





Figure 1

1. INTRODUCTION

This instruction sheet provides information on the assembly and disassembly procedures for the 13P MCON Unsealed Plug as shown in Figure 1.

i NOTE

All dimensions on this document are in metric units. Figures and illustrations are for reference only and are not drawn to scale.

Read these instructions carefully before attempting any assembly procedures. Also, refer to Application Specification 114-18464 for termination requirements.

2. DESCRIPTION

Figure 1 provides the components required to make the assembly in this instruction sheet. Contact material is made from a copper alloy, pre-plated with tin or gold. The connector components are made from glass-filled plastic materials.

3. ASSEMBLY PROCEDURES

3.1. Tooling

Refer to Application Specification 114-18464 for specific manual and semi-automatic termination tooling for the 1.2 mm receptacle.

3.2. Contact Assembly

The following procedures provide the details of the contact installation into the connector housing.

1. Terminate the contacts to the correct wire size according to the information provided in the specific application specifications.



NOTE

The connector assemblies are shipped with the ISL in a pre-set position, however, during shipping, the ISL may become seated. Make sure the ISL is in the pre-set position before any contacts can be inserted into those contact cavities. See Figure 2.

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Figure 2

2. The terminated contact must be aligned with the contact cavity at the wire end of the connector and oriented as shown. The contact orientation feature faces toward the ISL. See Figure 3. Terminals will only easily go into cavity in one orientation.



Figure 3



NOTE

Contacts crimped to 1.0-1.5 mm² wire should only be inserted into contact cavity 10.

3. Each contact must be inserted into a contact cavity until the insulation barrel is within the contact cavity and the connector terminal latch engages behind the contact orientation feature. See Figure 4A. (There should be an audible and tactile click which indicates that the contact has been fully inserted.) Pull back gently to endure the contact has been locked in place. See Figure 4B.





4. The ISL must be inserted to the seated position. The ISL is in the seated position when the ISL press pad is flush to the body of the plug housing. The ISL is the detection for partially installed terminals. If resistance is felt when seating the ISL, reset the ISL to the pre-set position and push/pull on the wire of each contact to ensure they are fully inserted and engaged with the primary contact latch in each cavity.

3.3. Circuit Testing

NOTE

On the plug housing, test probe windows are located at each cavity on the mating face, to accommodate test probes for circuit testing. Individual test probes, or equivalent, must have a maximum width/diameter of 0.6 mm. The force exerted by the probe should be no more than 10 N [2.25 lb] per contact cavity. Test probe location layout is shown in Figure 5.



The test probe should not enter into the terminal mating area.





CAUTION

Figure 5

Pointed or sharp instruments MUST NOT be used for probing; otherwise, damage to the socket connector could result. To avoid system failure, the wire insulation MUST NOT be pierced.

3.4. Contact Removal

The ISL must be in the pre-set position before any contacts can be removed. To open the ISL, insert a small jeweler's screwdriver (with maximum width of 4.0 mm [.157 in.]) between the ISL and plug housing to move the ISL to the pre-set position.



CAUTION

Care must be taken not to damage the ISL with the tool.

The terminal latch must be deflected before the contact can be removed from the connector. The suggested extraction tool is TE tool (p/n 8-1579008-4). The extraction tool must be inserted into the corresponding contact removal window to release the primary contact latch, and the wire must be pulled gently to remove the contact from the connector.

- 1. Insert a suitable tool (as described in Paragraph 3.4) into the tapered slot on the inside of the ISL push pad as shown in Figure 6.
- 2. Gently pry away from the plug housing to move the ISL to a pre-set position.







3. Insert contact extraction tool into the selected exposed contact cavity, as shown in Figure 7.



Figure 7

- 4. Grasp the wire of the contact to be removed and push the contact forward until it stops.
- 5. Simultaneously pull the wire and contact from the plug housing.
- 6. Follow Steps 1 through 4 for remaining contacts.

4. REPAIR/REPLACEMENT



CAUTION

These contacts and connectors are non-repairable. Damaged or defective contacts or connectors MUST NOT be used. A contact MUST NOT be re-terminated.

5. REVISION SUMMARY

• Initial release of document