APPLICATION SPECIFICATION

ECONOSEAL 3 HIGH CURRENT

SCOPE

This specification covers the assembly of the tabs and receptacles into their respective housings, and the crimping requirements of these contacts.

Please note that this specification covers a sealed system and an unsealed system.

GENERAL

The ECONOSEAL 3 High Current System uses .250" (6,35mm) series "Faston Type" tabs and receptacles.

These contacts are suitable for thin walled cables from 0,5mm to 3,0mm² only.

For the sealed connector requirements, each cable is inserted into a discrete cable seal prior to being crimped into the contact. The insulation barrel is crimped so that the cable seal is gripped sufficiently to stop any movement of the seal on the cable.

For the unsealed connector requirements, discrete cable seals are not required, and the contact part numbers are different to those used for the sealed connectors. The cables are crimped in the normal way.
Please note that where cable seals are required only single cables may be crimped, but for unsealed requirements single or double cables may be crimped.

The insulation barrel is crimped with an "O" or "F" crimper when discrete cable seals are used.

The insulation barrel is crimped with an "OL" (Over-lap) crimper when single cables are used, without seals.

The insulation barrel is crimped with an "F" crimper when double cables are used.

DIST

LTR	REVISION RECORD	APP	DATE
D	EBA0-0001-05	MH	01/05
C	EB00-0258-93	KHW	7/7/93
B	Updated (S0080)	RS	19.1.91
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LOC E | NO 114-3036 | REV D

SHEET 1 OF 22

TITLE APPLICATION SPECIFICATION FOR ECONOSEAL III HIGH CURRENT CONNECTORS

For sealed connectors, the receptacle half of the connector is an assembly that comprises a receptacle housing and a peripheral seal, which seals the interface between tab and receptacle housings. These assemblies have unique part numbers. The receptacle housing part numbers used in these assemblies are common for sealed on unsealed applications. The tab housing part numbers are common for sealed or unsealed applications. For unsealed connectors, peripheral and cable seals are not required.

Contacts (tabs or receptacles - with or without seals), are inserted into the housings, which have a "resin" lance in each cavity that retains the contact.

To ensure that 0,5 to 1,0mm² cable, with seal, does not deform, when hand inserting, use tool P/No. 344525-1 (see figure 9). Deformation of the cable within the seal can result in a leak path. For automatic assembly a tool to do the same job shall be incorporated in the assembly machine.

To prevent 0,5 to 1,0mm² cables, without seals, from deforming, when hand inserting, the cable shall be gripped just behind the insulation barrel with a suitable tool such as smooth-jawed pliers. For automatic assembly the insertion tool shall grip the cable in the same area.

For ease of insertion of contact into cavity, the angle of entry shall be ±5° to the centre line of the bore.

When all contacts are in their correct position within the cavities, a secondary locking component (anti-backout) can be inserted easily and "clicked" into position. If the contacts are not in their correct position, difficulty will be experienced when inserting the anti-backout. This must be investigated. The cause, apart from obviously damaged parts, will be that the contacts are not quite fully inserted, and it will be seen that the resin lance is in an upwards deflected position. The back end of the insulation barrel or the seal may or may not be protruding beyond the back of the cavity.

If the anti-backout "clicks" home, there may still be a problem with under insertion of the contact, but this will be obvious because the contact or seal will be protruding from the back of the cavity.

The problem of contacts not being postioned correctly will be obviated by automatic assembly of the contacts. The assembly equipment must be capable of inserting the contacts and testing that they are correctly retained, by pulling back on the cable with a small force, not exceeding 10 Newtons.

The secondary locking component can also be inserted automatically. It is inserted into the front of the housings and insures that the "resin" lances are fully locked behind the contacts, giving added security to the retention of the contacts. In addition, it helps to align the tabs and receptacles when mating the connectors.

A flat faced tool, suitable cut-away to miss the anti-backout protrusion and the tabs, shall be used to insert the tab housing anti-backout to ensure that it is properly locked into position. (See Figures 10, 10a and 10b).

A tool of this type shall be used for hand or automatic assembly.

Any flat tool of suitable size may be used when inserting the receptacle housing anti-backout. (See Figures 11, 11a and 11b).

To remove contacts from housings, the anti-backouts must first be removed.

The tab housing anti-backout shall be removed by a straight pull on the anti-backout protusion with smooth-jawed pliers.

The receptacle housing anti-backout shall be removed by gently easing the flange of the anti-backout out of the housing with a small screwdriver with a blade width not exceeding 5mm.

With the anti-backouts removed, the tabs and receptacle may be removed by using tool number 724712-1 (for receptacles), and number 724713-1 (for tabs), or a small screwdriver with blade width not exceeding 1.5mm. (See Figure 12 and 12a).

The tool is used to lift the "resin" lance clear of the contact, which can then be extracted.

The following part numbers shall be governed under this specification.

2 Way Rec. Hsg. Assy (with seal)	-	344081-1
4 Way Rec. Hsg. Assy (with seal)	-	344080-1
8 Way Rec. Hsg. Assy (with seal)	-	344079-1

2 Way Rec. Hsg. (without seal)	-	344078-1
4 Way Rec. Hsg. (without seal)	-	344077-1
8 Way Rec. Hsg. (without seal)	-	344076-1
2 Way Tab Hsg.	-	344075-1
4 Way Tab Hsg.	-	344074-1
8 Way Tab Hsg.	-	344073-1
2 Way Rec. Hsg. Anti-Backout	-	344089-1
4 Way Rec. Hsg. Anti-Backout	-	344087-1
8 Way Rec. Hsg. Anti-Backout	-	344085-1
2 Way Tab Hsg. Anti-Backout	-	344090-1
4 Way Tab Hsg. Anti-Backout	-	344088-1
8 Way Tab Hsg. Anti-Backout	-	344086-1
.250 Series Tab (for use with seal)	-	344008-1
.250 Series Rec (for use with seal)	-	344009-1
.250 Series Tab (for use with seal)	-	344069-1
.250 Series Rec (for use with seal)	-	344070-1
.250 Series Tab (no seal - for 1 or 2 cables)	-	344067-1
.250 Series Rec (no seal - for 1 or 2 cables)	-	344068-1
.250 Series Tab (no seal - for 1 or 2 cables)	-	344071-1
.250 Series Rec (no seal - for 1 or 2 cables)	-	344072-1
*Discrete Cable Seal (for 0,5 to 1,5 sq.mm)	-	344095-1
**Discrete Cable Seal (for 2,0 to 3,0 sq.mm)	-	172747-1 or 347713-1
*** Descrete cable seal (for 2,0 sq.mm)	-	347707-1

* Please note that seal, PN344095-1, is suitable for cables with insulation diameters of 1.6mm minimum and up to, and including 2.4mm

