

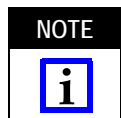
Number of Circuits	Plug Base Part Number	Cap Base Part Number
6	480273	480276
9	480274	480277
12	480275	480278
15	480323	480324

Figure 1

## 1. INTRODUCTION

This instruction sheet covers the MATE-N-LOK panel-mount connectors. Representative part numbers for these connectors are provided in Figure 1.

Read these instructions carefully before assembling connectors.



*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets].  
Figures are not drawn to scale.*

Reasons for reissue of this document are provided in Section 4, REVISION SUMMARY.

## 2. DESCRIPTION

Each connector consists of a cap, a plug, and pin and socket contacts. The plug, which may be panel mounted, accepts socket contacts. The cap accepts pin contacts.

## 3. ASSEMBLY PROCEDURE

### 3.1. Contact Selection and Crimping

Refer to Figure 2 and select an appropriate contact.

Crimp strip-form contacts using the proper applicator, according to the instructions supplied with the tooling.

Crimp loose-piece (LP) contacts using the hand tools listed in Figure 2.

Socket Part No.		Pin Part No.		Tool Part No.	Doc No.
Strip	LP	Strip	LP		
61314	60617	60511	60618	90123	408-7159
--	60619	61118	60620	90124	
350557	330638	--	--		

Figure 2

### 3.2. Contact Insertion

Use pin contacts only in the cap, and socket contacts only in the plug.

For single-wire leads, push the socket or pin into the housing as far as it will go. See Figure 1. Pull back lightly on the wire to make sure that the contact is secured in place.

For two-wire leads, first align the contact with the cavity as shown in Figure 3, then push the contact into the housing and check that it is secured in place.

When inserting contacts crimped to small, flexible wire, use insertion tool 91002-1.

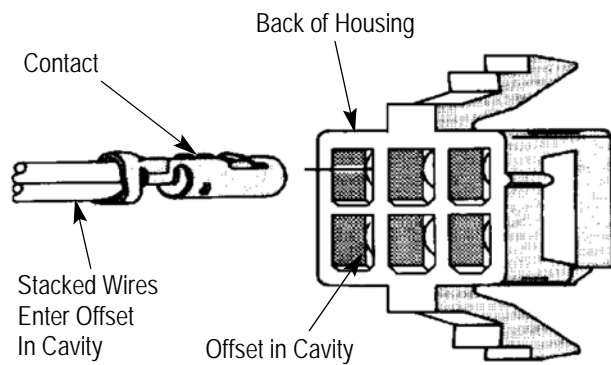


Figure 3

### 3.3. Housing Engagement

Align the index ribs on the plug and cap and push the housings together until the locking leg engages the locking bridge. See Figure 4. It may be necessary to squeeze the locking legs together slightly to engage the housings.

