



25-Way D-Sub (Female) install instructions

502-002-02



KIT Contents
25-Way D-Sub receptacle M24308/2-3F
25 Machined size 20 DM female contacts M39029/63-368
DA Backshell with cable clamp
Backshell clamping screwlocks

The components that make up this assembly are designed in accordance with military specification MIL-C-24308 with machined contacts and all case and fixing components cadmium plated.

The shell houses a one-piece thermoplastic insert containing metal contact retention springs. The connectors are designed for rear insertion and extraction of **size 20** machine contacts.

WIRE SELECTION AND PREPARATION

Select the wire (Mil-spec M22759/16 is recommended) in the range **20 to 24 AWG**.

Strip the wire using a high quality (e.g. Stripmaster) wire stripper.

1. Determine the proper length of insulation to be removed.
 - a. For M39029/63-368 (368 Bin) machined female contacts, guide length is 0.14" / 3.56mm
 - b. Wire must be visible in inspection hole.
 - c. Insulation must be 1/64" – 1/32" from end of contact or inside of insulation cup.
2. Insert wire into exact center of correct slot for wire size to be stripped. Each slot is marked with wire size.
3. Close handles together as close as possible.
4. To prevent bird-caging the wire, partially open handles to allow grips to open, then remove wire before allowing handles to fully open.
5. Release handles, allowing wire holder to return to open position.
6. Remove stripped wire.
7. After stripping, strands of wire should be twisted firmly together in the same direction as the normal lay of the wire.
8. Stripped wire with nicked or cut strands is not acceptable.



CRIMPING PROCEDURES

The AFM8 Miniature Adjustable crimp tool M22520/2-01 is recommended.



The K13-1 (M22520/2-08) positioner is needed for crimping 368 BIN contacts.

368 BIN contacts are recognised by Orange-Blue-Gray color banding

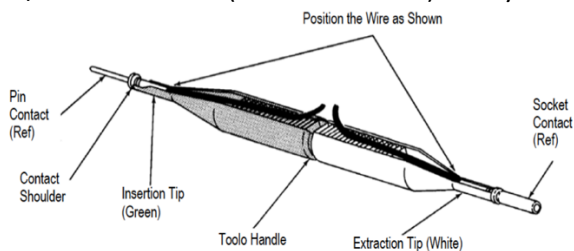


Crimping process

1. Insert the positioner
2. Dial in the crimp depth for the selected wire gauge as referenced on the positioner data plate.
 - a. Guide for 368 Bin contacts:

WIRE		TOOL SELECTOR SETTING
Size (AWG)	Strip Length	
24	3.56 [.140]	5
22		6
20		7

3. Insert the contact into the crimp tool
4. insert stripped end into the contact
5. close and open to crimp
6. Insert the terminal into the correct pin number of the housing using the insertion tip of the insert/ extraction tool (as shown below) until you hear a click.



7. Give the wire a tug to ensure that it is securely crimped and fully seated.