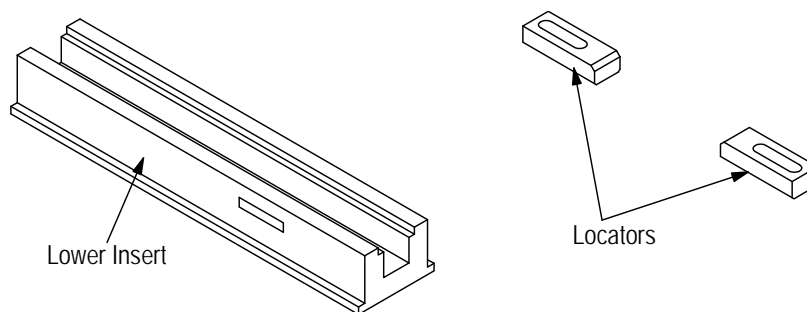


Connector-Specific Kit 1490479-1



Typical Application Tooling

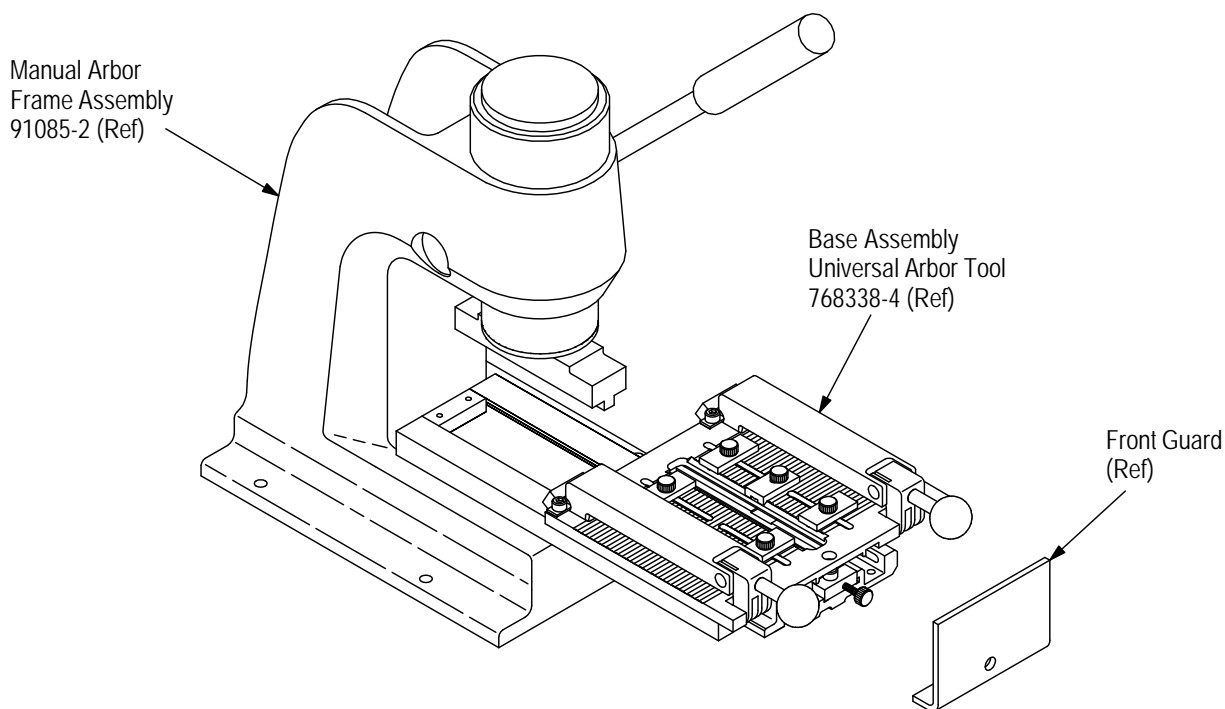


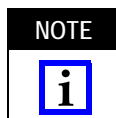
Figure 1

1. INTRODUCTION

This instruction sheet covers the installation and setup procedures for Connector-Specific Kit 1490479-1. The connector-specific kit is used in conjunction with Base Assembly Universal Arbor Tool 768338-4 and Manual Arbor Frame Assembly 91085-2 (see Figure 1), or Pneumatic Auto-Cycle Unit 91112-3 to terminate 0.64 mm [.025 in.] Plug and Receptacle Connectors to 0.64 mm [.025 in.] centerline flat ribbon cable.

