical strippers do not cut or nick strands.
  - See Table 1 for proper finished outside wire dimensions.
  - Twist strands together to form a firm bundle.
  - Insert stripped wire into contact applying slight pressure until wire insulation butts against wire well. Check inspection hole to see that wire strands are visible. If there are strayed wire strands, entire wire end should be re-twisted.
- When wire is stripped and properly installed into contact, the next step is to crimp the wire inside the contact by using the proper crimping tool.



### STRIPPING DIMENSIONS

Wire Size	A
20	.188 (4.77)
16	.188 (4.77)
12	.188 (4.77)

TABLE 1

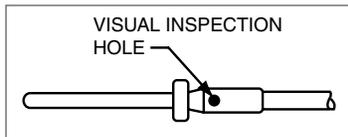
Contact Size	Wire Dimension (inches)**	
	Min.	Max.
12	.040	.083
16	.053	.103
20	.097	.153

\*\* Min. diameters to ensure moisture proof assembly; max. diameters to permit use of metal removal tools.

### CRIMPING

See table on preceding page for recommended M22520 series crimping tools, turret head or positioner selection settings according to contact size, part number and wire gauge size.

- Insert stripped wire into contact crimp pot. Wire must be visible through inspection hole.
- Using correct crimp tool and locator, cycle the tool once to be sure the indentors are open, insert contact and wire into locator. Squeeze tool handles firmly and completely to insure a proper crimp. The tool will not release unless the crimp indentors in the tool head have been fully actuated.
- Release crimped contact and wire from tool. Be certain the wire is visible through inspection hole in contact.



Example M22520 Series Crimping Tool for size 20, 16 or 12 contacts, and has a positioner that can be dialed for each contact size.

### CONTACT INSERTION

- First remove hardware from the plug and receptacle and slide the hardware over wires in proper sequence.



- Use proper plastic or metal insertion tool for corresponding contact. (Consult tool table on preceding page). Slide correct tool (with plastic tool use colored end) over wire insulation and slide forward until tool bottoms against rear contact shoulder.

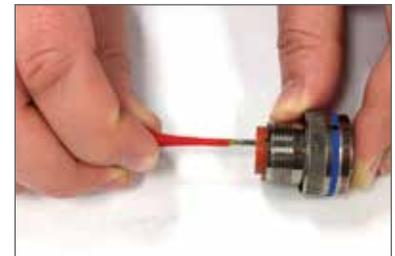


Plastic tool with contact in proper position.

- Next align the tool and contact up to the properly identified cavity at rear of connector plug. Use firm, even pressure; do not use excessive pressure. It is recommended to start at the center cavity. Contact must be aligned with grommet hole and not inserted at an angle. Push forward until contact is felt to snap into position within insert.



Metal tool with contact.



Note: All plastic tools are double-ended. The colored side is the insertion tool and the white side is the removal tool.

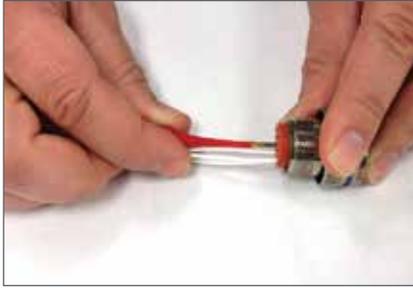
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# Assembly Instructions

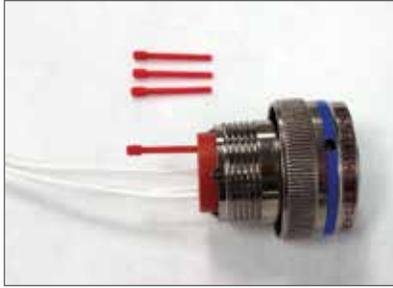
## Military (MS3476), Commercial (MB16)

### CONTACT INSERTION, CONT.

4. Remove tool and pull back lightly on wire, making sure contact stays properly seated and isn't dragged back with the tool. Repeat operation with remainder of contacts to be inserted, beginning with the center cavity and working outward in alternating rows.



5. After all contacts are inserted, fill any empty cavities with wire sealing plugs. (Refer to sealing plug charts for Series III on page 18, for Series I, II, and SJT on page 19.)



6. Reassemble plug or receptacle hardware - slide forward and tighten using connector pliers. Connector holding tools are recommended while tightening back accessories. When using strain relief, center wires at bar clamp. Slide clamp grommet into position and tighten clamp bar screws. When tightening screws, pressure should be applied in the same direction that clamp is threaded to rear threads of connector. When not using clamp grommet, build up wire bundle with vinyl tape so clamp bar will maintain pressure on wires.



CAUTION when inserting or removing contacts, do not spread or rotate tool tips.

### CONTACT REMOVAL

1. Remove hardware from plug or receptacle and slide hardware back along wire bundle.



2. Use proper plastic or metal removal tool for corresponding contact. (Consult tool table on page 277). Slide correct size tool over wire insulation.



Use white end of plastic tool for removal of contacts.

3. Insert plastic or metal removal tool into contact cavity until tool tips enter rear grommet and come to a positive stop. Hold tool tip firmly against positive stop on contact shoulder. Grip wire and simultaneously remove tool and contact. (On occasion, it may be necessary to remove tool, rotate 90° and reinsert.)



Removal of contacts with metal tool.