

# ASSEMBLY INSTRUCTIONS FOR PYLE® MINIATURE CYLINDRICAL MIL-C-26500 CONNECTORS

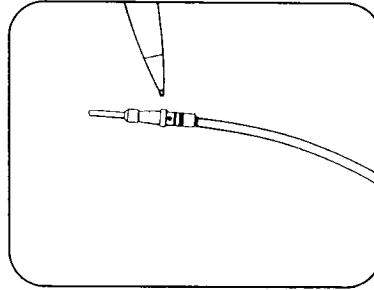
## Contact Termination

Contacts should be crimped to the wire with MS Standard hand crimping tools or specification automatic crimping machines.

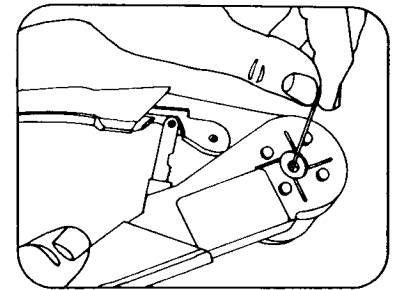
When stripping the wire avoid nicking wires or damaging the insulation as it is a functional part of the sealing system.

Contact Size	Wire Size	Stripping Length
20	20 to 24	.170" – .201"
16	16 to 18	.207" – .238"
12	12 to 14	.207" – .238"

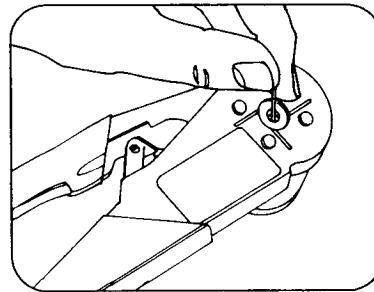
## Contact Crimping Procedure



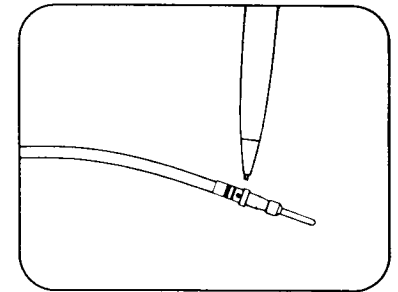
1. Insert stripped wire into contact pocket until it is visible through inspection hole.



2. Carefully seat contact in crimp tool positioner.



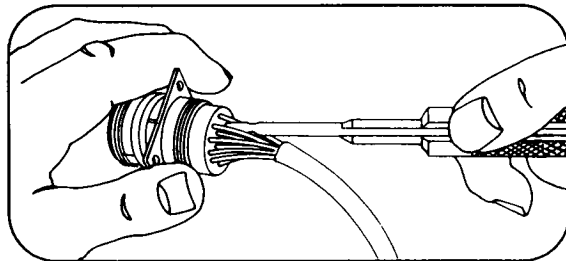
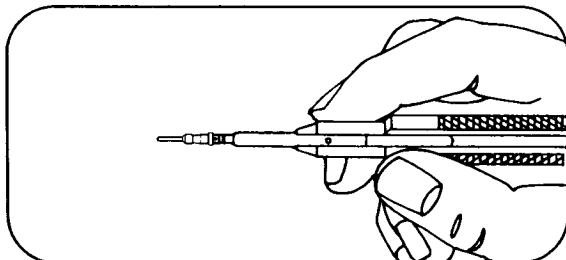
3. Crimp in one full stroke. (The ratchet will not release jaws until tool has completed stroke).



4. Inspect crimp for wire visibility through inspection hole.

## Contact Insertion into the Connector

The following steps are recommended for assembly.



### NOTE:

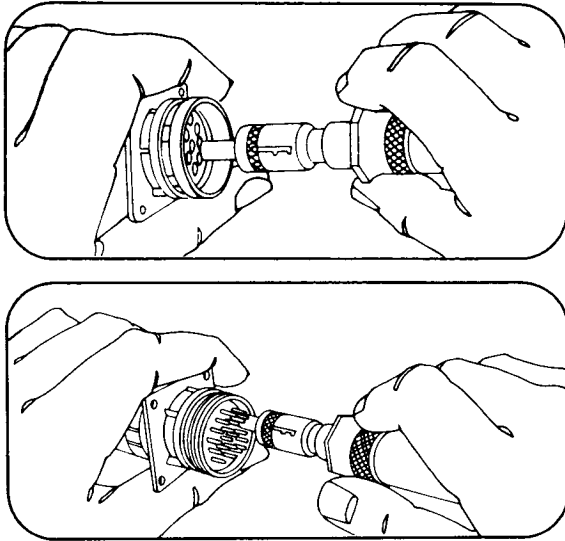
The Pyle Miniature Connector is designed with a unique sealing principle. Assembly of contacts into the connector must be made with reasonable care to avoid damage to the silicone rubber insert.

