

HYBRID I/O CONNECTOR

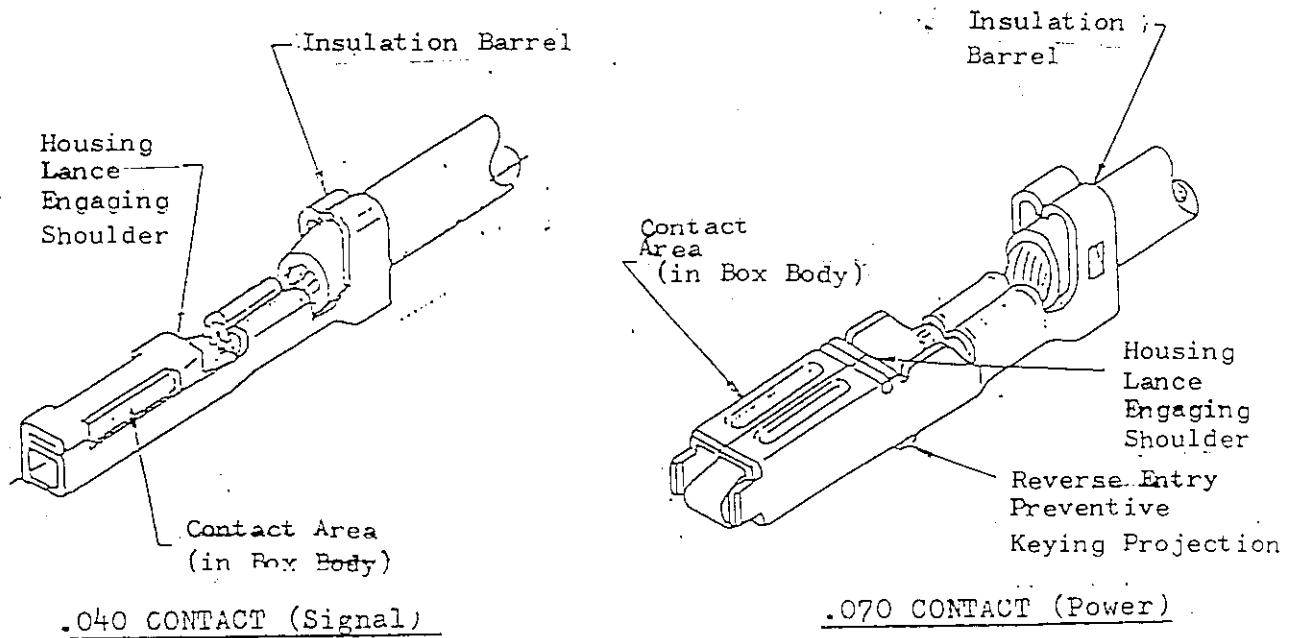
Customer Manual

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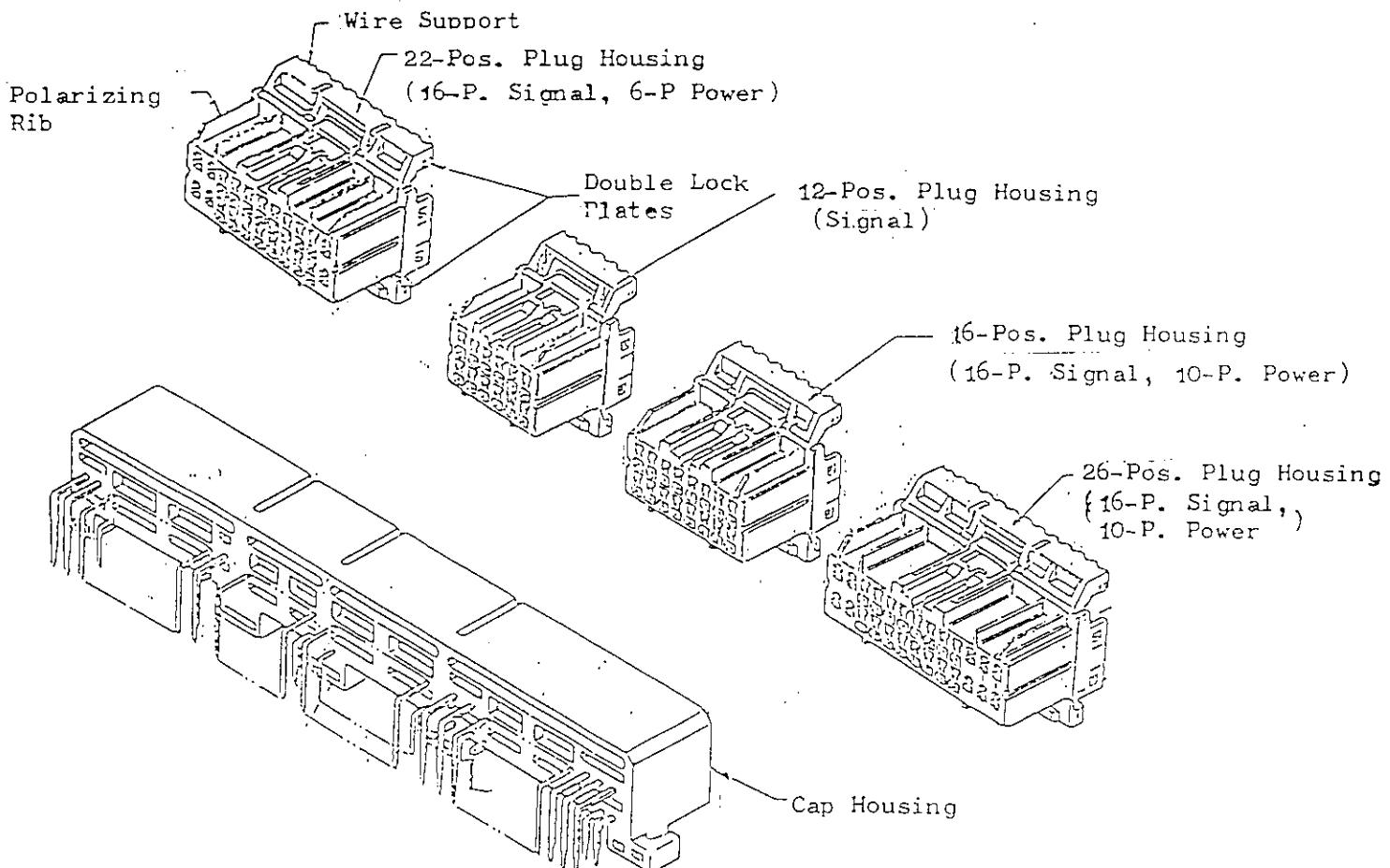
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1. PRODUCT NAMES AND PART NUMBER

1.1 Contact



1.2 Housing



2.2 Customer Receiving Inspection

In addition, the customers should conduct at least the following receiving inspections based on the specific customer drawings.

(Terminal)

Item	Inspection Description & Methods	Measuring Methods
Appearance Inspection	1) Shape	Visual inspection
	2) Plated condition	Visual inspection
	3) Reeled condition	Visual inspection
Dimension Inspection	1) Wire barrel width and height	Vernier Calipers
	2) Insulation barrel width & height	Vernier Calipers
	3) Locking lever height	Vernier Calipers

When reels are delivered, each reel is classified by date code and inspected visually for AQL 4% based on Level II (MIL-STD-105) standards, including additional inspection of 5 contacts on reel ends. The lot may be accepted if all reels successfully pass the inspection.

(Housing)

Item	Inspection Description & Methods	Measuring Methods
