

Amphenol Luminus Series Connectors



A LIGHTWEIGHT, COST-EFFECTIVE CONNECTOR THAT IS HIGHLY RELIABLE AND SIMPLE TO USE.

With multiple product options to choose from, they meet MIL-T-81714, accept AS39029 and Stamped & Formed contacts, and are environmentally-sealed to IP67. Ideal where space is limited, these innovative, “scoop-proof” connectors feature a locking mechanism that ensures stability, are suitable for blind-mating, and are RoHS compliant.

APPLICATIONS

- Cockpit
- Airline Seats/Power Distribution
- Interior Lighting / LED
- Aircraft Galley
- In-flight Entertainment
- Railway
- Heavy Equipment
- Business Jets

FEATURES

MIL-T-81714

Developed to meet MIL-T-81714 requirements

QUICK, SIMPLE CONNECTION

Makes wire installation and maintenance easy and efficient; positive “click” when locked with ¼ turn bayonet coupling system; push and pull system.

INTERFACIAL AND TRIPLE-BARRIER SEAL

Enables environmental sealing (IP 67 rating)

AS39029 CONTACTS

Accepts standard AS39029 contacts (MIL-C-39029)

STAMPED & FORMED CONTACTS

For applications where Mil-Spec contacts are not necessary; lighter vs. Mil-Spec contacts

MULTIPLE KEYING POSITIONS

Ensures proper connectivity

MULTIPLE CONFIGURATIONS AND ACCESSORIES

Flexible product options

DURABILITY

Rugged polyamide housings; 500 mating cycles

BLIND-MATE CONNECTION

Polarization feature enables simple, blind mating

VISUAL MARKINGS

Visual aid to help user mate connector

TECHNICAL SPECIFICATIONS

MATERIALS & FINISHES

Insulator Body	Polyamide 6/6 (Nylon)
Grommet	Silicone Rubber
Contact Retainer:	Stainless Steel
Contacts	Copper Alloy; Stamped & Formed Contact - Hood Stainless Steel; Stamped & Formed Contact - Sleeve Stainless Steel
Contacts	Copper alloy
Plating	Gold-plated 50 microinches per MIL-G-45204 type II, grade C, class I Stamped & Formed Contact - Selective gold plate over mating area 3-5 micro inches over nickel

ELECTRICAL DATA

Insulation Resistance 5000 Ω Min. @ 500 VDC

Dielectric Withstanding 60 Hz

	PUSH AND PULL	TWIST AND LOCK
SEA LEVEL	1500VAC	1500VAC
45,00 FEET	600VAC	-
70,000 FEET	-	300VAC
100,000 FEET	-	300VAC

Current Rating by Contact Size & Wire Accommodation (Test Amps)

WIRE SIZE	22D	20	16	12
28	1.5	-	-	-
26	2.0	-	-	-
24	3.0	3.0	-	-
22	5.0	5.0	-	-
20	-	7.5	7.5	-
18	-	-	10.0	-
16	-	-	13.0	-
14	-	-	-	17.0
12	-	-	-	23.0

Contact Resistance of Mated Contacts End to-End

CONTACT SIZE	MAXIMUM MILLIVOLT DROP
22D	73
20	55
16	49
12	42

MECHANICAL DATA

Temperature Range	-65°F to 257°F (-65°C to 125°C)
Temperature Life	Push and Pull - 150 hours @ 203°F (95°C) Twist and Lock - 500 hours @ 185°F (85°C)
Temperature Cycling	Push and Pull - 5 (1) Hour Cycles: 32°F to 203°F (0°C to 95°C) Twist and Lock - 5 (1) Hour Cycles: -85°F to 257°F (-65°C to 125°C)
Durability	Push and Pull - 50 mating cycles Twist and Lock - 500 mating cycles
Thermal Shock	Twist and Lock - 85°F to 392°F (-65°C to 200°C)

MECHANICAL DATA (CONT.)

Altitude Immersion	Push and Pull - 5% salt solution, 55K feet, DWV 1500VAC Twist and Lock - 5% salt solution 5000 Megohms @ 1500 VAC, sea level 5000 Megohms @ 300 VAC, 70K feet 5000 Megohms @ 300 VAC, 100K feet
Vibration	10-2000 Hz, 15G Peak
Shock	Twist and Lock - 100G Sawtooth, 6MS
Salt Spray	Twist and Lock - 5% Salt Spray @ 203°F (95°C) for 48 hours
Humidity	10 Days @ 77°F to 149°F (25°C to 65°C), 90-95% RH
Seal Rating	IP67
Flammability	Push and Pull - UL94, V0 Twist and Lock - UL94, V0, DOTG section 26.6.2 & 26.6.3, FAR Part 25 App F Part I
RoHS & REACH Compliant	Yes
Fluid Immersion	<p>Push and Pull</p> Skydrol Hydraulic Fluid Hydraulic Fluids per MIL-PRF-832282 & MIL-PRF-87257 Ethylene Glycol Propylene Glycol Aviation Jet Fuel - A
	<p>Twist and Lock</p> Lubricating Oil per MIL-PRF-7808 Cleaning Compound per MIL-PRF-87937, Alkaline Base Isopropyl Alcohol & Mineral Spirit Solution Skydrol Hydraulic Fluid Hydraulic Fluids per MIL-PRF-832282 & MIL-PRF-87257 Ethylene Glycol Propylene Glycol Aviation Jet Fuel - A

TWIST AND LOCK PART NUMBERS



CONTACT QTY	CONTACT SIZE	SHELL SIZE	PLUG FOR SOCKET CONTACTS	INLINE RECEPTACLE FOR PIN CONTACTS	PANEL MOUNT RECEPTACLE FOR PIN CONTACTS	COLOR	SELF-ADHESIVE CRADLE	SCREW MOUNT CRADLE	STRAIN RELIEF
2	22	5	SJS830250	SJS830270	-	Black	SJS257000	N/A	N/A
			SJS830251#	SJS830271#	-				
3	22	5	SJS830210	SJS830230	-	Black	SJS257000	N/A	N/A
			SJS830211#	SJS830231#	-				
3	20	7	SJS862300	SJS862400	-	White	SJS883000	SJS450250	SJS450300
			SJS862301#	SJS862401#	-				
3	16	8	SJS840310	SJS840300	SJS840320	White	SJS445000	SJS450100	N/A
			SJS840311#	SJS840301#	SJS840321#				
3	16	8	SJS840340	SJS840350	SJS840330	Black	SJS445000	SJS450100	N/A
			SJS840341#	SJS840351#	SJS840331#				
4	16	8	SJS840410	SJS840400	-	White	SJS445000	SJS450100	N/A
			SJS840411#	SJS840401#	-				
5	22	8	SJS860510	SJS860500	SJS860520	White	SJS445000	SJS450100	N/A
			SJS860511#	SJS860501#	SJS860521#				
5	22	8	SJS870510*	-	SJS870520*	White	SJS445000	SJS450100	N/A
			SJS870511*#	-	SJS870521*#				
6	22	7	SJS861700	SJS861800	-	Black	SJS883000	SJS450250	SJS450300
			SJS861701#	SJS861801#	-				
8	22	7	SJS830100	SJS830200	SJS830220**	Black	SJS883000	SJS450250	SJS450300
			SJS831100#	SJS831200#	SJS831220***				
8	22	7	SJS830101	SJS830201	SJS830221**	Green	SJS883000	SJS450250	SJS450300
			SJS831101#	SJS831201#	SJS831221***				
8	22	7	SJS830102	SJS830202	SJS830222**	Yellow	SJS883000	SJS450250	SJS450300
			SJS831102#	SJS831202#	SJS831222***				
9	1#16 & 8#22	8	SJS860100	SJS860200	-	White	SJS445000	SJS450100	N/A
			SJS860101#	SJS860201#	-				
9	4#16 & 5#22	10	SJS860910	SJS860900	-	White	SJS991000	N/A	N/A
			SJS860911#	SJS860901#	-				
9	22	8	SJS862100	SJS862200	-	Black	SJS445000	SJS450100	N/A
			SJS862101#	SJS862201#	-				
10	4#16 & 6#22	10	SJS861100	SJS861200	-	White	SJS991000	N/A	N/A
			SJS861101#	SJS861201#	-				
12	22	8	SJS861300	SJS861400	-	White	SJS445000	SJS450100	N/A
			SJS861301#	SJS861401#	-				

