



110 4P and 5P Plug Assy

# Instruction Sheet

## 1. PART NUMBER AND PART NAME

- 1.1 Housing
- 1.2 Contact
- 1.3 Component View

## 2. CUSTOMER RECEIVING INSPECTION

## 3. STORAGE AND CARRY

- 3.1 Contact
- 3.2 Housing

## 4. CRIMPING OPERATION

- 4.1 Wire
- 4.2 Crimping Specification
- 4.3 Storage and Handling of Crimping Products

## 5. HARNESS ASSEMBLY

- 5.1 Insertion of the Contact insertion
- 5.2 TPA Final Lock (Secondary Lock)
- 5.3 TPA unlock
- 5.4 Instruction of the Contact extraction
- 5.5 Wire Harness Control

## 6. CONNECTOR MATING AND UNMATING

- 6.1 Connector Mating
- 6.2 Connector Unmating

## 7. SPECIFICATION APPROVAL

# PRELIMINARY

1. PART NUMBER AND PART NAME

1.1 Housing

Part Number	Part Name
2337612-2	JPT 110 4P PLUG INNER HSG
2337613-2	JPT 110 4P PLUG OTTER HSG
2337614-1	JPT 110 4P PLUG DBL HSG
2337620-2, 1-2337620-3	JPT 110 5P PLUG INNER HSG
2337621-2	JPT 110 5P PLUG OTTER HSG
7337622-1	JPT 110 5P PLUG DBL HSG

Fig. 1

1.2 Contact

1.2.1 REC. Contact

Part Number	Part Name	Applicable Wire Range
1241868-1	. 110 PRE-TIN	0.5 ~ 1.0 mm <sup>2</sup>
1241872-1		1.0 ~ 2.5 mm <sup>2</sup>
1241868-6	. 110 SILVER	0.5 ~ 1.0 mm <sup>2</sup>
1241872-6		1.0 ~ 2.5 mm <sup>2</sup>
2-964282-1	. 110 GOLD	0.2 ~ 0.5 mm <sup>2</sup>
2-964286-1		0.5 ~ 1.0 mm <sup>2</sup>
2-964273-1		1.0 ~ 2.5 mm <sup>2</sup>

Fig. 2

1.3 Component View



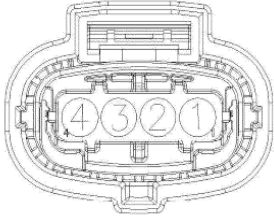
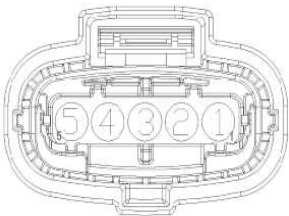
DESCRIPTOIN	PLUG ASSY(4P)	PLUG ASSY(5P)
P/NO	2337611-2	2337619-2
IMAGE		
SIMBOL		

Fig. 3

## 2. CUSTOMER RECEIVING INSPECTION

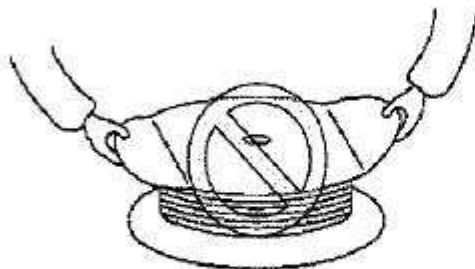
Tyco conducts inspection according to their quality control regulations to maintain an over all lot control. In addition, the customers should conduct receiving inspections based on the specific customer drawings.

## 3. STORAGE AND CARRY

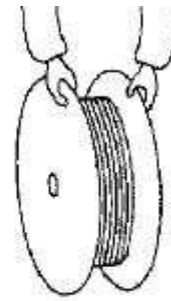
### 3.1 Contact

(1) Avoid receiving or carrying the contact reel in an open area without wrapping it in proper material.

(2) Do not lift up and carry the contact reel by gripping one the side of the reel, this may result in damage to the reel and contacts before use.