** The seal, PN 172747, & 347713 is suitable for cables with insulation diameters of 2.6mm minimum and 3.4mm maximum.

*** The seal PN347707 is suitable for cables with insulation diameter of 2,2mm minimum

Cavity Blanking Plug	-	172749-1

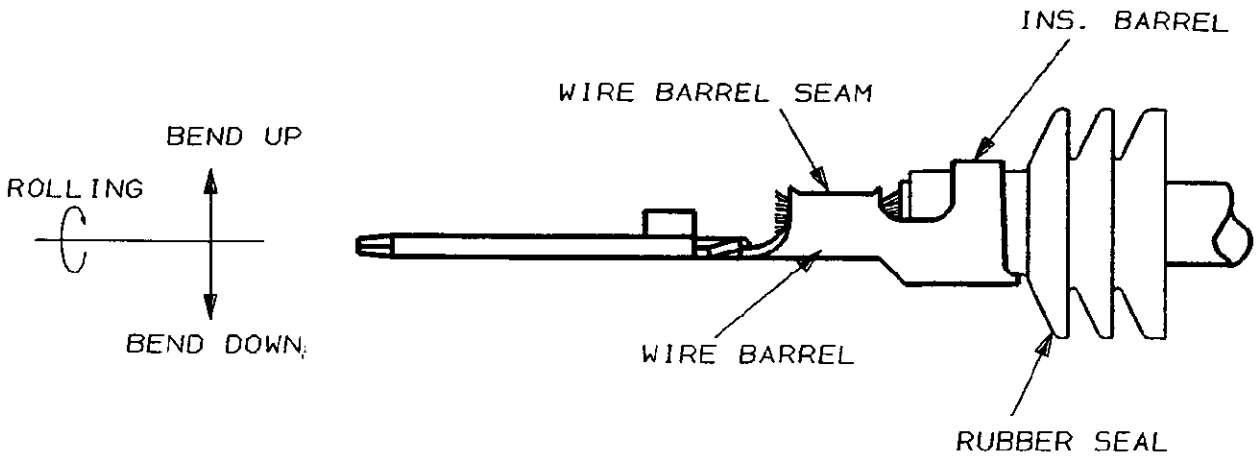
Cavity blanking plugs must be used for sealed connectors, where connectors are not fully loaded.

These plugs can also be assembled automatically.

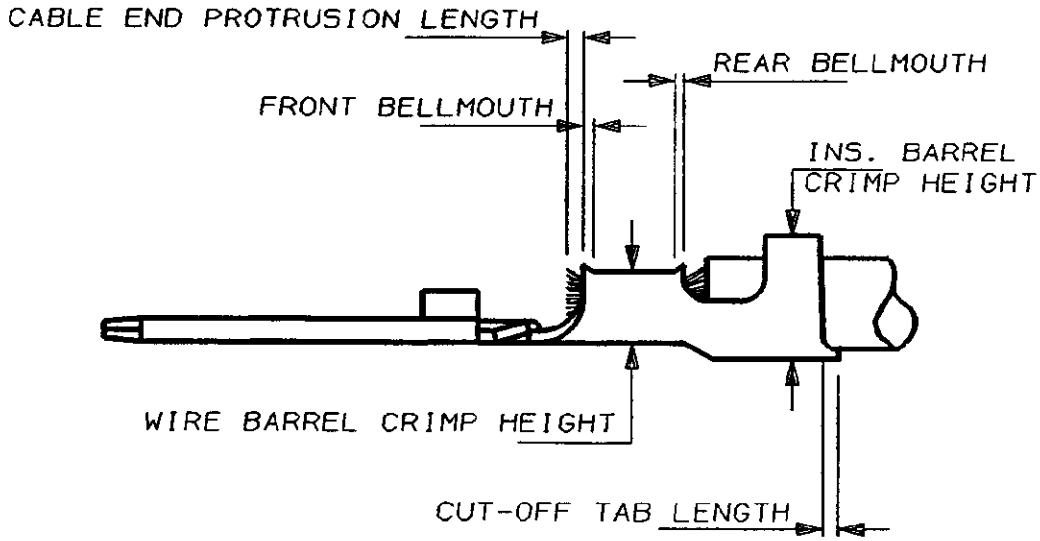
1. CRIMPING

The following information contains nomenclature, crimping conditions, crimp data for mini-applicators and hand tools, installation of rubber seals on cables, correction or replacement of parts and checks.

1.1 NOMENCLATURE:



CONTACT WITH SEAL



CONTACT WITHOUT SEAL

NOTE: NOMENCLATURE IS THE SAME FOR TAB OR REC.

2. CRIMPING CONDITIONS (Tabs and Recs - Sealed and Unsealed

Refer to nomenclature (Clause 1.1).

a. Cut off tab length shall be 0,5mm max. (Also front cut-off tab length shall be 0,5mm max).

b. Front bellmouth shall be 0,3mm max.

c. Rear bellmouth shall be 0,5 to 0,9mm.

d. Cable end protrusion length shall be 0 to 1,5mm.

e. Wire barrel seam must be neatly closed.

f. Insulation stripping length shall be 5,25 ± 0,25 for single cables (sealed or unsealed applications), and 5,75 ± 0,25 for double cables. (See crimp data for contacts).

g. Form Deviation

Bend up shall be 4 degrees max. for tabs.

Bend up shall be 5 degrees max. for receptacles.

Bend down shall be 3 degrees max for tabs or receptacles.

Twisting shall be 5 degrees max. for tabs

Twisting shall be 10 degrees max. for receptacles.

Rolling shall be 5 degrees max. for tabs.

Rolling shall be 8 degrees max. for receptacles.

h. Cable strands and insulation must be visible in transition area (between wire an ins. barrel), for cables crimped without seals.

j. Wire barrel flash to be 0.25 max.

