

1. Product Name and Parts Number

1.1 2.3 Series Housing

Fig.1

Pos.	Color	Tyco Parts No.	Parts Name
2	White	1674085-1	Cap Assembly
	Brown	1674085-2	
	White	1674082-1	Plug Assembly
	Brown	1674082-2	
3	White	1674092-1	Cap Assembly
	White	1674088-1	Plug Assembly
4	White	1674098-1	Cap Assembly
	Brown	1674098-2	
	White	1674095-1	Plug Assembly
	Brown	1674095-2	
6	White	1674104-1	Cap Assembly
	Brown	1674104-2	
	White	1674101-1	Plug Assembly
	Brown	1674101-2	
8	White	1674110-1	Cap Assembly
	Brown	1674110-2	
	White	1674107-1	Plug Assembly
	Gray	1674107-3	
	Brown	1674107-2	
10	White	1674116-1	Cap Assembly
	White	1674113-1	Plug Assembly
12	White	1674122-1	Cap Assembly
	Gray	1674122-3	
	Brown	1674122-2	
	White	1674119-1	Plug Assembly
	Gray	1674119-3	
	Brown	1674119-2	
16	White	1674012-1	Cap Assembly
	Gray	1674012-3	
	Brown	1674012-2	
	White	1674009-1	Plug Assembly
	Gray	1674009-3	
	Brown	1674009-2	

1.2 2.3 Series Contact

Tyco Parts Number	Tyco Parts Name	Wire Type (○; Applicable, –; Not Applicable)			
		Type	0.3	0.5	0.5f
1612891-1 (Pre-Tin)	2.3 S Tab Contact (Male Contact)	AVS/AEX	○	○	–
		CAVS/CAVUS	○	○	–
		ABAVX	–	–	○

Tyco Parts Number	Tyco Parts Name	Wire Type (○; Applicable, –; Not Applicable)				
		Type	0.75f	0.85	1.25	2.0
1612891-2 (Pre-Tin)	2.3 M Tab Contact (Male Contact)	AVS/AEX	–	○	○	–
		CAVS/CAVUS	–	○	○	–
		AVSS	○	○	–	○

Tyco Parts Number	Tyco Parts Name	Wire Type (○; Applicable, –; Not Applicable)			
		Type	0.3	0.5	0.5f
1612892-1 (Pre-Tin)	2.3 S Receptacle Contact (Female Contact)	AVS/AEX	○	○	–
		CAVS/CAVUS	○	○	–
		AVX/AEX ABAVX	–	–	○

Tyco Parts Number	Tyco Parts Name	Wire Type (○; Applicable, –; Not Applicable)				
		Type	0.75f	0.85	1.25	2.0
1612892-2 (Pre-Tin)	2.3M Receptacle Contact (Female Contact)	AVS/AEX	–	○	○	–
		CAVS/CAVUS	–	○	○	–
		AVSS	○	○	–	○

Fig.2

1.3 Components View

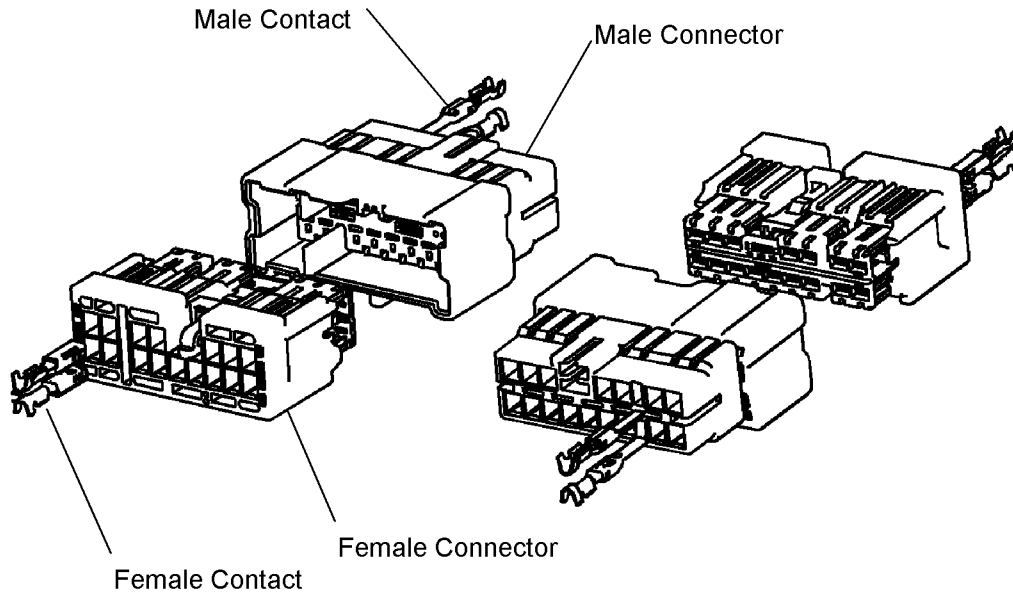


Fig.3

2. Customer Receiving Inspection

We conduct inspections according to our quality control regulations to maintain an over all lot control. In addition, the customer should conduct receiving inspections based on the specific customer drawings.

3. Storage and Carrying

3.1 Contact

- (1) Avoid leaving 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 reel, this may result in damage to the reel, and contacts before use.(See Fig.4)

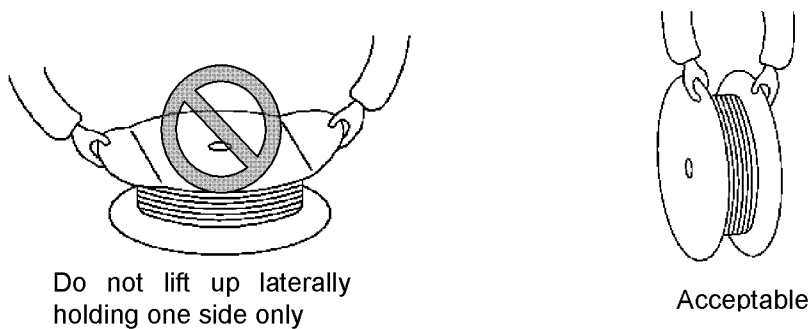


Fig. 4

(3) Avoid storing the contact reel in a moist or dusty place. Stock the reel in a comparatively dry and clean place (5~35°C, 45~85%RH) away from direct sunlight.