Do not lift up laterally holding one side only.



Acceptable

Fig. 4

(3) Avoid storing the contact reel in a moist or dusty place. Stock the reel in a comparatively dry and clean place (5~34 °C, 45~85%RH) away from direct sunlight.

(4) When removing the contact reel from the machine, fasten the end of the contact strip onto the edge of the reel with use of proper string or wire. Fig.5

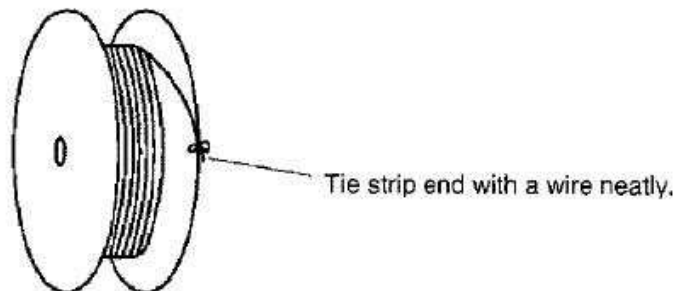


Fig. 5

3.2 Housing

- (1) Avoid storing the contact reel in a moist or dusty place. Stock the reel in a comparatively dry and clean place (5~35 °C, 45~85RH) away from direct sunlight.
- (2) Avoid leaving or carrying the housing in an open area without wrapping it in proper material.
- (3) Do not drop or shock the housing when carrying it.

4. CRIMPING OPERATION

4.1 Wire

4.1.1 Applicable Wire. See Fig.6 for applicable wire.

4.1.2 Notes FOR Stripping Wire End  
Wire end must be stripped without cut or damage of wire strands.

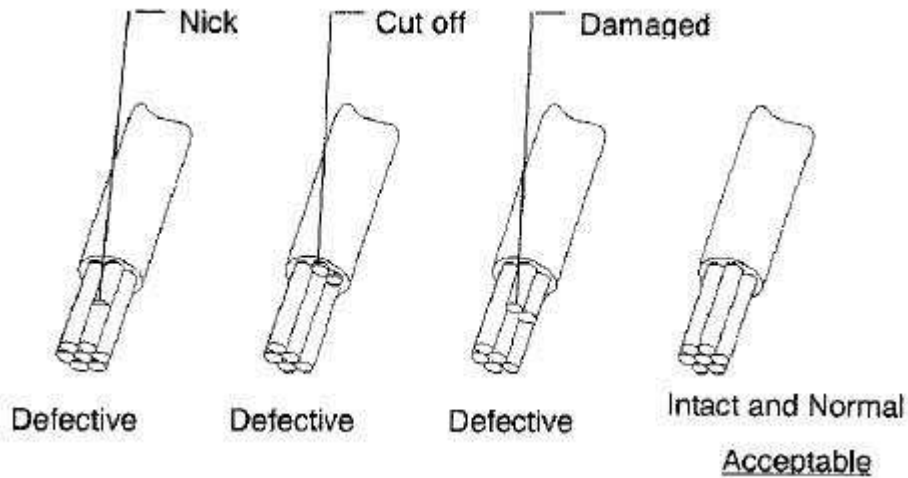


Fig. 6

- 4.2 Crimping Specification  
See following Application Specification for each contact

REC.	110	114-18050
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- 4.3 Storage and Handling of Crimping Products

- (1) Store the products in a clean, dry area cover with proper sheet or paper when placed in an open area until the next day.
- (2) Care should be taken for tangle and deform of contacts in case of the leads should be in bands.
- (3) Do not stack the product so many layers. It makes electrical connection defective and low contact retention force by catch together or by deform causing the weight of themselves.
- (4) Must no hit tip of the contacts to coordinate the bundle. It makes mating or electrical defective.

## 5. HARNESS ASSEMBLY

- 5.1 Instruction of the Contact insertion

- (1) Check TPA is in pre-lock condition as shown in Fig.7. The contact cannot be inserted in case of the final lock condition so do it again after rework.

