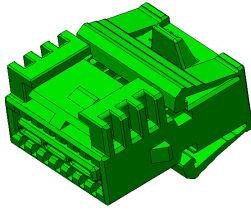
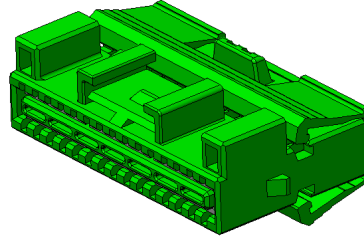


.025 JOINT 14P/30P CONNECTOR



025 Joint 14P Connector



.025 Joint 30P Connector

Figure 1

1. INTRODUCTION

This instruction sheet provides assembly and disassembly procedures for 025 Joint connector. Connector part number and description are given as follows;

| Part number | Description | Accessory Cover | Remarks |
|-------------|-------------------------|-----------------|---------|
| 2005496 | 025 Joint 14P Connector | 2005318 | |
| 2005499 | 025 Joint 30P Connector | 2005319 | |

* Refer to customer drawing for specific part numbers for each base number.

2. DESCRIPTION

The connector consists of a joint housing with retainer and splice tab. See Figure 2.

After all contacts are inserted, the retainer is used to ensure that all contacts are fully seated and to provide additional contact retention. If a contact is not fully seated or improperly oriented in the contact cavity, the retainer will not close properly.

Refer to the customer drawing of the specific connector for compatible contact part numbers. See Figure 3.

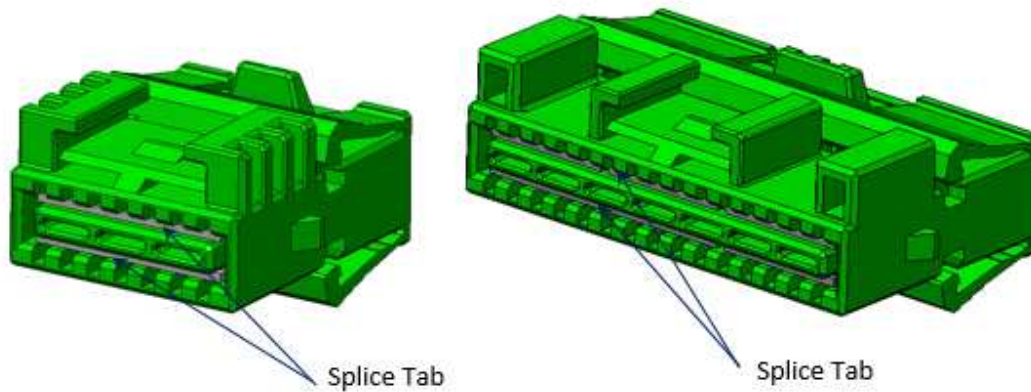
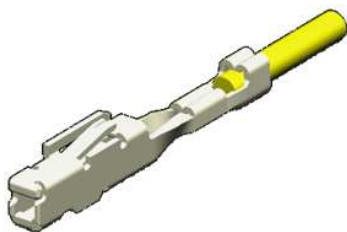


Figure 2



| TE P/N | Wire Range (mm ²) | Insulation Diameter (mm) |
|-----------|-------------------------------|--------------------------|
| 2005097-1 | 0.22 | 0.9-1.2 |
| 2005427-1 | 0.3-0.5 | 1.1-1.7 |
| 2188446-1 | 0.22 | 0.9-1.2 |
| 2188446-2 | 0.3-0.5 | 1.1-1.7 |

Figure 3

3. ASSEMBLY PROCEDURE

3.1 Contact Insertion

1. Make sure that the contacts are properly crimped and installed onto the wires. Refer to the latest application spec. 114-61030 for inspection requirements.
2. Make sure that the retainer is open as shown in Figure 4. If it is not, open the retainer according to Paragraph 4.1.2.

