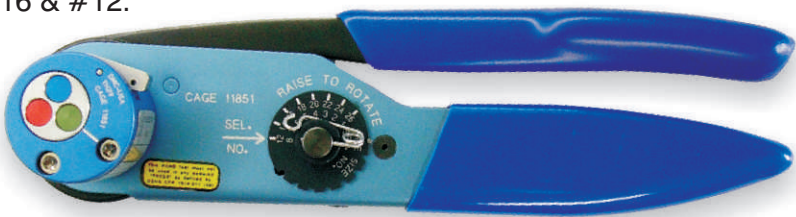


AEC CRIMP KIT



A30/C30 ASSEMBLY INSTRUCTIONS

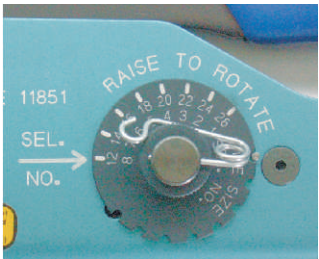

Allied's MS & MG Range of connectors are available with Crimp contacts in #16 & #12. Allied recommends the use of **M-22520/1-01 (Hand Crimp Tool)** with Contact Positioner (Locator) NO.: TH 29 as shown here.



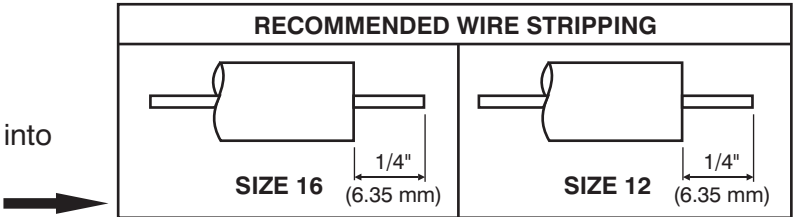
In addition appropriate Insertion Tool, Extraction Tool & Guide/Pilot Pins are required.

CRIMPING A30/C30 CONTACTS

1. Set the Crimp Tool with Positioner pressed in as shown below. Select position depending upon the type of contact used.

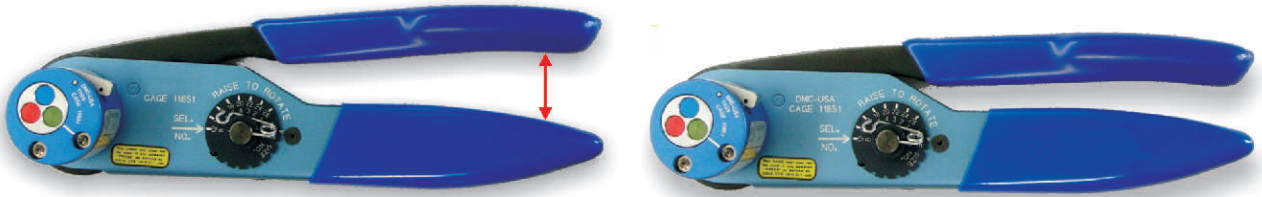
TYPE OF CONTACT	POSITIONER SELECTION	SET FOR
#12 PLUG & SOCKET	GREEN	
#16 SHORT PLUG & SOCKET	RED	
#16 LONG PLUG	BLUE	
#16 LONG SOCKET	GREEN	

2. Place the contacts, Mating end first into the tool.
3. Insert the stripped (see table) wire into the hollow end of the contact.

