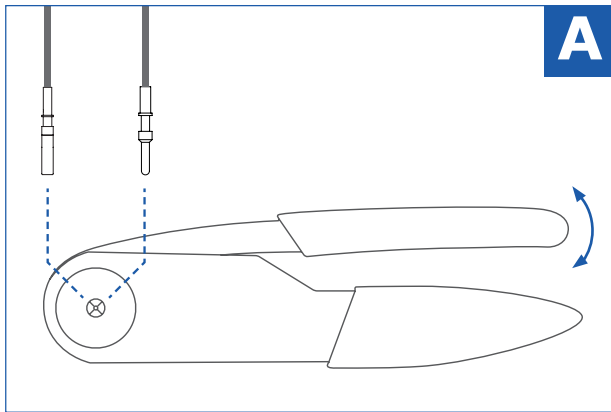
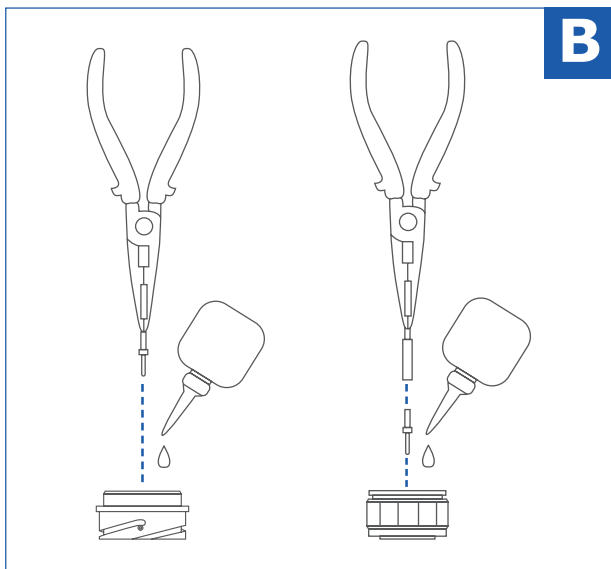


## TOOLS & CRIMPING INSTRUCTIONS

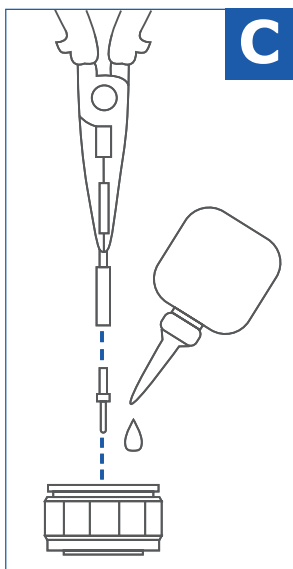
for 11 | 12 | 16 | 18 | 20 contact size



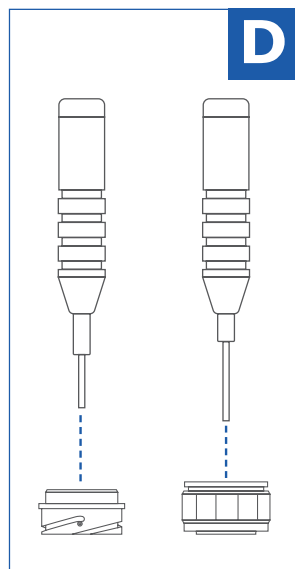
**A**



**B**



**C**



**D**

1. Strip the wire
2. Assemble the turret positioner on the crimp tool frame
3. Raise and rotate the wire gauge selection knob on the tool frame, to select the correct crimping dimension.
4. Place the contact (mating end first) into the crimp tool (see pic. A).
5. Insert the stripped wire into the hollow end of the contact. Close the crimp tool arms completely and release.
6. For ease of insertion it is beneficial to lubricate insert cavities with the recommended lubricant, like isopropyl alcohol. **DO NOT USE ALTERNATIVE GREASES OR OILS** which could damage the insert and slip out the pin.
7. Insert the wired contact from the rear of the connector as shown below, using the insertion tool (see pic. B).
8. When inserting socket contacts, it is recommended to use the guide pin (FEMALE CONTACTS ONLY see pic. C). Remove the guide pin from the inserted contact and use it for the next contact.
9. Apply a slow, even pressure until the contact snaps into position.
10. Only use the recommended removal tool (pic. D) to remove the contact or to adjust its position in the cavity. Use of other tools could damage the contact or insert.



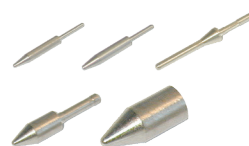
**Turret positioner**  
Part No. **SVKTOR**



**Manual crimping tool**  
Part No. **SVKTCRIMP**



**Insertion tool**  
Part No. **SVKTINS12**  
Part No. **SVKTINS16**  
Part No. **SVKTINS18/20**



**Guide pins  
for female contacts**  
Part No. **SVKT20GP**  
Part No. **SVKT18GP**  
Part No. **SVKT16GP**  
Part No. **SVKT12GP**



**Removal tool**  
Part No. **SVKTESTR11**  
Part No. **SVKTESTR12**  
Part No. **SVKTESTR16**  
Part No. **SVKTESTR18**  
Part No. **SVKTESTR20**