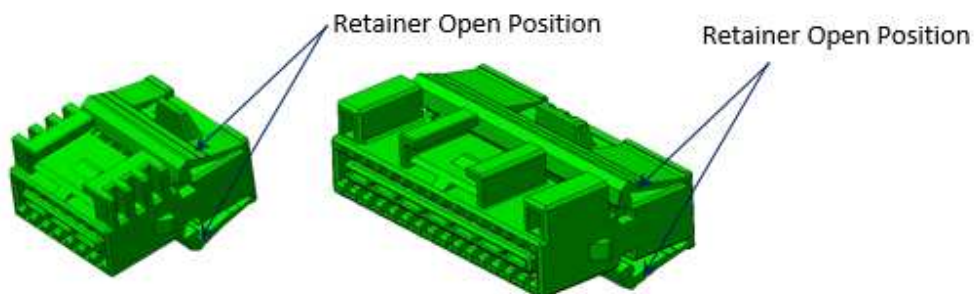


Figure 4

3. Align a terminated contact with the selected contact cavity of the inner housing so that the contact latch features are oriented in same direction as shown in Figure 5. Insert the contact into the contact cavity until it bottoms. There should be an audible or tactile "click" when the contact is fully seated.

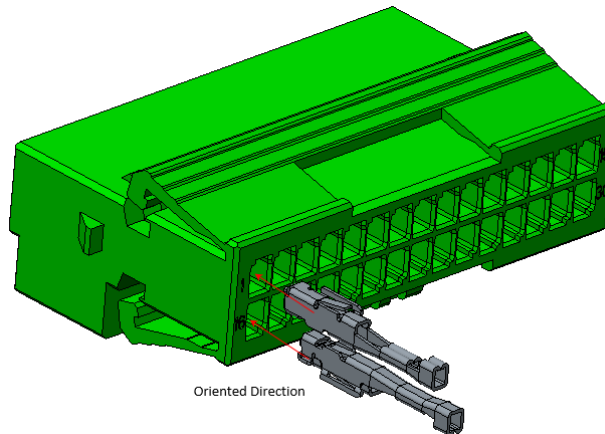


Figure 5

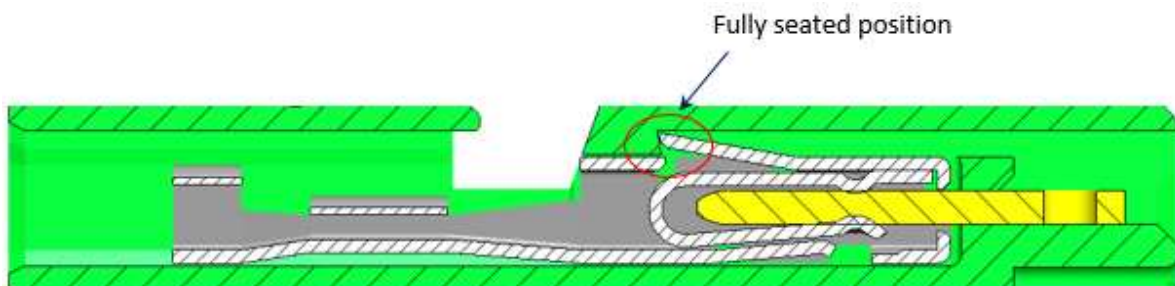


Figure 6

