

## ■ Tool name / Model name

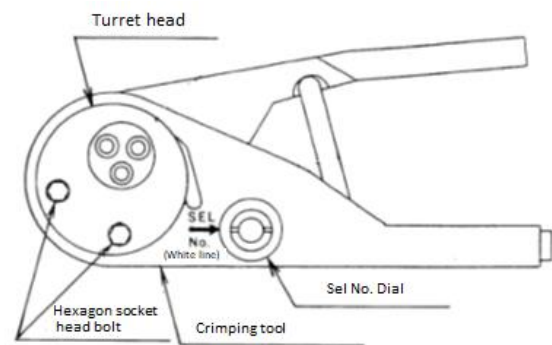
Tool name	Tool part name
Crimping tool	M22520/1-01
Turret head	TH20-DDV
Contact insertion tool	IT20-DDV
Contact extraction tool	RT20-DDV

Contact size	Contact type	Part number	Wire size
#20	Socket	SC20C-DDV	AWG#20 - 24
#20	Pin	PC20C-DDV	AWG#20 - 24

## ■ Tool handling instruction

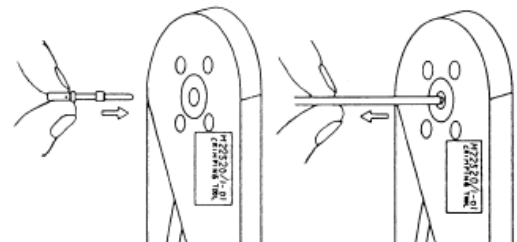
### 1. Setting Turret head

- ① Attaching the turret head to the crimping tool and tightening the hexagon socket head cap screw.
- ② Pulling up the SEL No. Dial, and putting it at the position of the white line according to the size of the crimping wire.



### 2. Crimping operation

- ① After tightening the handle as far as it will go, the handle will automatically go to an open status when it releases the handle
- ② Inserting the insulation stripped wire enough until you can see it through the confirmation hole in the wire well of the contact. (Insulation stripping length: about 6mm)
- ③ Inserting into the crimp hole of the contact crimping tool
- ④ Gradually squeezing the handle while gently pressing the electric wire so that it doesn't come out of the contact, and tighten until the ratchet comes off. Crimping is completed in this state.
- ⑤ However, please don't forcibly open the handle while the ratchet does not come off.



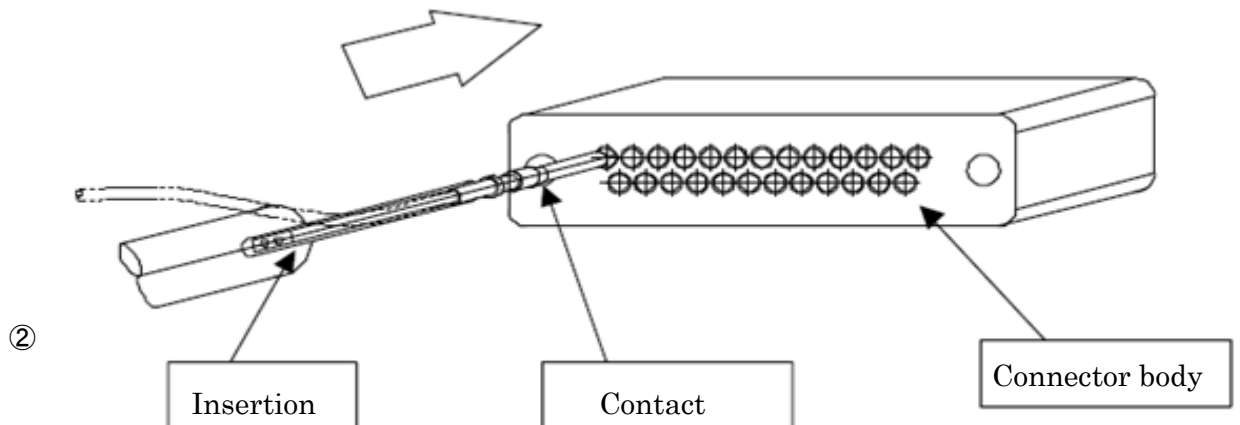
### 3. Insertion / extraction

#### ① Insertion operation

Placing the tip of the tool on the shoulder of the contact at the electric wire side, and inserting it in the direction of the arrow from the back of the connector.

Insertion is complete if the entire contact is inserted with retention from the ring.

※) Please be careful not to damage (bend, etc.) the tool when inserting it.



#### ② Extraction operation

If there is incorrect wiring or incorrect insertion, pull out the contact as described below.

Please use the specified extraction tool. Inserting the contact into the tip sleeve in the direction of the arrow from the front surface (mating surface) of the connector, and then extract the contact to the back side of the connector.

At that time, please be careful not to bend the contacts.

※) Please be also careful not to damage (bend, etc.) the tool when extracting it.