* SJS870510 uses pin contacts; SJS870520 uses socket contacts

** Square Panel Mount

With Contacts. Marked with part number without contacts.

PUSH AND PULL PART NUMBERS

CONTACT QTY	CONTACT SIZE	SHELL SIZE	PLUG FOR SOCKET CONTACTS	RECEPTACLE FOR PIN CONTACTS	CODE / COLOR	STRAIN RELIEF
1	12	7			Blue	SJS450300
			SJS512100	SJS512200		
			SJS512101#	SJS512201#	Red	
			SJS512110	SJS512210		
SJS512111#	SJS512211#					
1	16	6	SJS716100	SJS716200	Blue	N/A
			SJS716101#	SJS716201#		
1	16	6	SJS716110	SJS716210	Red	
			SJS716111#	SJS716211#		
1	20	6	SJS720100	SJS720200	Blue	N/A
			SJS720101#	SJS720201#		
1	20	6	SJS720110	SJS720210	Red	
			SJS720111#	SJS720211#		
3	16	11	SJS816100	SJS816200	A / Red	N/A
			SJS816101#	SJS816201#		
3	16	11	SJS816110	SJS816210	B / White	
			SJS816111#	SJS816211#		
3	16	11	SJS816120	SJS816220	C / Blue	
			SJS816121#	SwJS816221#		
3	20	8	SJS820100	SJS820200	A / Red	SJS450400
			SJS820101#	SJS820201#		
3	20	8	SJS820110	SJS820210	B / White	
			SJS820111#	SJS820211#		
3	20	8	SJS820120	SJS820220	C / Blue	
			SJS820121#	SJS820221#		

With Contacts. Marked with part number without contacts.

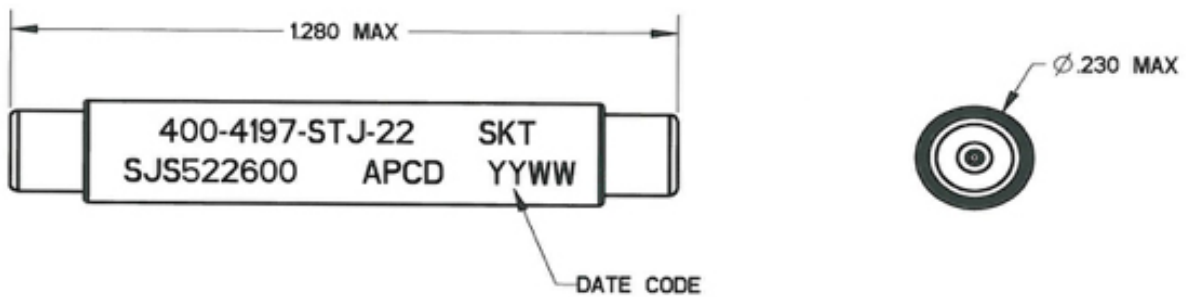
BACC CROSS REFERENCE

BACC PART NUMBER	AMPHENOL PCD PART NUMBER
BACC15BFA	SJS345000
BACC15BFB	SJS891000
BACC63DE0316SA	SJS616100
BACC63DE0316SB	SJS616110
BACC63DE0316SC	SJS616120
BACC63DE0320SA	SJS620100
BACC63DE0320SB	SJS620110
BACC63DE0320SC	SJS620120
BACC63DF0316PA	SJS616200
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BACC63DF0320PB	SJS620210
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BACC63DG0116SR	SJS516110
BACC63DG0120SG	SJS520100
BACC63DG0120SY	SJS520110
BACC63DH0116PB	SJS516200
BACC63DH0116PR	SJS516210
BACC63DH0120PG	SJS520200
BACC63DH0120PY	SJS520210
BACC63EDA-03PA	SJS830351
BACC63EDA-03PAH	SJS830350
BACC63EDA-03PN	SJS830301
BACC63EDA-03PNH	SJS830300
BACC63EDA-04PN	SJS830401
BACC63EDA-04PNH	SJS830400
BACC63EDA-05PN	SJS850501
BACC63EDA-05PNH	SJS850500
BACC63EDB-09PN	SJS850901
BACC63EDB-09PNH	SJS850900
BACC63EEA-03SA	SJS830341
BACC63EEA-03SAH	SJS830340
BACC63EEA-03SN	SJS830311
BACC63EEA-03SNH	SJS830310
BACC63EEA-04SN	SJS830411
BACC63EEA-04SNH	SJS830410
BACC63EEA-05SN	SJS850511
BACC63EEA-05SNH	SJS850510
BACC63EEB-09SN	SJS850911
BACC63EEB-09SNH	SJS850910
BACC63EFA-03PA	SJS830331
BACC63EFA-03PAH	SJS830330
BACC63EFA-03PN	SJS830321
BACC63EFA-03PNH	SJS830320
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BACC63EJ01A	SJSE83050

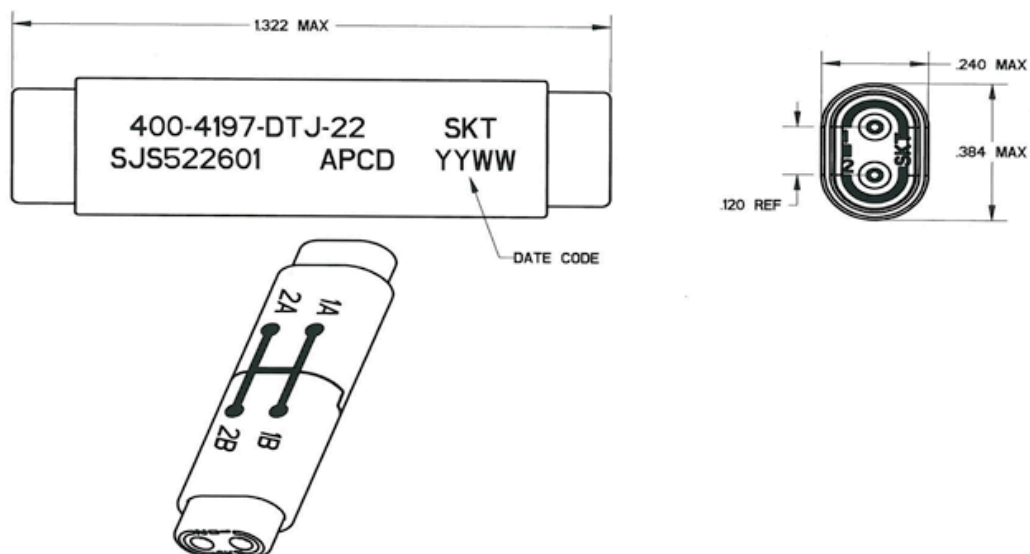
CONTACT QTY	CONTACT SIZE	PART NUMBER	ITT PART NUMBER	SOCKET CONTACTS (Not Included)	WIRE SIZE AWG	CRIMP TOOL	POSITIONER
1	22	SJS522600	400-4197-STJ-22	M39029/22-191	22,24,26,28,30,32	M22520/7-01	M22520/7-11
2 Bussed	22	SJS522601	400-4197-DTJ-22	M39029/22-191			



