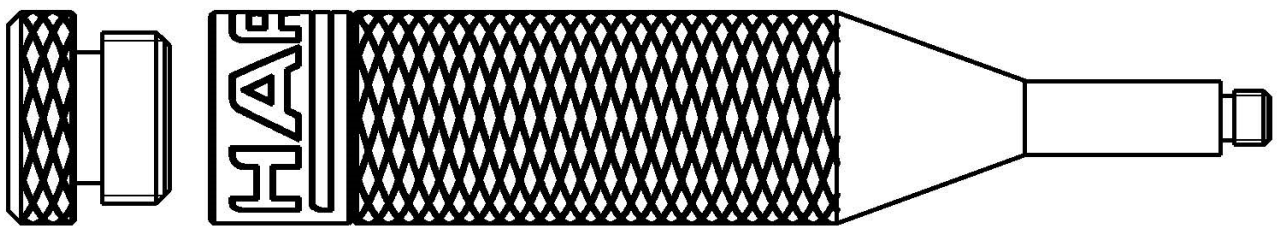


HARWIN

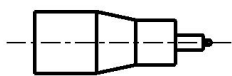
Instruction Sheet

IS-25

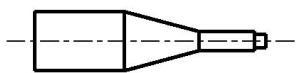
Datamate Assembly Tool Z80-280



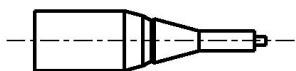
Insertion/Extraction Tool Holder



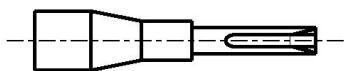
Z80-044E Extraction Tool (Female contacts L-Tek and J-Tek)



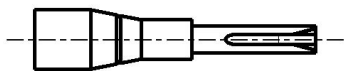
Z80-044F Extraction Tool (Male contacts L-Tek only)



Z80-044G Extraction Tool (Male contacts J-Tek only)



Z80-044C Insertion Tool (for insulation up to Ø0.9mm)



Z80-044D Insertion Tool (for insulation from Ø0.9mm to Ø 1.1mm)

INSERTION PROCEDURE

1. Strip the wire and crimp the contact onto the wire, ensuring that the correct part is used (see Instruction Sheet IS-01, Hand Crimp Tool M22520/01).
2. Ensure all parts (housing and crimp 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 contact partially into the housing. 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 contact (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 contact is correctly seated within the housing.
7. Repeat steps 4 to 6 until the housing is populated as required. Care should be taken not to damage any contacts. It is recommended that the housing be supported by a small fixture or a hard flat surface. Do not support the housing on any latches fitted, or pressure exerted on inserting the contacts will bend the latches.

