CONTACT CRIMPING

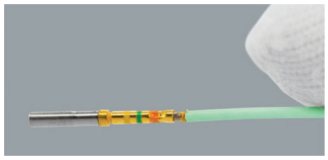
STEP 1: Use a crimping tool with the appropriate pilot stop.

STEP 2: Strip the copper wire over* 5 mm maximum.

STEP 3: Insert the contact in the crimping tool.

STEP 4: Insert the wire in the contact.

STEP 5: Tighten the crimping tool.



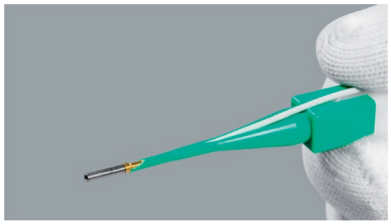
STEP 6: Inspect the contact. It must have 8 markings, and the wire must be seen in the contact side hole.

*For aluminum wire, contact us.
Note: For the use of a shielded version, do not forget to slide the cables in the chimney before crimping the contacts.

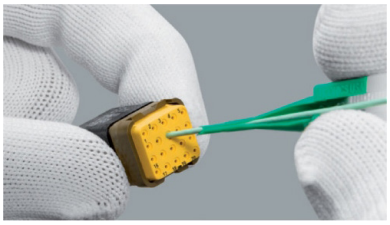
CONTACT INSERTION / EXTRACTION

STEP 1: Use the appropriate plastic tool. There is one tool for each contact size.

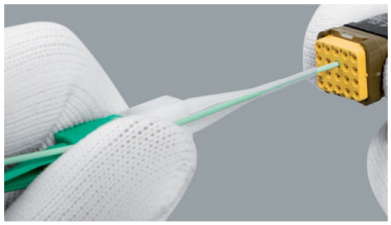
TOOLS PART NUMBERS	CONTACTS SIZE
M81969/14-01	22
M15570-20	20
M15570-16	16
M15570-12	12
114-008 or M81969/14-06	8



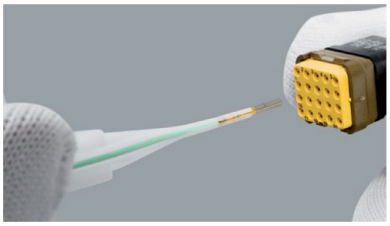
STEP 2: Insert the wire in the slot of the colored side of tool. Pull the wire until the contact butts against the tool.



STEP 3: Insert the contact in the corresponding module cavity. Push the contact fully home. Then remove the tool and lightly pull the wire back to make sure that the contact is well inserted.

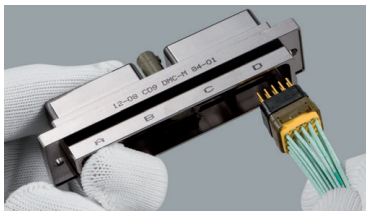


STEP 4: For extraction, insert the wire in the slot of the white side of the tool. Slide the tool into the cavity and push fully home until it is butted against the contact shoulder.



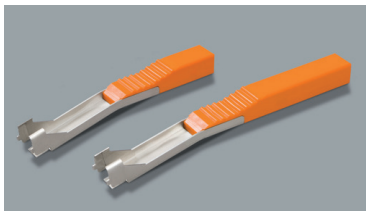
STEP 5: Press the wire between the fingers and the tool. Then pull the overall wire and tool back.

MODULE INSERTION / EXTRACTION

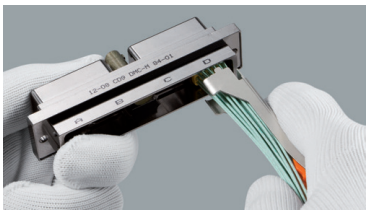


STEP 1: The module must be inserted from the rear side of the housing. The module polarization key must be visible from the marked side of the housing.

STEP 2: Push manually the module (wired or not) until butting. For sealed modules use the insertion tool part number 057-0699-00 A or B. Make sure that the module is well inserted either by pulling back the wires (if wired) or by pushing the module from the front of the housing

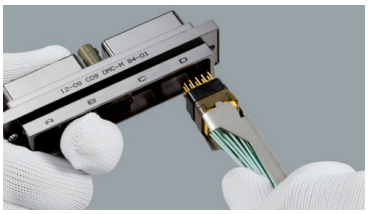


STEP 3: For extraction use the tool part number 057-0289-00 A or B.



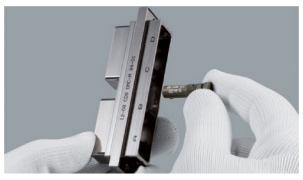
STEP 4: Slide the tool around the cable. Then push the tool inside the housing until butting.

