

**INSTALLATION INSTRUCTIONS FOR  
MIL-C-26482, SERIES 2 CONNECTORS AND MIL-C-83723, SERIES III CONNECTORS**

**SECTION I: DESCRIPTION**

- 1.1 This connector series meets the requirements of MIL-C-26482 classes E and L, Series 2; and MIL-C-83723 Series III. This connector series incorporates the use of crimp type contacts which are rear insertable and removable. The contact retention system is a dielectric disc or metal clip style. Since the contacts are inserted and removed from the rear, serviceability is made easier.

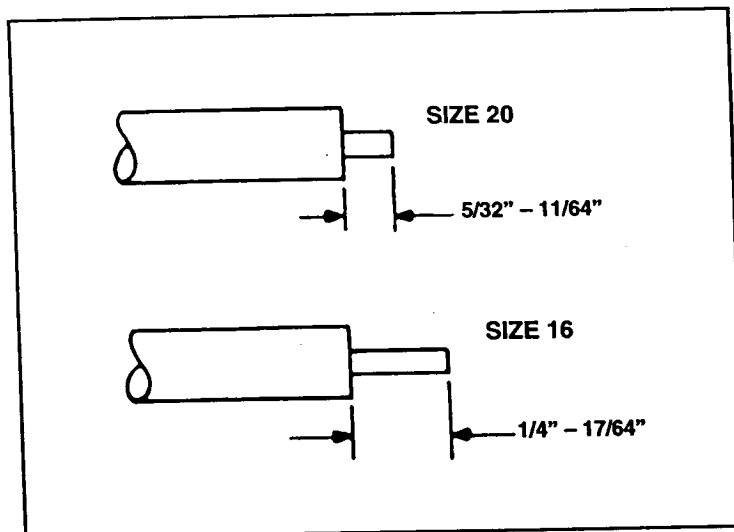
**SECTION II: INSTALLATION**

**2.1 PREPARATION OF WIRE**

- a. Cut wire or cable to required length.
- b. Strip each wire. **DO NOT CUT** or nick strands. Hot wire stripping methods are recommended in order to avoid damage to the wire strand. See Figure 2 for stripping dimensions.

- 2.2 Check to be sure strands of conductors are not separated. If necessary, reform by lightly twisting the strands together.

- 2.4 The recommended crimping tool for the size 16 and 20 contacts is the M22520/1-01 tool with turret head M22520/1-02. Other tools are available and may be used. See Table I below.



**Figure 2: STRIPPING DIMENSIONS**

**2.3 CRIMPING**

**Table I: CRIMPING TOOLS**

Contact Size	Military Part Number			
	Tool	Turret or Positioner	Tool	Turret or Positioner
20	M22520/1-01	M22520/1-02	MS3191-4	MS3191-3T
20	M22520/2-01	M22520/2-02	MS3198-1	MS3198-1P MS3198-1PA
16	M22520/1-01	M22520/1-02	MS3191-4	MS3191-3T

All tools are available from the MS approved tool manufacturer.

- 2.5 Install turret head in M22520 crimp tool. Select positioner desired from color-coded data plate on side of turret head. Red is for size 20 and blue is for size 16. Raise the selector knob and rotate it until the desired selector number is opposite the index mark. Selector numbers for particular wire size and contact size combinations are called out on the data plate on the side of the turret head.
- 2.6 Insert stripped end of wire into contact wire well and apply pressure until it is positively bottomed. Check visually to make sure the wire strands are visible in the contact inspection hole. With the wire in place, insert the contact through the indenter opening into the turret positioner. Squeeze handles together until the ratchet releases. Handle will return to a fully opened position. Remove crimp contact and wire.
- 2.7 Make a final visual check to be sure contacts are properly crimped and the ends of wires are visible in the contact inspection hole.

## 2.8 INSTALLING CONTACTS

2.9 Slide back accessories over the wires in proper sequence.

## 2.10 CONTACT INSERTION

2.11 The tool used to insert contacts is a combination extract/insert tool Military Part No. M81969/14-11. The -20 tool is for size 20 contacts and the -16 tool is for size 16 contacts. The size 20 tool is color-coded red and white. The size 16 tool is color-coded blue and white. The white end of the tool is for contact extraction and the red or blue end of the tool is for contact insertion.

2.12 Slip the insertion end of the M81969/14-11 tool over the wire insulation and slide forward until the tool bottoms against the rear shoulder of the contact. Keep the wire taut so that the contact shoulder remains firmly against the tool. Use care to provide alignment with the contact, tool, and insert cavity in order to prevent any loading against the side wall of the insert cavity during insertion. Insert contact firmly into rear of grommet hole until it bottoms. Remove tool and pull gently (no intermittent tugging or excessive pulling) on wire to assure contact is properly retained.

2.13 Fill any unused holes in the connector with an uncrimped contact and a sealing plug.

## 2.14 ASSEMBLE BACK ACCESSORIES

2.15 Slide back accessories forward and thread onto rear of connector.

## SECTION III: CONTACT EXTRACTION

3.1 Loosen any back accessories and slide back on wire.

3.2 Slip white end of M81969/14-11 tool over wire insulation and slide forward until tool bottoms against the rear shoulder of the contact. Apply a slight forward pressure on the tool and pull on wire simultaneously. Contact and tool should come out together.