

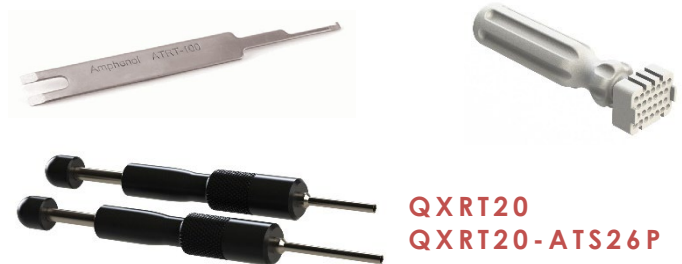
ATS ATSSeries™

Assembly and Disassembly Instructions for ATS Series™

The following instructions refer to the steps needed for proper contact insertion/extraction when using our ATS Series™ plugs and receptacles.

Required Tooling

Part Number	Description
ATRT-100	Contact and Wedgelock Extraction Tool
QXRT20	Extraction Tool for #20 Contact
QXRT20-ATS26P	Extraction Tool for #20 Contact - ATS
FT-ATS26P	Installation Fixture for ATS04-26P



ATS Series Plug: Contact Insertion

Step 1

Crimp socket contacts to wire. See appropriate datasheets for application tool.



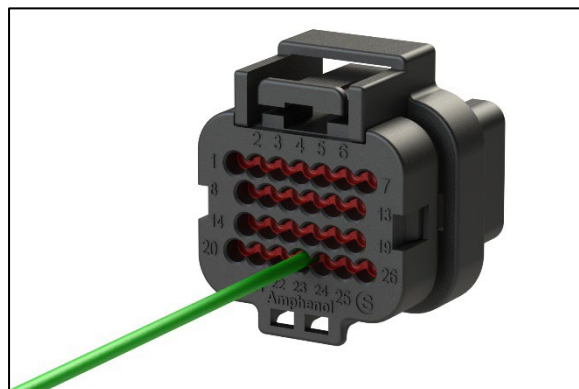
Step 2

Insert crimped contact through rear seal of plug.



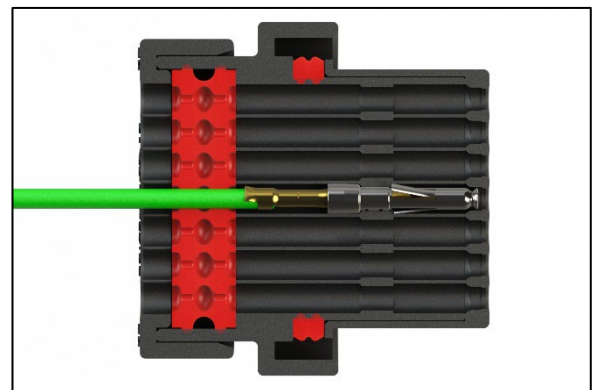
Step 3

Push contact straight into connector until a positive stop is felt. A slight tug will confirm that it is properly locked in position.



Step 4

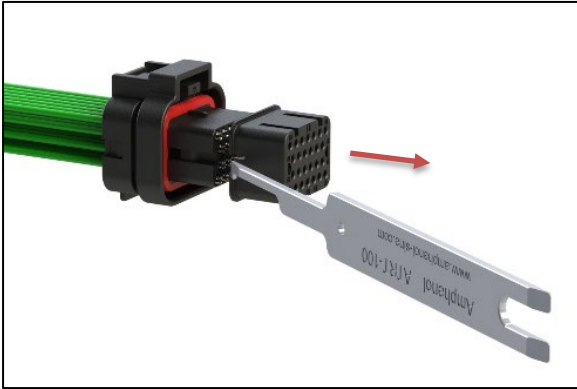
Section View showing final position of contact for reference.



ATS Series Plug: Contact Extraction

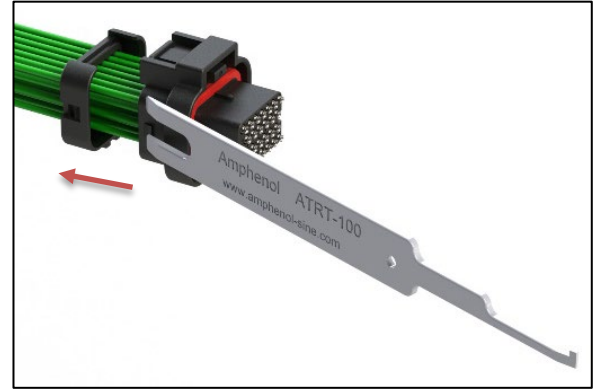
Step 1

Use the small end of the AT Extraction Tool to pry open the 2 side clasps and remove the Location Block.