STEP 5: Note the different tool's position depending on the A, B, C or D cavities.

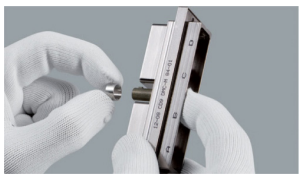


STEP 6: Press the cable between the tool and the fingers and pull the overall back. If the module is not wired, use the same tool, but push the module from the front of the housing.

RECEPTACLE KEYING COMPONENT MOUNTING



STEP 1: The receptacle keying component must be inserted by the rear side of the receptacle housing. Choose the orientation 1, 2, 3, 4, 5 or 6 by 60° rotation. Orientation is indicated by the largest keyway.

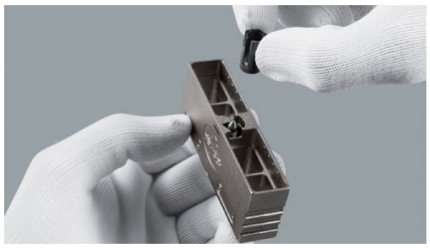


STEP 2: Insert the nut from the front of the receptacle housing.

STEP 3: For mounting and dismounting, use the tool part number 057-0590-80.

STEP 4: Tighten the nut with the tool, by applying a $0.15^{\pm 0.02}$daN.m coupling torque.

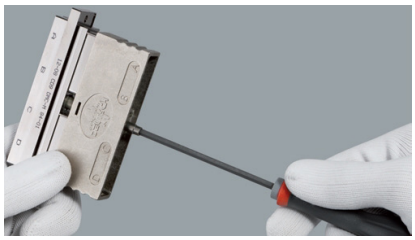
PLUG KEYING COMPONENT MOUNTING



STEP 1: Use the plug keying component corresponding to the receptacle keying component (same color code). Choose the orientation 1, 2, 3, 4, 5 or 6 by 60° rotation. Orientation is indicated by the largest keyway.

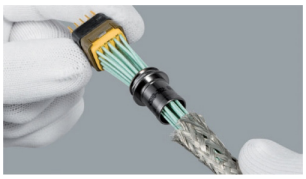
STEP 2: Insert the plug keying component in the front side of the plug housing. Make sure that the orientation allows the insertion of the receptacle keying component. Then fix the plug keying component manually by pushing it down to the bottom of its cavity.

FREE PLUG / RECEPTACLE COUPLING

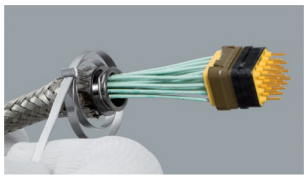


STEP 1: Use the tool part number 057-0592-80 or a standard allen key and apply a 0.1± 0.03 daN.m coupling torque.

SHIELDED BRAID MOUNT ON CHIMNEY

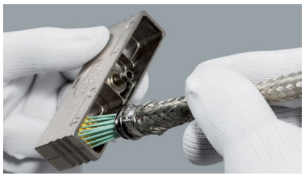


STEP 1: Slide the chimney and the shielded braid around the cable.



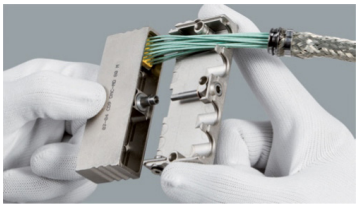
STEP 2: Slide the shielded braid and the 3 mm “band it” ring over the chimney.

STEP 3: Use the tool part number 057-0450-00 to tighten the ring around the shielded braid over the chimney.

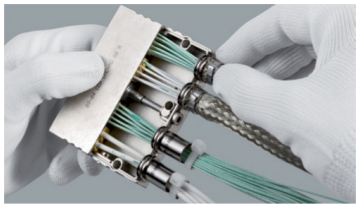


STEP 4: Clip the module in the housing.

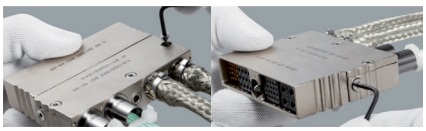
SHIELDED ACCESSORIES



STEP 1: Choose the appropriate plug or receptacle accessory. Insert the accessory in the housing. Make sure that the marking of the accessory is in front of the respective housing’s cavities.