Visual Inspection	1) Burrs, discoloring & deformation	Visual inspection
	2) Cracks, fissure, or chipping	Visual inspection
Functional Inspection	1) Mating/Unmating: Corresponding tabs fit into each other to allow them to lock. The unlocking leg can be smoothly pulled out while being depressed.	By hand

Each package is classified by date code and inspected for appearance for AQL 40% based on Level II (MIL-STD-105) standards, and then inspected for the functions of 5 pieces in each package. The lot may be accepted if all of them successfully pass the inspection.

3. CRIMPING OPERATION

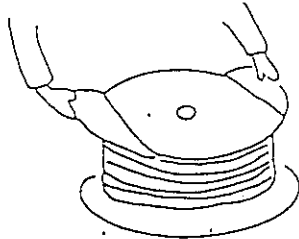
Any crimping of contacts must be performed by using appropriate AMP tools according to the applicable Instruction Sheet and Specification.

The part numbers and date code (such as the above example, 89402) should be recorded for future reference.

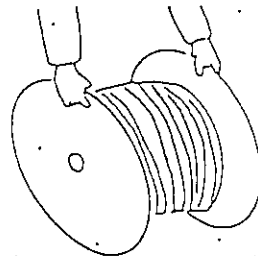
3.1 Storage and Handling

- 1) Avoid carrying unpacked products. Carry and store products in the containers.
- 2) Carrying reels by only one of flanges can damage the reel and makes it unusable, or unloadable onto crimping machines. Be sure to carry a reel by holding both flanges as shown below.

