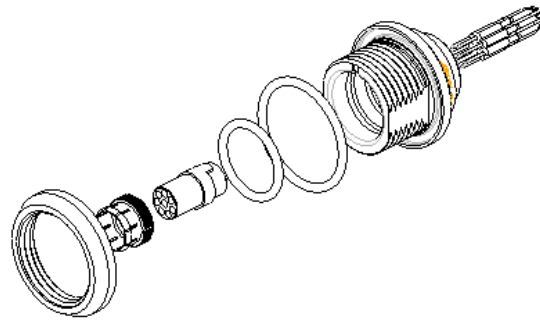


JKX RECEPTACLE ASSEMBLY INSTRUCTIONS



1. Select the proper JKX receptacle and contact size for the specific cable application by using the contact layout chart as depicted in the Push Pull catalog.
2. Strip the cable/wire to the required strip length.

Wiring and Assembly Instructions

• Cable stripping for connectors with crimp contacts

ØI - diameter over insulation

| Shell size | Ø Contacts | Ø I | Stripping for FD / PC | | |
|------------|------------|--------|-----------------------|-----|---|
| | | | L | C | T |
| 0 | 0.7 | ≤ 1.35 | 15 | 4 | 7 |
| | | > 1.35 | | 5.5 | |
| | 0.9 | ≤ 1.6 | 15 | 4 | 7 |
| | | > 1.6 | | 5.5 | |
| 1 | 0.7 | ≤ 1.35 | 17 | 4 | 8 |
| | | > 1.35 | | 5.5 | |
| | 0.9 | ≤ 1.6 | 17 | 4 | 8 |
| | | > 1.6 | | 5.5 | |
| | 1.3 | ≤ 2.1 | 17 | 4 | 8 |
| | | > 2.1 | | 5.5 | |

• Cable stripping for connectors with solder contacts

| Shell size | Ø Contacts | Stripping for FD / PC | | |
|------------|------------|-----------------------|-----|---|
| | | L | S | T |
| 0 | 0.5 | 11 | 2 | 7 |
| | 0.7 | 12 | 3 | 7 |
| | 0.9 | 12 | 3 | 7 |
| 1 | 0.5 | 13 | 2 | 8 |
| | 0.7 | 14 | 3 | 8 |
| | 0.9 | 14 | 3 | 8 |
| | 1.3 | 14 | 3.5 | 8 |

3. Depending on application and shell type, the nut and washer may be removed before attaching the wires to the contacts.
4. Attach crimped contacts to wires:
 - a. If using crimped contacts, crimp the contacts onto the ends of the exposed wires using the proper crimping tool and locator set on the correct AWG wire size. After the contact has been crimped to the wire, check each contact to insure that the contact is securely crimped.

Crimping Tool



Specifications MIL-C-22520 / 7.01

| | MIL P/N - SOURIAU P/N | Supplier P/N |
|-------------------------------------|-----------------------|---------------------------------------|
| Contacts 0.7 mm - 0.9 mm and 1.3 mm | MIL-22520/7-01 | Daniels : MH860 Buchanan : 616 336 |

Specifications MIL-C-22520 / 1.01

| | MIL P/N - SOURIAU P/N | Supplier P/N |
|--------------------------|-----------------------|-------------------------------------|
| Contacts 1.6 mm and 2 mm | MIL-22520/1-01 | Daniels : AF8 Buchanan : 615 708 |

