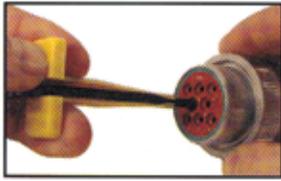
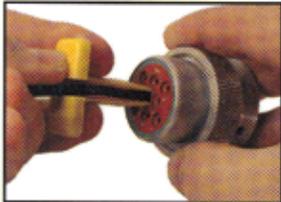




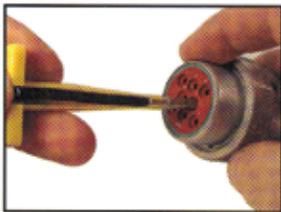
Step 1: Contact Removal



1. With rear insert toward you, snap appropriate size extractor tool over the wire of contact to be removed.



2. Slide tool along wire into the insert cavity until it engages contact and resistance is felt.



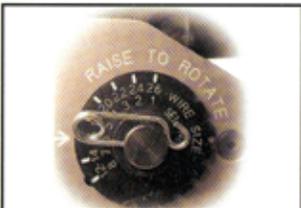
3. Pull contact/wire assembly out of connector.
NOTE: Do not twist tool or insert at an angle.

Step 2: Wire Stripping Solid Contacts

| Contact Part Number | Wire Gauge Range | Strip Length (inches) |
|---------------------|------------------|-----------------------|
| 0460-202-20141 | 20 AWG | .156 - .218 |
| 0462-201-20141 | 20 AWG | .156 - .218 |
| 0460-202-16141 | 16, 18 & 20 AWG | .250 - .312 |
| 0462-201-16141 | 16, 18 & 20 AWG | .250 - .312 |
| 0460-215-16141 | 14 AWG | .250 - .312 |
| 0462-209-16141 | 14 AWG | .250 - .312 |
| 0460-204-12141 | 12 & 14 AWG | .222 - .284 |
| 0462-203-12141 | 12 & 14 AWG | .222 - .284 |
| 0460-204-08141 | 8 & 10 AWG | .430 - .492 |
| 0462-203-08141 | 8 & 10 AWG | .430 - .492 |
| 0460-204-0490 | 6 AWG | .430 - .492 |
| 0462-203-04141 | 6 AWG | .430 - .492 |

Step 3: Contact Crimping

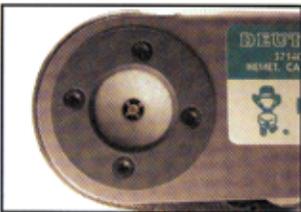
Use Crimp Tool #HDDT48-00



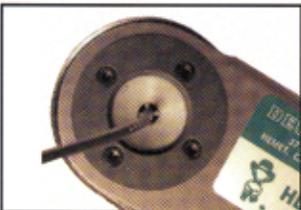
1. Strip insulation from wire. (See Step 2).

2. Raise selector knob and rotate until arrow is aligned with wire size to be crimped.

3. Loosen locknut, turn adjusting screw in until it stops.



4. Insert contact with barrel up. Turn adjusting screw counter-clockwise until contact is flush with indenter cover. Tighten locknut.



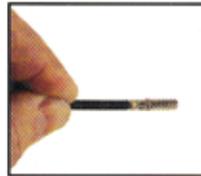
5. Insert wire into contact. Contact must be centered between indicators. Close handles until crimp cycle is completed.

6. Release handles and remove crimped contact.

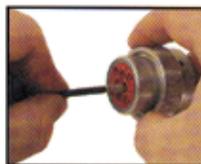


7. Inspect terminal to ensure that all strands are in crimp barrel. **NOTE:** Tool must be readjusted for each type/size of contact. Use HDT04-08 for size 8 and 4 contacts.

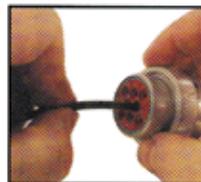
Step 4: Contact Insertion



1. Grasp contact approximately one inch behind the contact crimp barrel.



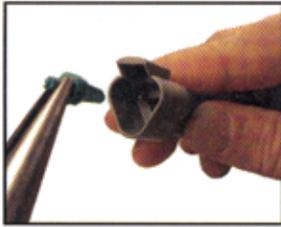
2. Hold connector with rear grommet facing you.



