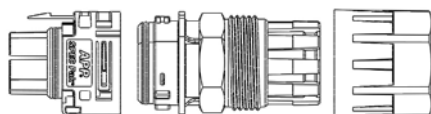


## 5 Position Mini PL SPEC Pak® Plug (female) Assembly Instructions



### Tools & supplies you will need:

- Wire stripper
- Wire lubricant
- Crimp tool(s)
- Insertion tool
- Extraction tool
- Wrench

### Step 1 Wire Protection

- Strip approximately 0.75 inches (19 mm) from the outer cable jacket, if applicable.
- Lubricate individual wires using IDEAL® Wire Pulling Lubricant that is compatible with nylon and polyester.
- Slide approximately 1.6" (40 mm) of wires through wire protection nut and then through the sealing grommet side of the sealing grommet assembly. ( See figure 1)

### Step 2 Prepare Wires

- Strip individual wires, taking care not to damage the copper conductor. (See Table 1)

Table 1 (See figure 2)

APP Contact Number	X Inches	X (mm)	Instruction Sheet
PM16S2024S32	Wire Insulation OD < crimp barrel ID x = 0.21" (5.5mm)	----	1S6420
PM16S1620S32			
PM16S1416S32	Wire Insulation OD > crimp barrel ID x = 0.28" (7.0mm)	----	
PM16S12S32			

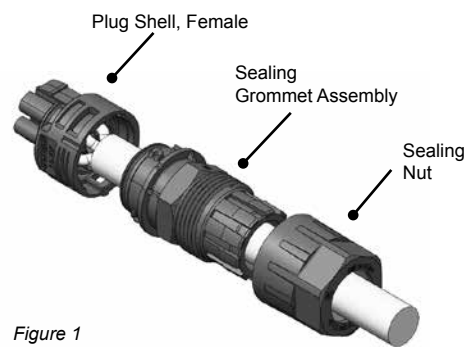


Figure 1



Figure 2

### Step 3 Crimp Contacts

- Crimp contacts per crimp tool instructions. (See Table 2)

**WARNING:** APP tooling is required for UL and CSA compliance. Use of unapproved tooling will void the connector warranty.

Table 2

APP Contact Part Number	Wire Size	Hand Tool Part Number	Instruction Sheet	Please inquire for additional tooling options:
PM16S2024S32	24 – 20 AWG 0.25 – 0.50 mm <sup>2</sup>	PM1000G1	1S6497	Pneumatic
PM16S1620S32	20 – 16 AWG 0.50 – 1.30 mm <sup>2</sup>			
PM16S1416S32	16 – 14 AWG 1.30 – 2.10 mm <sup>2</sup>			
PM16S12S32	12 AWG 3.30 mm <sup>2</sup>			

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**Step 4 Contact Insertion**

- a. Insert the contact from the rear side of the connector, using insertion tool (part number PM1002G1). (See figure 3)
  - i. **NOTE:** A tactile snap will be felt when contacts are properly inserted. Apply a slight tug on the wire(s) to confirm that the contact(s) are properly inserted. If using discrete wires, the wires will spin freely when properly inserted in the housing.
  - ii. **NOTE:** If necessary, contacts can be extracted by using extraction tool part number PM1003G1. (See figure 4)
    1. Slide tool over the contact until the tool bottoms on the housing.
    2. Push the button on the top of the tool with your thumb while gently pulling on the wires from the back of the connector.
    3. Contact will be released.
- b. Repeat Step 4a as necessary.

**Step 5 Final Assembly**

- a. Insert the sealing grommet assembly in the back of the connector and twist to lock. (see figure 5)
- b. Gently pull on the wires to remove excess slack in the wires.
- c. Hand tighten sealing nut.
- d. Wrench (24 mm wrench or strap wrench) tighten sealing nut 1/4 - 1/2 turn more.

**Step 6 Assembly is complete. (See figure 6)**



Figure 3



Figure 4



Figure 5



Figure 6