1 CONTACT - DIMENSIONS



2 CONTACTS - DIMENSIONS

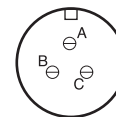
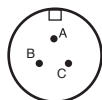
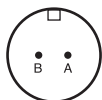


LAYOUTS BY NUMBER OF CONTACTS

12 16 20 22

View of mating-face of plug insert

CONTACTS 2 3 3



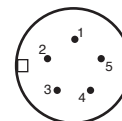
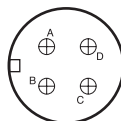
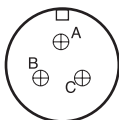
TWIST LOCK
OF CONTACTS

2-#22

3-#22

3-#20

CONTACTS 3 4 5



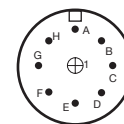
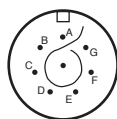
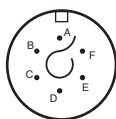
TWIST LOCK
OF CONTACTS

3-#16

4-#16

5-#22

CONTACTS 6 8 9



TWIST LOCK
OF CONTACTS

6-#22

8-#22


8-#22
1-#16

12 16 20 22

View of mating-face of plug insert


CONTACTS	9	9	10
TWIST LOCK			
# OF CONTACTS	5-#22 4-#16	9-#22	6-#22 4-#16
CONTACTS	12	1	1
TWIST LOCK		PUSH-PULL	PUSH-PULL
# OF CONTACTS	12-#22	1-#12	1-#16
	3	3	
PUSH-PULL			
# OF CONTACTS	3-#16	3-#20	

PINS FOR PUSH & PULL



CONTACT SIZE	WIRE SIZE AWG	PIN CONTACT PART NUMBER	COLOR BANDS			WIRE STRIP LENGTHS	WIRE RANGE		WIRE HOLE FILLER	COLOR
			1	2	3		MIN.	MAX.		
22D	22,24,26 & 28	M39029/58-360	Orange	Blue	Black	.125 (3.18)	.030 (0.76)	.054 (1.37)	MS27488-22-2	Black
20	20,22 & 24	M39029/58-363	Orange	Blue	Orange	.188 (4.77)	.040 (1.02)	.083 (2.11)	MS27488-20-2	Red
		SCP058363#	-	-	-					
16	16,18 & 20	M39029/58-364	Orange	Blue	Yellow	.188 (4.77)	.065 (1.65)	.109 (2.77)	MS27488-16-2	Blue
		SCP058364#	-	-	-					
12	12 & 14	M39029/58-365	Orange	Blue	Green	.188 (4.77)	.097 (2.46)	.142 (3.61)	MS27488-12-2	Yellow


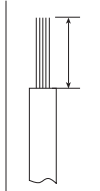


PINS FOR TWIST & LOCK



CONTACT SIZE	WIRE SIZE AWG	PIN CONTACT PART NUMBER	COLOR BANDS			WIRE STRIP LENGTHS	WIRE RANGE		WIRE HOLE FILLER	COLOR
			1	2	3		MIN.	MAX.		
22D	22,24,26 & 28	M39029/58-360	Orange	Blue	Black	.125 (3.18)	.030 (0.76)	.054 (1.37)	MS27488-22-2	Black
20	20,22 & 24	M39029/58-363	Orange	Blue	Orange	.188 (4.77)	.040 (1.02)	.083 (2.11)	MS27488-20-2	Red
		SCP058363#	-	-	-					
16	16,18 & 20	M39029/58-364	Orange	Blue	Yellow	.188 (4.77)	.065 (1.65)	.109 (2.77)	MS27488-16-2	Blue
		SCP058364#	-	-	-					
12	12 & 14	M39029/58-365	Orange	Blue	Green	.188 (4.77)	.097 (2.46)	.142 (3.61)	MS27488-12-2	Yellow

Stamped and Formed Contact
 All dimensions in inches (millimeters in parenthesis)

SOCKETS FOR PUSH & PULL

Insert head first, trim excess

CONTACT SIZE	WIRE SIZE AWG	SOCKET CONTACT PART NUMBER	COLOR BANDS			WIRE STRIP LENGTHS	WIRE RANGE		WIRE HOLE FILLER	COLOR
			1	2	3		MIN.	MAX.		
20	20, 22 & 24	M39029/56-351	Orange	Green	Brown	.188 (4.77)	.040 (1.02)	.083 (2.11)	MS27488-20-2	Red
16	16, 18 & 20	M39029/56-352	Orange	Green	Red	.188 (4.77)	.065 (1.65)	.109 (2.77)	MS27488-16-2	Blue
12	12 & 14	M39029/56-353	Orange	Green	Orange	.188 (4.77)	.097 (2.46)	.142 (3.61)	MS27488-12-2	Yellow

SOCKETS FOR TWIST & LOCK



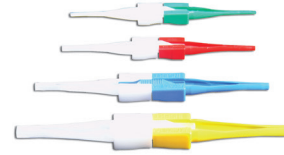



Insert head first, trim excess

CONTACT SIZE	WIRE SIZE AWG	SOCKET CONTACT PART NUMBER	COLOR BANDS			WIRE STRIP LENGTHS	WIRE RANGE		WIRE HOLE FILLER	COLOR
			1	2	3		MIN.	MAX.		
22D	22,24,26 & 28	M39029/57-354	Orange	Green	Yellow	.125 (3.18)	.030 (0.76)	.054 (1.37)	MS27488-22-2	Black
20	20, 22 & 24	M39029/57-357	Orange	Green	Violet	.188 (4.77)	.040 (1.02)	.083 (2.11)	MS27488-20-2	Red
		SCS057357#	-	-	-					
16	16, 18 & 20	M39029/57-358	Orange	Green	Gray	.188 (4.77)	.065 (1.65)	.109 (2.77)	MS27488-16-2	Blue
		SCS057358#	-	-	-					
12	12 & 14	M39029/57-359	Orange	Green	White	.188 (4.77)	.097 (2.46)	.142 (3.61)	MS27488-12-2	Yellow

Stamped and Formed Contact (Tape & Reel versions not available)
All dimensions in inches (millimeters in parenthesis)

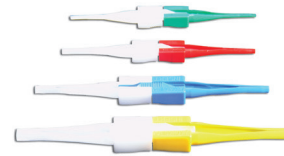
PIN FOR PUSH & PULL



CONTACT SIZE	HAND-CRIMP TOOL	POWER-CRIMP TOOL	TURRET HEADS	USE LOCATOR COLOR	PLASTIC INSERTION/EXTRACTION TOOL	INSERTION TIP COLOR	EXTRACTION TIP COLOR
22D	M22520/2-01	WA22††	M22520/2-09	-	M81969/14-01	Green	White
20	M22520/1-01	WA27F††	M22520/1-04	Red	M81969/14-11	Red	White
16	M22520/1-01	WA27F††	M22520/1-04	Blue	M81969/14-03	Blue	White
12	M22520/1-01	WA27F††	M22520/1-04	Yellow	M81969/14-04	Yellow	White

†† Contact us for more tool accessories.