3. Push contact straight into connector grommet until a click is felt. A slight tug will confirm that contact is properly locked in place.
NOTE: For unused wire cavities, insert sealing plugs for full environmental sealing.



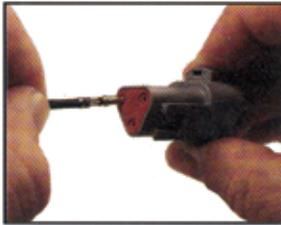
Step 1: Contact Removal



1. Remove wedge lock using needle-nose pliers or removal tool. Pull wedge lock straight out.



2. To remove the contacts, gently pull wire backwards, while at the same time releasing the locking finger by moving it away from the contact with a screwdriver.



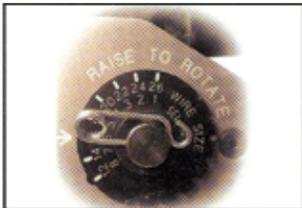
3. Hold the rear seal in place when pulling contact/wire out, as removing the contact may displace the seal.

Step 2: Wire Stripping Solid Contacts

| Contact Part Number | Wire Gauge Range | Strip Length (inches) |
|---------------------|------------------|-----------------------|
| 0460-202-20141 | 20 AWG | .156 - .218 |
| 0462-201-20141 | 20 AWG | .156 - .218 |
| 0460-202-16141 | 16, 18 & 20 AWG | .250 - .312 |
| 0462-201-16141 | 16, 18 & 20 AWG | .250 - .312 |
| 0460-215-16141 | 14 AWG | .250 - .312 |
| 0462-209-16141 | 14 AWG | .250 - .312 |
| 0460-204-12141 | 12 & 14 AWG | .222 - .284 |
| 0462-203-12141 | 12 & 14 AWG | .222 - .284 |
| 0460-204-08141 | 8 & 10 AWG | .430 - .492 |
| 0462-203-08141 | 8 & 10 AWG | .430 - .492 |
| 0460-204-0490 | 6 AWG | .430 - .492 |
| 0462-203-04141 | 6 AWG | .430 - .492 |

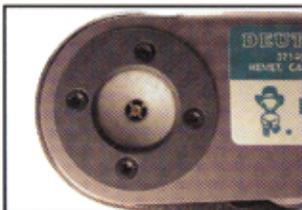
Step 3: Contact Crimping

Use Crimp Tool #HDDT48-00



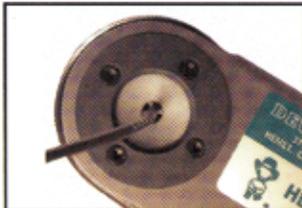
1. Strip insulation from wire. (See Step 2).

2. Raise selector knob and rotate until arrow is aligned with wire size to be crimped.



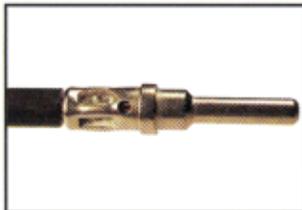
3. Loosen locknut, turn adjusting screw in until it stops.

4. Insert contact with barrel up. Turn adjusting screw counter-clockwise until contact is flush with indenter cover. Tighten locknut.



5. Insert wire into contact. Contact must be centered between indicators. Close handles until crimp cycle is completed.

6. Release handles and remove crimped contact.

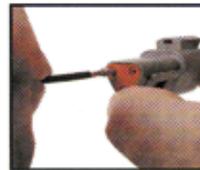


7. Inspect terminal to ensure that all strands are in crimp barrel. **NOTE:** Tool must be readjusted for each type/size of contact. Use HDT04-08 for size 8 and 4 contacts.

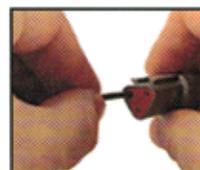
Step 4: Contact Insertion



1. Grasp crimped contact approximately one inch behind the contact barrel.



2. Hold connector with rear grommet facing you..



3. Push contact straight into connector grommet until a click is felt. A slight tug will confirm that contact is properly locked in place.



4. Once all contacts are in place, insert wedge lock. The wedge lock will snap into place. **NOTE:** The receptacle is shown. Use the same procedure for plug.