PART NO.	WIRE SIZE (mm^2)	INSULATION DIAMETER (mm)	STRIP LENGTH (mm)	WIRE BARREL CRIMP			INS. BARREL CRIMP		
				HEIGHT (mm)	WIDTH (mm)	CRIMP TYPE	HEIGHT REF. * (mm)	WIDTH (mm)	CRIMP TYPE
344008	3.0	3.2-3.4	5.0-5.5	2.24	2.79	"F"	5.3	5.84	"O"
344008	2.5	2.9-3.1	5.0-5.5	2.06	2.79	"F"	4.9	5.84	"O"
344008	2.0	2.6-2.7	5.0-5.5	1.91	2.79	"F"	4.4	5.84	"O"
344009	3.0	3.2-3.4	5.0-5.5	2.03	2.79	"F"	5.0	5.84	"O"
344009	2.5	2.9-3.1	5.0-5.5	1.85	2.79	"F"	4.5	5.84	"O"
344009	2.0	2.6-2.7	5.0-5.5	1.70	2.79	"F"	4.2	5.84	"O"
344069	1.5	2.3-2.4	5.0-5.5	1.80	2.03	"F"	4.4	5.84	"O"
344069	1.0	2.0-2.1	5.0-5.5	1.60	2.03	"F"	4.3	5.84	"O"
344069	0.75	1.85-1.9	5.0-5.5	1.50	2.03	"F"	4.2	5.84	"O"
344069	0.5	1.7	5.0-5.5	1.37	2.03	"F"	4.1	5.84	"O"
344070	1.5	2.3-2.4	5.0-5.5	1.65	2.03	"F"	4.3	5.33	"F"
344070	1.0	2.0-2.1	5.0-5.5	1.45	2.03	"F"	4.2	5.33	"F"
344070	0.75	1.85-1.9	5.0-5.5	1.35	2.03	"F"	4.1	5.33	"F"
344070	0.5	1.7	5.0-5.5	1.24	2.03	"F"	4.0	5.33	"F"

THE ABOVE CHART SHOWS CRIMP DATA FOR SINGLE CABLE, WITH CABLE SEAL, APPLICATIONS WHEN CRIMPING WITH MINI-APPLICATORS.

* THIS COLUMN SHOWS NOMINAL VALUES FOR INS. CRIMP HEIGHTS, BUT CRIMPERS MUST BE ADJUSTED SO THAT THE CABLE SEAL IS GRIPPED FIRMLY BUT NOT CRUSHED OR PIERCED.

FIGURE 1

PART NO.	WIRE SIZE (mm^2)	INSULATION DIAMETER (mm)	STRIP LENGTH (mm)	WIRE BARREL CRIMP			INS. BARREL CRIMP		
				HEIGHT (mm)	WIDTH (mm)	CRIMP TYPE	HEIGHT REF. * (mm)	WIDTH (mm)	CRIMP TYPE
344067	3.0	3.2-3.4	5.0-5.5	2.24	2.79	"F"	3.90	4.57	"O/L"
344067	2.5	2.9-3.1	5.0-5.5	2.06	2.79	"F"	3.65	4.57	"O/L"
344067	2.0	2.6-2.7	5.0-5.5	1.91	2.79	"F"	3.40	4.57	"O/L"
344068	3.0	3.2-3.4	5.0-5.5	2.03	2.79	"F"	3.75	4.57	"O/L"
344068	2.5	2.9-3.1	5.0-5.5	1.85	2.79	"F"	3.50	4.57	"O/L"
344068	2.0	2.6-2.7	5.0-5.5	1.70	2.79	"F"	3.20	4.57	"O/L"
344071	1.5	2.3-2.4	5.0-5.5	1.80	2.03	"F"	3.10	3.56	"O/L"
344071	1.0	2.0-2.1	5.0-5.5	1.60	2.03	"F"	2.85	3.56	"O/L"
344071	0.75	1.85-1.9	5.0-5.5	1.50	2.03	"F"	2.70	3.56	"O/L"
344071	0.5	1.6 MIN.	5.0-5.5	1.37	2.03	"F"	2.60	3.56	"O/L"
344072	1.5	2.3-2.4	5.0-5.5	1.65	2.03	"F"	2.95	3.56	"O/L"
344072	1.0	2.0-2.1	5.0-5.5	1.45	2.03	"F"	2.70	3.56	"O/L"
344072	0.75	1.85-1.9	5.0-5.5	1.35	2.03	"F"	2.55	3.56	"O/L"
344072	0.5	1.6 MIN.	5.0-5.5	1.24	2.03	"F"	2.35	3.56	"O/L"

THE ABOVE CHART SHOWS THE CRIMP DATA FOR SINGLE CABLE APPLICATIONS, WITH OVERLAP CRIMPS ON THE INSULATION - USING MINI-APPLICATORS.

*INS. CRIMP HEIGHTS STATED ARE NOMINAL VALUES BASED ON THE FORMULA BELOW, BUT INS. CRIMPERS MUST BE ADJUSTED SO THAT THE INSULATION IS GRIPPED FIRMLY WITHOUT DAMAGING THE INSULATION.

NOMINAL INS. CRIMP HEIGHT = 0.9 (MIN. INS. DIA. + 3 X ST. THK.)

FIGURE 2

	PART NO.	WIRE SIZE (mm^2)	INSULATION DIAMETER (mm)	STRIP LENGTH (mm)	WIRE BARREL CRIMP HEIGHT (mm)	WIRE BARREL CRIMP WIDTH (mm)	WIRE BARREL CRIMP TYPE	INS. BARREL CRIMP HEIGHT REF.* (mm)	INS. BARREL CRIMP WIDTH (mm)	INS. BARREL CRIMP TYPE
TAB	344067	1.5+1.5	2.3+2.3	5.5 - 6.0	2.24	2.79	"F"	2.75	4.83	"F"
	OR	1.5+1.0	2.3+2.0	5.5 - 6.0	2.06	2.79	"F"	2.48	4.83	"F"
	344778	1.0+1.0	2.0+2.0	5.5 - 6.0	1.91	2.79	"F"	2.48	4.83	"F"
REC.	344068	1.5+1.5	2.3+2.3	5.5 - 6.0	2.03	2.79	"F"	3.55	4.83	"F"
	344068	1.5+1.0	2.3+2.0	5.5 - 6.0	1.85	2.79	"F"	2.95	4.83	"F"
	344068	1.0+1.0	2.0+2.0	5.5 - 6.0	1.70	2.79	"F"	2.80	4.83	"F"
TAB	344071	0.75+0.75	1.85+1.85	5.5 - 6.0	1.80	2.03	"F"	2.35	4.06	"F"
	OR 344780	0.5+0.5	1.6 MIN. + 1.6 MIN.	5.5 - 6.0	1.60	2.03	"F"	2.21	4.06	"F"
REC.	344072	0.75+0.75	1.85+1.85	5.5 - 6.0	1.33	2.54	"F"	2.35	4.06	"F"
	344072	0.5+0.5	1.6 MIN. + 1.6 MIN.	5.5 - 6.0	1.18	2.54	"F"	2.15	4.06	"F"

THE ABOVE CHART SHOWS RECOMMENDED CRIMP DATA FOR DOUBLE CABLE APPLICATIONS WHEN CRIMPING WIH MINI-APPLICATORS.
(FOR OTHER CABLE COMBINATIONS CONSULT AMP ENG.)

*INS. CRIMP HEIGHTS STATED ARE NOMINAL VALUES BASED ON THE FORMULA BELOW, BUT INS. CRIMPERS MUST BE ADJUSTED SO THAT THE INSULATION IS GRIPPED FIRMLY WITHOUT DAMAGING THE INSULATION.

