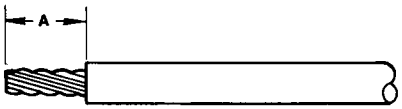
Amphenol 97 Series crimp, rear release assembly instructions

L-1268
(123-1650)
Feb. 1996

WIRE PREPARATION

Strip wire to length shown in chart. Do not cut or nick wire strands. Twist wire strands back to their original lay.

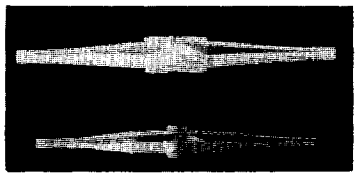


CONTACT AND WIRE SIZES

Contact Size	Contact Part Number	Insulation O.D.	Stripping Length "A"
12	9738-1216X-X	.097 / .160	.200 – .240
16	97XX-1418X-XX	.079 / .100	.170 – .190
16	97XX-1622X-X	.079 / .100	.140 – .160
16	97XX-2026X-X	.039 / .090	.140 – .160
16	97XX-2630X-X	.030 / .054	.140 – .160

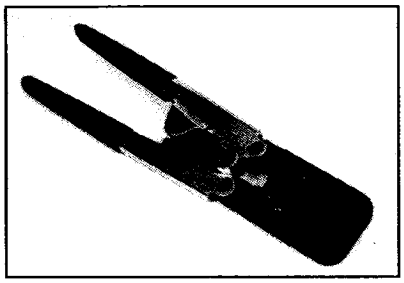
Note: XX = 45 or 55 (38 = 12 size; 45, 55 = 16 size)

INSERTION/EXTRACTION TOOLS



	Contact Size	
	16	12
Part Number:	M81969/14-03	M81969/14-04

CRIMPING TOOLS

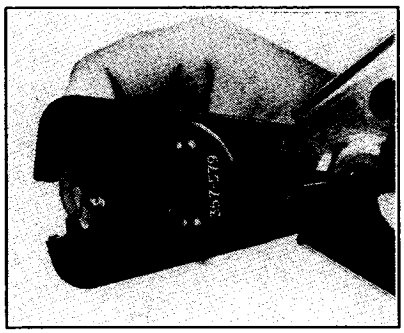


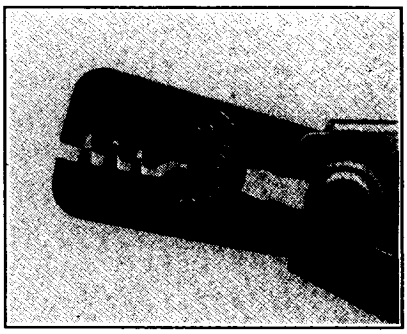
Full Cycle Type

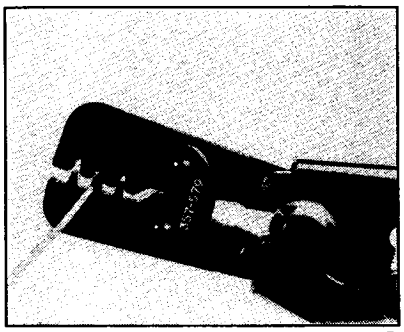
Crimping Tool Part Number	Contact Part Number
357-578	9738-1216X-X thru 9745-1622X-X
357-579	9745-2026X-X and 9745-2630X-X

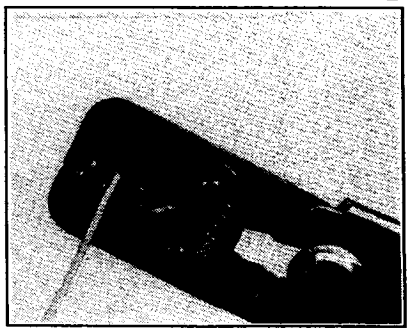
CRIMP WIRE TO CONTACTS

Place contact crimp barrel on correct anvil of tool with open side facing up (A). Slowly close jaws until contact is retained by crimping jaws (B). Do not overset. Accurately locate the wire crimp by lining up the edge of the wire crimp tab with the contact side of the jaw. Place prepared wire into crimp barrel to correct depth, making sure all wire strands are in crimp barrel (C). Continue to close the jaws *slowly*, until the ratchet disengages (D). The tool will not release until the crimp cycle is complete.