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

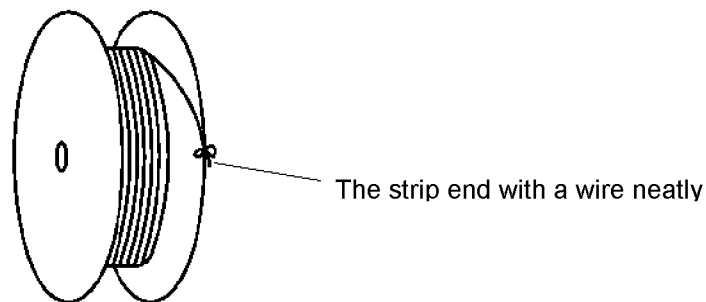


Fig. 5

3.2 Housing

(1) Avoid storing the housing in a moist or dusty place. Stock the housing in a comparatively dry and clean place (5~35°C, 45~85%RH) 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

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

4.1 Wire

4.1.1 Applicable Wire

See Fig.2 for applicable wire.

4.1.2 Notes for Stripping of Wire End

Wire end must be stripped without nick, cutoff, or damage of wire strands.

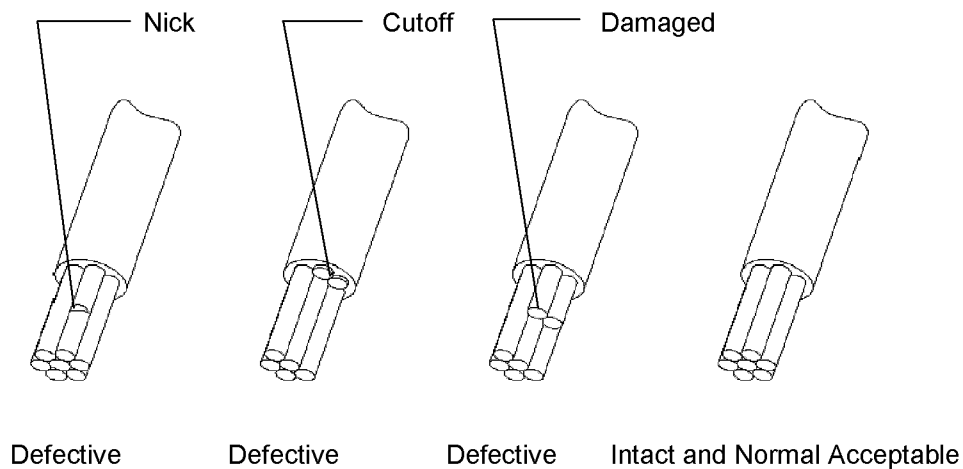


Fig.6

4.2 Instruction of Crimping Machinery

See Crimping Machinery Specification 412-5022

4.3 Crimping Specification

See the following application specification.

2.3 Male Contact	114-5324
2.3 Female Contact	114-5325

4.4 Storage and Handling of Crimped 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) Crimping leads should be processed in bundles of less than 100 pieces.
 - (3) Avoid stacking and piling up the in-process products in large volume.
- Contact failure and fall of retention force occur by deformation of the contact.

5. Harness Marking

1). If the retainer is fully engagement, it return to primary set position. Please review section7 “Unlocking retainer”

2). See Fig.7, 8 for identify of contact stabilizer.

When male and female contact insert housing, contacts insert back to back.

3) When the inserted contact is seated properly into the housing cavity, a clicking sound is heard which is made by the action of the lance.

By pilling the contact by 10N max, check to make sure that the contact can not be withdrawn.

5-1 Male contact loading in housing

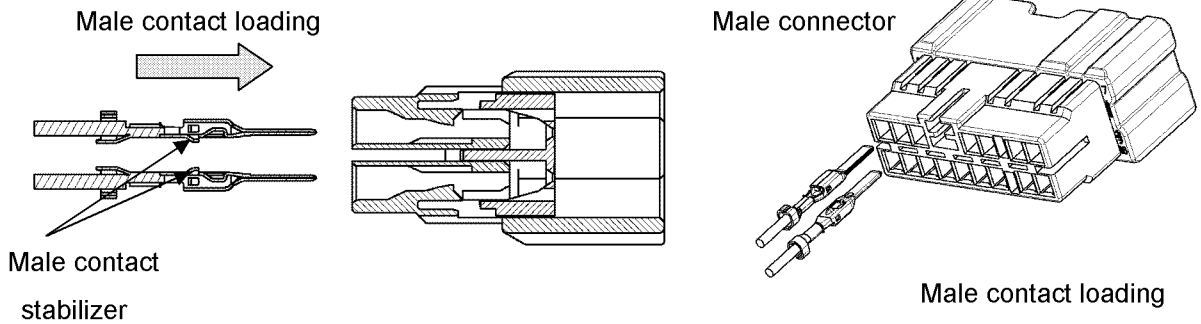


Fig7

5-2 Female contact loading

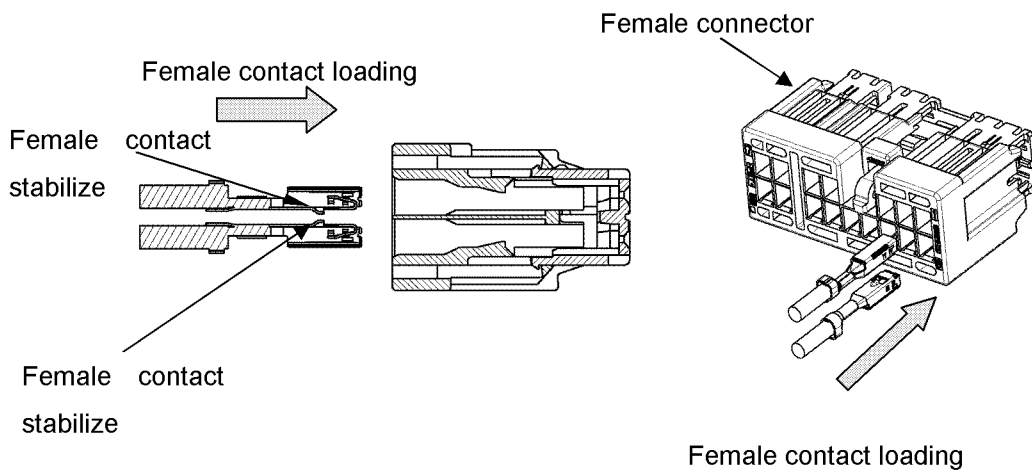


Fig8

6. How to Set Full Engagement of Retainer

After all the contacts are correctly inserted into the connector cavities, the retainer is ready to be engaged per the following procedure:

(See Fig9,10)

Male connector use Extraction Tool to set full engagement of retainer.