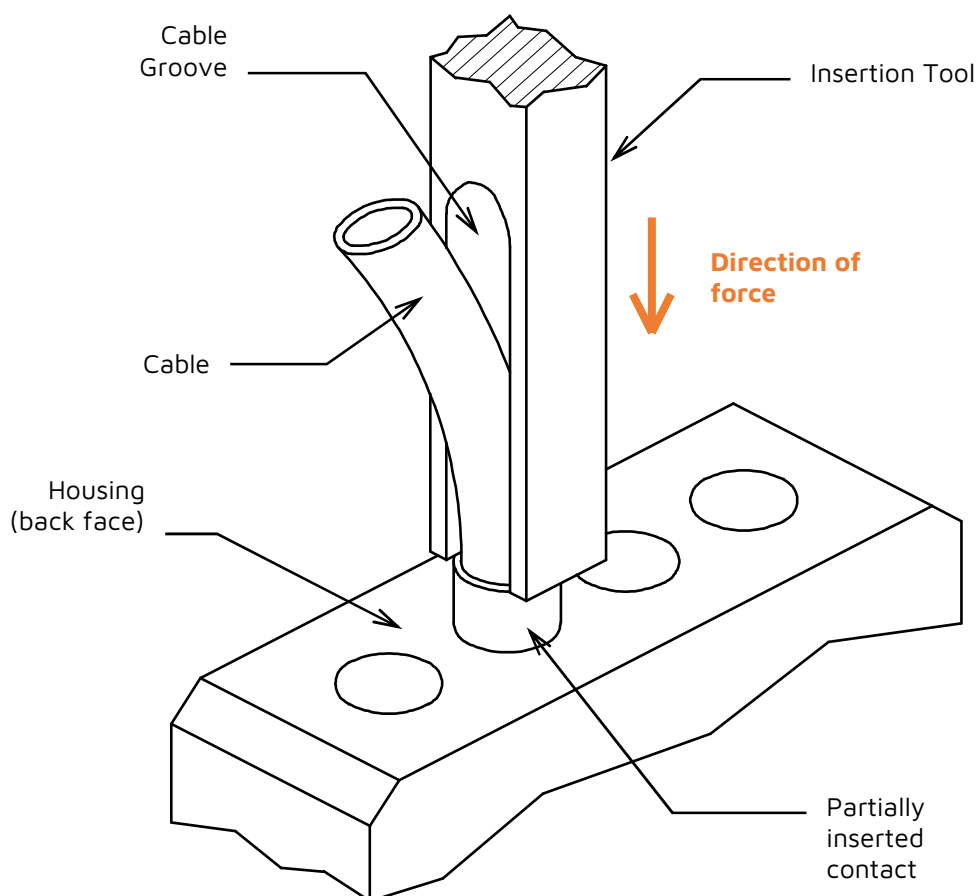


Figure 1

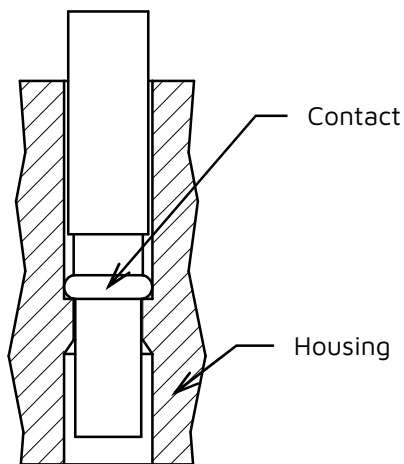


Figure 2
Correct contact position
prior to final 'click-in'

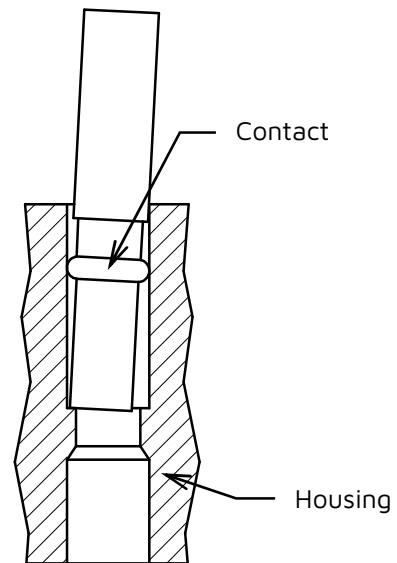


Figure 3
Incorrect contact position
prior to final 'click-in'

Note: Female contact shown

EXTRACTION PROCEDURE

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

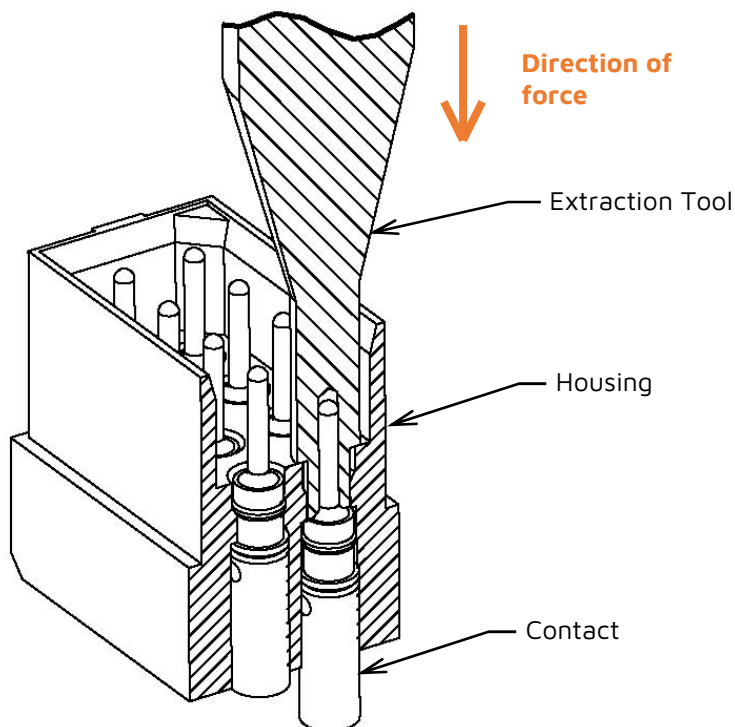


Figure 4 - Male contact shown

**Notes:**

- A different tool tip is required for female and male contacts.
- Datamate J-Tek, Mix-Tek: Following the extraction of female contacts from their housing, re-use of that housing is not advised. It is recommended that a new housing be used to ensure the integrity of the contact retention in the housing. Male contacts can be extracted and replaced in housing 2 times. Re-use of a male housing that has had a contact replaced more than 2 times is not recommended.
- Datamate L-Tek: Following the extraction of contacts from their housing, re-use of that housing is not advised. It is recommended that a new housing be used to ensure the integrity of the contact retention in the housing.