Step 2

Use the large end of the AT Extraction Tool to pry open the 2 side clasps and retract the end cap.



Step 3

Insert the size 20 Extraction Tool into the plastic housing hole. Hold the tool and press the tail, pushing out the contact until it meets the seal. Push out all the contacts in order to reach the seal.



Step 4

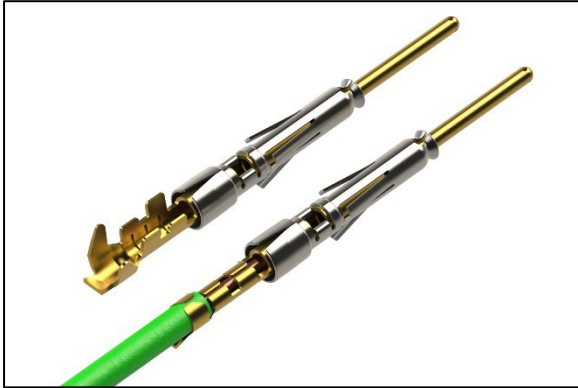
Wrap the contact with the tool and push the contact out of the wire seal.



ATS Series Inline Receptacle: Contact Insertion

Step 1

Crimp pin contacts to wire. See appropriate datasheets for application tool.



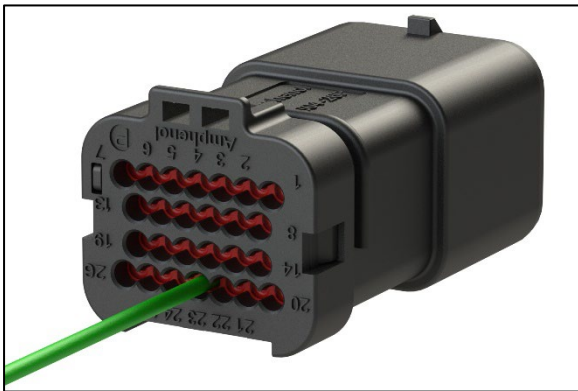
Step 2

Insert crimped contact through rear seal of plug.



Step 3

Push contact straight into connector until a positive stop is felt. A slight tug will confirm that it is properly locked in position.



Step 4

Section View showing final position of contact for reference.



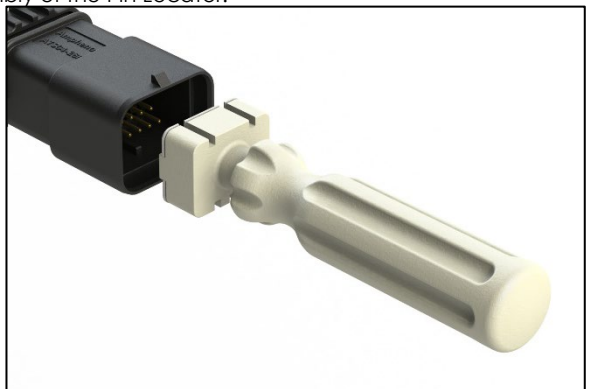
Step 5

If using the Installation Fixture, pre-install the Pin Locator on the fixture, paying close attention to the alignment keys.



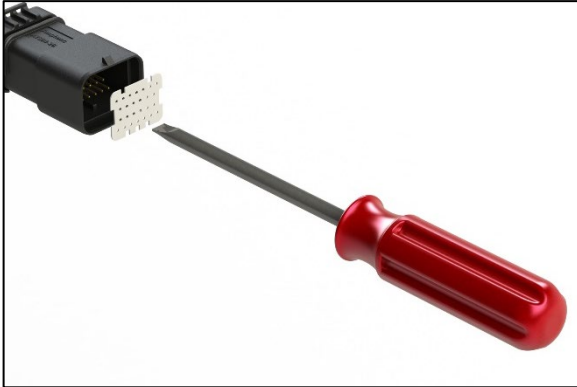
Step 6

Carefully push the fixture into the connector moving it back and forth if necessary to align the pins. Remove the fixture and check for proper assembly of the Pin Locator.