6-1 Male connector

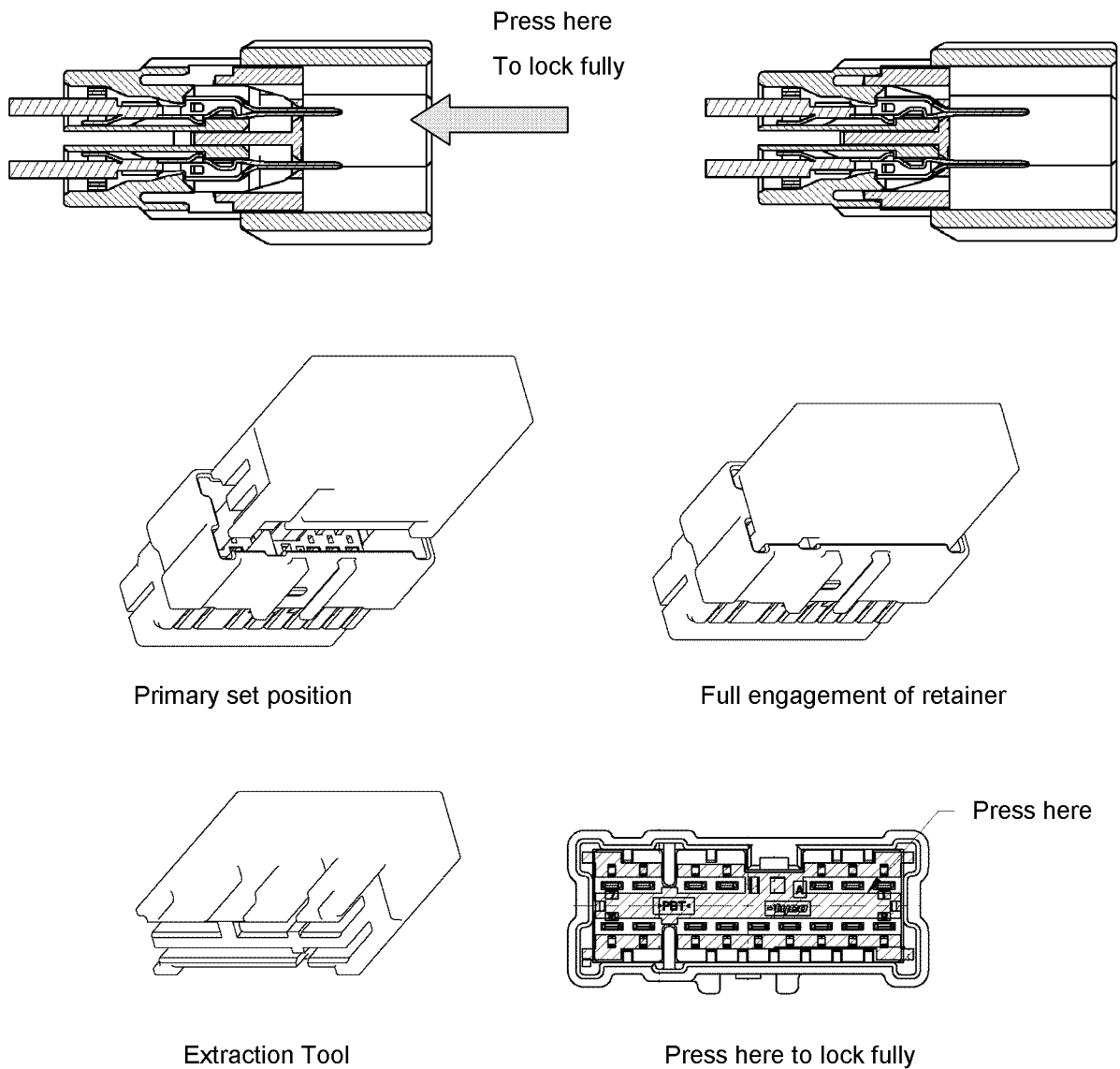


Fig9

6-2 Female connector

Even and uniform manner fully depress the retainer

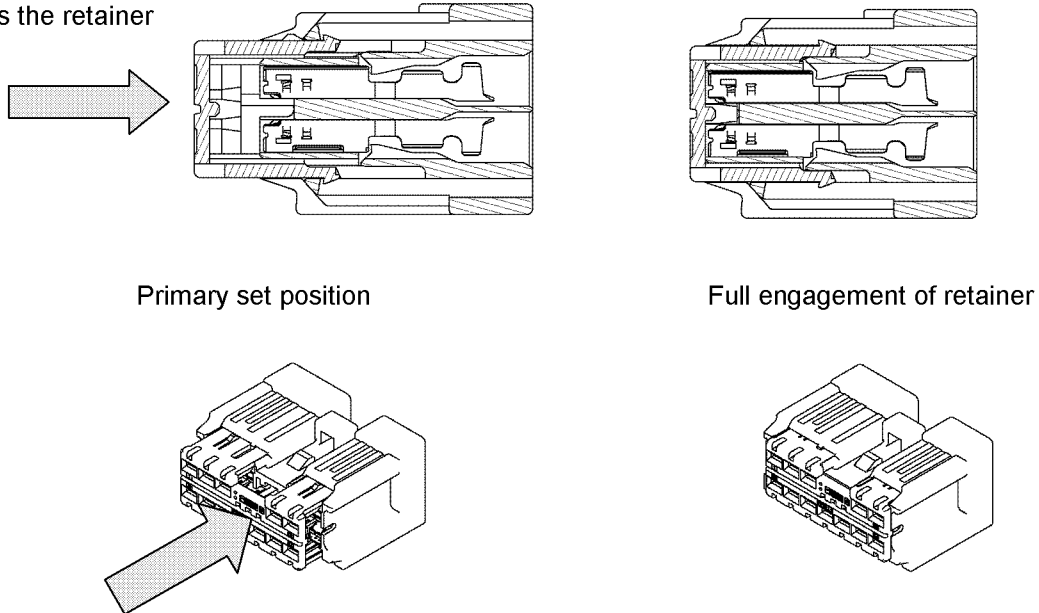


Fig10

7.Unlocking retainer (How to return retainer to primary set position)

During the assembly operation, you may to remove the inserted contact after the retainer was fully engaged or the retainer was engaged before contacts were inserted. In such cases, you need to know how to return the retainer to it`s primary set condition.

