

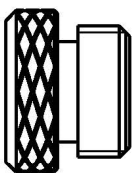
# HARWIN

## Instruction Sheet

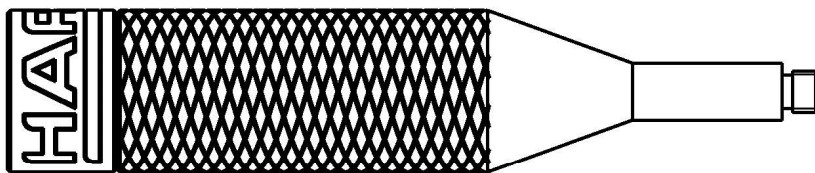
**IS-47**

Gecko-MT Assembly Tool Z125-905  
(Power Contacts)

### Insertion/Extraction Tool Holder



**Z300-920**  
Insertion tip  
(all contacts)



**Z125-924**  
Removal tip  
(Female contact)

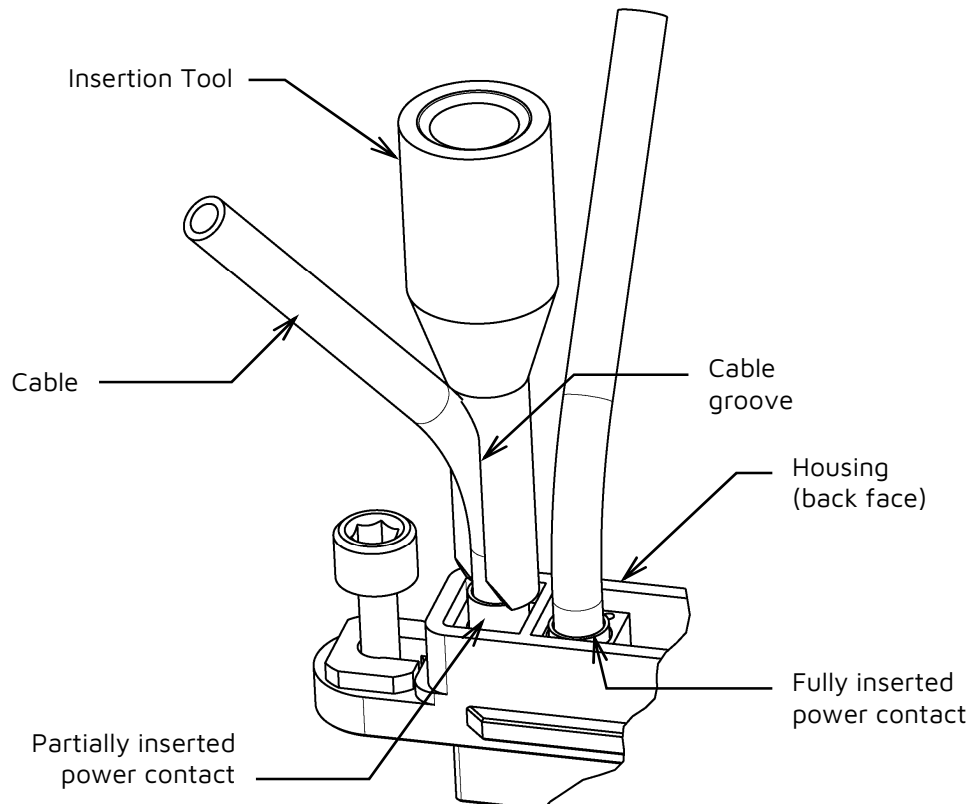


**Z300-923**  
Removal tip  
(Male contact)

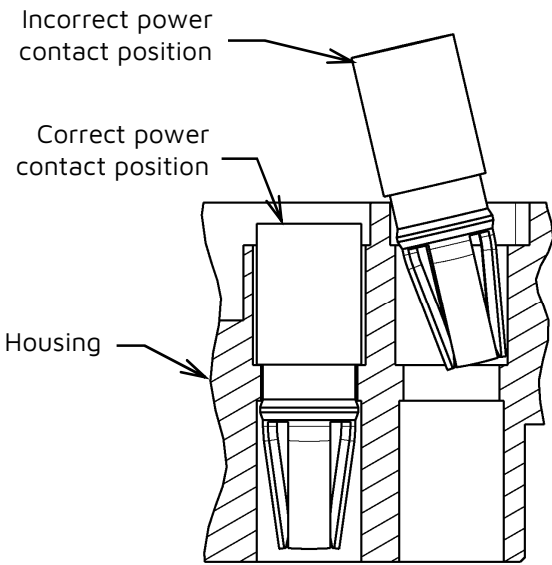
## **INSERTION PROCEDURE**

See Instruction Sheet IS-37 for crimping Gecko-MT signal contacts, and Instruction Sheet IS-38 for assembling Gecko-MT signal contacts to the housing. This Instruction Sheet is for inserting the Power contacts into a Gecko-MT housing.

