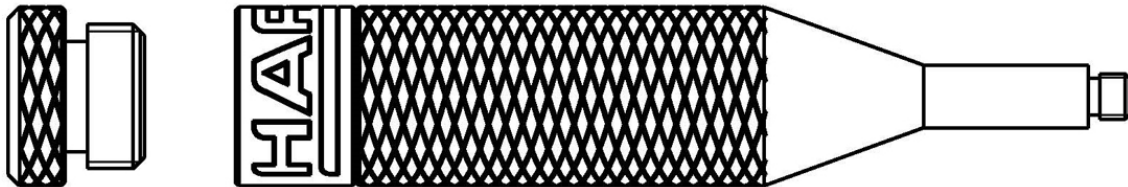


HARWIN

Instruction Sheet

IS-40

M300 Assembly Tool Z300-902



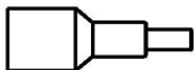
Insertion/Extraction Tool Holder



Z300-920 Insertion Tool (all contacts)



Z300-922 Extraction Tool (Female contacts)



Z300-923 Extraction Tool (Male contacts)

INSERTION PROCEDURE

1. Strip the wire and crimp the contact on to the wire, ensuring that the correct part is used (see Instruction Sheet IS-01, Hand Crimp Tool M22520/2-01).
2. Ensure all parts (housing and crimp contacts) are clean and ready for final assembly.
3. Select the insertion tip for the tool 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 1.2-1.6mm of contact 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 housing 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 (like an unpopulated mating housing in a vice) or a hard flat surface. Do not support the housing on any jackscrews fitted, or pressure exerted on inserting the contacts will not be evenly distributed.