Refer to Instruction Sheets 408-7777 (supplied with Manual Arbor Frame Assembly) and 408-6732 (supplied with Pneumatic Auto-Cycle Unit) for tooling

information. Installation and termination procedures for the Base Assembly Universal Arbor Tool are available in Instruction Sheet 408-4201.



Dimensions on this sheet are in millimeters [followed by inches in brackets]. Figures and illustrations are for reference only and are not drawn to scale.

2. DESCRIPTION (Figure 1)

The connector-specific kit features a lower insert and two locators. The lower insert and locators properly align the connector for termination.

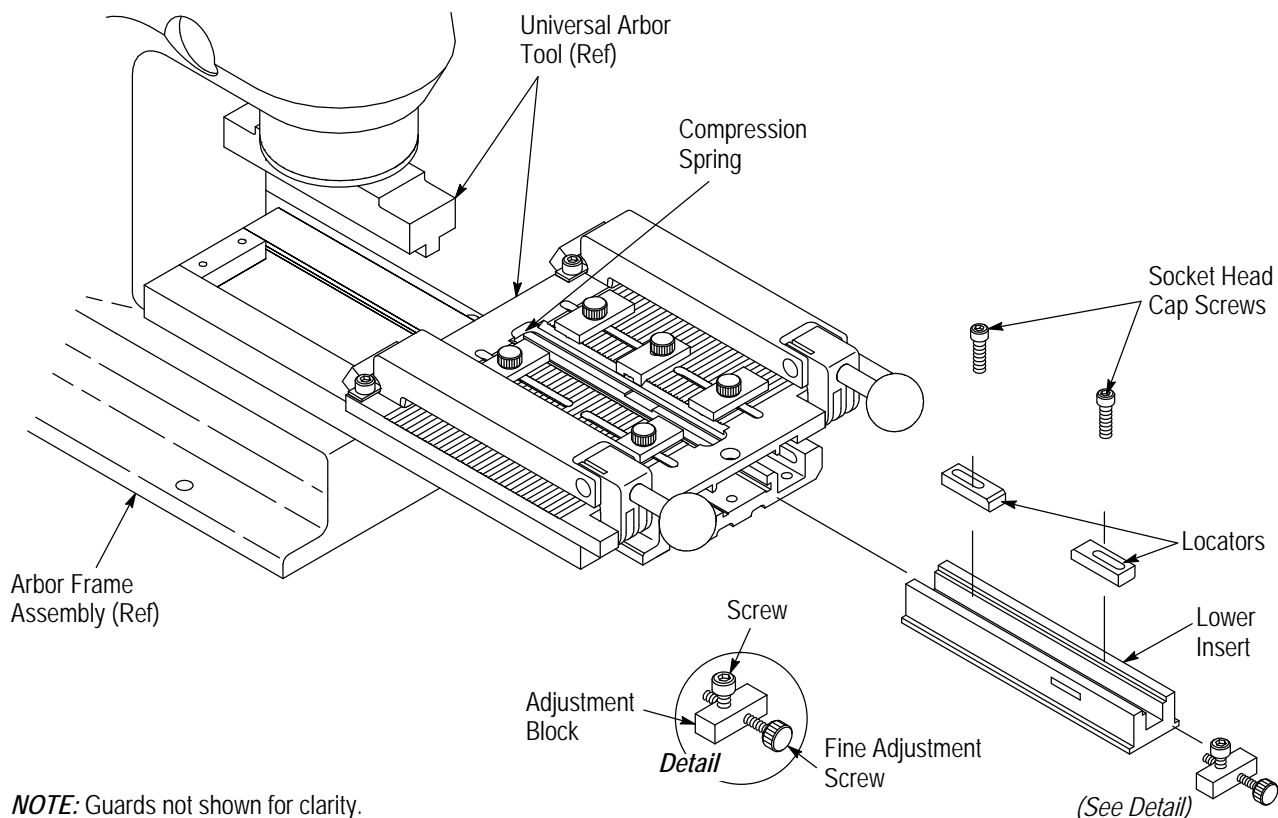


Figure 2

3. INSTALLATION AND SETUP OF CONNECTOR -SPECIFIC KIT

3.1. Installation

These procedures are typical for the manual arbor frame assembly and the pneumatic auto-cycle unit.

1. Loosen the two socket head cap screws that secure the locators onto the lower insert.
2. Place the connector between the locators and slide the locators against the connector; then secure the locators by fully tightening the socket head cap screws.

NOTE



Depending on which style connector is being terminated the connector will rest on either the mating face of the connector on the bottom of the slot that is in the lower insert; or the shoulders of the connectors will rest on the step of the lower insert, as shown in Figure 3.

