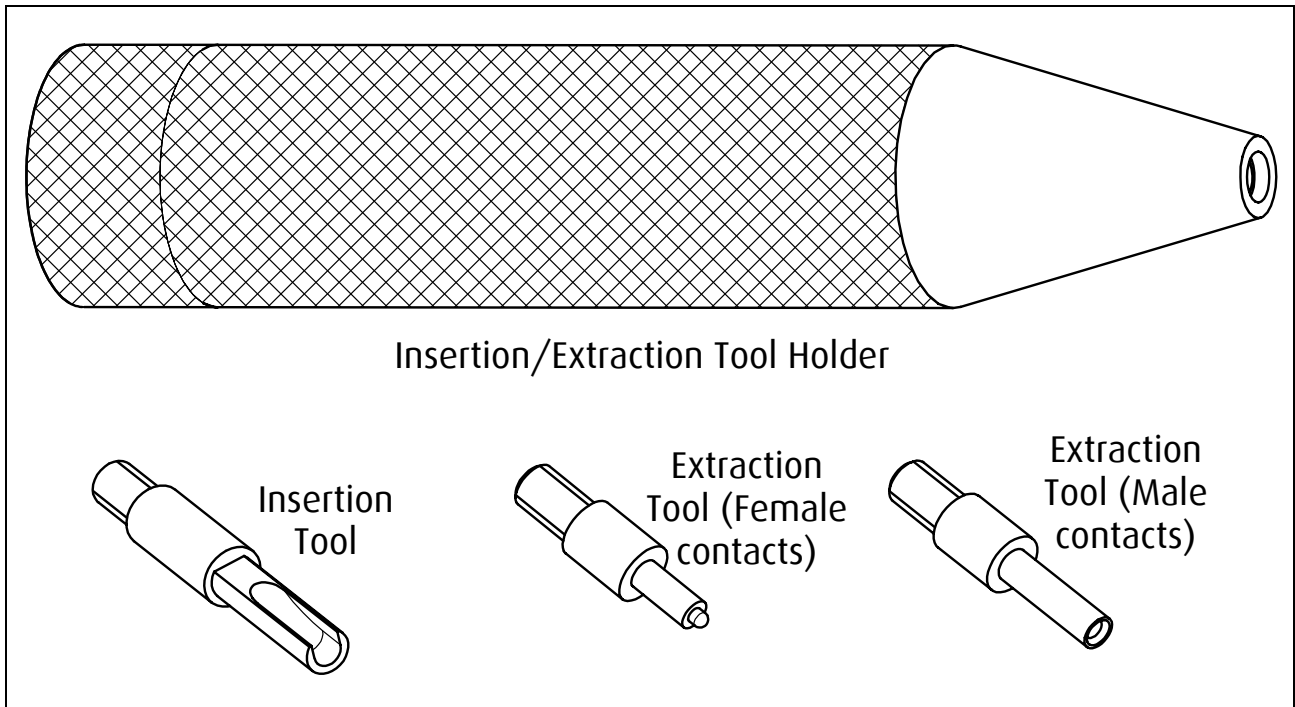


POWER CONNECTOR ASSEMBLY TOOL ZK3610-00



INSERTION PROCEDURE

1. Strip the wire and crimp or solder the socket onto the wire, ensuring that the correct part is used (see Instruction Sheet IS-01, Hand Crimp Tool M22520/01).
2. Ensure all parts (moulding and contacts) are clean and ready for final assembly.
3. Select the appropriate insertion tool for the wire size in use and attach to the handle. The different tools can be found by unscrewing the cap at the end of the handle (see above for tool identification).
4. Place the crimped socket partially into the moulding. The correct position is reached when approximately 1.5-2mm of socket protrudes (see Figures 2 and 3).
5. Place the insertion tool over the wire, with the wire sitting in the groove and the tool resting on the back of the crimped socket (see Figure 1).
6. To complete the assembly, push firmly on the rear of the contact while ensuring the tool remains perpendicular to the mould face. There will be an audible click when the socket is correctly seated within the moulding.
7. Repeat steps 4 to 6 until the moulding is populated as required. Care should be taken not to damage any contacts. It is recommended that the moulding be supported by a small fixture or a hard flat surface.

EXTRACTION PROCEDURE

To remove a contact from the moulding, select the correct Extraction Tool from the handle and attach as before. Place this tool in the mating end of the socket and push firmly. Care should be taken to keep the tool perpendicular to the mould face, or mould damage may occur.