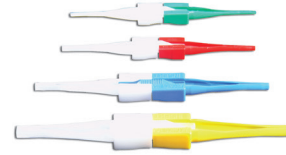
PINS FOR TWIST & LOCK



CONTACT SIZE	HAND-CRIMP TOOL	POWER-CRIMP TOOL	TURRET HEADS	USE LOCATOR COLOR	PLASTIC INSERTION/EXTRACTION TOOL	INSERTION TIP COLOR	EXTRACTION TIP COLOR
22D	M22520/2-01	WA22††	M22520/2-09	-	M81969/14-01	Green	White
20	M22520/1-01	WA27F††	M22520/1-04	Red	M81969/14-11	Red	White
16	M22520/1-01	WA27F††	M22520/1-04	Blue	M81969/14-03	Blue	White
12	M22520/1-01	WA27F††	M22520/1-04	Yellow	M81969/14-04	Yellow	White

†† Contact us for more tool accessories.

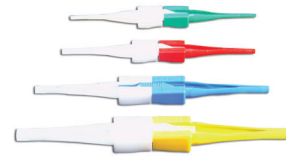
SOCKETS FOR PUSH & PULL



CONTACT SIZE	HAND-CRIMP TOOL	POWER-CRIMP TOOL	TURRET HEADS	USE LOCATOR COLOR	PLASTIC INSERTION/EXTRACTION TOOL	INSERTION TIP COLOR	EXTRACTION TIP COLOR
20	M22520/1-01	WA27F††	M22520/1-04	Red	M81969/14-11	Red	White
16	M22520/1-01	WA27F††	M22520/1-04	Blue	M81969/14-03	Blue	White
12	M22520/1-01	WA27F††	M22520/1-04	Yellow	M81969/14-04	Yellow	White

†† Contact us for more tool accessories.

SOCKETS FOR TWIST & LOCK

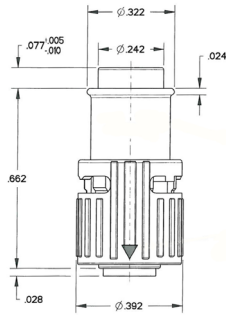


CONTACT SIZE	HAND-CRIMP TOOL	POWER-CRIMP TOOL	TURRET HEADS	USE LOCATOR COLOR	PLASTIC INSERTION/EXTRACTION TOOL	INSERTION TIP COLOR	EXTRACTION TIP COLOR
22D	M22520/2-01	WA22††	M22520/2-06	-	M81969/14-01	Green	White
20	M22520/1-01	WA27F††	M22520/1-04	Red	M81969/14-11	Red	White
16	M22520/1-01	WA27F††	M22520/1-04	Blue	M81969/14-03	Blue	White
12	M22520/1-01	WA27F††	M22520/1-04	Yellow	M81969/14-04	Yellow	White

†† Contact us for more tool accessories.