NOMINAL INS. CRIMP HEIGHT = 0.9 (INS. DIA. + 2 X ST. THK.)

WHERE "INS. DIA." = DIA. OF ONE CABLE OR DIA. OF SMALLEST CABLE OF THE THE PAIR, PROVIDED THE DIFFERENCE IN DIAMETERS OF THE PAIR DOES NOT EXCEED 0.3 mm.

FIGURE 3

HAND TOOL PART NO.	PART NO. (LOOSE PIECE)	WIRE SIZE (mm^2)	INSULATION DIAMETER (mm)	STRIP LEN. ±0.25 (mm)	WIRE BARREL CRIMP HEIGHT (mm)	WIRE BARREL CRIMP WIDTH (mm)	WIRE BARREL CRIMP TYPE	INS. BARREL CRIMP HEIGHT REF. (mm)	INS. BARREL CRIMP WIDTH (mm)	INS. BARREL CRIMP TYPE
525316-1 TAB	344989-1	3.0 2.5	3.2-3.4 2.9-3.1	5.25 5.25	2.15	2.79	"F"	4.2	5.33	"F"
		2.0	2.6-2.7	5.25	1.91	2.79	"F"	4.1	5.33	"F"
525316-2 REC.	344993-1	3.0 2.5	3.2-3.4 2.9-3.1	5.25 5.25	1.94	2.79	"F"	4.1	5.33	"F"
		2.0	2.6-2.7	5.25	1.70	2.79	"F"	4.0	5.33	"F"
525316-3 TAB	344991-1	1.5 1.0	2.3-2.4 2.0-2.1	5.25 5.25	1.70	2.03	"F"	4.1	5.33	"F"
		0.75 0.5	1.85-1.9 1.60 MIN.	5.25 5.25	1.43	2.03	"F"	4.0	5.33	"F"
525316-4 REC.	344995-1	1.5 1.0	2.3-2.4 2.0-2.1	5.25 5.25	1.55	2.03	"F"	4.0	5.33	"F"
		0.75 0.5	1.85-1.9 1.60 MIN.	5.25 5.25	1.29	2.03	"F"	3.9	5.33	"F"

THE ABOVE CHART SHOWS CRIMP DATA FOR SINGLE CABLE, WITH CABLE SEAL, APPLICATIONS WHEN CRIMPING WITH HANDTOOLS.

FIGURE 4

HAND TOOL PART NO.	PART NO. (LOOSE PIECE)	WIRE SIZE (mm^2)	INSULATION DIAMETER (mm)	STRIP LEN. ±0.25 (mm)	WIRE BARREL CRIMP HEIGHT (mm)	WIRE BARREL CRIMP WIDTH (mm)	WIRE BARREL CRIMP TYPE	INS. BARREL CRIMP HEIGHT REF. (mm)	INS. BARREL CRIMP WIDTH (mm)	INS. BARREL CRIMP TYPE
525316-5 TAB	344990-1	3.0 2.5	3.2-3.4 2.9-3.1	5.25 5.25	2.15	2.79	"F"	3.0	4.57	"O/L"
		2.0	2.6-2.7	5.25	1.91	2.79	"F"	2.75	4.57	"O/L"
525316-6 REC.	344994-1	3.0 2.5	3.2-3.4 2.9-3.1	5.25 5.25	1.94	2.79	"F"	3.0	4.57	"O/L"
		2.0	2.6-2.7	5.25	1.70	2.79	"F"	2.75	4.57	"O/L"
525316-7 TAB	344992-1	1.5 1.0	2.3-2.4 2.0-2.1	5.25 5.25	1.70	2.03	"F"	2.3	3.56	"O/L"
		0.75 0.5	1.85-1.9 1.6 MIN.	5.25 5.25	1.43	2.03	"F"	2.15	3.56	"O/L"
525316-8 REC.	344996-1	1.5 1.0	2.3-2.4 2.0-2.1	5.25 5.25	1.55	2.03	"F"	2.3	3.56	"O/L"
		0.75 0.5	1.85-1.9 1.6 MIN.	5.25 5.25	1.29	2.03	"F"	2.15	3.56	"O/L"

THE ABOVE CHART SHOWS THE CRIMP DATA FOR SINGLE CABLE APPLICATIONS, WITH OVERLAP CRIMPS ON THE INSULATION - USING HANDTOOLS.

FIGURE 5

3. CRIMP DATA

3.1 For applicator crimping of tabs and receptacles with seals see Figure 1.

3.2 For applicator crimping of tab and receptacles used with single cables (no seal) see Figure 2.

3.3 For applicator crimping of tab and receptacles used with double cables (no seals) see Figure 3.

3.4 For handtool crimping of tabs and receptacles with seals see Figure 4.

3.5 For handtool crimping of tabs and receptacles used with single cables (no seal) see Figure 5.

Notes

a. Handtools are not available for double cable applications.

b. The tolerance of wire barrel crimp heights shall be within ±0.05mm.

c. All cables for use with these tabs and receptacles shall be thin walled non-irradiated cables only.

d. To assist insertion of cables into the cable seals an "attaching jig" shall be used - Part No. 753812-1 (AMP Japan). (See Figure 13).

For automatic asssembly of seal onto cable a S.C.A.T machine may be used.

4. INSTALLATION OF RUBBER SEAL ON THE CABLE

When the rubber seal is installed on the cable, the end of the cable insulation shall protrude to a length not exceeding 1mm beyond the edge of the rubber seal as shown in Figure 6. This length is common to tabs and receptacles regardless of cable size.

Note: Seals are supplied lubricated. This lubrication must not be removed.

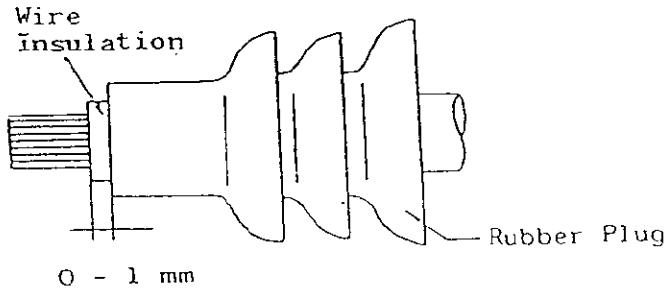


FIGURE 6

5. CORRECTION OR REPLACEMENT OF PARTS

When defects and/or improper applications are found on parts to be installed, as shown in Figure 7, rework to reform properly, or replace with new part.