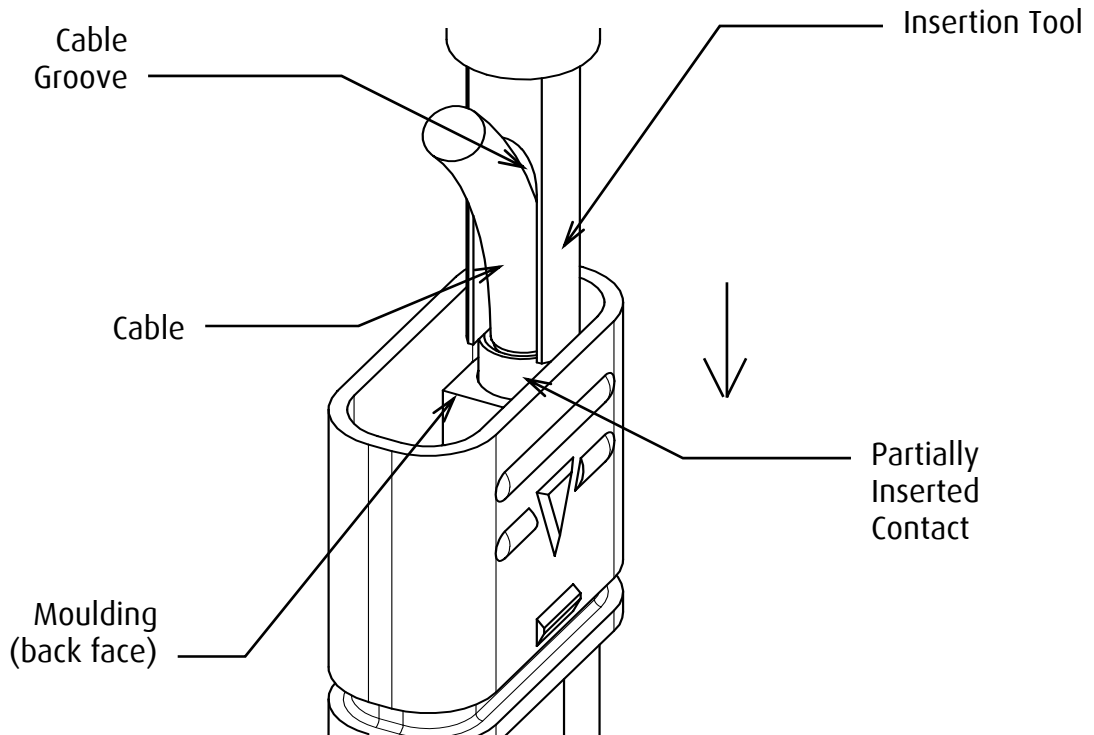


Figure 1

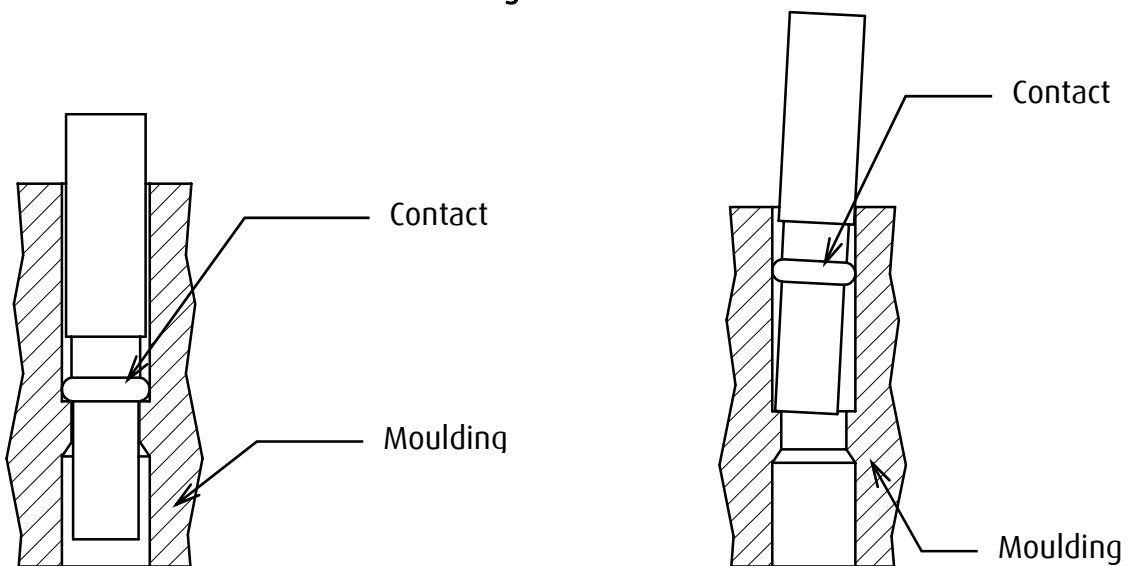


Figure 2
(Correct contact position
prior to final 'click-in')

Figure 3
(Incorrect contact position
prior to final 'click-in')