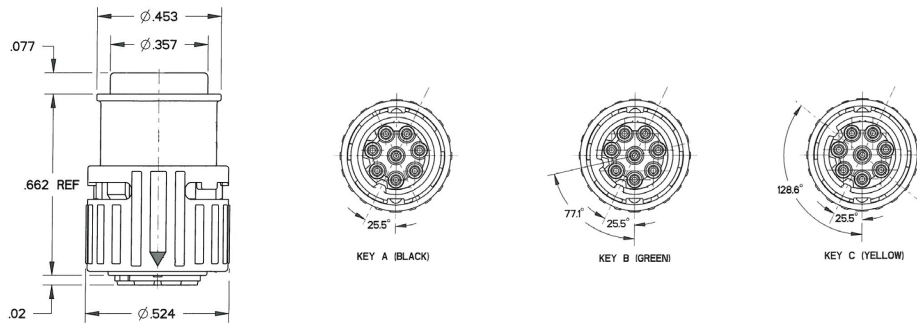
TWIST LOCK - PLUG

Shell Size 5



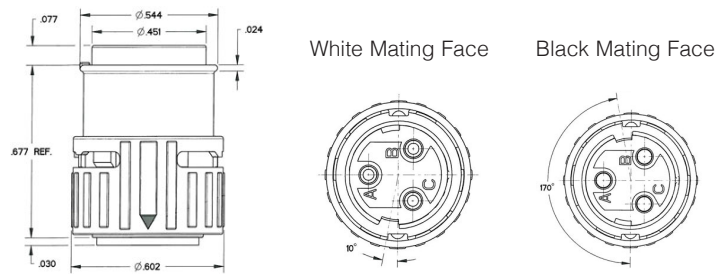
TWIST LOCK - PLUG

Shell Size 7



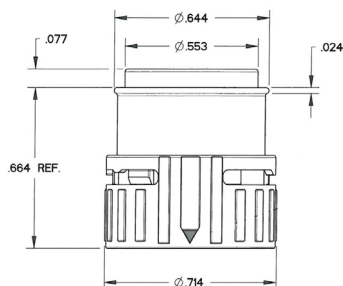
TWIST LOCK - PLUG

Shell Size 8



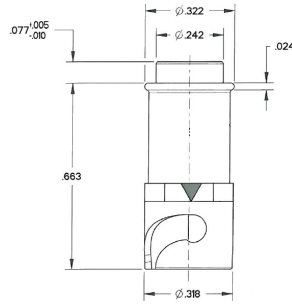
TWIST LOCK - PLUG

Shell Size 10



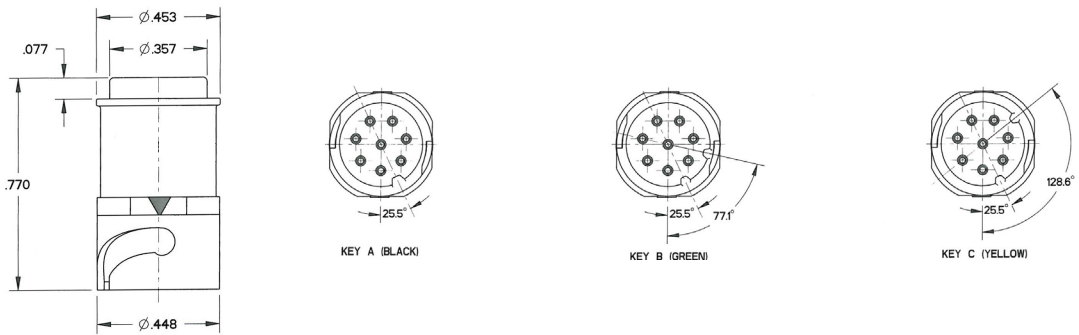
TWIST LOCK - INLINE RECEPTACLE

Shell Size 5



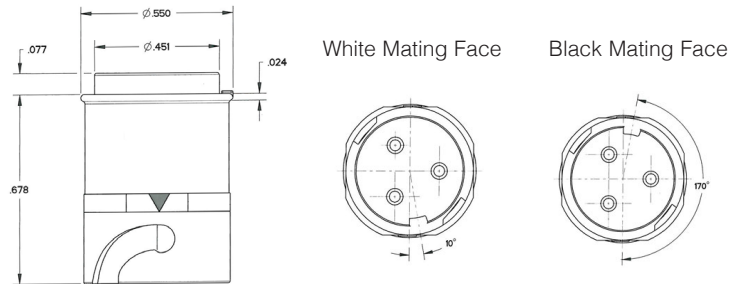
TWIST LOCK - PLUG

Shell Size 7



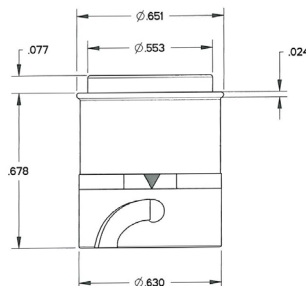
TWIST LOCK - PLUG

Shell Size 8



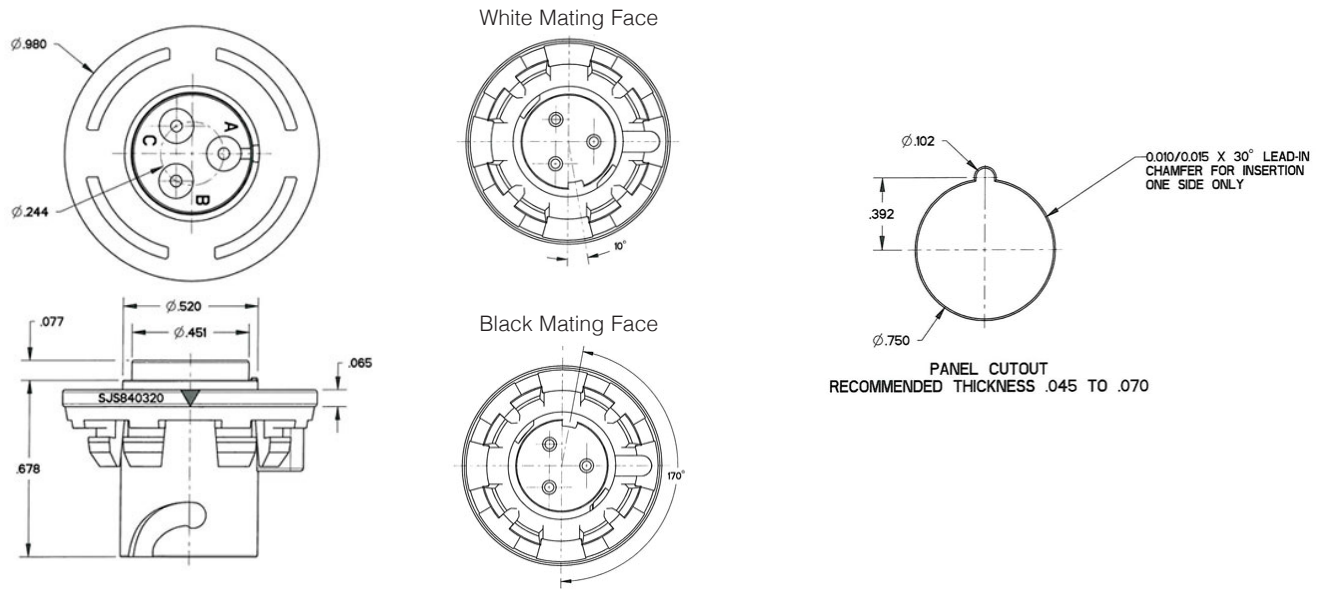
TWIST LOCK - PLUG

Shell Size 10



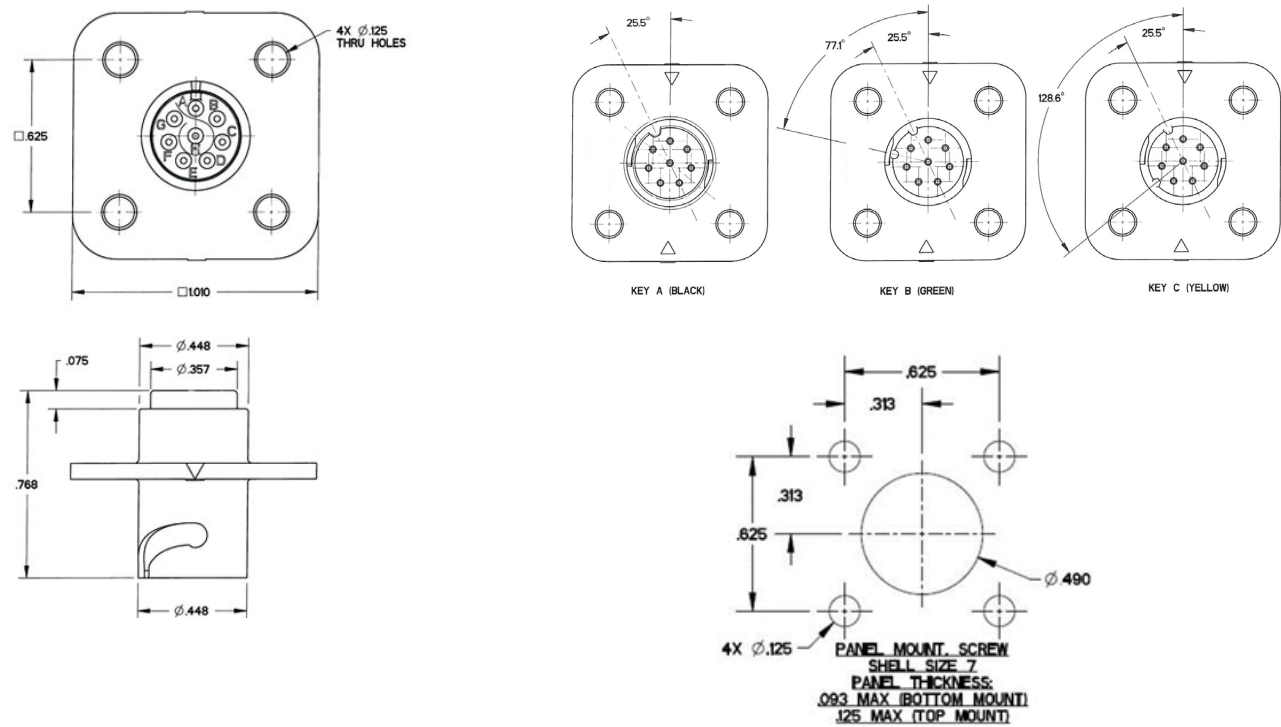
TWIST LOCK - PANEL MOUNT RECEPTACLE (REAR MOUNT)

Shell Size 8



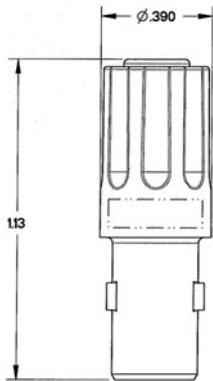
TWIST LOCK - PANEL MOUNT RECEPTACLE (FRONT MOUNT)