CAUTION



When locating the connector in the lower insert be sure to center the connector as much as possible.

3. When the locators are secure, remove the connector from the lower insert.

4. Remove the screw that secures the adjustment block to the universal arbor tool then remove the adjustment block. Slide the lower insert onto the base assembly until it is against the compression spring. See Figure 2.

5. Re-assemble the adjustment block. Make sure to orient the block so that the fine adjustment screw is closest to the right side and bottom side of the block. See detail in Figure 2.



To avoid improper terminations, the adjustment block must be re-assembled properly.

6. Loosen the fine adjustment screw so that it is not touching the lower insert.

7. Install the Base Assembly Universal Arbor Tool onto the frame assembly, as described in 408-4201.



To avoid personal injury, be sure to disconnect the air from the main air valve when using Pneumatic Auto-Cycle Unit 91112-3.

3.2. Setup

1. Remove the cover from the connector and place the connector into the lower insert as described in Paragraph 3.1.

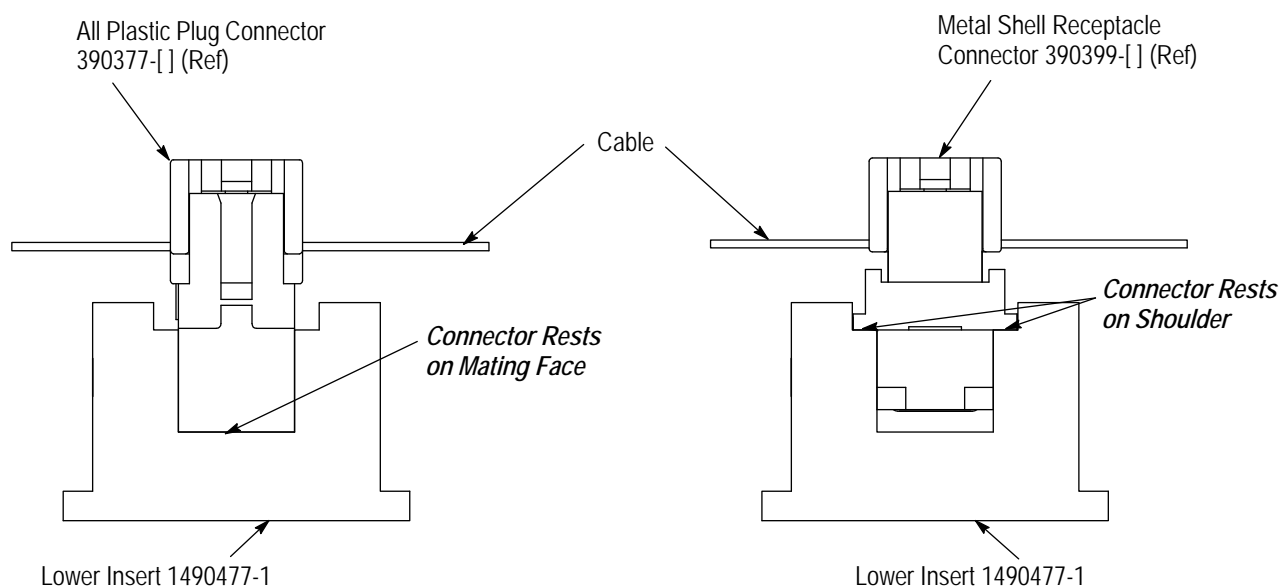


Figure 3

2. Position the cable onto the universal arbor tool and follow termination procedures according to the instructions packaged with the Base Assembly Universal Arbor Tool, Instruction Sheet 408-4201.