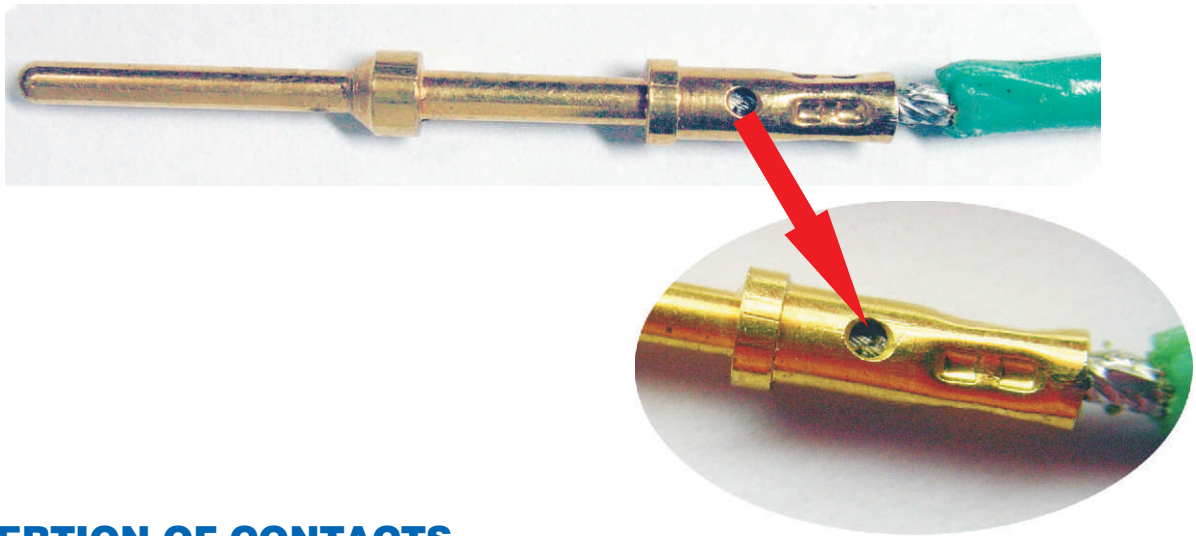


A30/C30 ASSEMBLY INSTRUCTIONS

4. Close the tool completely to crimp. (The tool will release/retract, only if closed completely).



5. Check the contact thru the inspection hole to ensure that the wire is fully inserted.

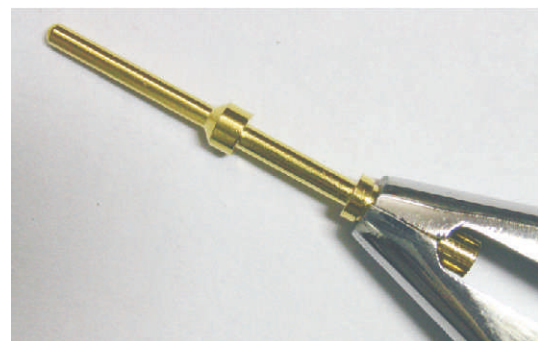


INSERTION OF CONTACTS

1. Before inserting the contacts, slide the coupling nut and the rear accessories over the wire bundle in proper sequence for re-assembly.
2. Hold the contact in the Insertion Tool & dip in Isopropyl Alcohol.
(Do not use any other type of lubricant)

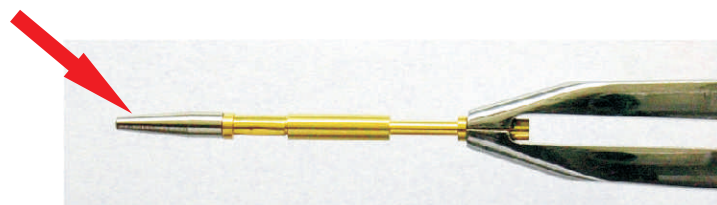


Wrong Grip



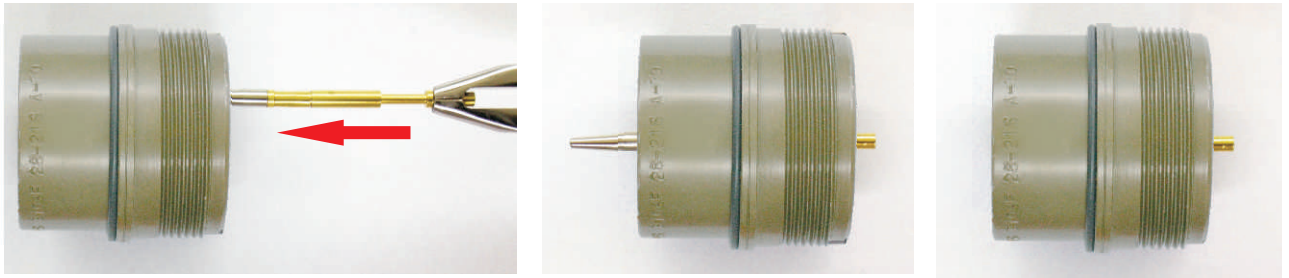
Correct Grip

3. For SOCKET Contacts always use Guide/Pilot pins.

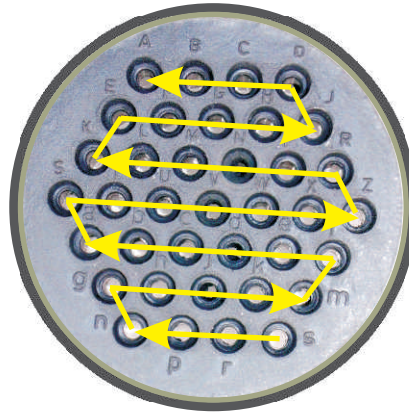


A30/C30 ASSEMBLY INSTRUCTIONS

4. Hold Connector body firmly and apply a slow, even pressure perpendicular to the insulator face until the contact snaps into position.