4. After all contacts have been inserted, shift the retainer until it is closed at both sides. See Figure 7 and 8.

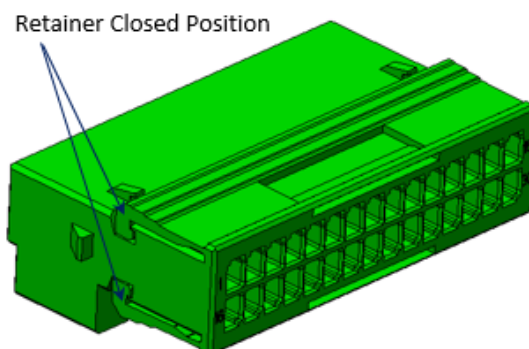


Figure 7

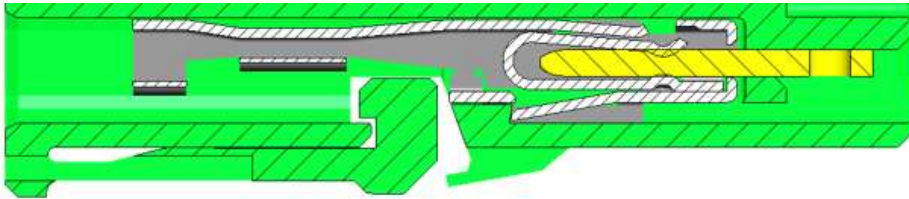


Figure 8

5. If need, install the cover housing.
See Figure 9 and 10.

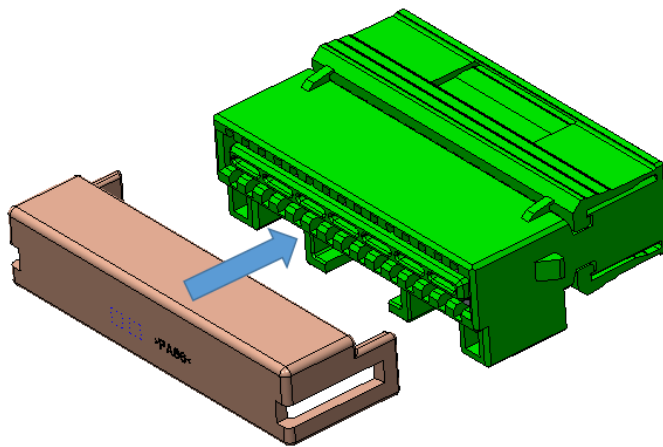


Figure 9

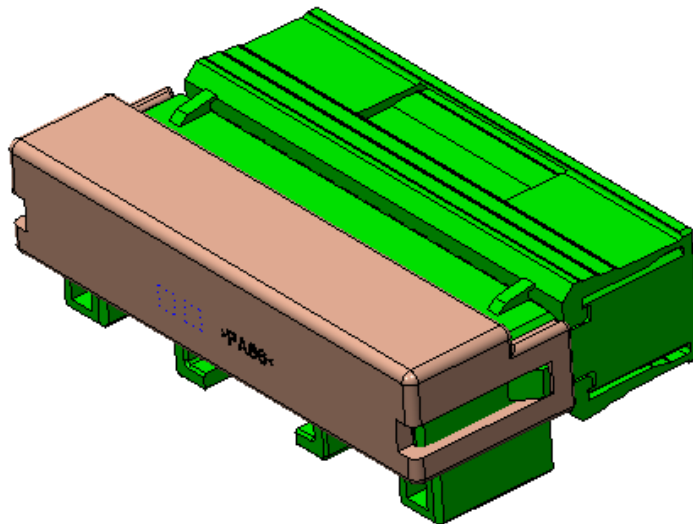


Figure 10

4. DISASSEMBLY PROCEDURE

4.1 Contact Removal

1. If using the cover, remove the cover.
2. Ensure that the retainer is open. See Figure 11.