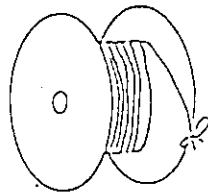
Never carry reels horizontally holding only one flange



Recommended method



- 3) Do not place reels in places with high humidity. Reels should be stored in a relatively dry, clean room where they will not be exposed to direct sunlight, and maintained at normal temperature and humidity. (5 to 35°C and 45 to 85% relative humidity)
- 4) If reels are temporarily taken off the crimping machine when suspending operation, tie the reel end to the flange with string to prevent the reel from loosening.



Tie reel ends to prevent them from loosening.

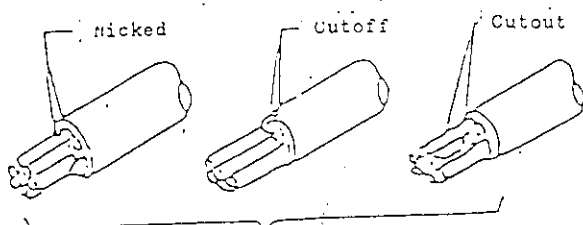
3.2 Crimping Procedure Control

An instruction manual for the crimping procedure control should be prepared referring to the following documents:

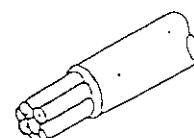
	.040 series	.070 series
Service Tool Instruction Sheet	IS-288	IS-287
Application Specification	114-5094	114-5091
Automatic Machine Customer Manual	CM-022J	
Applicator instruction	AI-8025	

Take the following precautions.

- (1) When stripping the wire, care must be taken not to nick, cut or scrape the conductors.

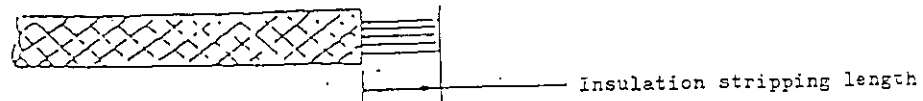


Rejectable



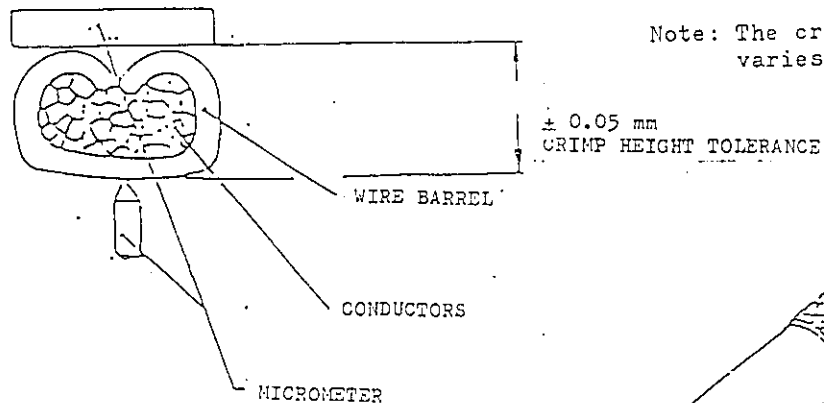
Acceptable

(2) Wire insulation stripping length

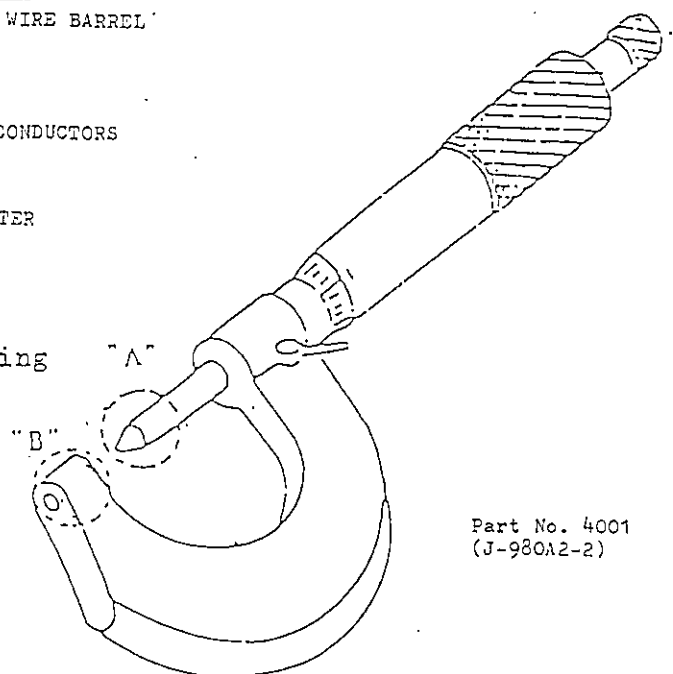


The length of the wire barrel of the contact used + 0.5 to 1.0mm is applicable.

