



## Assembly Instructions: Contact Insertion and Extraction for AT Series™

The following Assembly Instructions refer to the steps needed for proper contact insertion/extraction when using our AT Series™ plugs and receptacles.

### Required Tooling

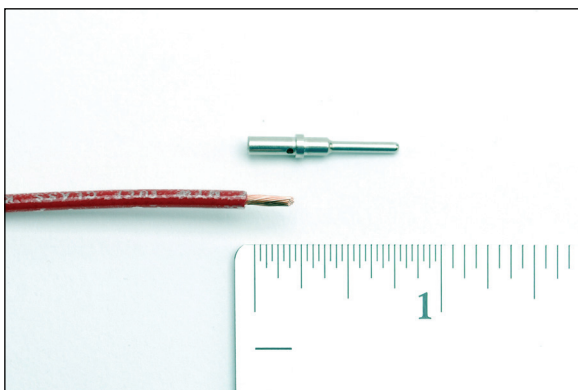
| Part Number | Description                           |
|-------------|---------------------------------------|
| ATRT-100    | Contact and Wedgelock Extraction Tool |



## Wire Prep and Contact Crimping

### Step 1

Strip 1/4" insulation from wire.



### Step 2

Insert contact into Contact Crimp Tool with barrel up.



### Step 3

Insert stripped end of wire into contact.



### Step 4

Squeeze handles of Contact Crimp Tool until proper seating has taken place.



#### Step 5

Release handles and remove the crimped contact from the Contact Crimp Tool.



#### Step 6

Inspect the contact to ensure all wire strands have been crimped properly.



### Contact and Wedgelock Insertion - Plug

#### Step 1

Grasp crimped contact approx. one inch behind the contact barrel.



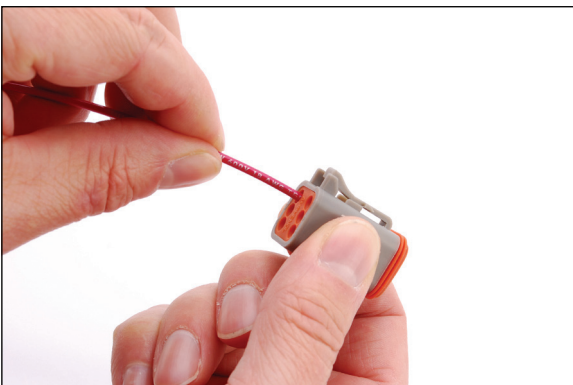
#### Step 2

Hold plug with rear grommet facing you.



#### Step 3

Push contact straight into plug until a 'click' is felt. A slight tug will confirm placement.



#### Step 4

Insert wedge into plug.



#### Step 5

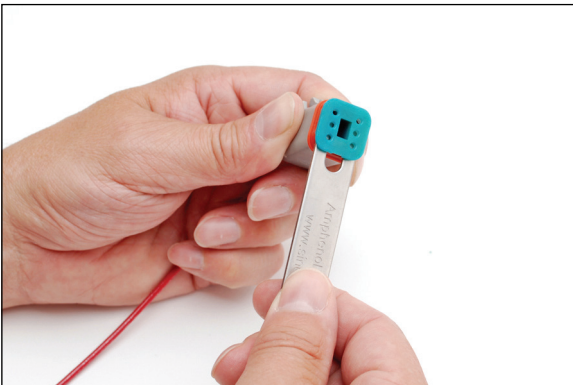
A 'click' will be felt when the wedge is fully installed.



### Contact and Wedgelock Extraction - Plug

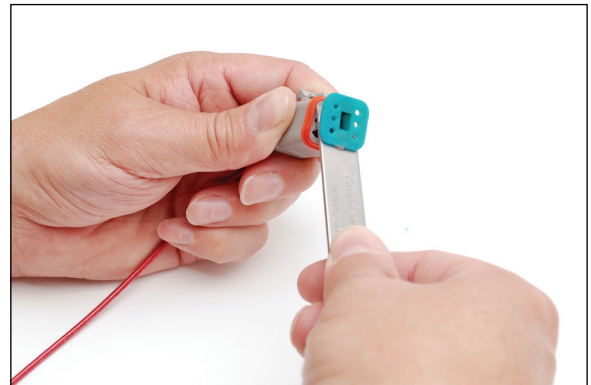
#### Step 1

Remove wedge by inserting the Wedge Extraction Tool underneath the lip of the wedge.



#### Step 2

Twist the Wedge Extraction Tool until wedge 'pops' out of plug.



#### Step 3

Turn the Wedge Extraction Tool around to use the Contact Extraction Tool to remove the contact inside the plug.



## Contact and Wedgelock Insertion - Receptacle

### Step 1

Grasp crimped contact approx. one inch behind the contact barrel.



### Step 2

Hold receptacle with rear grommet facing you.



### Step 3

Push contact straight into receptacle until a 'click' is felt. A slight tug will confirm placement.



### Step 4

Insert wedge into receptacle.



### Step 5

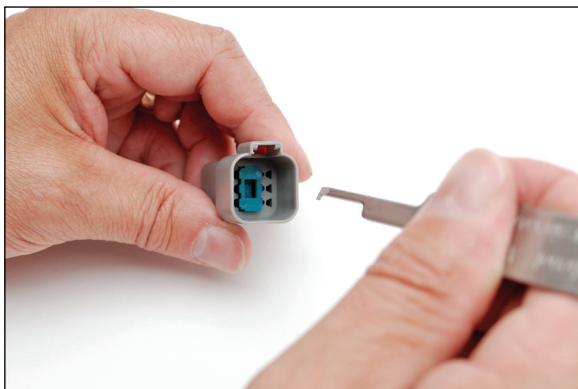
A 'click' will be felt when the wedge is fully installed.



## Contact and Wedgelock Extraction - Receptacle

### Step 1

Remove wedge by inserting the Wedge Extraction Tool into the opening of the wedge.



### Step 2

Pull the wedge until it 'pops' out of receptacle. Remove the wedge from receptacle.



### Step 3

Turn the Wedge Extraction Tool around to use the Contact Extraction Tool to remove the contact inside the receptacle.



**For more information, contact:** Customer Service, +1 800 394 7732, [csr@amphenol-sine.com](mailto:csr@amphenol-sine.com)