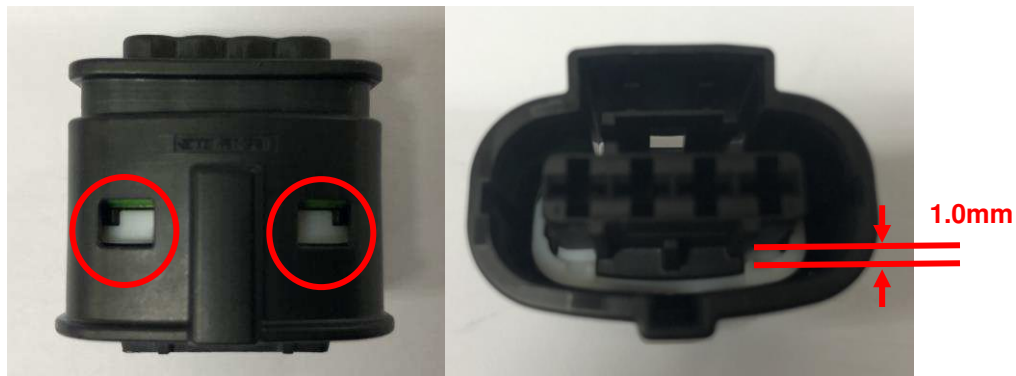


Fig. 7

**NOTE:** TPA and HSG have 1.0mm gap in pre-lock condition.

### 5.2 TPA Final Lock (Secondary Lock)

(1) After all cavities are filled by Contacts properly, insert TPA into Housing to deep end and complete Final Lock condition as shown in Fig.8. Operation is completed when contact is latched and the insertion is stopped.

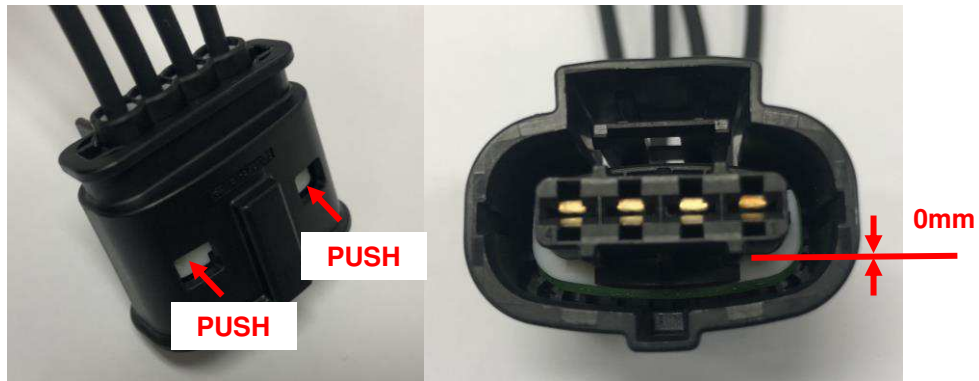


Fig. 8

**NOTE:** Push both side of TPA to lock final-status. The gap is to be 0mm flash with TPA and HSG. Check the gap is 0mm flash.

(2) When TPA can not be inserted or only one side is inserted or it happened the gap between TPA and HSG, do not operate with force and must find half insertion contact. In case of those, extract TPA from HSG and complete inserting the contact in correct position.