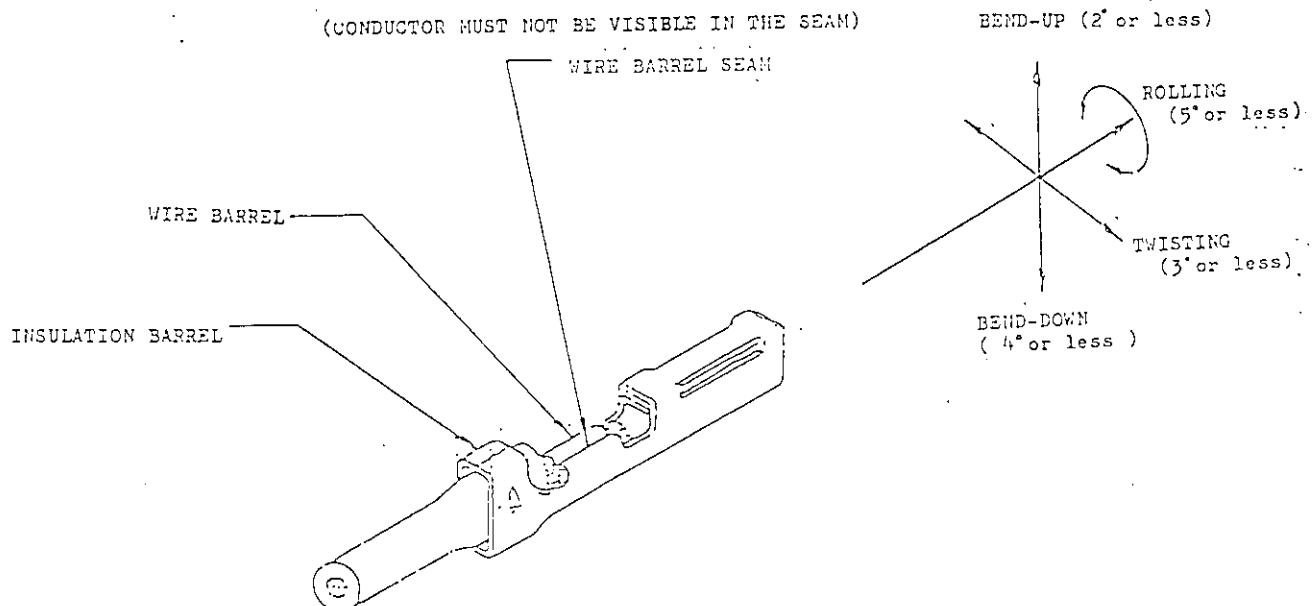
(3) Crimp cross-sectional diagram

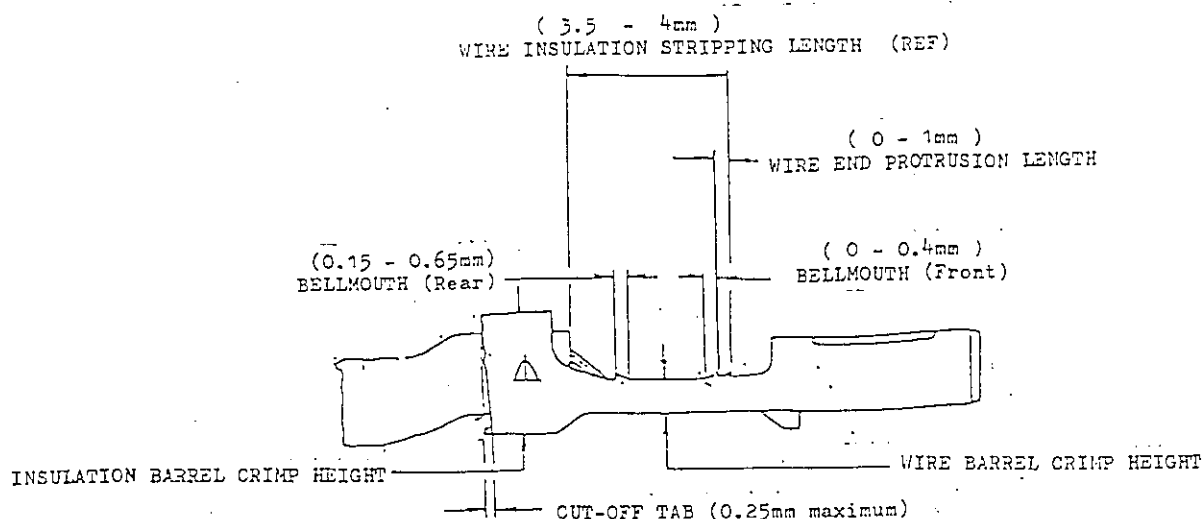


(4) Micrometer (for measuring the crimp height)



3.2.1 Inspection of Wire-Crimped Contact
(Refer to Crimping Specification on .040 and .070 series contacts for details)





3.2.2 Crimping Data

Applicator numbers and dimensions are listed below.
Be sure to refer to the following table before starting the operation.

.040 series Receptacle

Contact P/N (Strip form)	Wire Type (Nominal)	Applicator Part No.	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (kg)
			width (mm)	Height ± 0.05 mm (Fig. 1 ⑧)	Disk	Width (mm)	Height (mm) (Fig. 1 ⑨)	Disk (Ref.)	
173681 173716	0.3	755830 -2	1.57 F	0.92	B	1.78	3.7 $\pm$ 0.1	4	6 Minimum
	0.5			1.02	A			5	9 minimum

Note: 1 Crimp tensile strength includes the strength with the support of the insulation.

.070 series Receptacle

Contact P/N (Strip form)	Wire Type (Nominal)	Applicator Part No.	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (kg)
			width (mm)	Height ± 0.05 mm (Fig. 1 ⑨)	Disk	Width (mm)	Height (mm) (Fig. 1 ⑩)	Disk (Ref.)	
173630	0.2	1-755758 -2	1.78 F	0.96	D	2 S	3.8 $\pm$ 0.1	2	7 Minimum (Note 1)
	0.3			1.03	C			3	8 Minimum (Note 1)
173631	0.5	755769 -2	2.29 F	1.25	C	2.6 F	3.8 $\pm$ 0.1	3	9 Minimum
	0.85			1.37	B			4	13 Minimum
	1.25			1.52	A			5	18 Minimum

3.3 Crimped Lead Inspection Prior to Harness Assembly

3.3.1 Inspection

We recommend that crimped products be inspected under the same conditions observing the following tables. Each product is an inspection unit. That is, either products successively manufactured during one adjustment cycle of a crimping machine, or products manufactured within one working day are assumed to be one lot.

