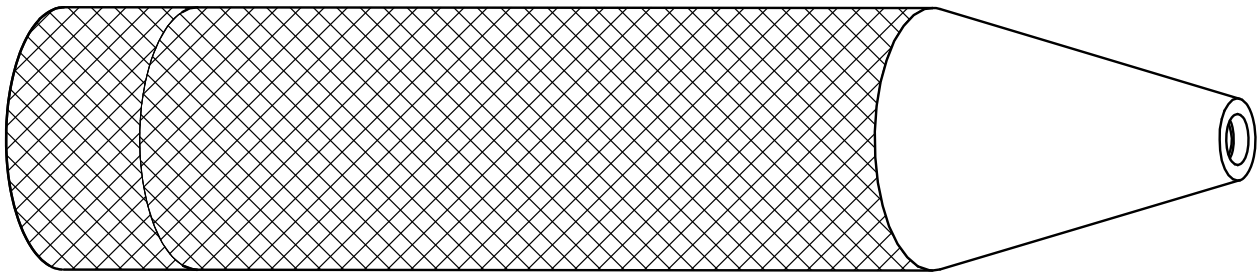
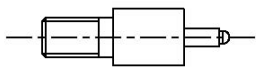


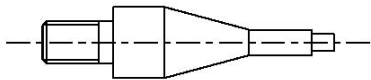
DATAMATE ASSEMBLY TOOL Z80-280



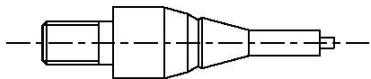
Insertion/Extraction Tool Holder



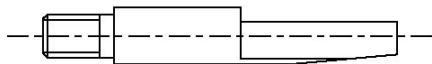
Extraction Tool (Female contacts L-Tek and J-Tek)



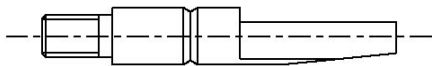
Extraction Tool (Male contacts L-Tek only)



Extraction Tool (Male contacts J-Tek only)



Insertion Tool (for insulation up to $\varnothing 0.9\text{mm}$)



Insertion Tool (for insulation from $\varnothing 0.9\text{mm}$ to $\varnothing 1.1\text{mm}$)

INSERTION PROCEDURE

1. Strip the wire and crimp the socket onto the wire, ensuring that the correct part is used (see Instruction Sheet IS-01, Hand Crimp Tool M22520/01).
2. Ensure all parts (moulding and crimp sockets) are clean and ready for final assembly.
3. Select the appropriate insertion tool for the wire size in use and attach to the handle. The different tools can be found by unscrewing the cap at the end of the handle (see above for tool identification).
4. Place the crimped contact partially into the moulding. The correct position is reached when approximately 1.5-2mm of socket protrudes (see Figures 2 and 3).
5. Place the insertion tool over the wire, with the wire sitting in the groove and the tool resting on the back of the crimped socket (see Figure 1).
6. To complete the assembly, push firmly on the rear of the contact while ensuring the tool remains perpendicular to the mould face. There will be an audible click when the socket is correctly seated within the moulding.

Harwin North America

T: +1 603 893 5376 F: +1 603 893 5396
E: misboston@harwin.com W: www.harwin.com

Harwin Europe

T: +44 (0) 23 9231 4545 F: +44 (0) 23 9231 4590
E: mis@harwin.co.uk W: www.harwin.com

Harwin Asia

T: +65 6 779 4909 F: +65 6 779 3868
E: mis@harwin.com.sg W: www.harwin.com.sg

7. Repeat steps 4 to 6 until the moulding is populated as required. Care should be taken not to damage any contacts. It is recommended that the moulding be supported by a small fixture or a hard flat surface. Do not support the mould on any latches fitted, or pressure exerted on inserting the contacts will bend the latches.