NOTE



For additional information on connector and cable alignment, refer to the instructions packaged with the universal arbor tool.

3.3. Connector Inspection

1. Perform a test termination and inspect the connector to ensure that the cable conductors are aligned with the contacts. If available, use a tester to inspect the termination, or remove the connector cover and inspect the termination with a microscope to ensure that the cable conductors are properly aligned with the contacts. Refer to applicable application specification (114-series) for termination height dimensions.

2. If the cable conductors are not aligned with the contacts, a re-alignment of the connector is necessary. Determine the direction the connector must be moved to align the cable conductors with the contacts. Loosen the two locking setscrews on the universal arbor tool (which secure the lower insert) and re-align the lower insert.

4. CONNECTOR-SPECIFIC KIT INSPECTION

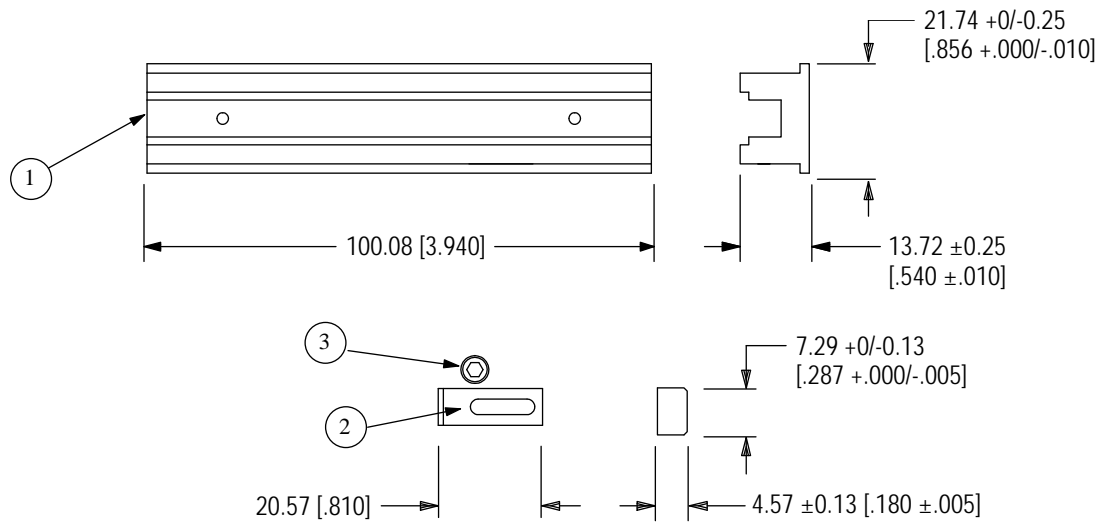
The connector-specific kit has been inspected and should be verified with the information provided in Figure 4. It is recommended that the kit be inspected immediately upon its arrival at your facility (and at regularly scheduled intervals) to ensure that the kit components have not been damaged during handling.

For additional information concerning connector-specific kits, or to purchase additional kits, contact your local TE Connectivity Representative or:

CUSTOMER SERVICE (038-035)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

5. REVISION SUMMARY

- New logo



REPLACEABLE PARTS			
ITEM	PART NUMBER	DESCRIPTION	QTY PER KIT
1	1490477-1	LOWER INSERT	1
2	1490478-1	LOCATOR	2
3	1-21000-4	SCREW, Socket Head Cap, 4-40 x .38 in. L	2

Figure 4