Shell Size 7



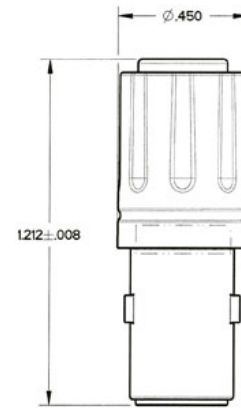
PUSH PULL - PLUG

Shell Size 6



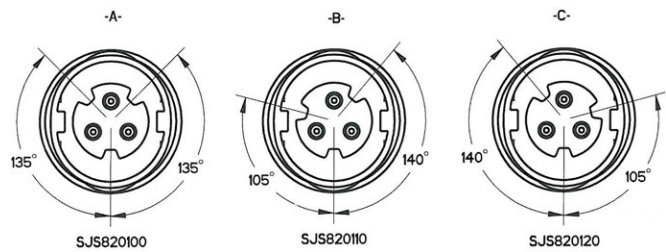
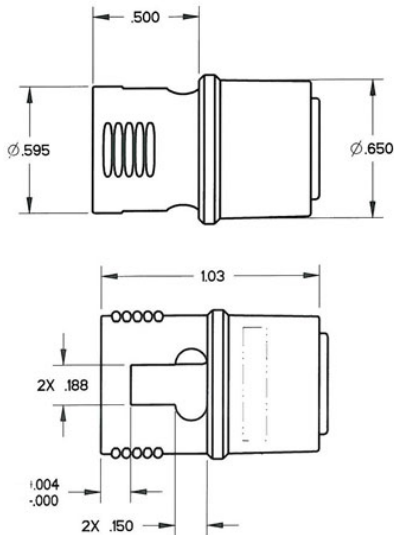
PUSH PULL - PLUG

Shell Size 7



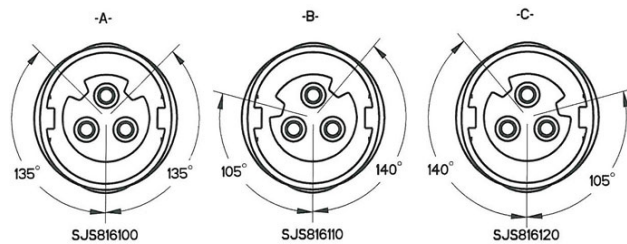
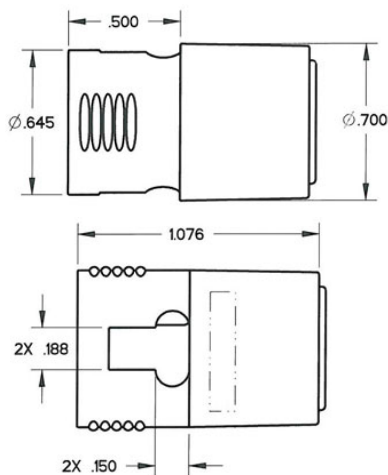
PUSH PULL - PLUG