Alternate Step

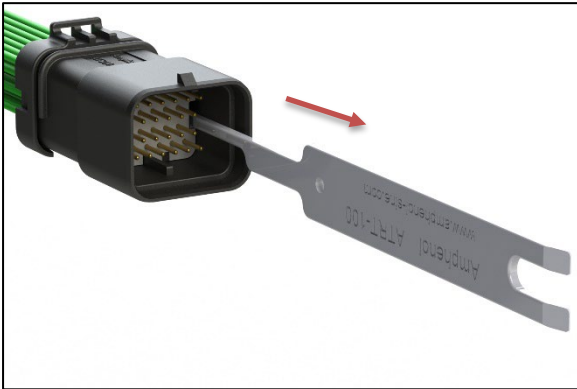
As an alternative to the Installation Fixture, you can use an ordinary screwdriver to push the Pin Locator into position, checking for proper assembly of the Pin Locator.



ATS Series Inline Receptacle: Contact Extraction

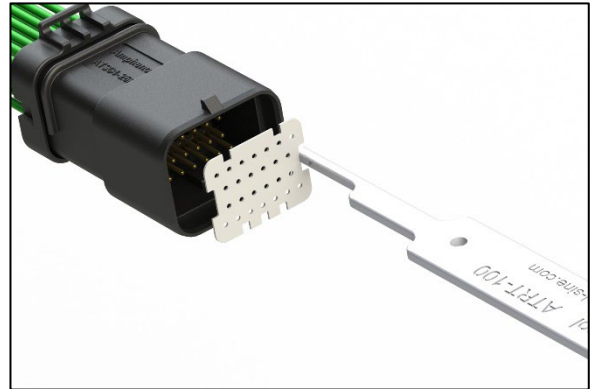
Step 1

Use the small end of the AT Extraction Tool to pull at both sides of the Pin Locator to pull it out.



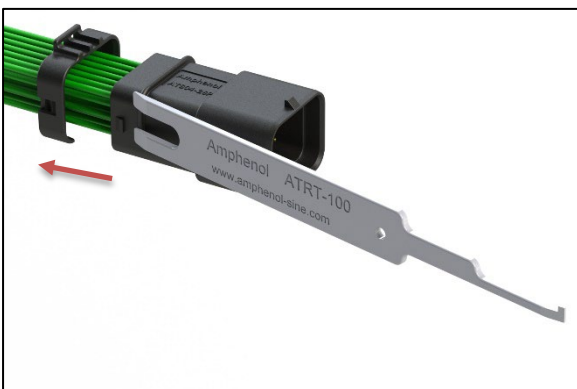
Step 2

Turn the tool sideways to hook the Locator if necessary.



Step 3

Use the large end of the AT Extraction Tool to pry open the 2 side clasps and retract the end cap.



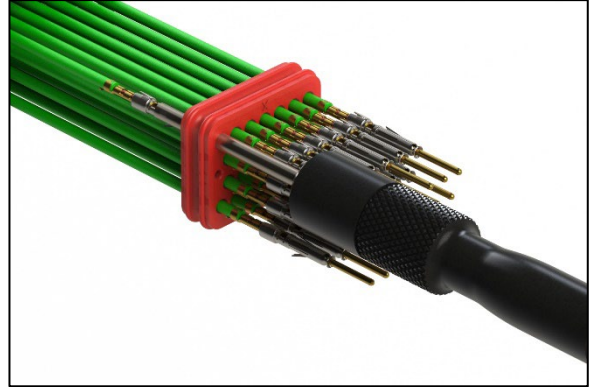
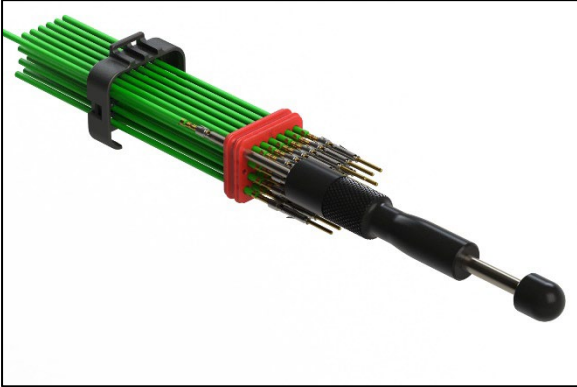
Step 4

Insert the size 20 Extraction Tool into the plastic housing hole. Hold the tool and press the tail, pushing out the contact until it meets the seal. Push out all the contacts in order to reach the seal.



Step 5

Wrap the contact with the tool and push the contact out of the wire seal.



For more information, contact: Customer Service, +1 800 394 7732, csr@amphenol-sine.com

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