1. Lubricate wire cavities in back face of insert with a very thin film of DC-200 Silicone Oil or equal before inserting contacts.
2. Locate contact in insertion tool (as shown in illustration).
3. Align contact with hole in rear face of insert. The alignment of insertion tool with contact must be coaxial with the axis of the connector. When contact has entered rear seal portion of insert, maintain alignment of contact and tool parallel to, and in line with hole. Insert contact to full depth. Seating of the contact in the retention collet is audible. The contact insertion force is less than five pounds.
4. Extract insertion tool, keeping it aligned with hole.

# Amphenol

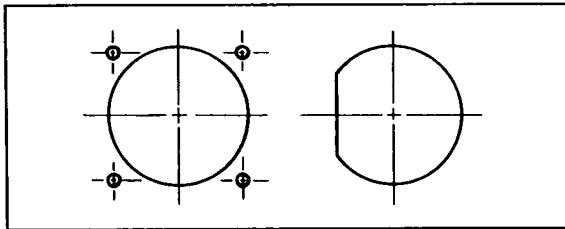
### Contact Removal from the Connector

A contact is removed from the connector insert with the extraction tool as follows:



1. Set the spacer sleeve in the proper position for removal of male or female contact.
2. Place tool over the contact and insert into front face of cavity. The alignment of removal tool with contact must be coaxial with axis of connector.
3. Exert a nominal force axially (from 5 to 10 lbs.) to release retention collet. Spacer sleeve will shoulder at front face of insulation when tool is inserted to proper depth.
4. Push extraction plunger to force the contact out of the rear of the insert.
5. Grasp contact or wire at rear face of insert and complete the extraction.
6. Remove extraction tool axially.
7. After using extraction tool the spacer sleeve should be set forward in last notch to protect the end of the plunger guide.

### Panel Mounting



Two receptacle shell styles, flange mount and D-hole mount, are available for panel mounting. See the applicable drawings for mounting hole dimensions. The square flange receptacle, sizes 10 through 22, is fastened to the panel with four size #4-40 machine screws. The 24 and 28 size shells are fastened with #6-32 machine screws.

### Assembly Tools

#### Crimping

Contact Size	Crimping Tool with Indenters		Adjustable Turret		Checking Gage for Crimping Tool	
	Amphenol/ Pyle No.	Mil. No.	Amphenol/ Pyle No.	Mil. No.	Amphenol/ Pyle No.	Mil. No.
20	TP-201354	M22520/1-01 (Class 1)	TP-201355	M22520/1-02 (Class 1)	TP-201356	M22520/3
16						
12						

#### Insertion

Contact Size	Insertion Tool			Insertion Tool Replacement Tip & Pin	
	Amphenol/ Pyle No.	Mil. No.	Color Code	Amphenol/ Pyle No.	Mil. No.
20	ZZL-R-9510-A-20	MIL-I-81969/17-9	Red	ZZL-R-9531-A-20	-
16	ZZL-R-9510-16	MIL-I-81969/17-4	Blue	ZZL-R-9531-16	-
12	ZZL-R-9510-12	MIL-I-81969/17-5	Yellow	ZZL-R-9531-12	-

#### Removal

Contact Size	Removal Tool			Removal Tool Replacement Tip	
	Amphenol/ Pyle No.	Mil. No.	Color Code	Amphenol/ Pyle No.	Mil. No.
20	ZZL-R-9511-20	MS-24256-R-20	Red	ZZL-R-9557-20	-
16	ZZL-R-9511-16	MS-24256-R-16	Blue	ZZL-R-9557-16	-
12	ZZL-R-9511-12	MS-24256-R-12	Yellow	ZZL-R-9557-12	-

If more information is needed concerning assembly instructions for MIL-C-26500 connectors, please contact -  
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