For contact remove, use Extraction Tool “ watchmaker`s screw driver of 1.0mm flat width“

7-1 1ROW TYPE Female connector

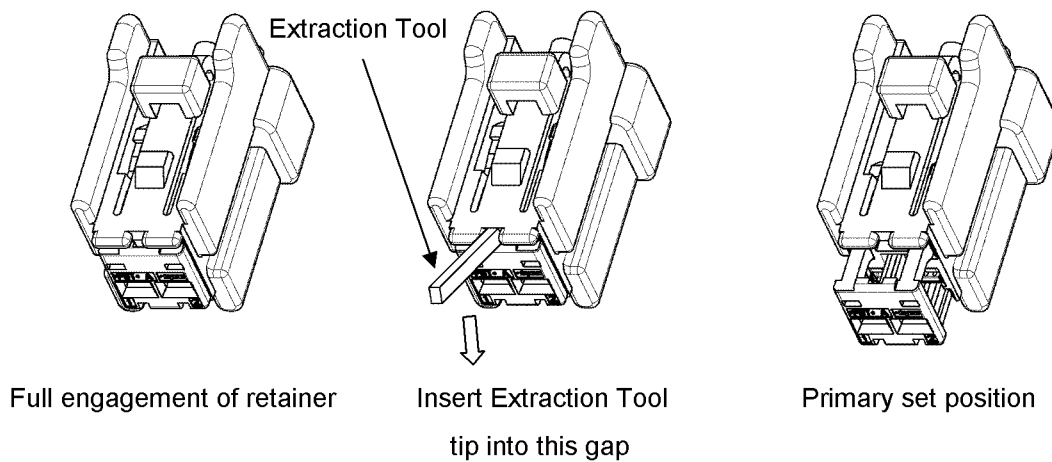
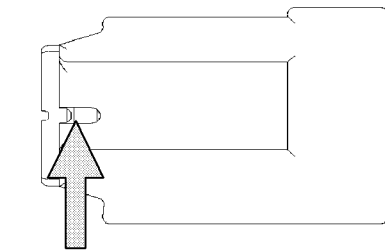
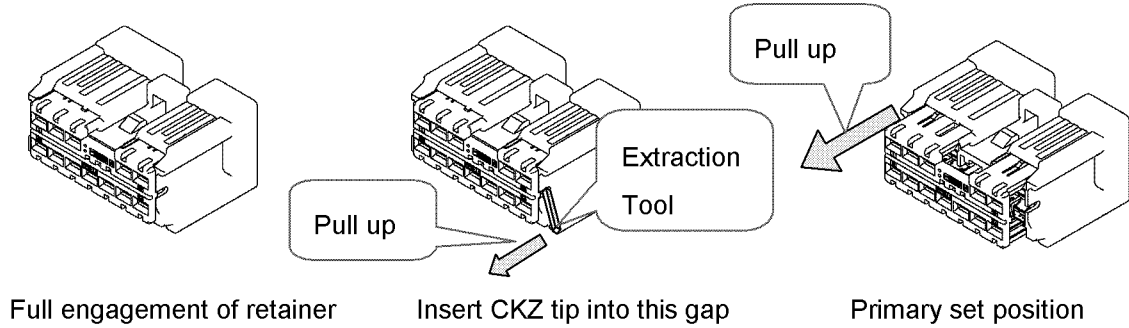


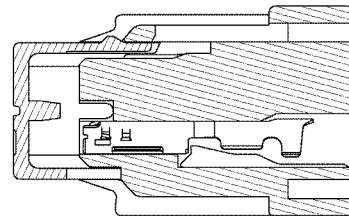
Fig11

7-2 2ROW TYPE Female connector

Insert Extraction Tool tip into this gap and pull up retainer. And other side same action.



Extraction Tool into this gap

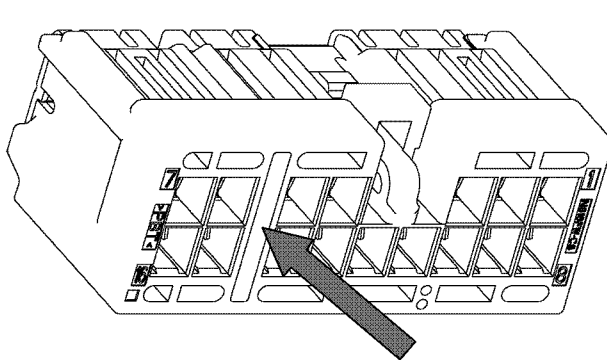


Extraction Tool insert straight and pull up

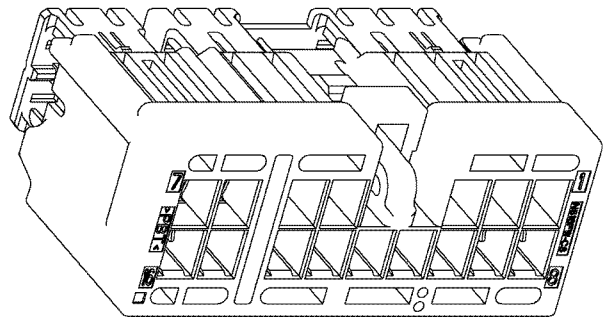
Fig12

7-3 2ROW TYPE Female connector(16position)

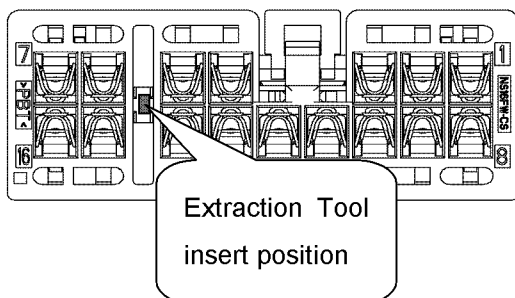
Extraction Tool insert the hole on the back of connector housing (with leading out side), and press until it became disengaged in the primary set position. Be careful do not make a scratch wire.



Full engagement of retainer



Primary set position



16position can operate instructions 7-2.

Fig.13

7-4 1ROW TYPE Male connector

Insert Extraction Tool into the full locking hole on the side of connector housing and pull up until it became disengaged in the primary set position.

Be careful do not make a scratch wire.