Locator Pin and Socket .07-.09 mm and 1.3 mm contacts



| Shell size | Ø contacts | AWG | Male contact | | | Female contact | | |
|------------|------------|--------------|----------------|-------------|-----------|----------------|-------------|-----------|
| | | | SOURIAU P/N | DANIELS P/N | ASTRO P/N | SOURIAU P/N | DANIELS P/N | ASTRO P/N |
| 0 | 0.7 | 22 - 24 - 26 | JBX 0 OUT LP07 | 86 - 223 | / | JBX 0 OUT LS07 | 86 - 224 | / |
| | 0.9 | 20 - 22 - 24 | JBX 0 OUT LP09 | 86 - 225 | / | JBX 0 OUT LS09 | 86 - 226 | / |
| 1 | 0.7 | 22 - 24 - 26 | JBX 1 OUT LP07 | 86 - 196 | 642 - 001 | JBX 1 OUT LS07 | 86 - 197 | 642 - 004 |
| | 0.9 | 20 - 22 - 24 | JBX 1 OUT LP09 | 86 - 198 | 642 - 002 | JBX 1 OUT LS09 | 86 - 199 | 642 - 005 |
| | 1.3 | 18 - 20 - 22 | JBX 1 OUT LP13 | 86 - 200 | 642 - 003 | JBX 1 OUT LS13 | 86 - 201 | 642 - 006 |
| 2 | 0.7 | 22 - 24 - 26 | JBX 2 OUT LP07 | 86 - 202 | 642 - 007 | JBX 2 OUT LS07 | 86 - 203 | 642 - 010 |
| | 0.9 | 20 - 22 - 24 | JBX 2 OUT LP09 | 86 - 204 | 642 - 008 | JBX 2 OUT LS09 | 86 - 205 | 642 - 011 |
| | 1.3 | 18 - 20 - 22 | JBX 2 OUT LP13 | 86 - 206 | 642 - 009 | JBX 2 OUT LS13 | 86 - 207 | 642 - 012 |
| 3 | 0.7 | 22 - 24 - 26 | JBX 3 OUT LP07 | 86 - 217 | 642 - 014 | JBX 3 OUT LS07 | 86 - 214 | 642 - 017 |
| | 0.9 | 20 - 22 - 24 | JBX 3 OUT LP09 | 86 - 218 | 642 - 015 | JBX 3 OUT LS09 | 86 - 215 | 642 - 018 |
| | 1.3 | 18 - 20 - 22 | JBX 3 OUT LP13 | 86 - 219 | 642 - 016 | JBX 3 OUT LS13 | 86 - 216 | 642 - 019 |

Turret with locator for pin and socket 1.6 mm and 2 mm contacts



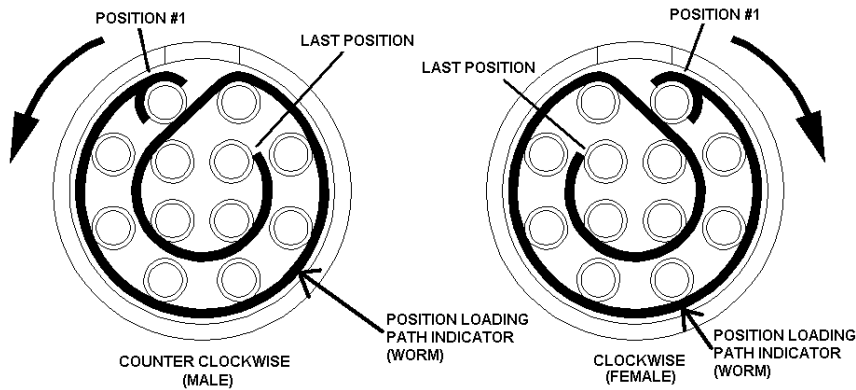
| Shell size | Ø contacts | AWG | Male and female contacts | | |
|------------|------------|--------------|--------------------------|-------------|-----------|
| | | | SOURIAU P/N | DANIELS P/N | ASTRO P/N |
| 2 | 1.6 | 14 - 16 - 18 | JBX 2 OUT LT16 | TH 564 | 650 - 030 |
| | 2 | 12 - 14 - 16 | JBX 2 OUT LT20 | TH 565 | 650 - 031 |
| 3 | 1.6 | 14 - 16 - 18 | JBX 3 OUT LT16 | TH 566 | 650 - 038 |
| | 2 | 12 - 14 - 16 | JBX 3 OUT LT20 | TH 567 | 650 - 035 |

- b. If using clipped solder contacts, prep each wire with flux and then tin dip each exposed wire end. Next pre-load a piece of heat shrink onto the wire (Individual heat shrink tubes are optional). Solder each wire to the solder cup end of the contact. To avoid shorts, make sure that no solder comes in contact with any other contact or wire on the connector. After the contact has been soldered to the wire, check each contact to insure that the contact is securely soldered to the wire. Slide the pre-loaded heat shrink over the solder joint and shrink into place. Do not over-heat the solder joint area as it can cause the solder to re-flow or it could burn the wire insulation.