Type of Inspection	Timing	Inspection Item
First-sight Inspection	When applicator is set up for a specific wire for the first time.	Appearance and dimensions inspection (All items described below)
Lot Inspection	When daily operation starts.	Same as above
	Any time during successive manufacturing processing.	Appearance (All items described below) and dimensions inspection (Section 3)

Item	Inspection Standards and Methods	Measuring Methods
Appearance Inspection	1. wire conductors not gripped in wire crimp or cut conductor(s).	Visual Inspection
	2. Deviative crimp(Bellmouth) (Wire-end protrusion)	Visual Inspection
	3. Defective crimp bottom (Burr)	Visual Inspection
	4. Insulation not gripped in insulation barrel	Visual Inspection
	5. Inadequate forming of contact area of contact	Visual Inspection
	6. Locking lever falling	Visual Inspection
Dimensions Inspection	1. Cut-off tab dimension: 0.25mm maximum	Vernier Calipers
	2. Terminal deformation(Bending,rolling,and twisting)	Magnifying glass
	3. Crimp height	Micrometer
	4. Front and rear Bellmouth for core crimp; Front: 0-0.4mm, Rear: 0.15-0.65mm	Vernier Calipers
	5. Locking lever height: 3.5mm minimum	vernier Calipers

* Vernier calipers or other equivalent measuring instruments

3.3.2 Storage

- a) Keep the products in a dry, clean place. They must be covered if stored for more than one day.
- b) If units are bundled, one bundle must not have more than 100 units in it.
- c) Stacking large amounts of crimped wire leads will cause entanglement of strip contacts resulting deformation by the weight. These will cause defective contacts.
- d) When unreeling the contacts, they apt to become caught one another and entangled. Care must be taken not to become deformed, when separating.