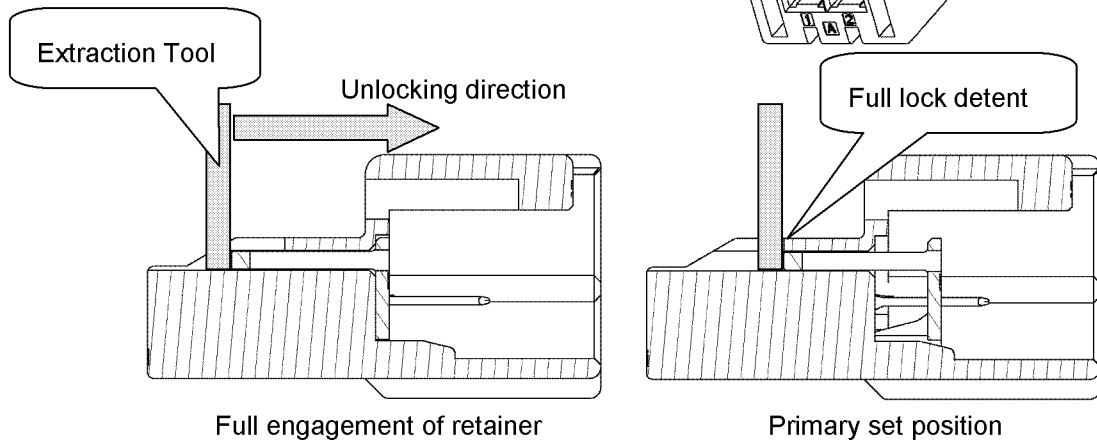


Fig.14

7-5 2ROW TYPE Male connector

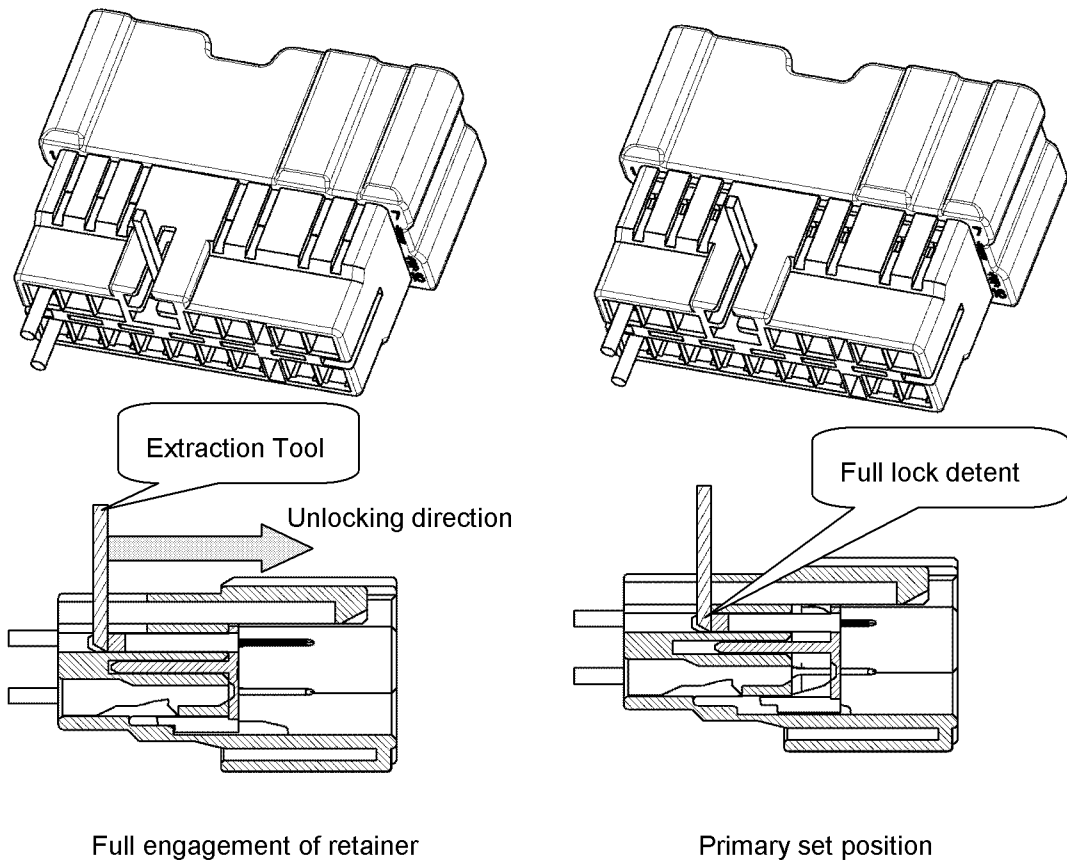


Fig15

8. Removal of Contact from Housing

After set retainer in the primary set condition, the tip end of Extraction Tool insert between the locking lance and contact while raising the locking lance in the direction of the arrow as indicated below.

(See Fig17,18)

Extraction tool is Extraction tool (See Fig. 16) or watchmaker's screw driver.

Raise the tool gently, just enough to unlock the lance.

At this point, pull back the crimped wire lead and the contact can be removed.