Shell Size 8



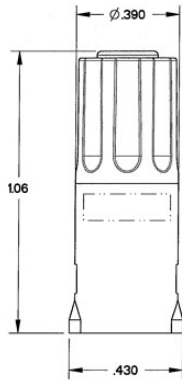
PUSH PULL - PLUG

Shell Size 11



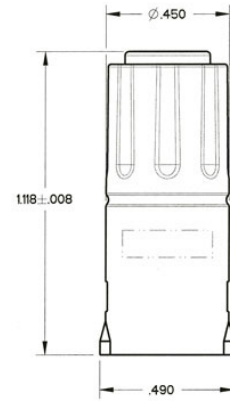
PUSH PULL - INLINE RECEPTACLE

Shell Size 6



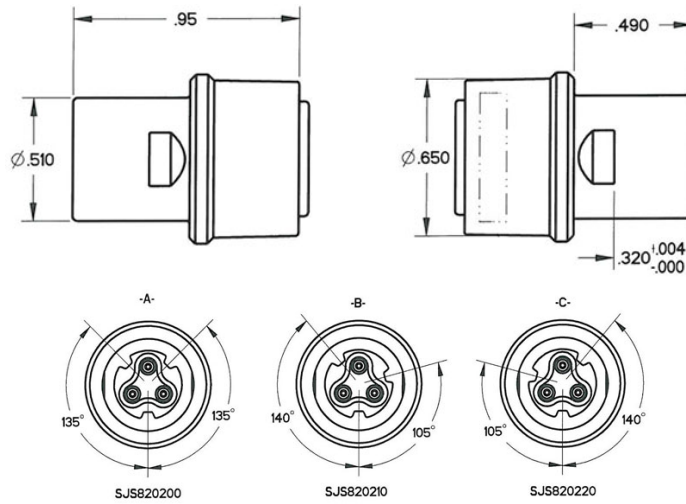
PUSH PULL - INLINE RECEPTACLE

Shell Size 7



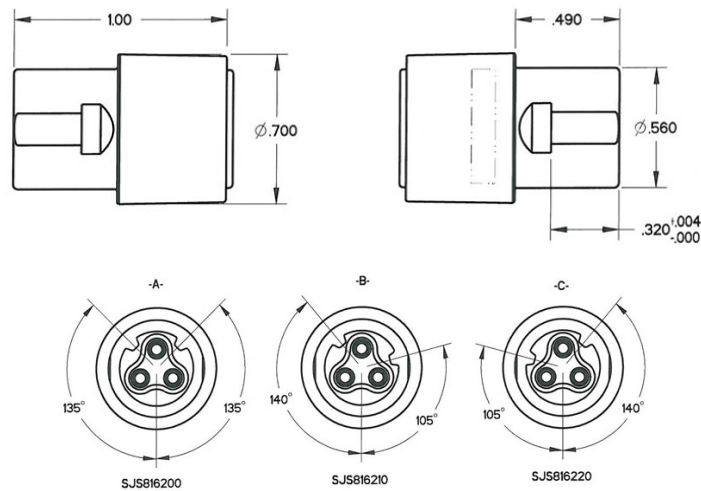
PUSH PULL - INLINE RECEPTACLE

Shell Size 8



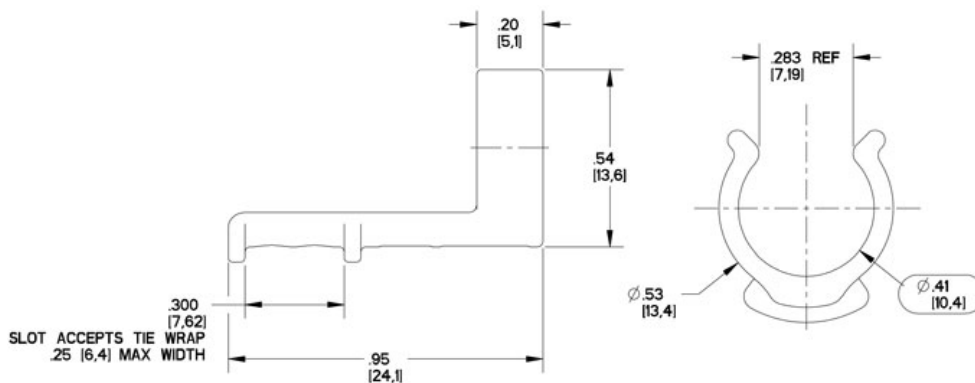
PUSH PULL - INLINE RECEPTACLE

Shell Size 11



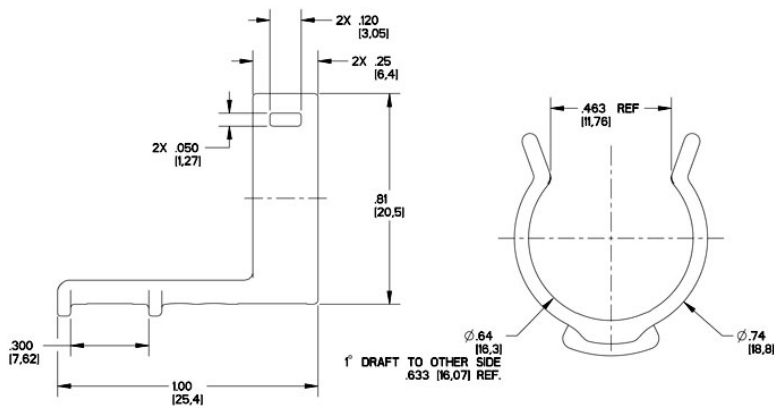
STRAIN RELIEF

Shell Size 7



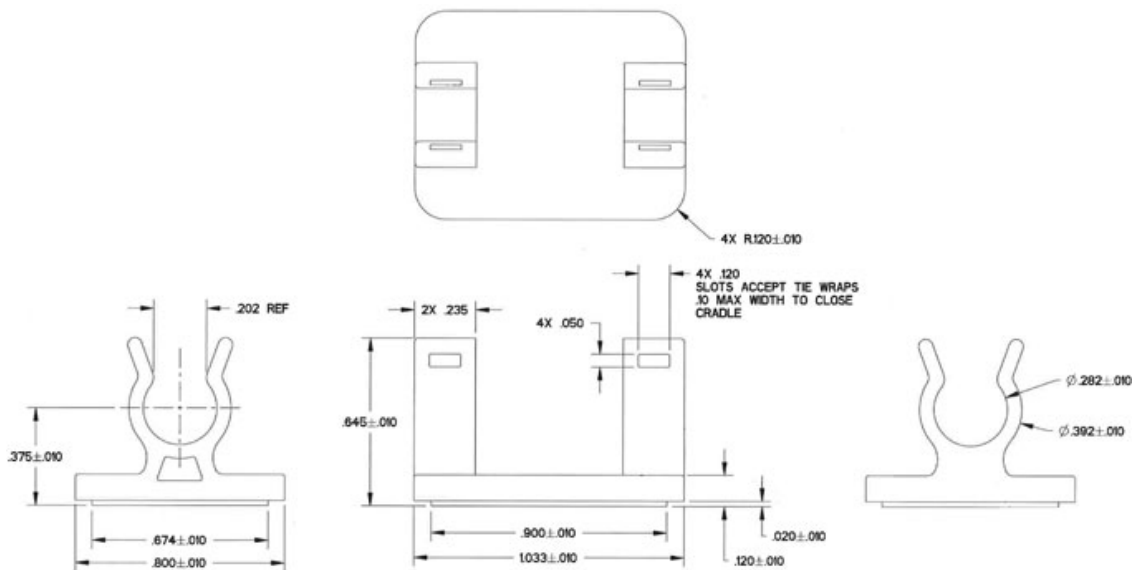
STRAIN RELIEF

Shell Size 8



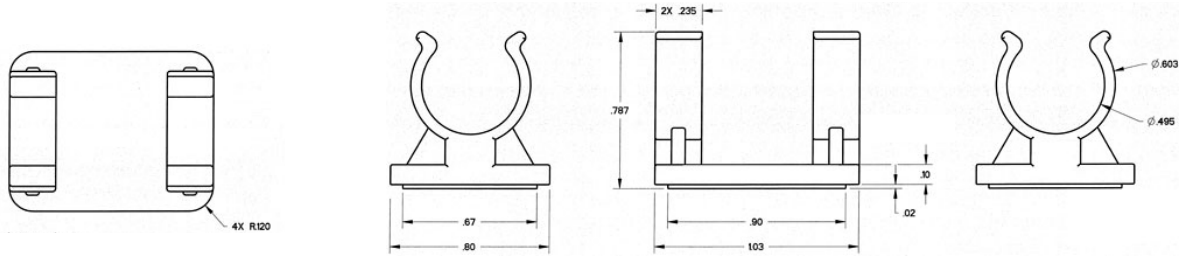
CRADLE - SELF ADHESIVE

Shell Size 5



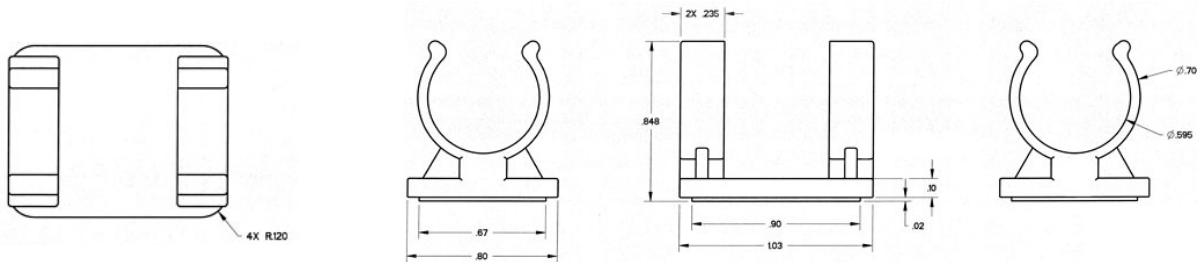
CRADLE - SELF ADHESIVE

Shell Size 8



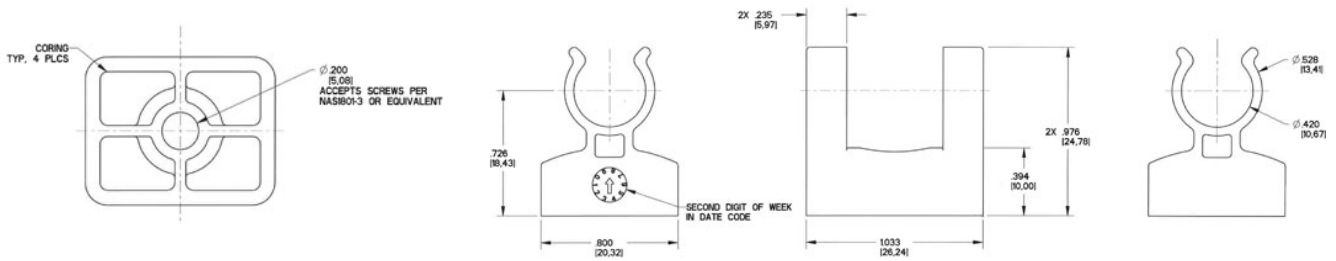
CRADLE - SELF ADHESIVE

Shell Size 10



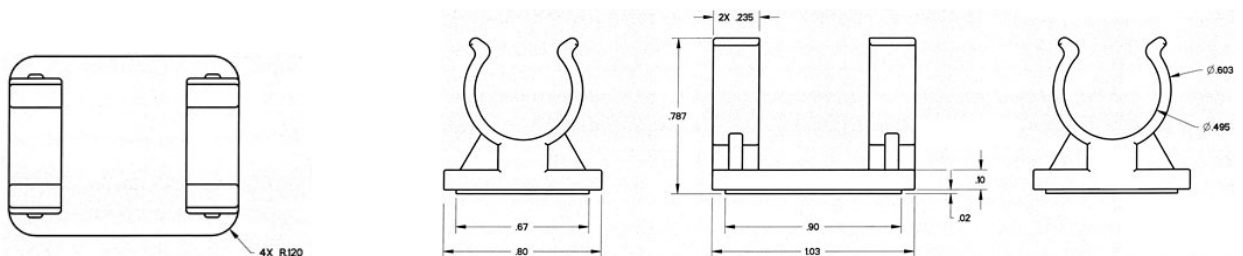
CRADLE - SCREW MOUNT

Shell Size 7






CRADLE - SCREW MOUNT

Shell Size 8



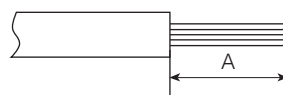
ACCESSORIES

SHELL SIZE	PART NUMBER	SERIES	COLOR	LENGTH (IN)	HEIGHT (IN)	WEIGHT (G)
5	SJS257000	Self-Adhesive Cradle 	Black	1.033	0.645	2.5
8	SJS445000		White	1.031	0.701	2.7
7	SJS883000		Black	1.031	0.701	2.7
10	SJS991000		White	1.031	0.846	2.8
8	SJS450100	Screw Mount Cradle 	Black	1.033	0.982	3.3
7	SJS450250		Black	1.033	0.976	3.9
7	SJS450300	Strain Relief 	Black	0.95	0.539	0.6
SJS8201xx & SJS8202xx	SJS450400		Black	1	0.685	0.8

ASSEMBLY INSTRUCTIONS

WIRE STRIPPING

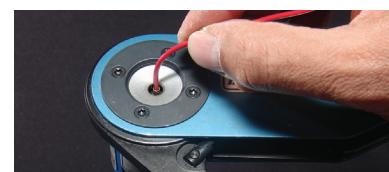
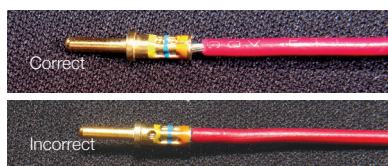
Strip insulation from end of wire to be crimped. (See table for proper stripping dimensions.) Do not cut or damage wire strands.



WIRE SIZE	A
22D	.125 (3.18)
20	.188 (4.77)
16	.188 (4.77)
12	.188 (4.77)

All dimensions in inches
(millimeters in parenthesis)

CONTACT CRIMPING

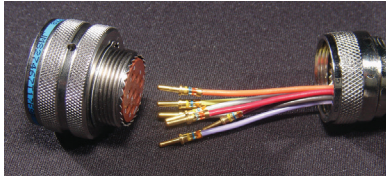


STEP 1: Insert wire into rear of contact. Wire insulation must press against rear of contact. Wire must be visible through inspection hole.

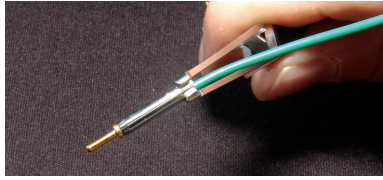
STEP 2: M22520 series crimp tool and locator is recommended. See Contact and Tool Table [⇒ on pages 428-429](#). for choice of turret head and selection setting according to contact size, part number and wire gauge size.