### 5.3 TPA unlock

TPA must be Pre-Lock status before Female TML extraction (See Fig.7)  
Instruction of TPA unlock, refer Fig.9

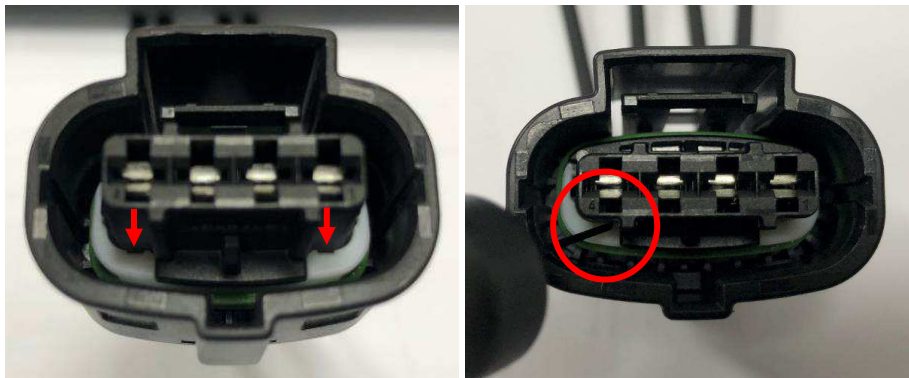


Fig. 9

5.4 Instruction of the Contact extraction

(1) Check the TPA status(Pre-Lock). If TPA is Final Lock status, It should be Pre-Lock status (See Par.5.1.). The contact can't be extracted in Final Lock status.

(2) Extract the TML with pulling the crimped wire whild pressing latch slightly using Extraction Tool. (see Fig.10)

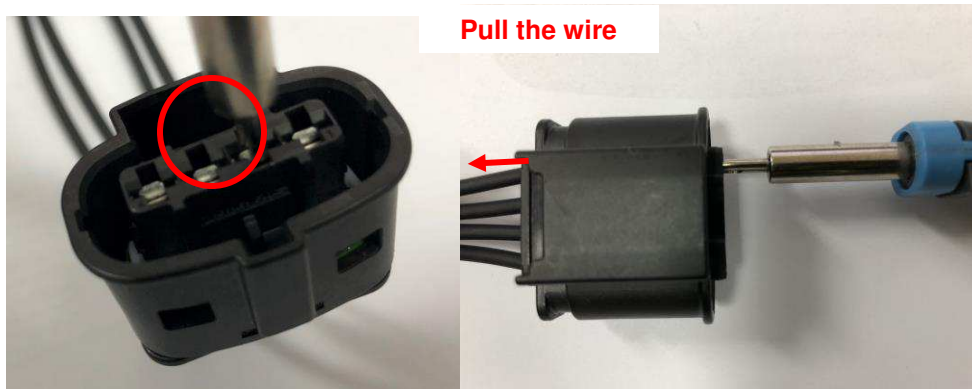



Fig. 10

**Note:** Do not insert the tool or screw driver into inside of the female contact.

Terminal	Extraction tool p/n	비고
110 (JPT)	1-1579007-6	 1-1579007-6

5.5 Wire Harness Control

5.5.1 Handling

Do not apply too much force or shock against connector or harness.

5.5.2 Wire tie up and taping

Wires are tied up at apart from 30mm more from the end of connector. The operation be conducted carefully so that too much force is applied against the wires.



### 5.5.3 Conductivity Check

- (1) Use applicable mating connector or equivalent for conductivity check jig. Confirm Lever is in final lock condition.
- (2) Check probe pin must not be inserted inside of female contact.

**NOTE:** Contact must be replaced in case of the prove pin insertion.

### 5.5.4 Storage

Store the product dry and clean area. In addition, do not leave the product with exposed condition.

### 5.13.5 Shipping and Carrying

Use Proper package which can prevent product from dust, rain, and etc. And handle carefully.

## 6.CONNECTOR MATING AND UNMATING OPERATION

### 6.1 Connector Mating

- (1) Check contact latching condition, proper wire tie up position, and TPA is in final lock condition. TPA must be adjusted to final condition if it is in initial lock condition.
- (2) In the next step, check no contact has deformation, discolor, damage, rust and housing has no deformation, crack breakage, and discolor.

**NOTE:** In case of any trouble is found, replace it to new one.

### 6.2 Connector Unmating.

- (1) Release Lever lock and keep OPEN position.
- (2) Release female housing from Unit.





**7. SPECIFICATION APPROVAL**

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