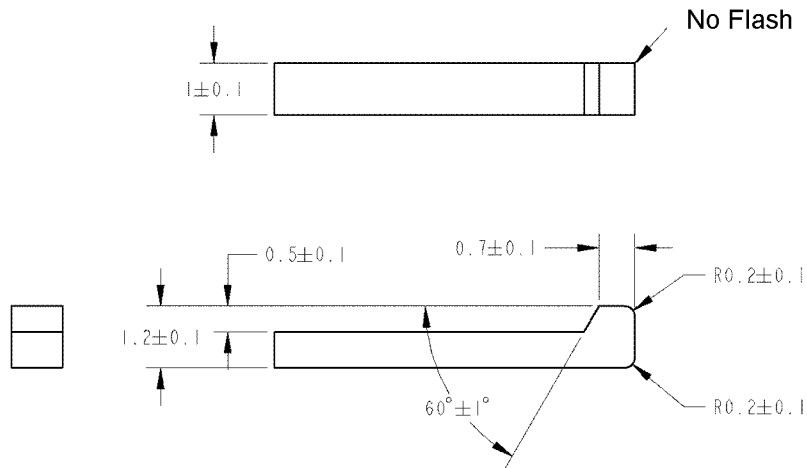


Fig.16

8-1 Remove of male contact from housing

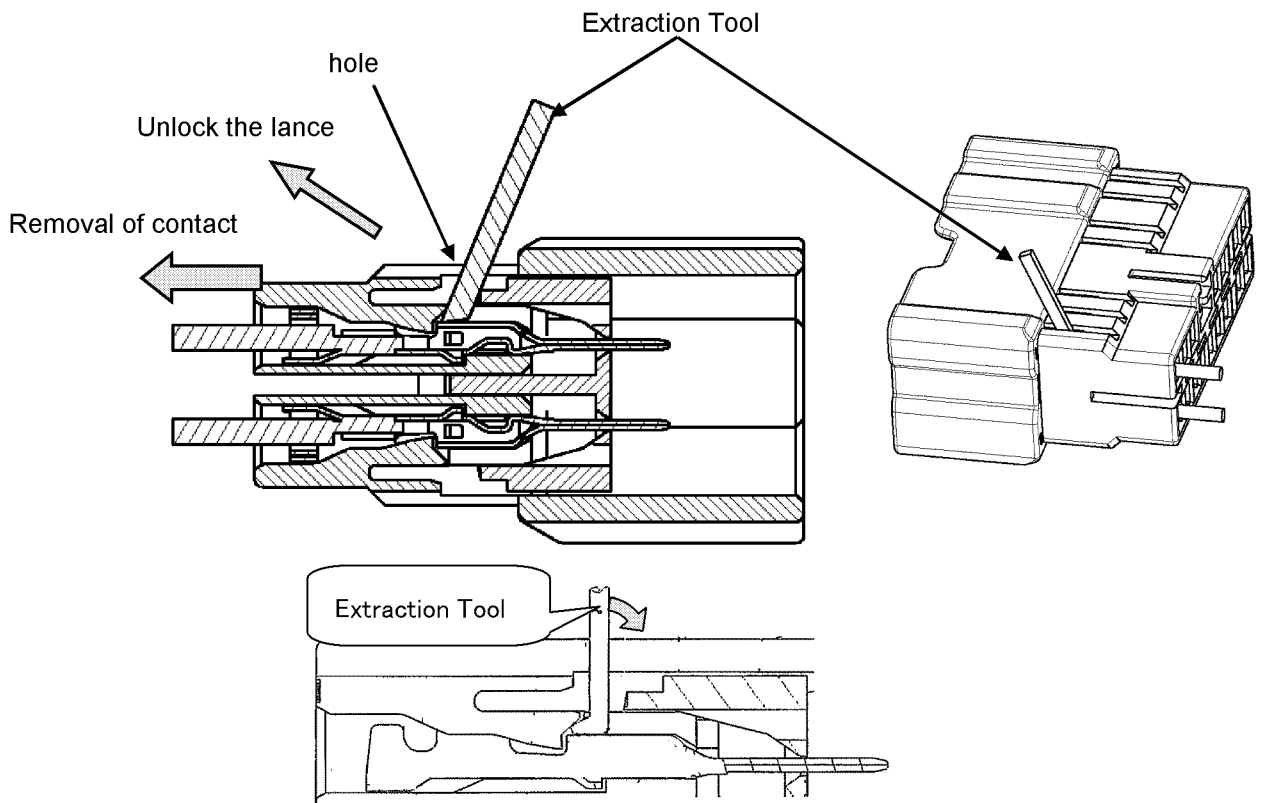
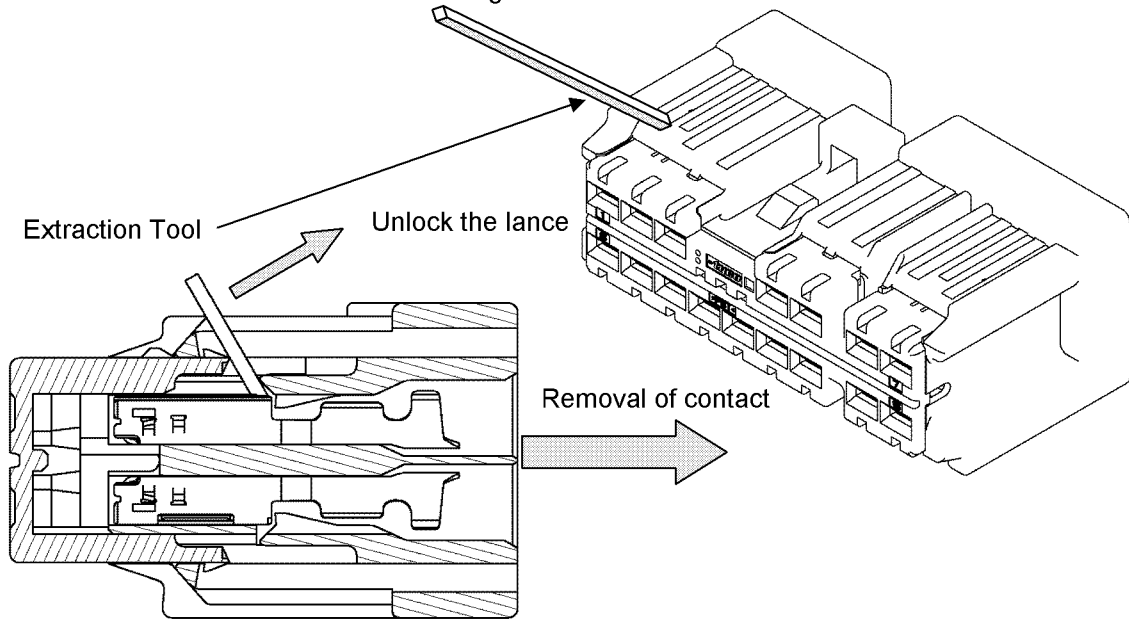


Fig.17

8-2 Removal of female contact from housing



Primary set position

Fig18

9.How to Check Setting Full Engagement of Retainer

9-1 Plug Housing

When the retainer is fully locked, measure the height of the retainer lock and checked the locking condition.
(Please review Fig.19)

