

Figure 1

1. INTRODUCTION

This instruction sheet provides assembly and disassembly procedures for the AMP* Category 1, Automotive, 3-Position, Hinged, Plug Connector Assembly shown in Figure 1.

NOTE

All dimensions are in millimeters.

2. DESCRIPTION

The plug assemblies are shipped as one piece, with the Terminal Position Assurance (TPA) cover plate in the open position. The assembly consists of a one-piece plug housing with the TPA cover plate molded integrally to the housing.

Contacts are available in strip form only. AMP Manual Applicator 680124-2 crimps 18 to 20 AWG contacts. Use Applicator 680125-2 for 22 AWG contacts. AMP Hand Tool 58587-1 is intended for crimping limited prototyping contacts and not production quantities.

3. ASSEMBLY PROCEDURES

Check to be sure the TPA cover plate is in the open, or as-shipped, position (see Figure 1). If the TPA cover plate is closed, see Section 4 (Steps 1 and 2 only). Proceed as follows:

1. Insert a terminated contact by pushing it straight into the appropriate circuit cavity as far as it will go. See Figure 2.
2. Pull back lightly on the wire and contact to ensure the retention finger is holding the contact.

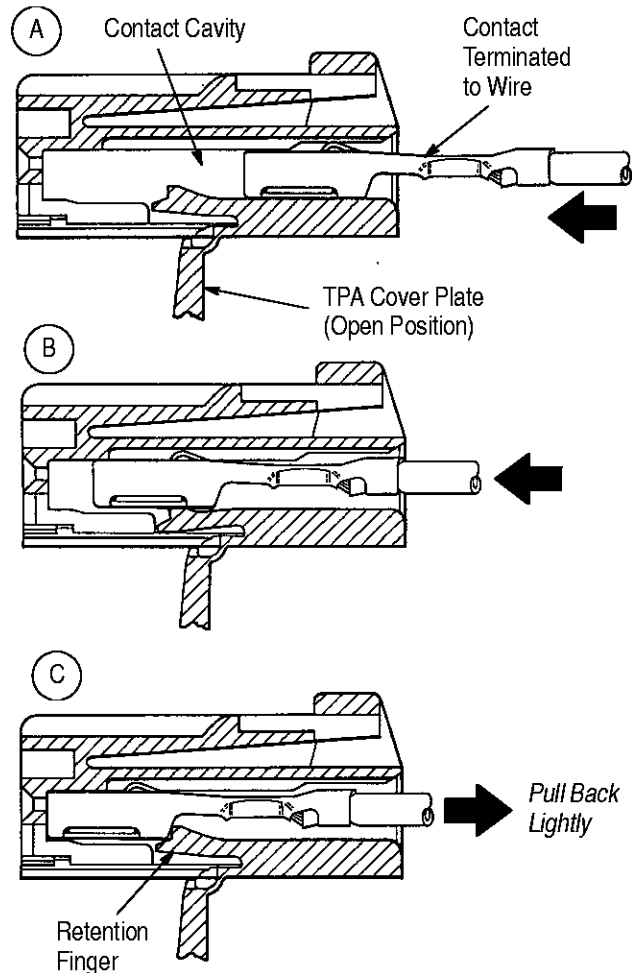


Figure 2

3. After all required contacts have been inserted, the TPA cover plate must be closed (see Figure 3). To close the TPA cover plate, push evenly across the outer surface and rotate the hinged cover plate until an audible snap is heard. The TPA cover plate should be flush with the connector body.

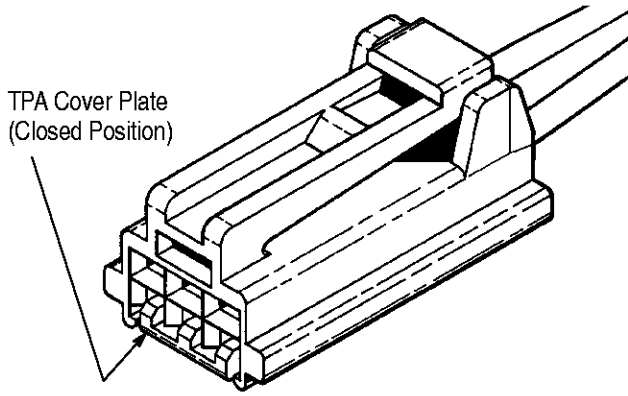


Figure 3

4. DISASSEMBLY PROCEDURES (Contact Removal)

Before removing contacts from the plug housing, the TPA cover plate must be in the open position. To move the TPA cover plate into the open position and remove contacts, proceed as follows:

1. Insert a 1 mm flat-blade screwdriver between the TPA cover plate and the mating face of the connector as shown in Figure 4.
2. Rotate the screwdriver until the entire front edge of the blade pushes the TPA cover plate away from the connector body.