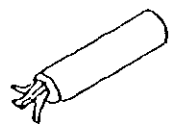
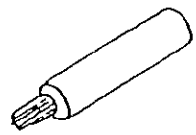
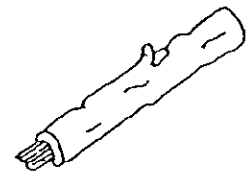
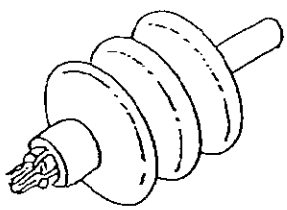
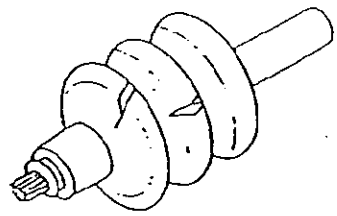
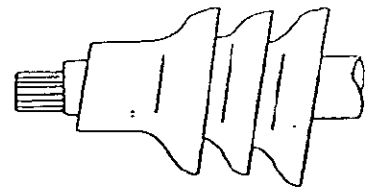
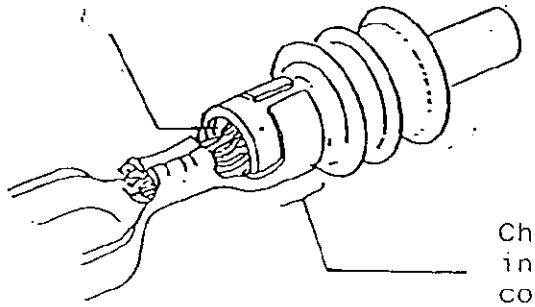
		
The end of the cut wire shall appear neat without disorder and bend of stranded conductor.	The conductor shall be free from nick, cut and scrape.	The wire insulation must have intact and smooth surface in a round form without damage, groove or recessed surface.
		
The end of the wire shall be straight without bend and disorder after it passed through the rubber plug. The bent wire shall be checked out.	The flanges of the rubber plug shall be free from cut and damage. Any plug having such defects shall be discarded, and replaced with new part.	Installation of rubber plug shall be done straight and evenly. If flanges are in tilt condition, the plug must be corrected so that flanges are perpendicular to contact axis.

FIGURE 7

5.1. After crimping, that part of the insulation of the cable that is inside the seal shall be in good condition and still be within the parameters shown in Figure 6. Check by visual inspection in the transition area (between wire and insulation barrel), as indicated in Figure 8.

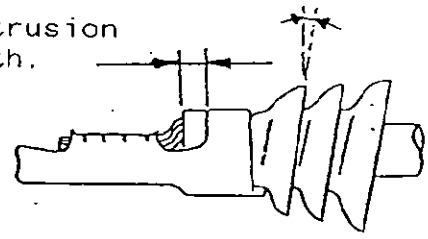
After crimping, the rubber seal must protrude from the insulation crimp without damage, but there must be no evidence of insulation or rubber in the wire crimp.



Check to see if the insulation is in the correct position.

8° Max.

Rubber plug protrusion 0.5mm Min. length.



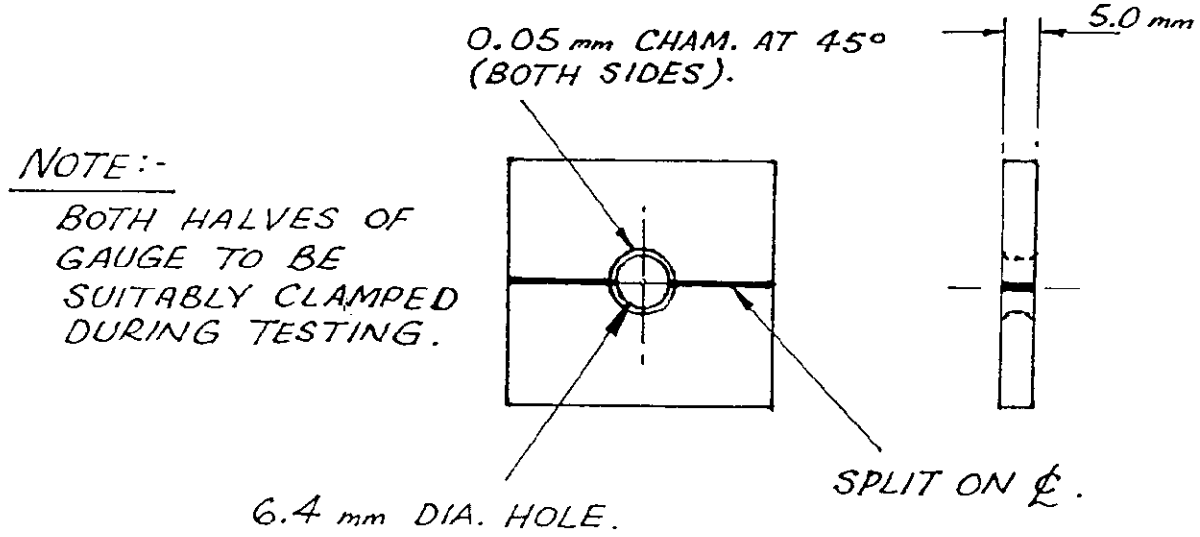
Rubber plug shall be inserted evenly not being in tilt condition.

FIGURE 8

5.2 Crimped contacts should appear as illustrated in Clause 1.1. (Nomenclature).

5.3 Retention of seals, by insulation crimp

USE GAUGE SHOWN BELOW



Pass crimped tab or receptacle through the hole, so that seal stops against face of gauge. (The gauge is to be suitably split to facilitate this).

Then pull on the contact, straight and steadily, and measure the force to either,

(a) Pull the seal through the hole without damage.

(b) Wholly or partially dislodge the seal from the insulation crimp.

(c) Tear seal.

This should not take place at a force of less than 10 Newtons, (this value is tentative - and a statistically based test is to be done).

NOTE: This test is destructive.

6.0 For overlap crimping of tabs and receptacles see crimp inspection sheet G.B. 3005 for additional information, but only refer to that part of this sheet that concerns single cable. The insulation crimp form for double cable shall be "F" crimp (cables side by side).

7.0 APPLICABLE CABLES AND TENSILE STRENGTH

WIRE SIZE MM^2 (NOMINAL)	DIA. OF INSULATION MM	TENSILE (NEWTONS)
0,5	1,6 TO 1,8	65 MIN.
0,75	1,9 MAX.	85 MIN.
1,0	2,1 MAX.	105 MIN.
1,5	2,4 MAX.	160 MIN.
2,0	2,7 MAX.	160 MIN.
2,5	3,1 MAX.	220 MIN.
3,0	3,4 MAX.	220 MIN.

The cables used must be thin walled non-irradiated PVC cables as specified in BLS.62.21.688 Issue 1.