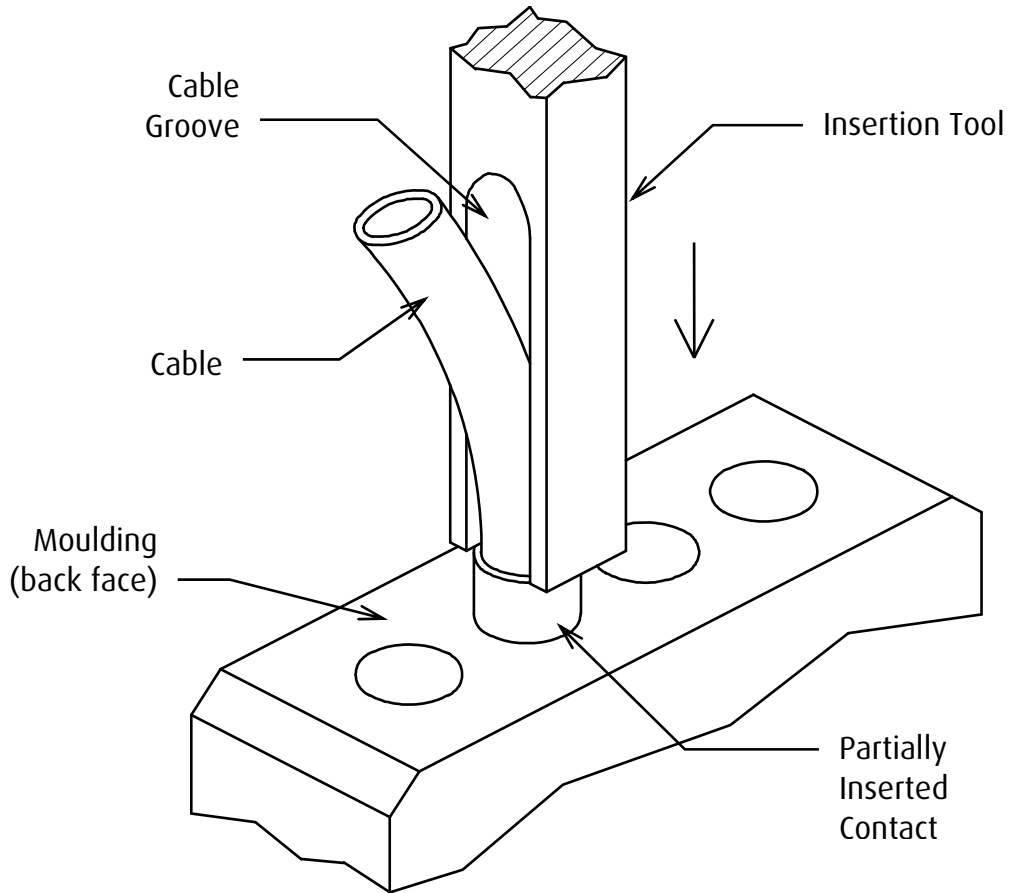


Figure 1

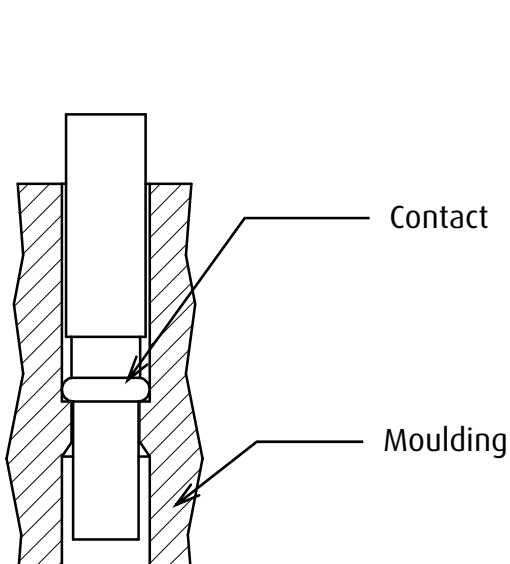


Figure 2
(Correct contact position prior to final 'click-in')

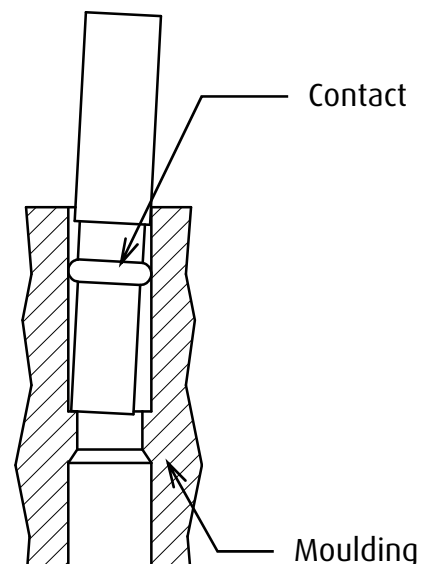


Figure 3
(Incorrect contact position prior to final 'click-in')

Note: Female contact shown

EXTRACTION PROCEDURE

To remove a contact from the moulding, select the appropriate Extraction Tool from the handle and attach as before. Place this tool over the mating end of the contact and push firmly. Care should be taken to keep the tool perpendicular to the mould face, or mould damage may occur.