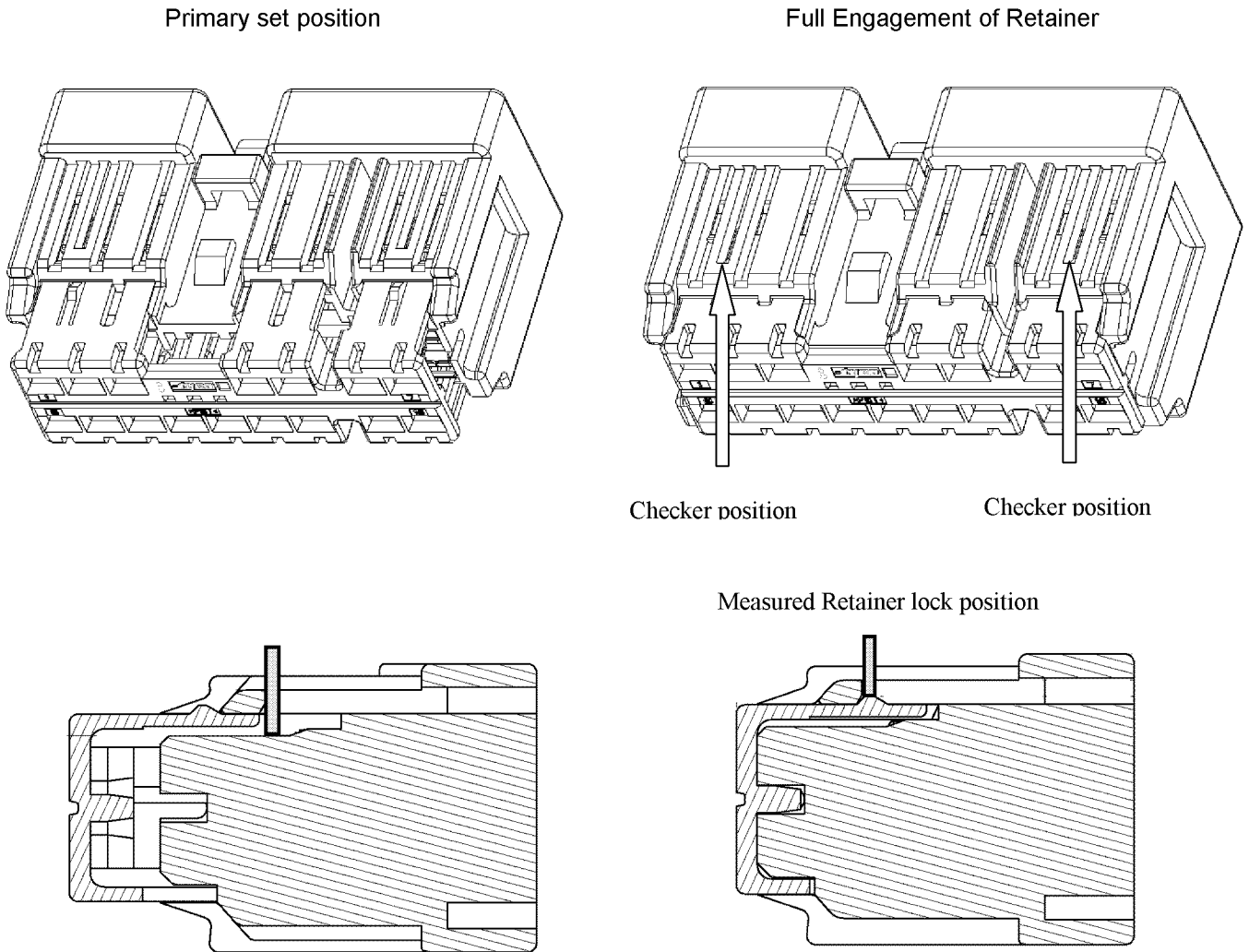


Fig. 19

9-2 Cap Housing (1ROW TYPE)

When the retainer is fully locked, measure the height of the retainer lock and checked the locking condition.
(Please review Fig.20)

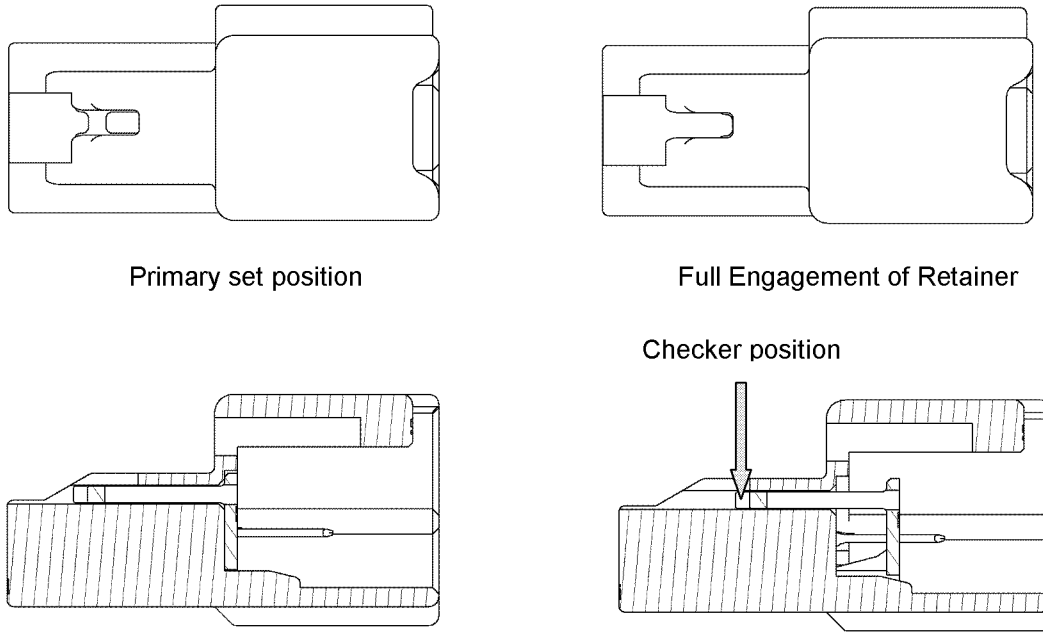


Fig.20

9-3 Cap Housing (2ROW TYPE)

When the retainer is fully locked, measure the height of the retainer lock and checked the locking condition.
(Please review Fig.21)