STEP 3: Insert contact and wire into tool jaws. To crimp, squeeze handles together fully until ratchet releases and allows handles to expand; otherwise, contact cannot be extracted from tool jaws. Maintain slight insertion pressure on wire while crimping contact to wire.

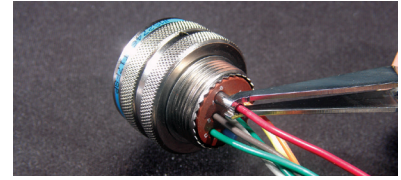
CONTACT INSERTION



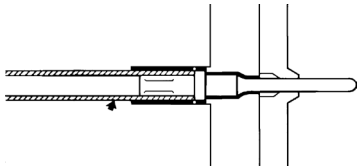
STEP 1: Remove hardware from plug or receptacle and slip over wire bundle in proper order for reassembly.



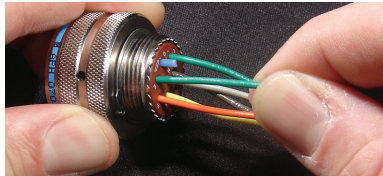
STEP 2: Using proper plastic or metal insertion tool for corresponding contact, position wire in tip of the tool so that the tool tip presses against the contact shoulder.



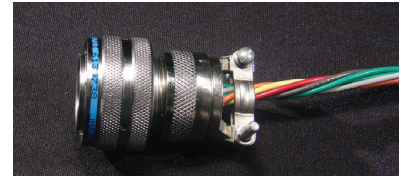
STEP 3: Press tool against contact shoulder and, with firm and even pressure, insert wired contact and tool tip into center contact cavity.



STEP 4: When contact bottoms, a slight "click" can be heard as tines of metal retaining clip snap into place behind contact shoulder.

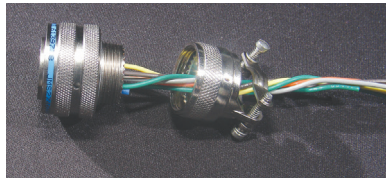


STEP 5: Remove tool and pull back lightly on wire to make sure contact is properly seated. Repeat operation with remainder of contacts to be inserted, beginning with the center cavity and working outward in alternating rows.

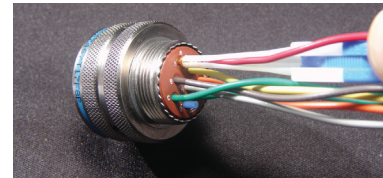


STEP 6: After all contacts are inserted, fill any empty cavities with wire sealing plugs. Reassemble plug or receptacle hardware.

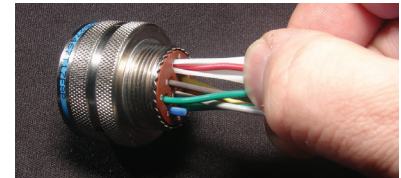
CONTACT EXTRACTION



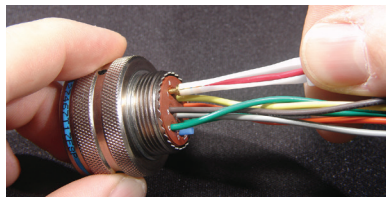
STEP 1: Remove hardware from plug or receptacle and slide hardware back along wire bundle.



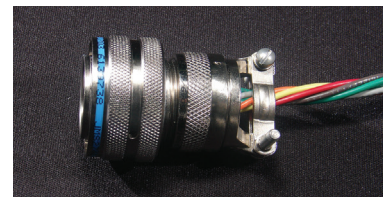
STEP 2: Using plastic or metal extraction tool with proper color code corresponding to contact size, place wire in tool.



STEP 3: Insert tool into contact cavity until tool tip bottoms against the contact shoulder, expanding clip retaining tines.



STEP 4: Hold wire firmly in tool and extract wired contact and tool. Repeat operation for all contacts to be extracted.



STEP 5: Fill any empty cavities with wire sealing plugs. Reassemble plug or receptacle hardware.

NOTE: LJT Series shown
All dimensions in inches (millimeters in parenthesis)