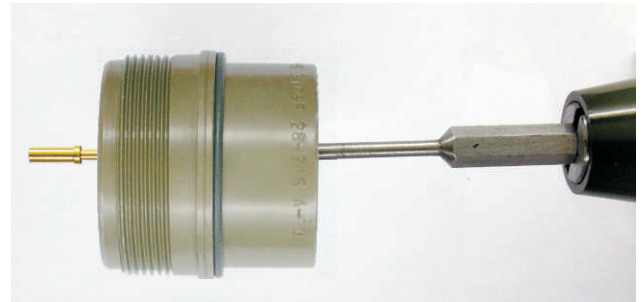
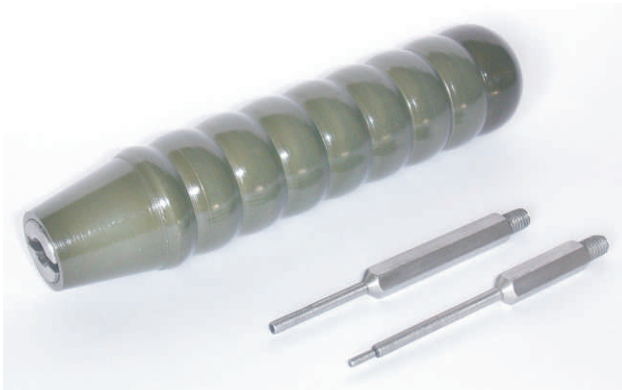
5. Check from the mating end to ensure that the contacts are inserted to its proper depth.
6. Continue the same by working progressively from contact-to-contact across the layout.



7. After all the contacts have been inserted, slide the coupling nut, ferrule, grommet, end-bell and any other accessory back into position.

EXTRACTION OF CONTACTS

1. To remove the contacts, use the Extraction Tool, which contains tool tips for Plug & Socket contacts.
2. Apply a slow even pressure to push the contacts out of the rear of the insulator.



CRIMP CONTACT PART NOS (A30 - SILVER PLATED, C30 - GOLD PLATED)		
CONTACT TYPE	PART NUMBER	SHELL SIZE
PLUG CONTACT	AEC 16 SPC A30/C30	10SL - 16S
	AEC 16 LPC A30/C30	16 - 44
	AEC 12 LPC A30/C30	16 - 44
	AEC 8 PLG A30/C30	16 - 44
	AEC 4 PLG A30/C30	16 - 44
	AEC 0 PLG A30/C30	16 - 44
SOCKET CONTACT	AEC 16 SSC A30/C30	10SL-16S EXCEPT 10SL-3S
	AEC 16 SSC (RD) A30/C30	10SL-3S ONLY
	AEC 16 LSC A30/C30	16 - 44
	AEC 12 LSC A30/C30	16 - 44
	AEC 8 SKT A30/C30	16 - 44
	AEC 4 SKT A30/C30	16 - 44
	AEC 0 SKT A30/C30	16 - 44
PILOT/GUIDE PIN FOR SOCKET CONTACT	AEC 16 PLT PIN	FOR AEC 16 SSC A30/C30, AEC 16 LSC A30/C30, BUT NOT AEC 16 SSC (RD) A30/C30
	AEC 16 PLT PIN RD	ONLY FOR AEC 16 SSC (RD) A30/C30
	AEC 12 PLT PIN	AEC 12 LSC A30/C30
	AEC 8 PLT PIN	AEC 8 SKT A30/C30

CONTACT RETENTION IN INSERT	
CONTACT SIZE	TEST FORCE N
16S, 16	35
12	55
8	80
4	90
0	95

PART NUMBER INFORMATION FOR CRIMP TOOLS					
CONTACT SIZE	CRIMP TOOL	TURRET/ POSITIONER	EXTRACTION TOOL	INSERTION TOOL	REMARKS
16	M22520/1-01	TH-29	AEC 16 EXTR TOOL	AEC 16/12 INSERTION TOOL	PL REFER INSTRUCTIONS
12	M22520/1-01	TH-29	AEC 12 EXTR TOOL		
8	M 300-BT	TP-1352 FOR PLG, TP-1353 FOR SKT	AEC 8 EXTR TOOL	AEC 8 INSERTION TOOL	RANGE 4.6sqmm
4	M22520/23-01	M22520/23-04 AMT23163L	AEC 4 EXTR TOOL*	AEC 4 INSERTION TOOL*	*ON ARBOUR PRESS
0	M22520/23-01	M22520/23-05	AEC 0 EXTR TOOL*	AEC 0 INSERTION TOOL*	