

INSTRUCTIONS FOR AMPHENOL® 11-8674-XX/M81969/8-XX SERIES CONTACT INSERTION TOOLS

1. APPLICATION

A. Amphenol 11-8674-XX Series Insertion Tools are designed for rear insertion of contacts from Amphenol JT-R Series connectors.

B. See table for maximum recommended wire insulation outside diameters.

2. PROCEDURE

A. Determine contact size, Example: JTR-20, JTR-22, etc.

B. Select correct tool from table below.

C. Remove any rear accessories on connector and slide them back on wire bundle.

D. Place tool around wire attached to contact and slide tool tip down wire until tip butts against rear shoulder of contact. See figure 1.

E. Grip tool and exert pressure with fingers in direction indicated by pressure arrows in "A" of figure 2. This action holds tool tip firmly against contact shoulder and assures tool, contact and wire will act as a unit.

F. Maintaining pressure, insert tool, contact and wire as a unit into the grommet hole until contact is fully seated as shown in "A" of figure 2.

CAUTION

To avoid damage to tool and/or grommet, do not tip, spread or rotate tool while in connector.

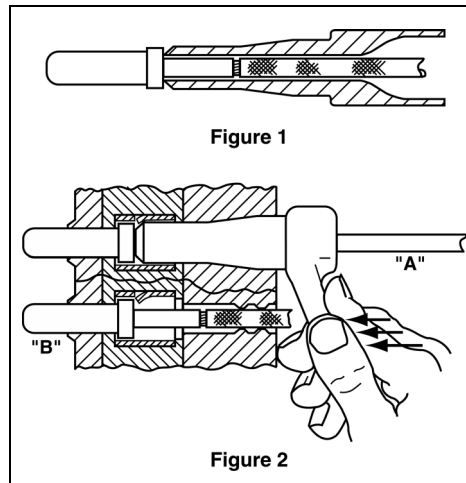
G. Relax pressure and slide tool back along wire insulation until it clears the grommet; remove tool from wire. Hold wire forward while tool is being removed. This prevents tool from dragging contact out of locked position.

"B" of figure 2 illustrates a contact properly positioned after tool removal.

H. Slide connector accessories forward and secure to rear of connector.

For additional information contact:

Amphenol Aerospace
40-60 Delaware Avenue
Sidney, NY 13838-1395
Phone: 607-563-5011
www.amphenol-aerospace.com



Contact Size	Amphenol® Part No.	MS Part No.	Color Code	Max. O. D. Insulation
22D	11-8674-24	M81969/8-01	Black	0.050 in.
22M	11-8674-24	M81969/8-01	Black	0.050 in.
22	11-8674-22	M81969/8-03	Brown	0.060 in.
20	11-8674-20	M81969/8-05	Red	0.077 in.
16	11-8674-16	M81969/8-07	Blue	0.109 in.
12	11-8674-12	M81969/8-09	Yellow	0.155 in.

Amphenol

INSTRUCTIONS FOR AMPHENOL® 11-8674-XX/M81969/8-XX SERIES CONTACT INSERTION TOOLS

1. APPLICATION

A. Amphenol 11-8674-XX Series Insertion Tools are designed for rear insertion of contacts from Amphenol JT-R Series connectors.

B. See table for maximum recommended wire insulation outside diameters.

2. PROCEDURE

A. Determine contact size, Example: JTR-20, JTR-22, etc.

B. Select correct tool from table below.

C. Remove any rear accessories on connector and slide them back on wire bundle.

D. Place tool around wire attached to contact and slide tool tip down wire until tip butts against rear shoulder of contact. See figure 1.

E. Grip tool and exert pressure with fingers in direction indicated by pressure arrows in "A" of figure 2. This action holds tool tip firmly against contact shoulder and assures tool, contact and wire will act as a unit.

F. Maintaining pressure, insert tool, contact and wire as a unit into the grommet hole until contact is fully seated as shown in "A" of figure 2.

CAUTION

To avoid damage to tool and/or grommet, do not tip, spread or rotate tool while in connector.

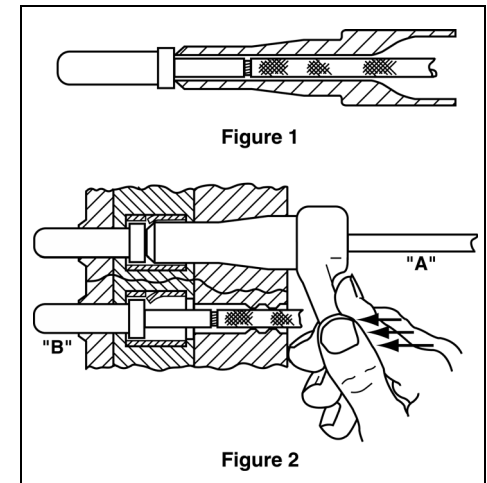
G. Relax pressure and slide tool back along wire insulation until it clears the grommet; remove tool from wire. Hold wire forward while tool is being removed. This prevents tool from dragging contact out of locked position.

"B" of figure 2 illustrates a contact properly positioned after tool removal.

H. Slide connector accessories forward and secure to rear of connector.

For additional information contact:

Amphenol Aerospace
40-60 Delaware Avenue
Sidney, NY 13838-1395
Phone: 607-563-5011
www.amphenol-aerospace.com



Contact Size	Amphenol® Part No.	MS Part No.	Color Code	Max. O. D. Insulation
22D	11-8674-24	M81969/8-01	Black	0.050 in.
22M	11-8674-24	M81969/8-01	Black	0.050 in.
22	11-8674-22	M81969/8-03	Brown	0.060 in.
20	11-8674-20	M81969/8-05	Red	0.077 in.
16	11-8674-16	M81969/8-07	Blue	0.109 in.
12	11-8674-12	M81969/8-09	Yellow	0.155 in.

Amphenol