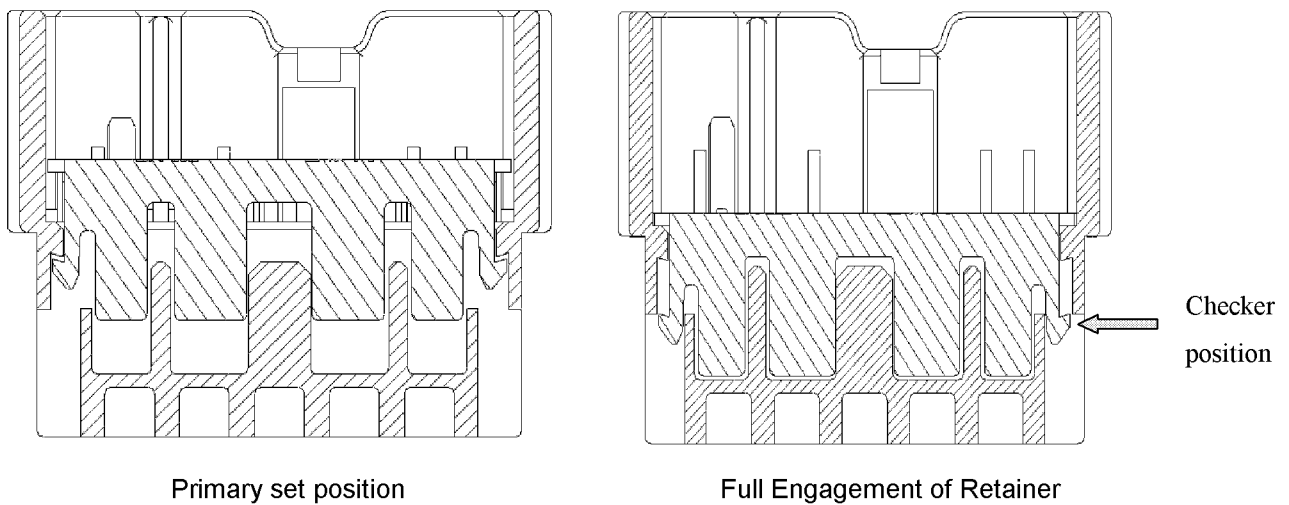
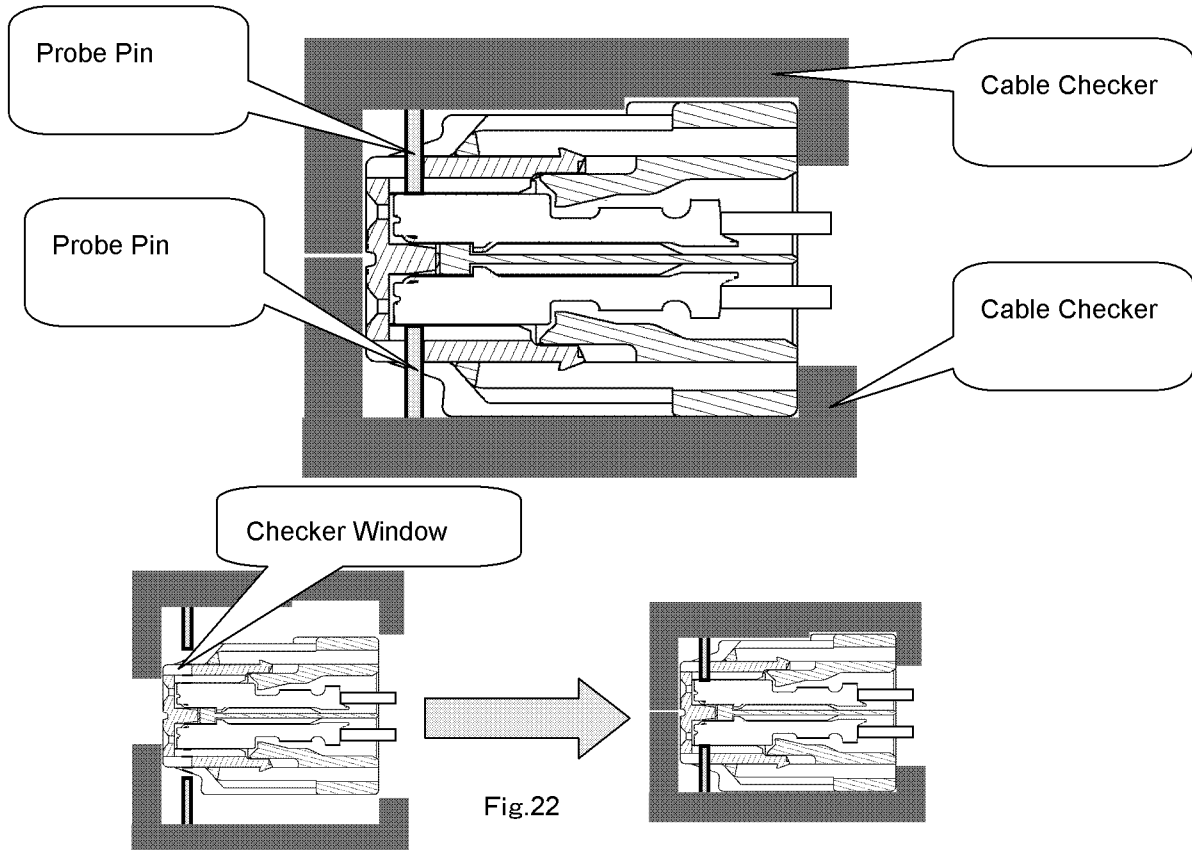
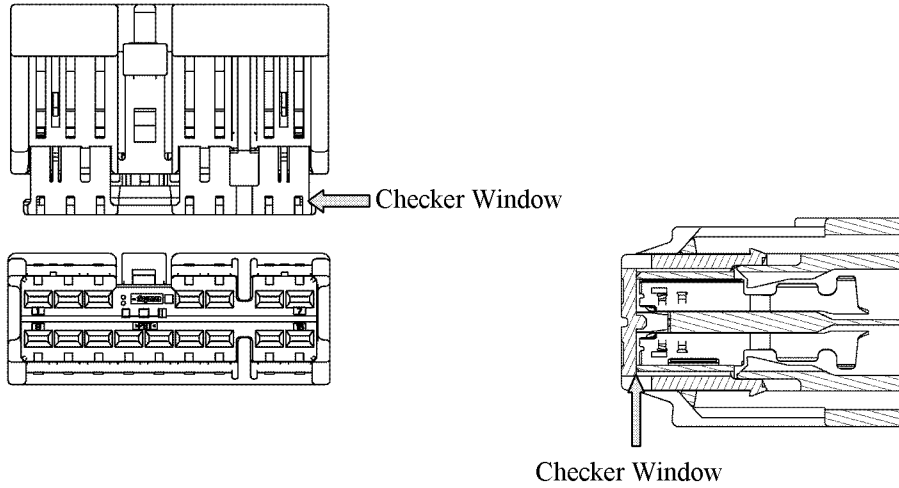


Fig.21

10.Cable Check

10-1 Receptacle Contact of Plug Housing

Cable check should be done by checker window (Please review Fig.22)



10-2 Tab Contact of Cap Housing

Cable check are used by Top of the Tab contact

When Tab contact is damaged, please change Tab contact.