Low Mating Force
contact installation instructions, repair/replacement

Individual contacts in the B³ Low Mating Force Connector line can be removed and replaced, thereby avoiding replacement of the entire connector.

TOOLS REQUIRED:
MB, PC Series  11-10368 Tool*
  11-10372 Insertion Tool*
solder removal equipment
I/O Series  M22520/2-01 Crimp Tool
  Daniels Tool #K743 Positioner
  10-296943-22 Removal Tool
  10-296940-22 Insertion Tool

CONTACT REMOVAL - DB SERIES
Contact removal is accomplished from the front or mating side of this connector series without removing the entire connector from the printed circuit board. Determine which contact is to be removed from the connector and cut tail. Unsolder cut tail. Solder sucking may be necessary to clear the printed circuit board of solder and cut tail.

Pull the contact through the front side of the connector with tweezers. Care must be taken not to damage adjacent contacts. Discard the damaged contact.

CONTACT REPLACEMENT/INSERTION - DB SERIES
Using tweezers or fingers, carefully place the replacement contact TAIL FIRST into the appropriate contact cavity in the front of the connector. Before final seating of the contact make provisions for proper dressing of the contact, since the 90° tail of the DB connector must be routed through its nest in the connector body molding and, in turn, into the printed circuit board hole.

Push the contact into the cavity with a flat-edged rod of .060 to .100 inch diameter until contact seats. Do not push against bristle wires or bend shroud. It may be necessary to simultaneously bend the contact tail during this step. Dress and resolder contact tail in proper location.

CONTACT REMOVAL - MB, PC SERIES**
Contact removal is accomplished from the front or mating side of these connector series without removing the entire connector from the printed circuit board. Determine which contact is to be removed from the connector and unsolder or unwrap the contact tail as applicable. Tail cutting and/or solder sucking may be necessary to clear the printed circuit board.

Inspect the damaged contact to determine if the bristle wires are bent in a particular direction within the contact cavity. The slot in the tube end of the 11-10368 Extraction Tool is designed to accommodate these bent strands.

Retract the plunger of the 11-10368 Extraction Tool to its furthest point of travel, and line up the slot in the tube end with any bent bristle wires in the contact cavity. Insert the tool into contact cavity. A moderate amount of resistance will be encountered until the contact retention tines are deflected, and then a positive stop will be felt.

* Available from Amphenol Corporation, Amphenol Aerospace, Sidney NY 13838-1395. FSCM 77820
** Except for MB with compliant contacts; consult Amphenol, Sidney, NY for details.
Using the thumb, push the plunger portion of the Extraction Tool through the holder body into the damaged contact until a slight resistance is felt. DO NOT PUSH PLUNGER HARD ENOUGH TO CLOSE THE GAP BETWEEN IT AND THE HOLDER BODY. The contact is now ready to be removed.

While maintaining slight pressure on the plunger, withdraw tool and contact through the front of the connector body. Discard damaged contact.

CONTACT REPLACEMENT/INSERTION - MB, PC SERIES

Using tweezers or fingers, carefully place the replacement contact TAIL FIRST into the appropriate contact cavity in the front of the connector. Push contact tail into the cavity until the tail centers in the molded locating ribs. DO NOT push against the bristle wires.

Position the tube end of the 11-10372 Insertion Tool over the brush contact wires. Be careful not to bend any bristle strands. Before final seating of the contact it is necessary to make provisions for proper dressing of the contact tail back into the printed circuit board hole. In the case of a 90° tail situation, extra care must be taken to dress the contact as it is being seated.

Push contact into cavity using the Insertion Tool until a positive stop is felt. Remove tool. Contact is now ready for termination.

CONTACT REMOVAL - I/O SERIES

Contact removal is accomplished from the rear of this connector series. Determine which contact is to be removed and locate its corresponding wire in the wire bundle. Position wire in Removal Tool (white). Slide tool along wire and insert into rear of connector body. A moderate amount of resistance will be encountered until the contact retention tines are deflected, and then a positive stop will be felt. Then, holding the wire in tension with the thumb against the tool serrations, withdraw tool, wire and contact in one steady motion. Cut off and discard damaged contact.

CONTACT REPLACEMENT/INSERTION - I/O SERIES

Using accepted industry procedures, strip wire end to be terminated 1/8 to 5/32 inch. Care should be taken not to nick wire strands. Assemble the M22520/2-01 Crimp Tool and Daniels K743 Positioner and place Tool Selector in correct setting for wire size being used as follows:

<table>
<thead>
<tr>
<th>AWG</th>
<th>22</th>
<th>24</th>
<th>26</th>
<th>28</th>
</tr>
</thead>
<tbody>
<tr>
<td>SEL</td>
<td>5</td>
<td>4</td>
<td>3</td>
<td>2</td>
</tr>
</tbody>
</table>

Insert stripped wire end into contact wire well. Strands should be visible in wire well inspection hole. Bottom contact and wire assembly in Positioner and close handles of Crimp Tool to complete crimp. Handles will not open unless full crimping cycle has been completed. Position crimped wire and contact in Insertion tool (brown). Snug insertion tip around contact.

Insert contact and wire assembly into rear of connector. Push tool gently forward until contact is fully seated. Withdraw tool and remove from wire. A slight pull on the wire assures retention. Redress wire bundle.

*Except for MB with compliant contacts; consult Amphenol, Sidney, NY for details.