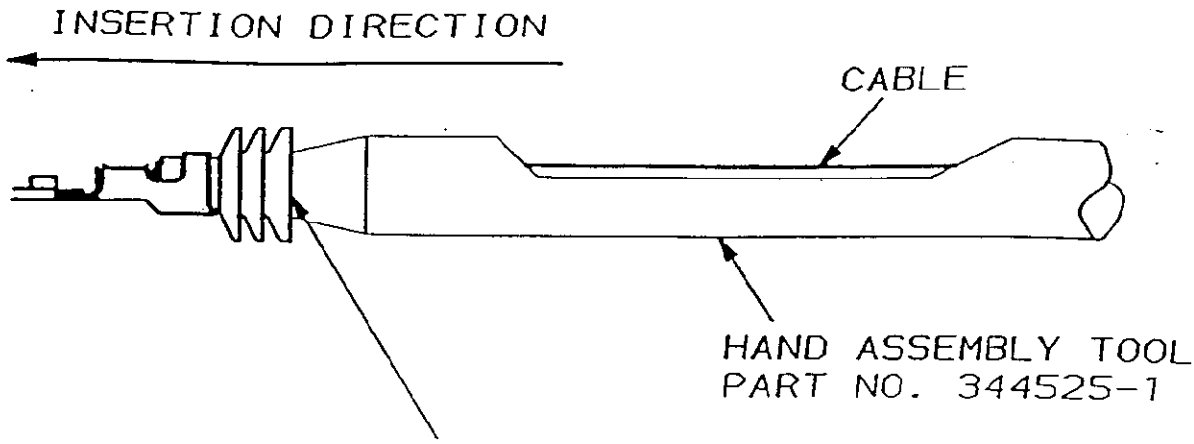
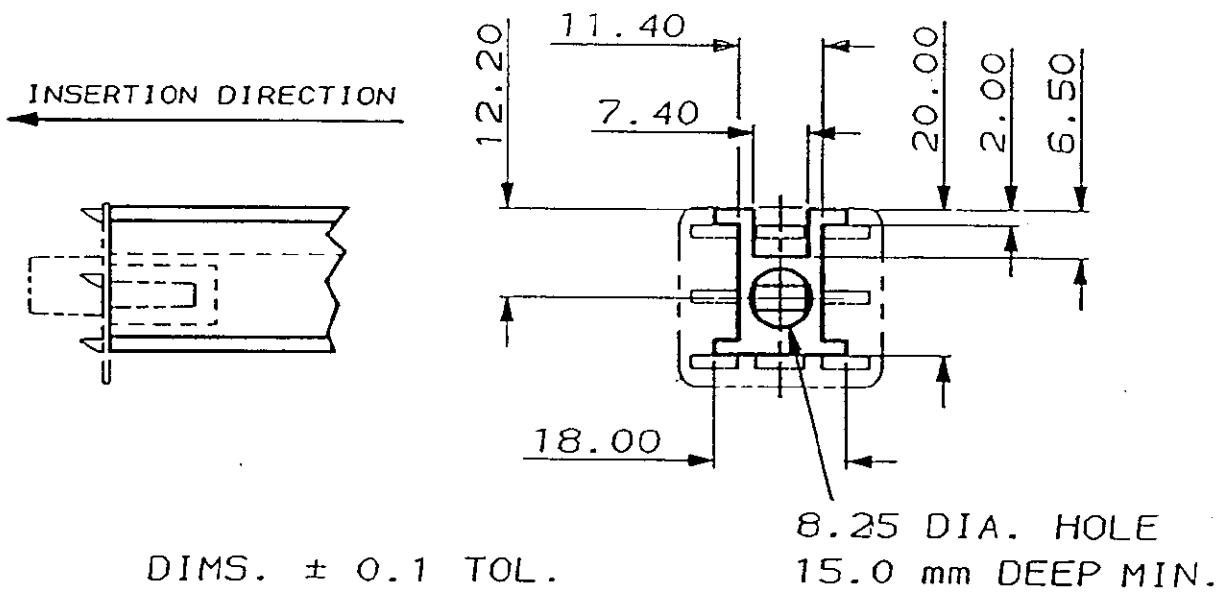
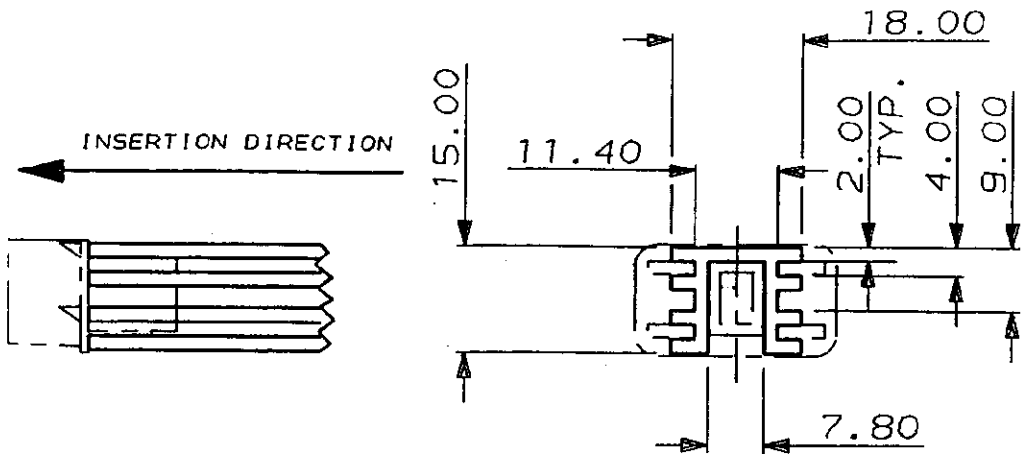


FIGURE 9



SUGGESTED SHAPE AND SIZE OF 8 WAY
TAB HSG. ANTI-BACKOUT INSERTION TOOL

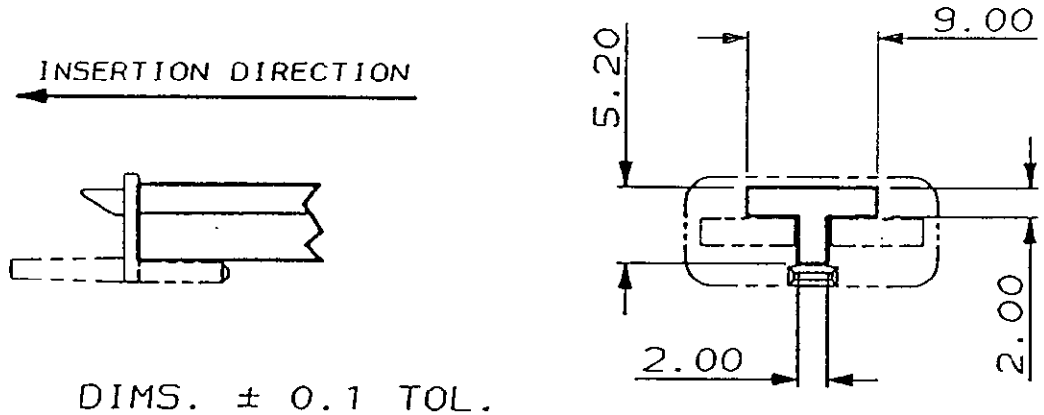
FIGURE 10



DIMS. ± 0.1 TOL.