4. HARNESS ASSEMBLY OPERATION

.1 Contact Loading into Housing and Double Locking

- (1) Before loading receptacles into the housing, verify that there are no incomplete crimps. As shown in the illustration in the next page, place the plug housing with the locking lever facing upward and then rightly insert the receptacles, its crimps are facing upward, into the housing.

If the receptacle is not easily seated in the housing, do not force it, but make sure that it is going in the right direction.

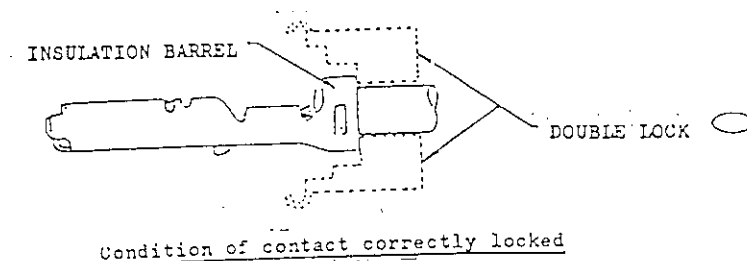
Terminals forced in backwards will accidentally scrape the housing lance off.

- (2) Verify that the terminal has been firmly locked to the housing lance. Locking it to the housing lance correctly will make a clicking sound.

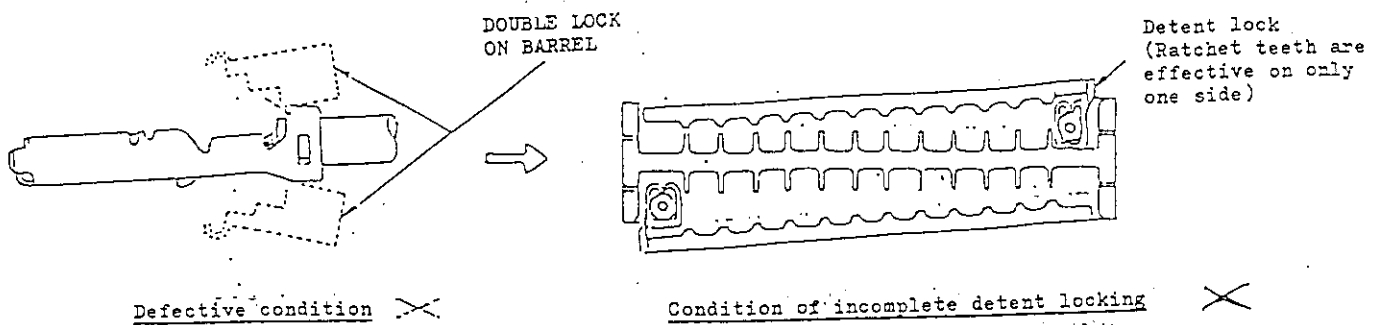
After inserting the receptacle in place, check locking conditions by lightly pulling the wire toward you. whenever the receptacle has to be removed for remounting, use the specified extraction tool.

- (3) Double Lock Ratchet:

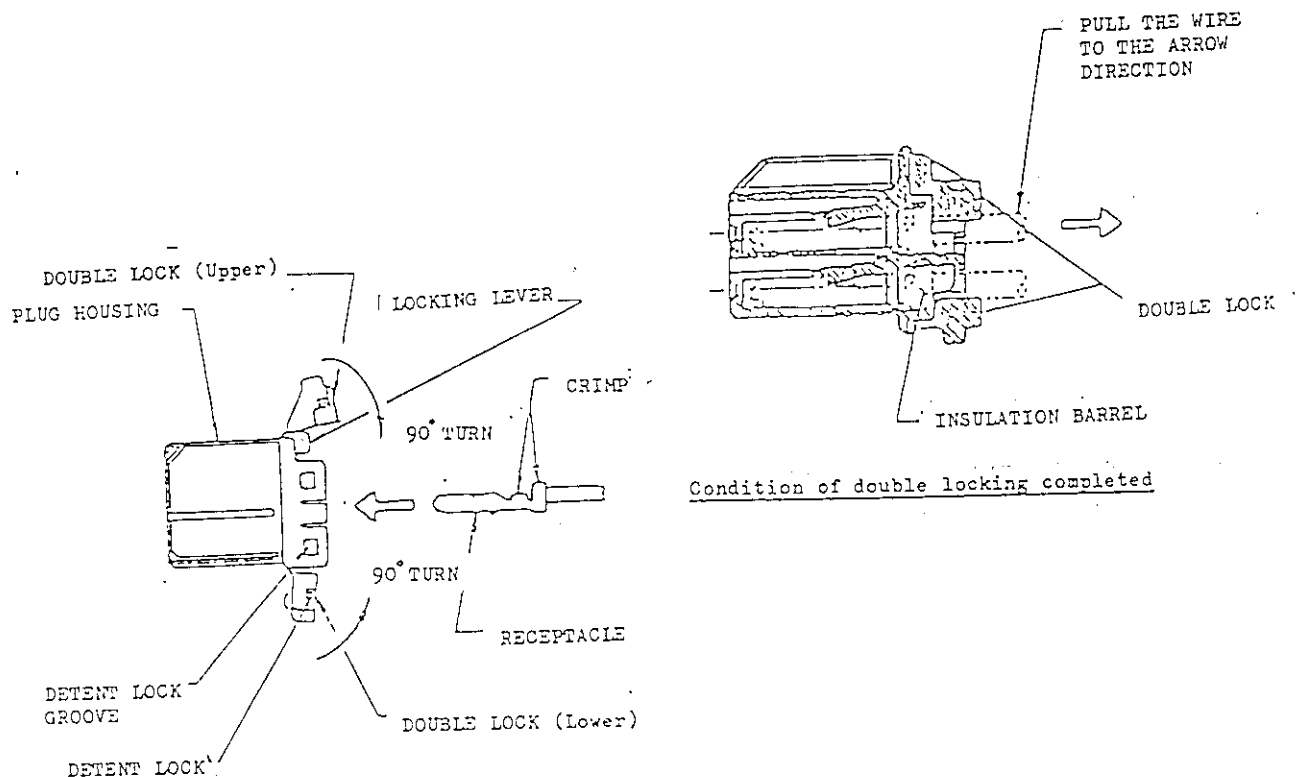
- The double lock plates are used to reinforce contact retention force in housing.
(They firmly hold the contact in housing, by locking the contact on insulation barrel of the contact.)



- If contacts are not mounted correctly inside the housing, the double lock device may fail to lock the contacts securely, or secure the contact at inadequate position. When detent locking is incomplete and is effective at only one side of housing, correct the contact mounting at the right position, using extraction tool.



- Verify that the double lock is firmly engaged. Press the double lock plates after checking completion of Steps (1) and (2) above. The double lock turns 90° to lock into the detent lock groove having a clicking sound. Upon completion of the said work, check locking conditions by lightly pulling the wire toward you.

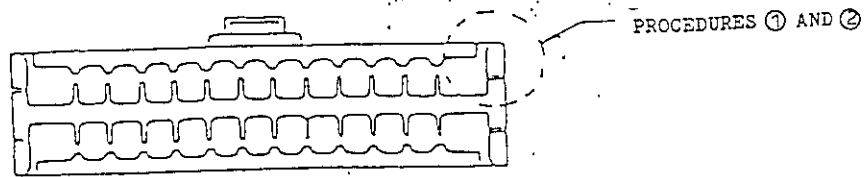


4.2 Extracting Contacts from the Housing

The extraction tool(jig) is used to pull Hybrid I/O series Contacts out of the double lock housings.

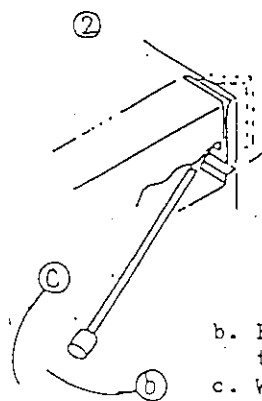
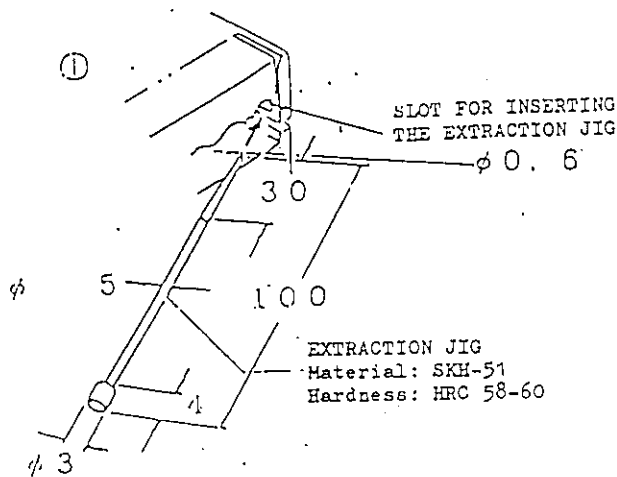
4.2.1 Unlocking the Hinge Lock Ratchet

Releasing the hinge lock ratchet must be orderly made one by one from one side of the housing taking the following procedures.