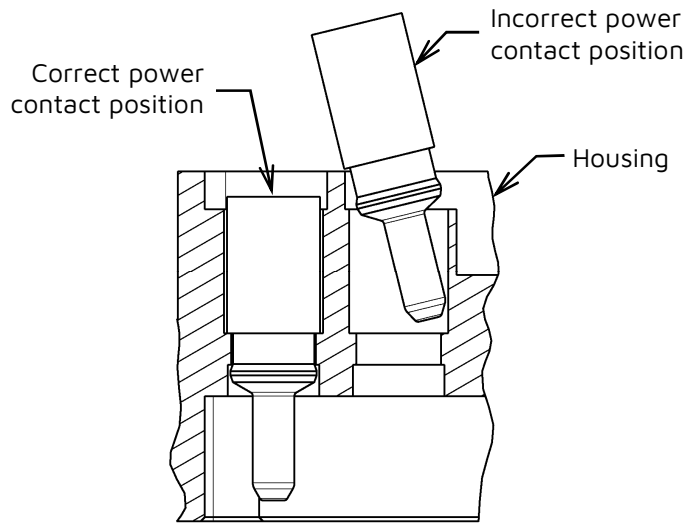
1. Strip the wire and crimp the contact on to the wire, ensuring that the correct part is used (see Instruction Sheet IS-44 for Hand Crimp Tool Z125-903).
2. Ensure all parts (housing and crimp sockets) are clean and ready for final assembly.
3. Select the insertion tip for the tool and attach to the handle. The different tools can be found by unscrewing the cap at the end of the handle (see above for tool identification).
4. Place the crimped contact partially into the housing. The correct position is reached when approximately 1.2-1.6mm of contact protrudes (see Figures 2 and 3).
5. Place the insertion tool over the wire, with the wire sitting in the groove and the tool resting on the back of the crimped socket (see Figure 1).
6. To complete the assembly, push firmly on the rear of the contact while ensuring the tool remains perpendicular to the housing face. There will be an audible click when the contact is correctly seated within the housing.
7. Repeat steps 4 to 6 until the housing is populated as required. Care should be taken not to damage any contacts. It is recommended that the housing be supported by a small fixture (like an unpopulated mating housing in a vice) or a hard, flat surface. Do not support the housing on any screw-loks fitted, or pressure exerted on inserting the contacts will not be evenly distributed.



**Figure 1**



**Figure 2**  
*Female power contact position prior to final 'click-in'*

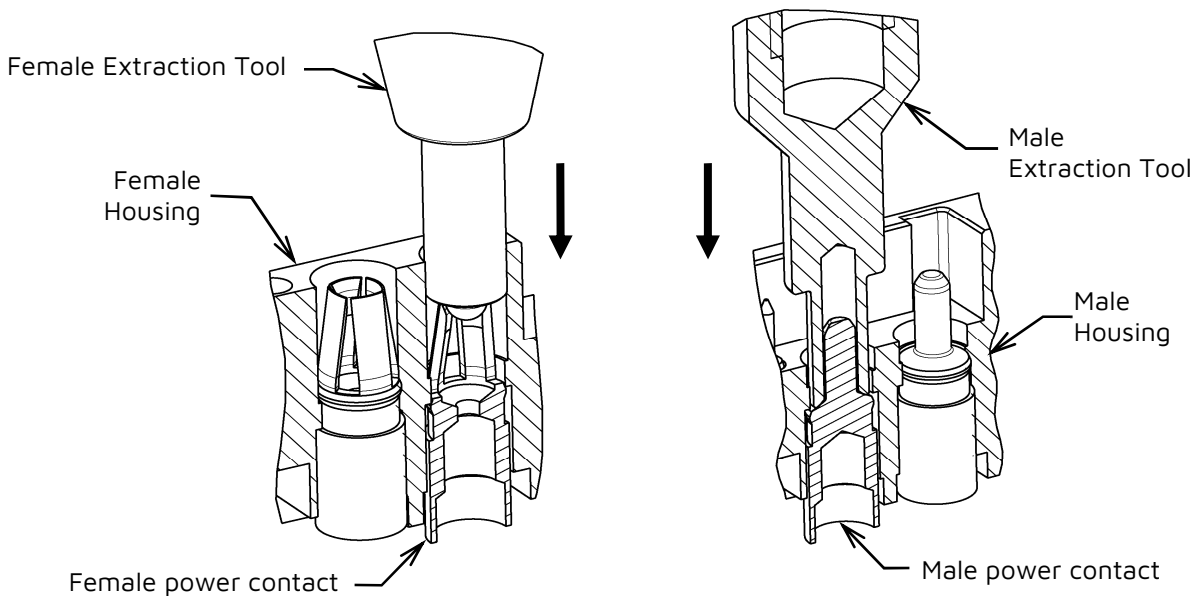


**Figure 3**  
*Male power contact position prior to final 'click-in'*

**EXTRACTION PROCEDURE**

To remove a contact from the housing, select the appropriate Extraction Tool from the handle and attach as before. Place this tool over the mating end of the contact and push firmly. Care should be taken to keep the tool perpendicular to the housing face, or housing damage may occur.

**Note:** Different tool tips are used for Female and Male power contacts.



**Figure 7**