SUGGESTED SHAPE AND SIZE OF 4 WAY TAB HSG. ANTI-BACKOUT INSERTION TOOL

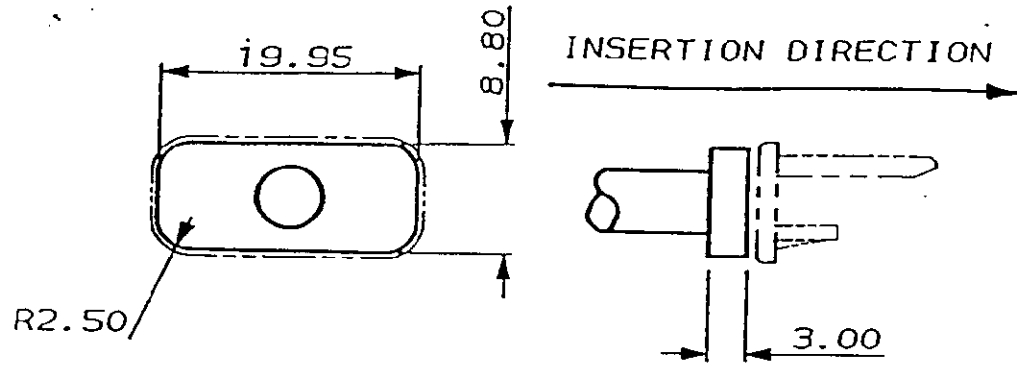
FIGURE 10 A



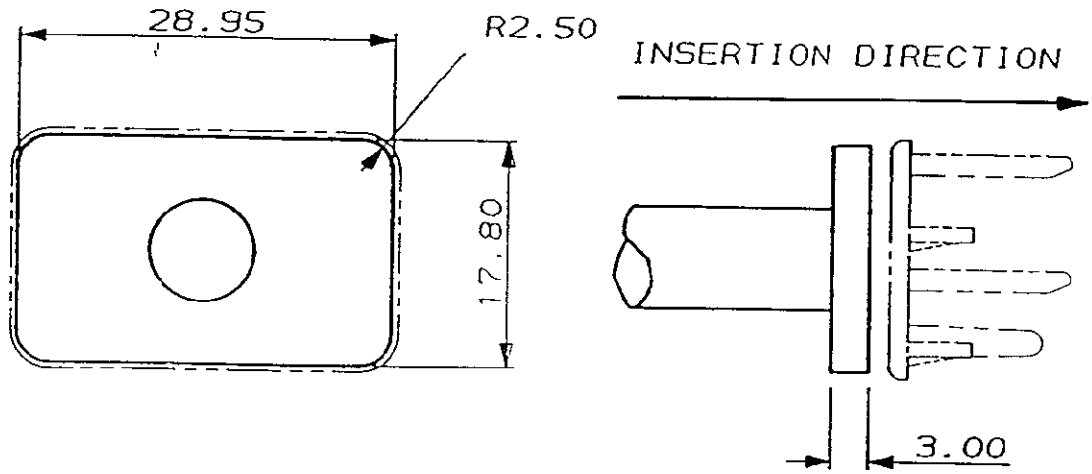
DIMS. ± 0.1 TOL.