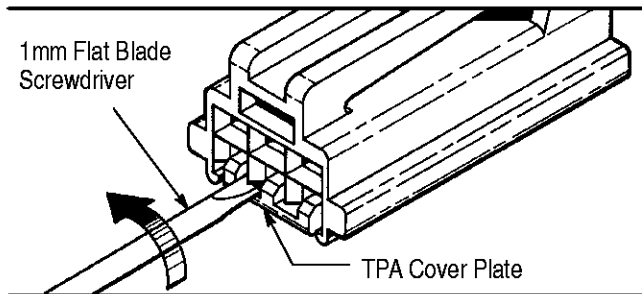


Figure 4

3. Rotate the TPA cover plate into the open position. See Figure 5.

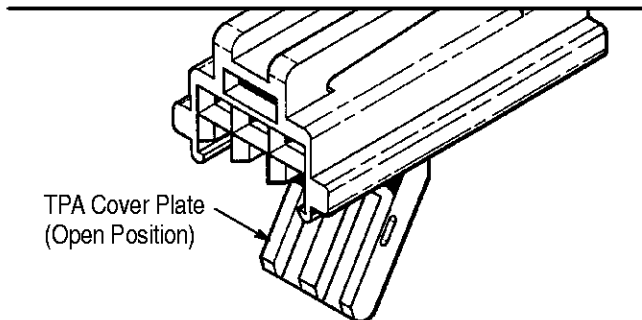


Figure 5

NOTE The TPA cover plate must be in the open position before removing contacts.

4. Insert a 1 mm flat-blade screwdriver into the selected exposed contact cavity, as shown in Figure 6A.
5. Grasp the wire of the contact to be removed and push the contact forward until it stops.
6. Using the 1 mm screwdriver, gently deflect retention finger (Figure 6B). Simultaneously pull wire and contact from the housing (Figure 6C).

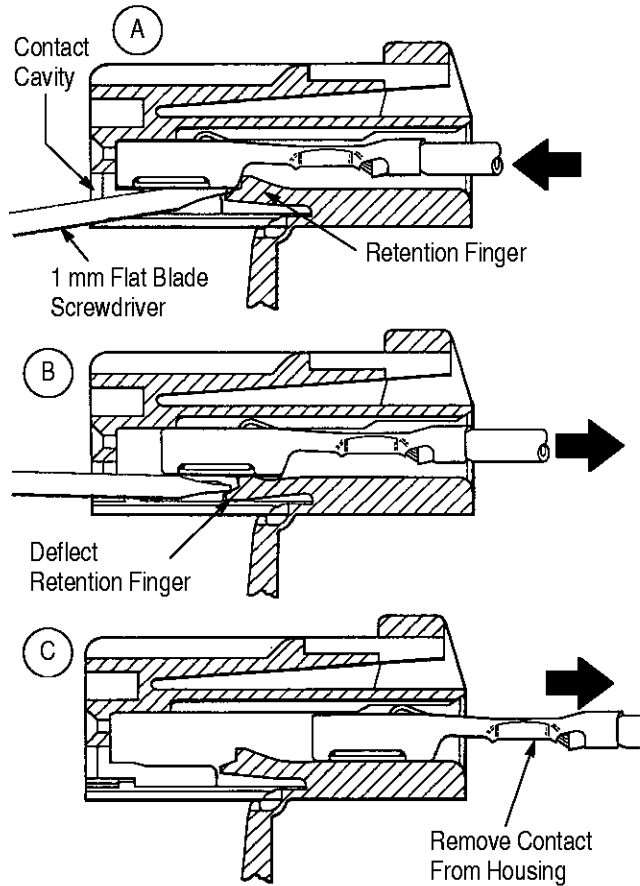


Figure 6

7. Follow steps 4 through 6 for remaining contacts.

NOTE To re-assemble the plug assembly, the TPA cover plate must be in the open position before insertion of terminated contacts.

5. ADDITIONAL INFORMATION

For information on contact crimping, refer to the instructions packaged with the tooling. For inspection information on crimped contacts, refer to Application Specification 114-6063.

6. REVISION SUMMARY

Per EC 0990-0399-99

- Initial release of instruction sheet