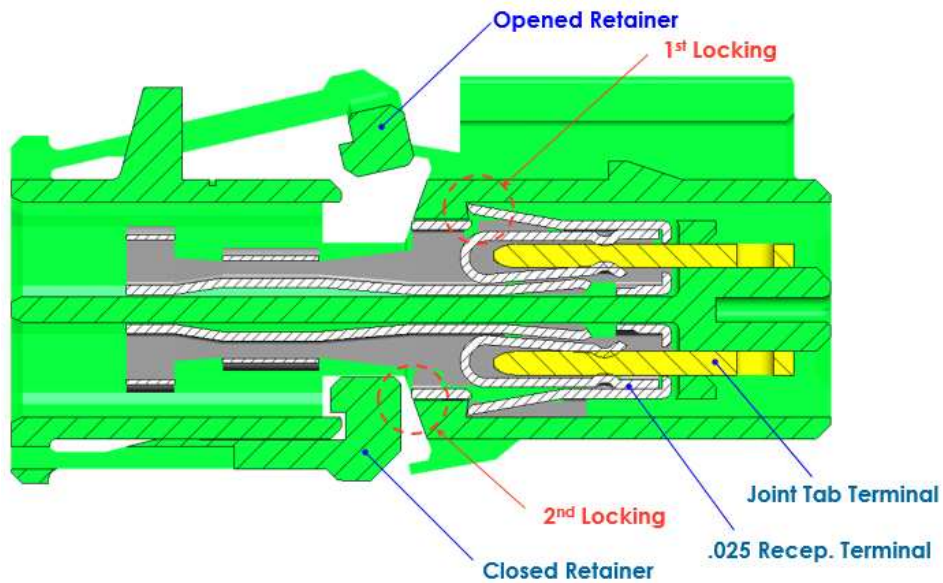


Figure 11

3. Insert the extraction tool per each terminal cavity and then pull out the crimped terminal from the connector using the wire. See Figure 19.
- See Figure 20 for tool detail. Extraction tool is not supplied by TE.

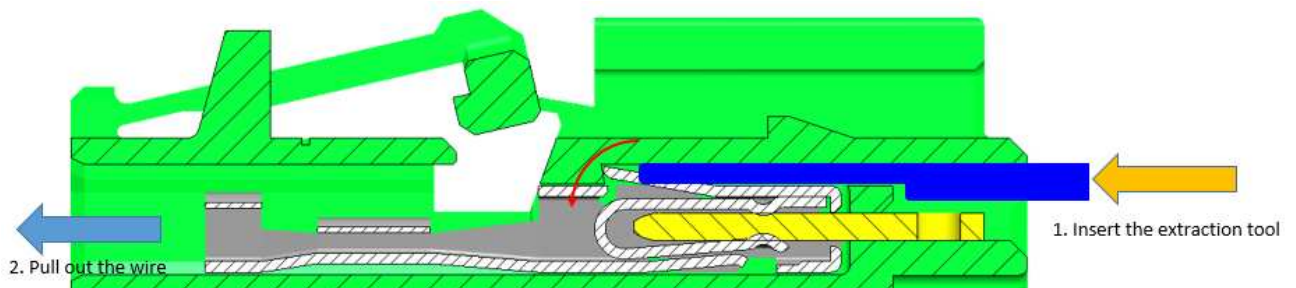


Figure 19

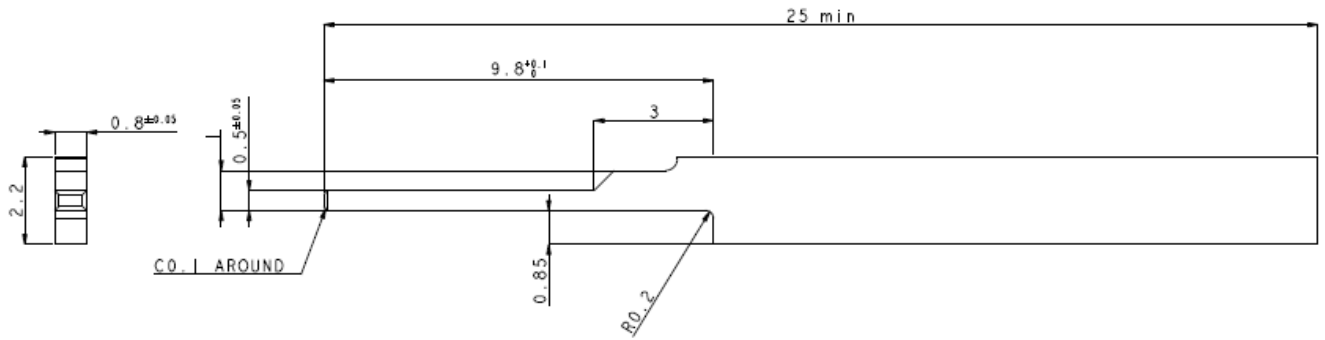


Figure 20

5. REPLACEMENT AND REPAIR

DO NOT reuse any defective or damaged contacts and connector.