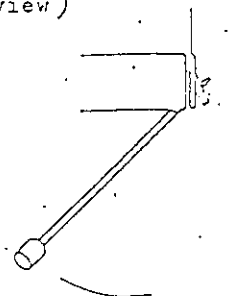


Procedures: Unlocking the side lock

- ① Insert the tool(jig) into the insertion slot.
- ② Release the hinge lock by turning the tool in the direction of the arrow so that the housing wall bends to allow you to lift the tool upward.



(A top view)



- b. Bend the housing until the lock is released.
- c. When the housing is bent, lift the hinge upward.

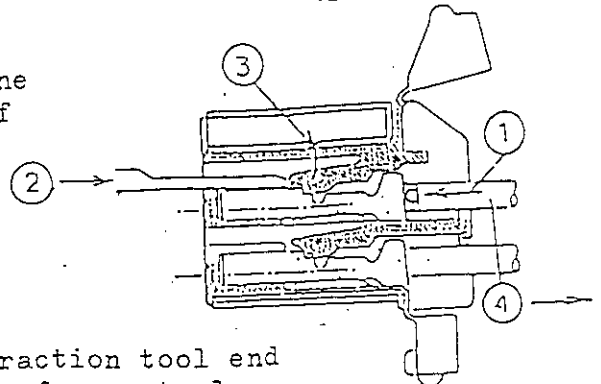
Caution: Bending the housing wall excessively may damage it.

4.2.2 Extracting Contacts

Remove contacts by inserting the extraction tool from the connector mating side to lift up the connector housing lance.

Procedures:

- ① Press the contact in the direction of the arrow of ① in the right picture.
- ② Insert the extraction tool.
- ③ Lift up the lance.
- ④ Remove the contact.



Note: Never insert the extraction tool end into the mating area of receptacle contacts (in order to prevent the contact leaf from deforming).

4.3 Harness Product Control

4.3.1 Inspection.

While total product inspection is required based on an inspection unit of one completed harness product, the following requirements must also be satisfied.

- a. Corresponding tab or its equivalent should be used as a probe to check the entire circuit within the connector.
- b. Inserting an inspection probe into the terminal is strictly prohibited, since it may cause deformation of the mating area. The inspection probe must be used inserting from the wire side, if needed.

4.3.2 Storage

- a) Storage must be done in a dry & clean area. The products should not be stored without covering for more than one day.

4.3.3 Shipment and Transportation

- a) Use appropriate packaging cartons to avoid any dust or moisture, and handle the cartons with care.
- b) Cartons must have necessary information on them.

5. MOUNTING ON VEHICLES

5.1 Acceptance Inspection

A minimum of the following points must be checked.

- a) Bundling location of each wire protruding out of the housing (more than 20mm for unbent wire, and more than 10mm for bent wire).
- b) Acceptability of contact mounting onto the housing.
- c) Contact cracks, defects, discoloring, and deformation, etc.
- d) Housing cracks, defects and discoloration, etc.
- e) Confirmation and removal of defective parts.

5.2 Mounting Operation Control

- a) Mating action should be made straightly along the mating axis. Then, confirm that the locking mechanism works correctly. When engaged correctly, a small clicking sound is heard. Lightly pull the connector toward you after mating to make sure it is locked.
- b) Do not repeat mating/unmating connectors if not necessary.
- c) When the contact has to be pulled out of the housing during processing, use the specified extraction tool and follow the instructions in paragraph 4.2.2.
- d) When checking the circuit, use the corresponding tabs or their equivalent.
- e) Handle the harness with as much care as possible. Take the following precautions in handling it.
 - i) Do not handle the harnesses roughly such as throwing them around.
 - ii) Do not draw the harness bundle dragging on the floor.
 - iii) Do not carry harnesses by the connectors. Carry them by holding the wires.
 - iv) Do not handle them in such a way that pulls on the wire and puts unnecessary force on the connectors.
- f) If connectors have to be removed, follow the instructions in paragraph 5.3 below.

5.3 Unmating Connectors

Hold the housing locking lever and press downward. While pressing downward, pull the connector straight out.

Caution:

- * Do not pull the wire harness.
- * Pull the connector straight.