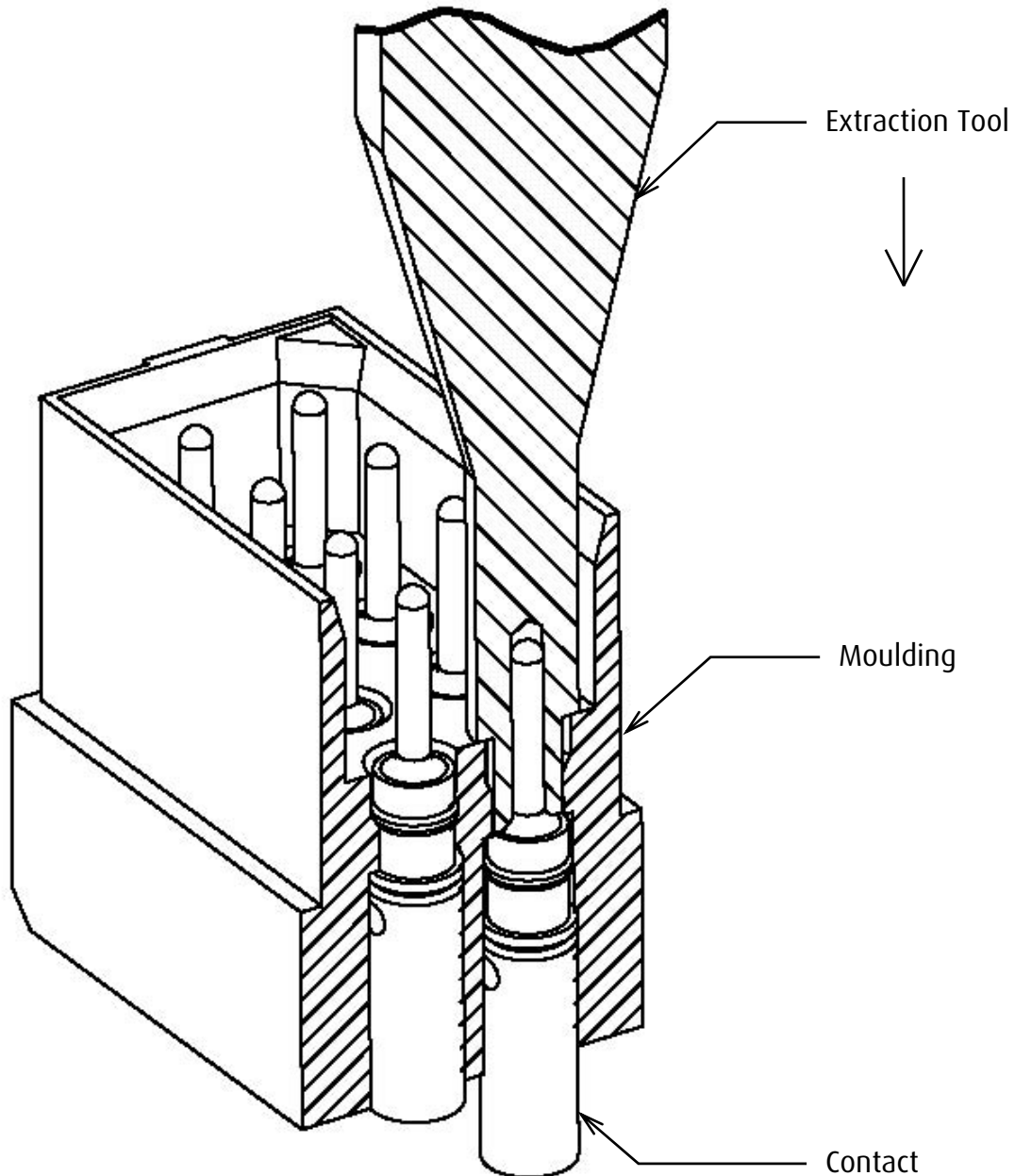


Figure 4

Note: Male contact shown