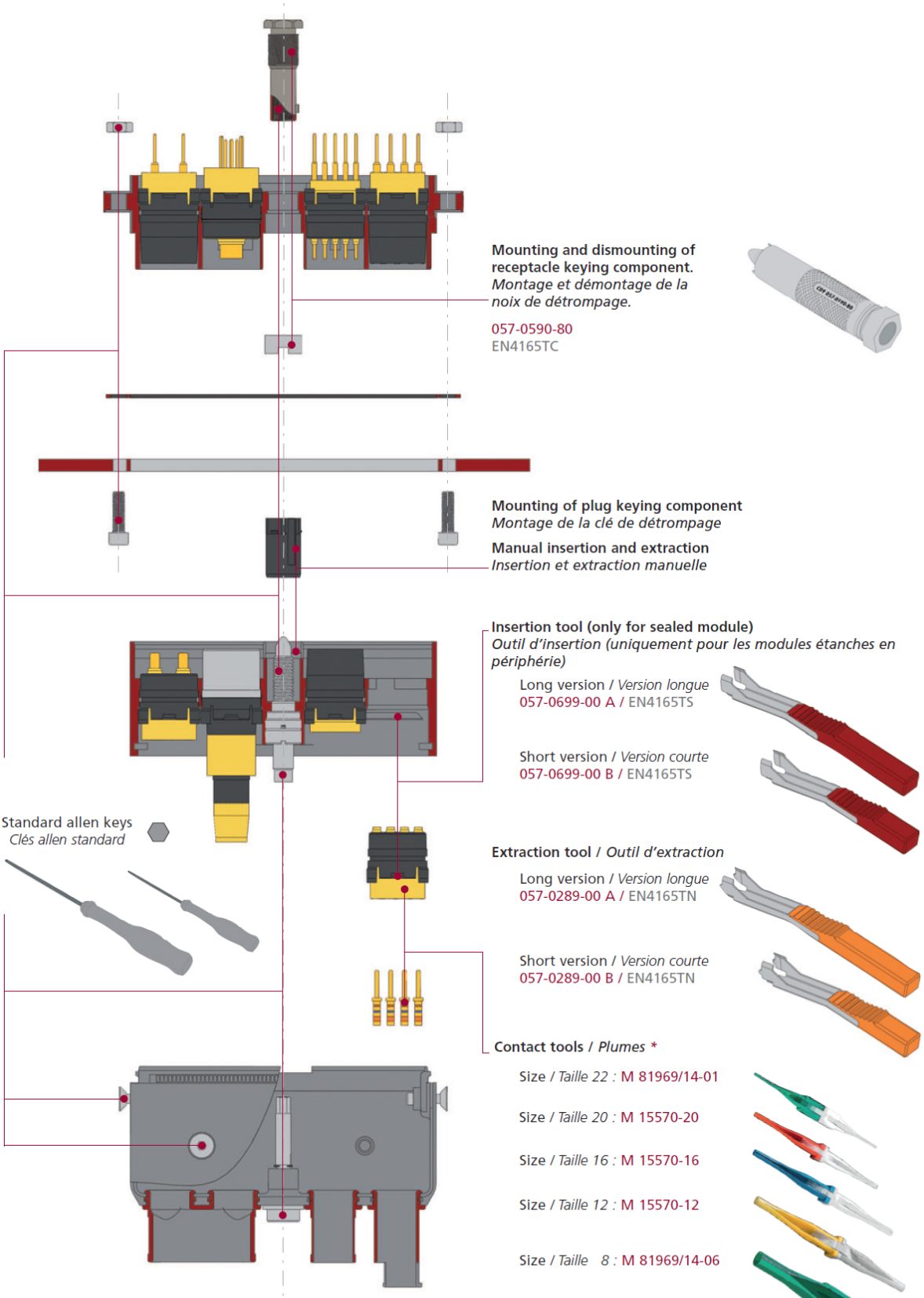


STEP 2: Insert the chimneys in their respective cavities.



STEP 3: Fit the accessory cover, and tighten the overall screws by applying a $0.05^{+0.02}$ daN.m coupling torque with a standard allen key.

TOOLING ASSEMBLY



Mounting and dismounting of receptacle keying component.
Montage et démontage de la noix de détrompage.

057-0590-80
EN4165TC

Mounting of plug keying component
Montage de la clé de détrompage

Manual insertion and extraction
Insertion et extraction manuelle

Insertion tool (only for sealed module)
Outil d'insertion (uniquement pour les modules étanches en périphérie)

Long version / *Version longue*
057-0699-00 A / EN4165TS

Short version / *Version courte*
057-0699-00 B / EN4165TS

Standard allen keys
Clés allen standard

Extraction tool / *Outil d'extraction*

Long version / *Version longue*
057-0289-00 A / EN4165TN

Short version / *Version courte*
057-0289-00 B / EN4165TN

Contact tools / *Plumes* *

Size / *Taille 22* : M 81969/14-01
Size / *Taille 20* : M 15570-20
Size / *Taille 16* : M 15570-16
Size / *Taille 12* : M 15570-12
Size / *Taille 8* : M 81969/14-06

* Delivered with contacts. *Fournis avec les contacts*