A


B


C

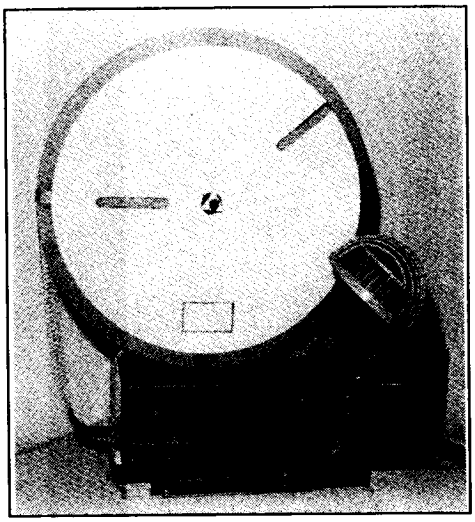

D

Amphenol

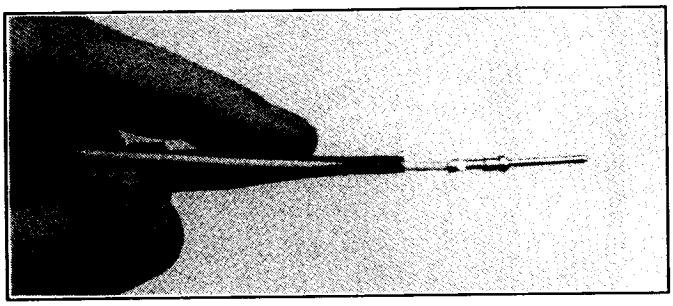
Amphenol Corporation
40-60 Delaware Avenue
Sidney, New York
Phone: (607) 563-5011
Fax: (607) 563-5351

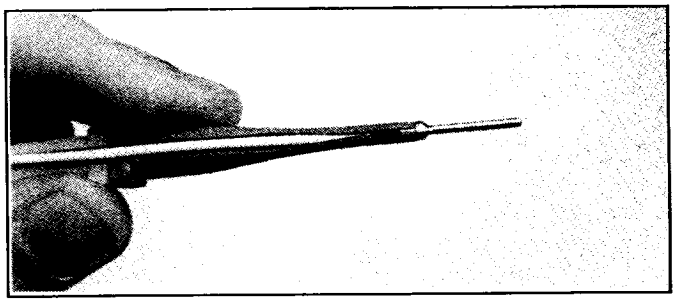
STRIPPER/CRIMPER

For large production quantities, consult the Amphenol North American sales office nearest you for information on semi-automatic crimping equipment.



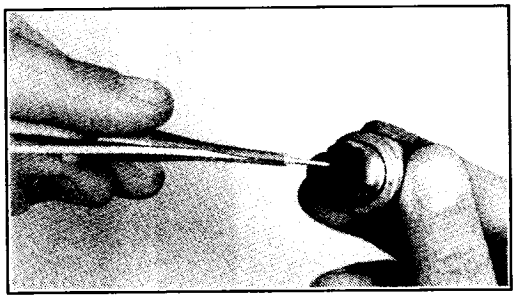
HOW TO INSERT CONTACTS



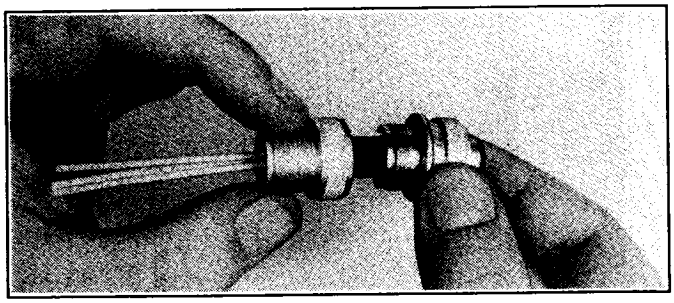


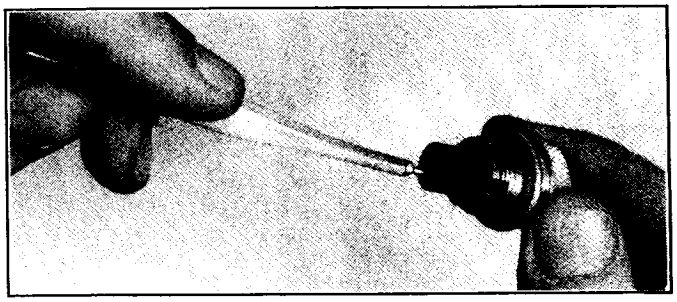
1. If back shell is to be used, thread all wire through the back shell in the proper direction.
2. Hold the colored half of the appropriate insertion/removal tool between the thumb and forefinger. Lay the wire to be inserted along the slot leaving about 1/2 inch of wire protruding.
3. The snap the wire into the tool. Pull the wire back through the tool until tip of tool seats against contact shoulder.
4. Slowly push the contact straight into the cavity until positive resistance is felt. Contact is fully seated. Release wire and pull out the tool. Check the retention by pulling gently on the wire.

NOTE: Contact may be inserted without the use of an insertion tool when using 18 gauge wire or larger.



HOW TO REMOVE CONTACTS





1. Remove back shell, if used, and slide back on wire.
2. Snap white end of appropriate insertion/ extraction tool over the wire of the contact to be removed. Slide tool along the wire into the insert cavity until it engages the contact rear and a positive resistance is felt. A slight rotation of the tool will aid its proper positioning.
3. Press the wire of the contact to be removed against the serrations of the plastic tool and pull both the tool and the contact wire assembly out of the connector.