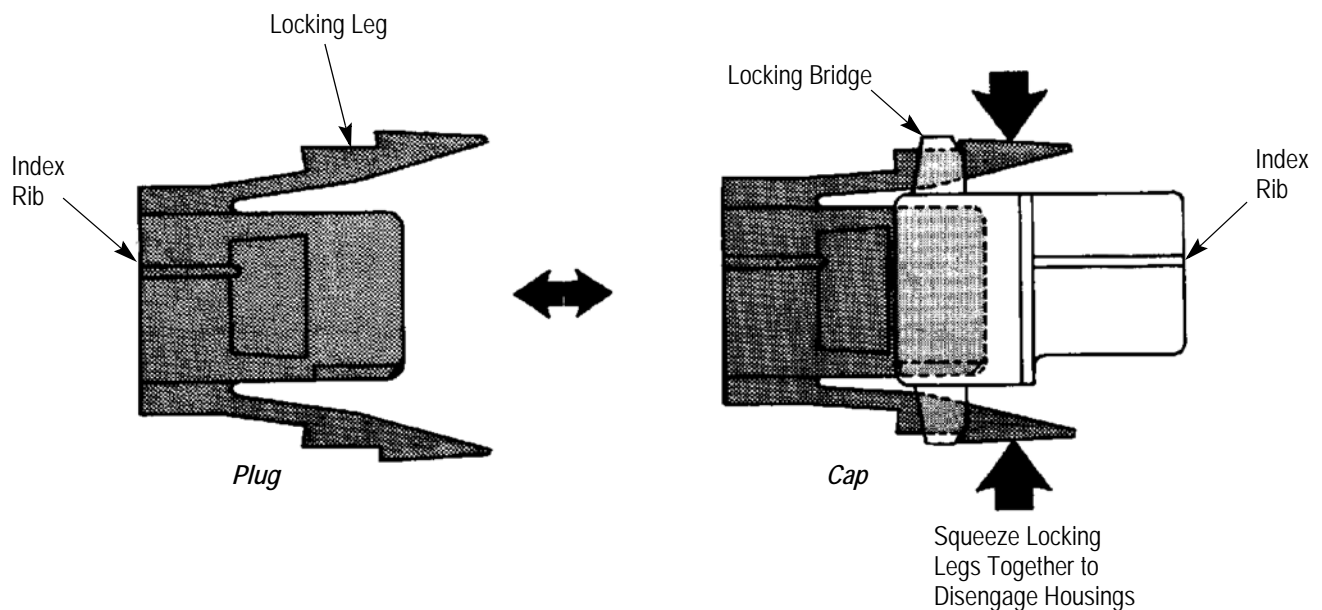


Figure 4

To disengage the housings, squeeze the locking legs together and pull the plug out of the cap. See Figure 4.

### 3.4. Panel Mounting

To mount the plug on a panel, first stamp a cutout in the panel using the dimensions provided in Figure 5. Be sure that the punch and the housing enter the panel from the same side. See Figure 6.

To install the plug on a panel, squeeze the locking legs together and push the housing straight through the panel, locking legs first. See Figure 6. Make sure that the panel locks on the locking legs engage the panel.

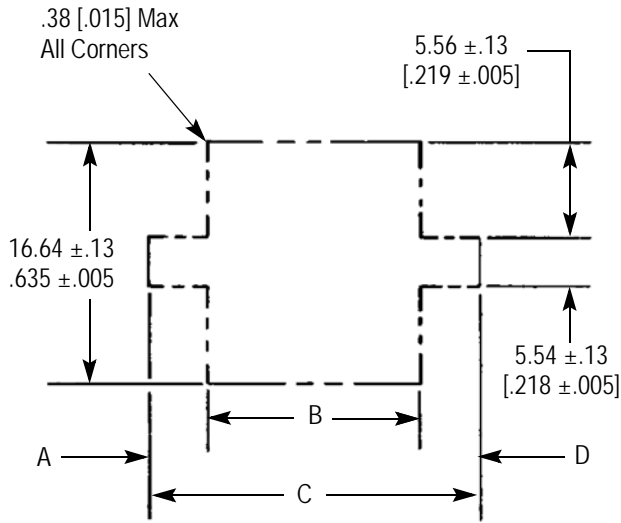
### 3.5. Contact Extraction

There are two types of extraction tool available. Use tool part number 465644-1 to extract both pin and socket contacts when you can clearly see the contacts as you looking into the front of the housing, and you can easily reach the rear of the housing. If either the view or the access is restricted, use tool part number 1-305183-1 for pin contacts and 1-305183-2 for socket contacts.

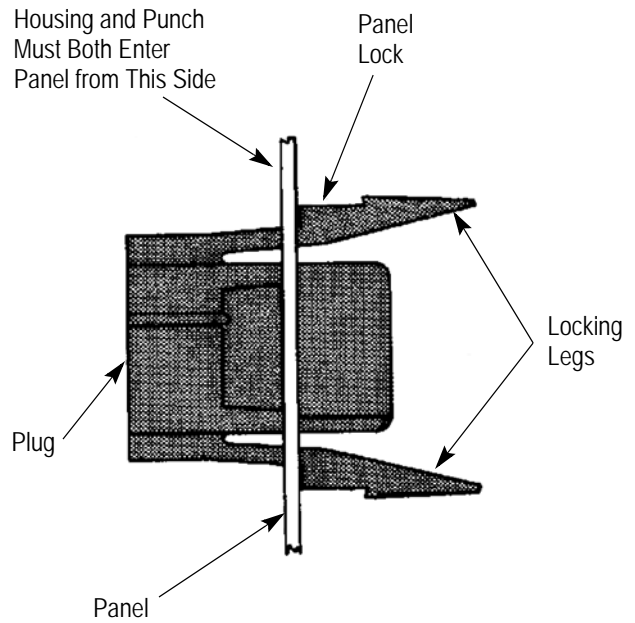
## 4. REVISION SUMMARY

Since the previous version of this document, the following has changed:

- Updated format and logo according to corporate requirements.



NOTES - Recommended panel thickness is .64 - 1.65 [.025 - .065]  
 - Dimensions A and D to be equal within .13 [.005]



Plug Part No.	Dimension B	Dimension C ±.13 [.005]
480273	14.48 - 14.61 [.570 - .575]	21.59 [.850]
480274	20.57 - 20.70 [.810 - .815]	27.56 [1.085]
480275	26.54 - 26.67 [1.045 - 1.050]	33.53 [1.320]
480323	32.64 - 32.77 [1.265 - 1.290]	39.50 [1.555]

Figure 5

Figure 6