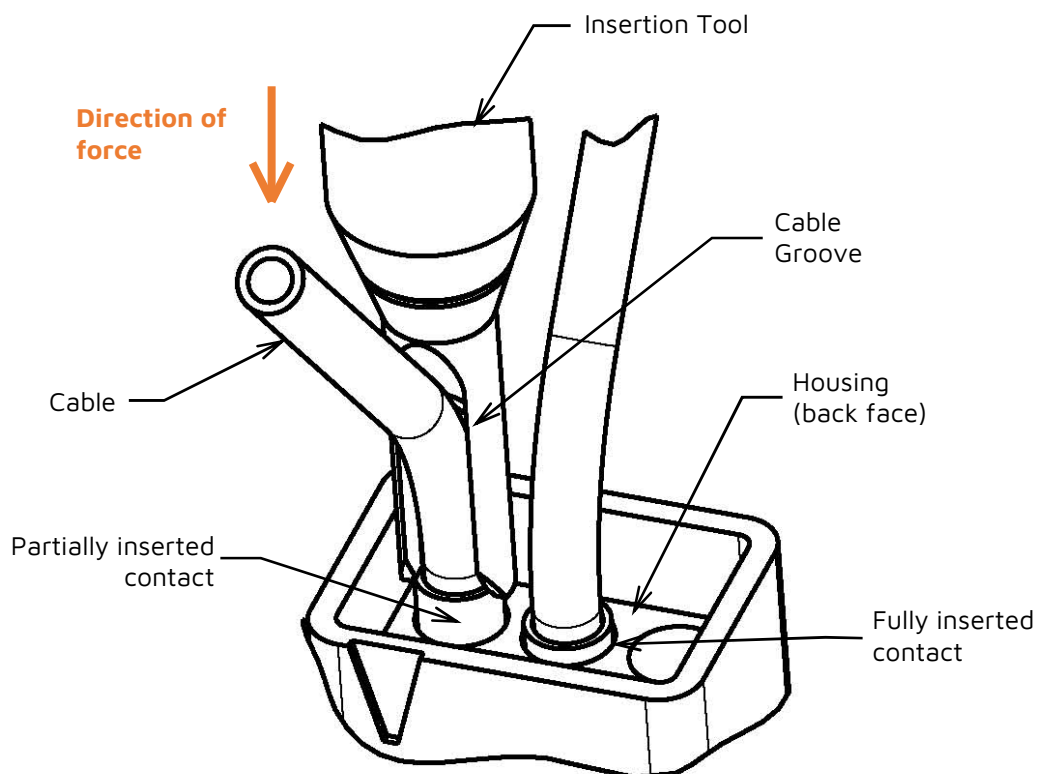


Figure 1 - Insertion Diagram for Crimped Contacts

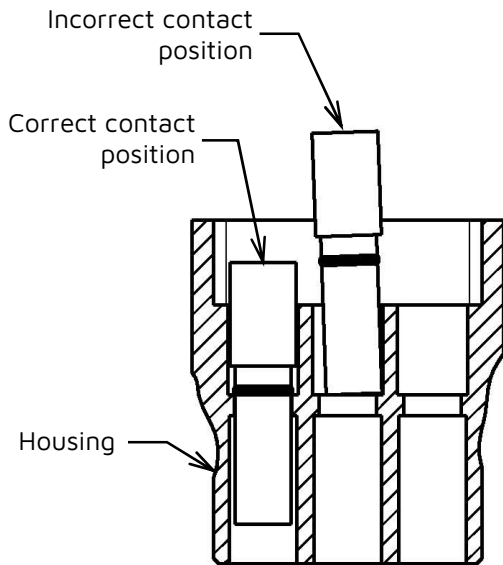


Figure 2 - Female contact position prior to final 'click-in'

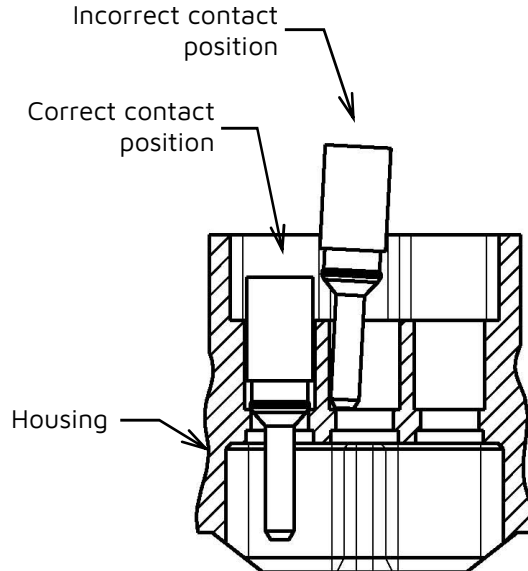


Figure 3 - Male contact position prior to final 'click-in'

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 housing damage may occur.

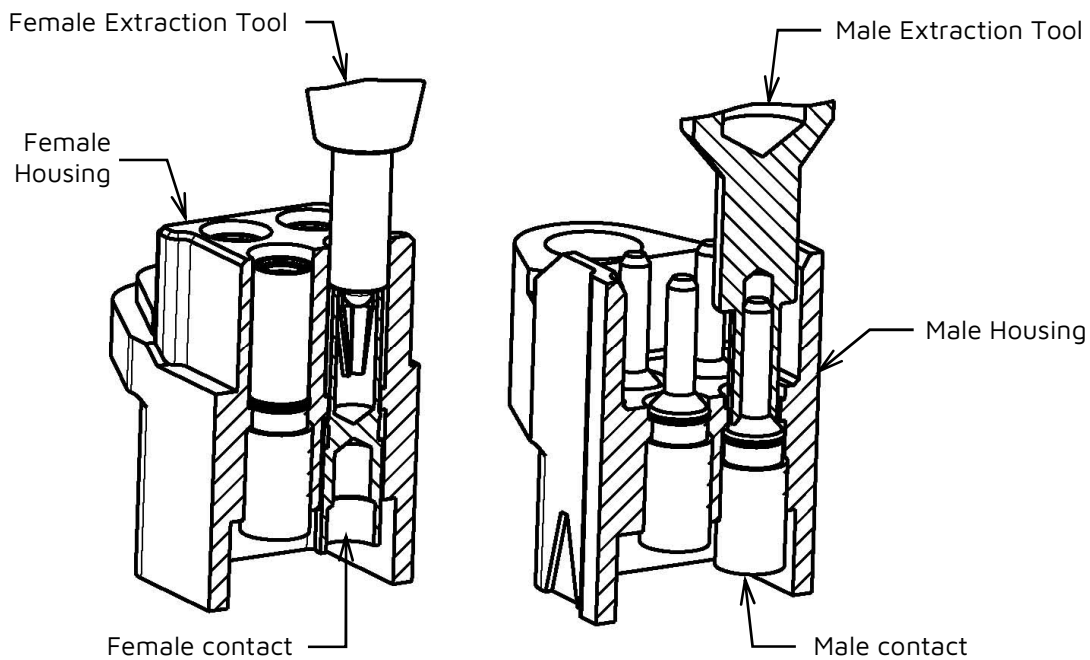


Figure 4

**Notes:**

- A different tool tip is required for female and male contacts.
- Contacts can be carefully extracted and replaced in housing up to 5 times. Re-use of a housing that has had a contact replaced more than 5 times is not recommended.