5. If inserting terminated contacts:

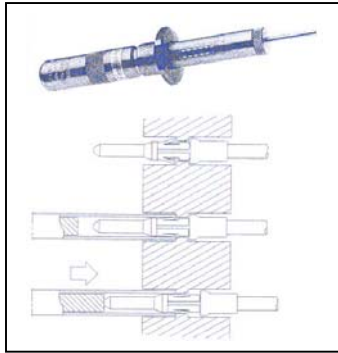
- a. Starting with the interface end of the contact, insert each contact into the backside of the insulator that has the position loading path indicator (worm) on it. Start with the end of the position loading path indicator (worm) that has the half circle on it (Position #1). Then follow the position loading path indicator (worm) around the insulator. You will go counter clockwise if using a male contact and clockwise if using a female contact (see diagram below for the position loading path indicator (worm) layout). If the connector has center contacts, it is sometimes easier to start at the end of the position loading path indicator (worm) (last position) and work backwards. This is up to the assembler and the process used to

insert the contacts. Make sure not to bend the contact when inserting it into the insulator. It is extremely important that the contact is seated in the insulator for the connector to function properly. The contact should click/snap into place when seated. Check each contact for proper seating.



6. Removal of contacts:

- a. Using the proper extraction tool (See FIGURE 6.A), insert the tool over the front of the contact and push contact out. Failure to use the proper extraction tool can result in damage to the contact.



| Shell size | Ø Contacts | SOURIAU Part number | ASTRO Part number |
|------------|------------|---------------------|-------------------|
| 0 | 0.7 | JBX OUT DC 07 | ATJP 2045 |
| | 0.9 | JBX OUT DC 09 | ATJP 2057 |
| 1 | 0.7 | JBX OUT DC 07 | ATJP2045 |
| | 0.9 | JBX OUT DC 09 | ATJP 2057 |
| | 1.3 | JBX OUT DC 13 | ATJP 2077 |
| 2 | 0.7 | JBX OUT DC 07 | ATJP 2045 |
| | 0.9 | JBX OUT DC 09 | ATJP 2057 |
| | 1.3 | JBX OUT DC 13 | ATJP 2077 |
| | 1.6 | JBX OUT DC 16 | ATJP 2095 |
| | 2.0 | JBX OUT DC 20 | ATJP 2115 |
| 3 | 0.7 | JBX OUT DC 07 | ATJP 2045 |
| | 0.9 | JBX OUT DC 09 | ATJP 2057 |
| | 1.3 | JBX OUT DC 13 | ATJP 2077 |
| | 1.6 | JBX OUT DC 16 | ATJP 2095 |
| | 2.0 | JBX OUT DC 20 | ATJP 2115 |

Trouble shooting

| Problem: | Cause: | Correction: |
|--|--|---|
| Contact will not seat in connector, contact backing out. | Wrong wire or insulation size, wrong strip length, poor crimping, broken clips, damaged insulator, removed contact without proper removal tool, bad crimp. | Use correct wire, adjust strip length, strip and re-crimp with new contact, replace insulator, using correct crimp tool, replace contact. |
| Bent solder contact | Bent in handling, bent in soldering operation, connector assembled incorrectly. | Replace insert with contacts. |
| Contact stubbing after mating. | Bent contact and damaged contact, connector-assembled incorrectly. | Re-align contact, replace insert with contacts. |
| Electrical failure. | Improper crimping, wrong wire strip length, wire loading incorrect location, poor solder joint. | Remove contact with correct removal tool, reinstall new contact, and verify strip length. |