SUGGESTED SHAPE AND SIZE OF 2 WAY TAB HSG. ANTI-BACKOUT INSERTION TOOL

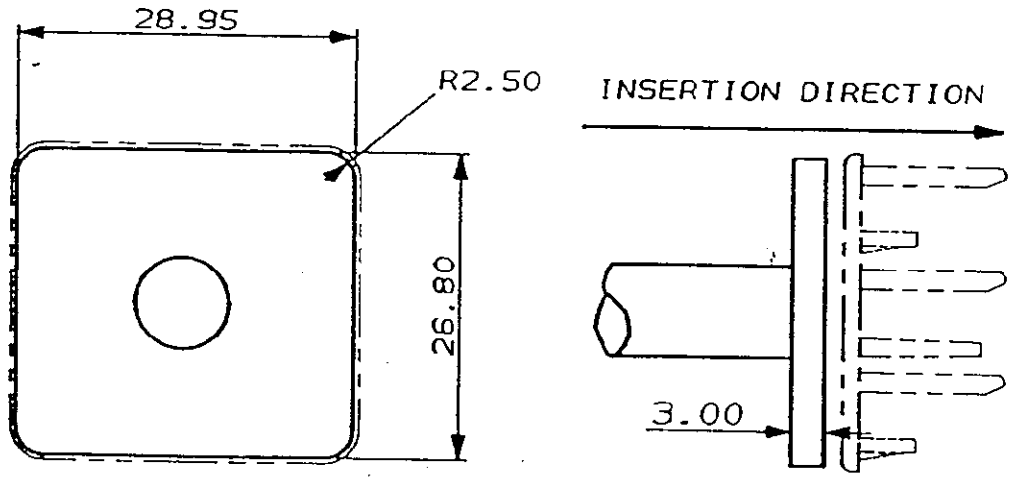
FIGURE 10 B



SUGGESTED SHAPE AND SIZE OF 2 WAY REC. HSG. A/BACKOUT INSERTION TOOL. FIGURE 11

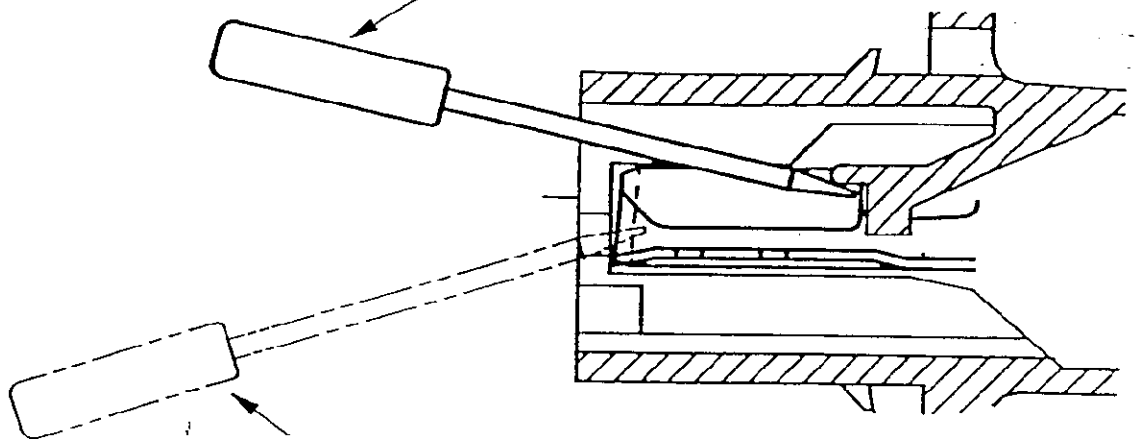


SUGGESTED SHAPE AND SIZE OF 4 WAY REC. HSG. A/BACKOUT INSERTION TOOL. FIGURE 11A



SUGGESTED SHAPE AND SIZE OF 8 WAY REC. HSG. A/BACKOUT INSERTION TOOL. FIGURE 11B

INSERT TOOL ABOVE SCROLLS TO LIFT RESIN LANCE

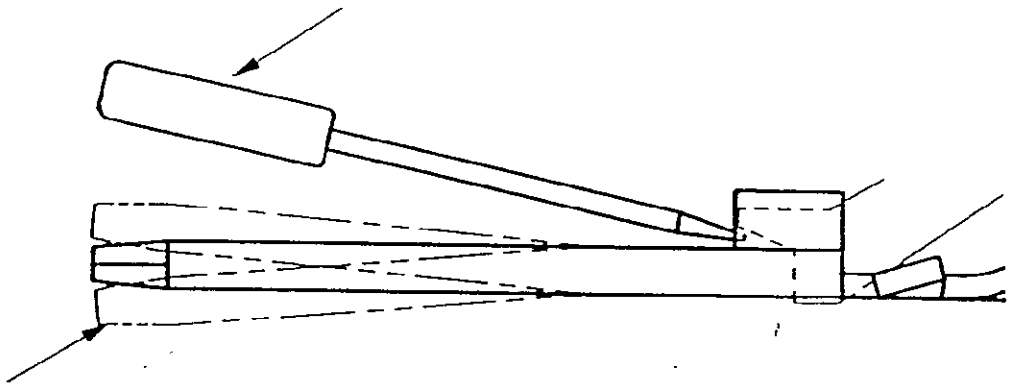


DO NOT INSERT TOOL INTO CLIP GAP

CARE MUST BE TAKEN, WHEN LIFTING LANCE, NOT TO DAMAGE THE RECEPTACLE SCROLLS.

FIGURE 12

INSERT TOOL UNDER RESIN LANCE TO LIFT



CARE MUST BE TAKEN, WHEN LIFTING LANCE, NOT TO DEFORM THE TAB.

FIGURE 12A

Application of Attaching Jig

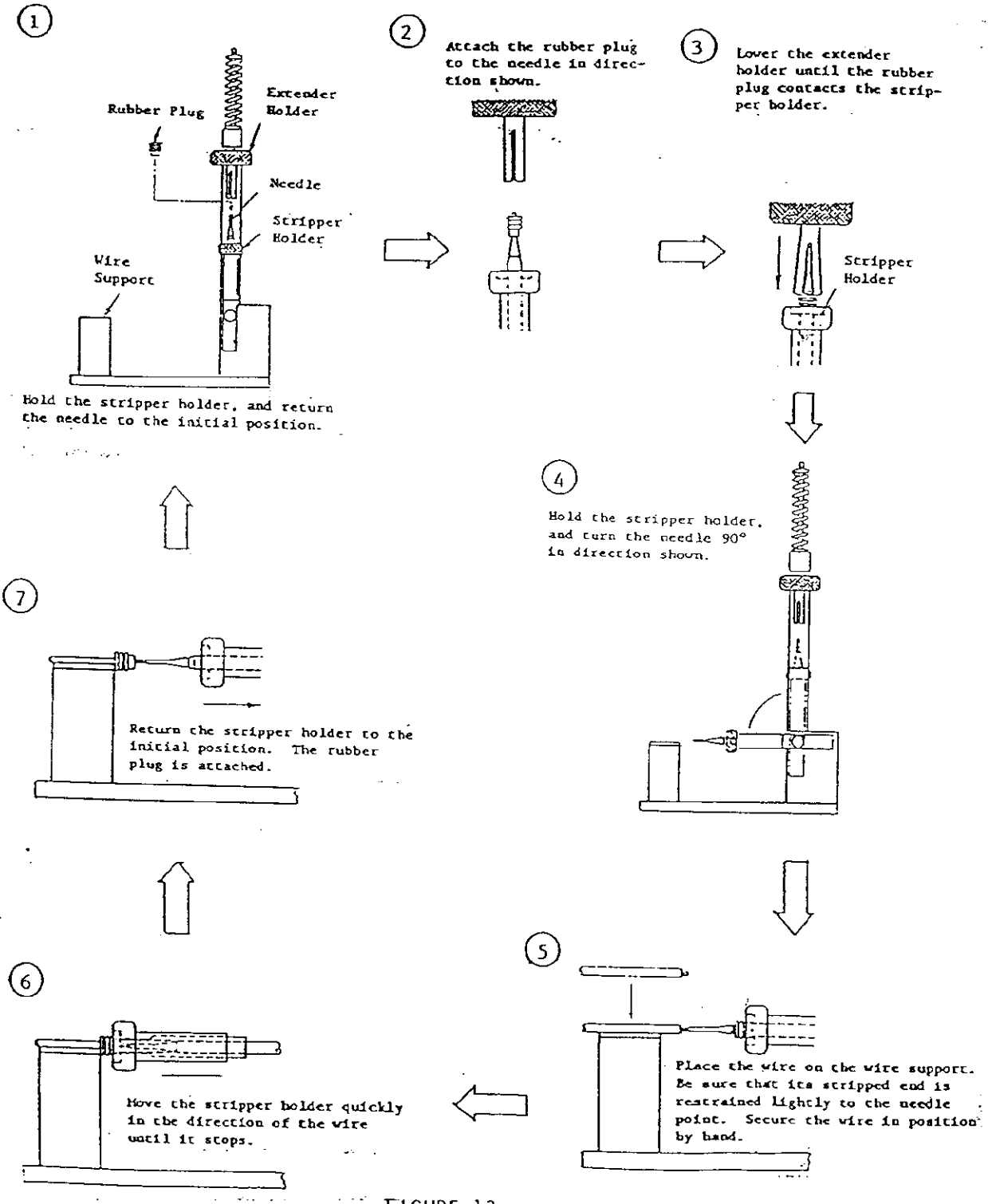


FIGURE 13

AMP of Great Britain Ltd TERMINAL HOUSE, STANMORE, MIDDLESEX	LOC E	SHEET 22 OF 22	NO 114-3036	REV D