

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE PER ECN# T-4587	1/4/84	<i>E. Staller</i>
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ELECTRONICS GROUP

ENGINEERING STANDARD

ES 61207

TERMINATION PROCEDURE FOR
 TERMINATING ROUND WIRES TO MTC100 BOXMOUNT
 RECEPTACLES USING AS-4000 SYSTEM

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		APPROVED		<i>E. Staller</i>							
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		PROJECT									

TERMINATION PROCEDURES FOR TERMINATING
ROUND WIRES TO MTC100 BOXMOUNT RECEPTACLES
USING AS-4000 SYSTEM

TITLE

ES 61207

DWG. NO.

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SHEET

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Rev. A

REVISION REFERENCE PAGE

TERMINATION PROCEDURE FOR
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1. SCOPE

1.1 This Engineering Standard defines termination procedures for MTC100 Boxmount Receptacles and Round Wires using AS-4000 application equipment.

2. COMPONENT DESCRIPTION

2.1 For use on the following boxmount receptacles:

MTC100-BXMT-004 2-inch, Flangeless

MTC100-BXMT-008 2-inch, Flanged

MTC100-BXMT1-004 1-inch, Flangeless

MTC100-BXMT1-008 1-inch, Flanged

MTC100-BXMT-001 2-inch, Flanged

3. APPLICABLE DOCUMENTS

3.1 Specifications and Standards.

QQ-S-571 Solder, Tin Alloy, Tin-lead Alloy,
and Lead Alloy.

MIL-F-14256 Flux, Soldering, Liquid (Rosin Base,
Type RA).

3.2 APPLICATION EQUIPMENT INSTRUCTIONS

AS-4000 Termination Procedure and Operating Instructions for Solderpak System, Raychem Document No. H50089, 3/83.

3.3 AS-4000 Supplementary SolderPak System Instructions for use with Die-Blade Cutter/Stripper, Raychem Document No. H50324, 9/78.

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4.0 EQUIPMENT, MATERIALS AND TOOLS

4.1 Wire Handling Tools

- (1) AD-4110 Cutter/Stripper, Die-Blade
- (2) AD-4050 Termination Station Base
- (3) CE-1201800 I.D. Block
- (4) AT-4030-10 I.D. Plate
- (5) AT-4044-10 Wire Clamp, Standard
- (6) AT-4044-12 Wire Clamp, For TFE-Insulated Wire
- (7) CE-1201500 Connector Fixture
- (8) Die Blades and Holder Assemblies
 - (a) AT-4110-20 for 20 gauge wires
 - (b) AT-4110-22 for 22 gauge wires
 - (c) AT-4110-24 for 24 gauge wires
 - (d) AT-4110-26 for 26 gauge wires

4.2 HEATING TOOLS

- (1) AA-400 SuperHeater compressed air heating tool, without tip.

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5.0 PROCEDURE

5.1 AS-4000 SET-UP

Set-up the Cutter/Stripper as directed in Section 2.0 of the AS-4000 Instructions (H50089) and Section 2.0 of the AS-4000 Die-Blade Instructions (H50062).

5.2 Wire Cutting and Stripping

Cut and strip the wires for each terminal row as directed in Section 3.1 of the AS 4000 Instructions and Section 3.0 of the AS-4000 Die Blade Instructions.

5.3 Transferring and Wire Positioning

Transfer the prepared wires to the Boxmount Receptacle as directed in Section 3.2 of the AS-4000 Instructions (H50089).

- The upper row of terminals (as the boxmount receptacle is mounted in its fixture) must be terminated first.
- When the first row is already terminated, rotate the boxmount receptacle in the fixture so the second row is on top for termination.

5.4 Terminating

- (1) Terminate the wires to the boxmount terminals as directed in Section 3.3.6 of the AS-4000 Instructions (H50089).
 - In Step 1, no heat shield is required.
 - In Step 2, the SuperHeater is used without an extra tip (nozzle).
- (2) After the first row is terminated, repeat Steps 5.2, 5.3, and 5.4 for the second row of terminals.

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6.0 INSPECTION

6.1 Wire Positioning Inspection (Figure 1)

Wires are to overlap the terminals at least twice the wire diameter.

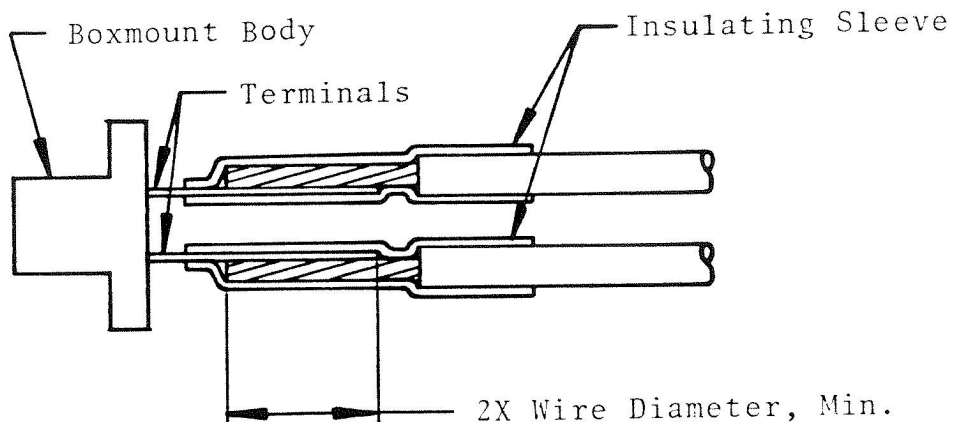


FIGURE 1

6.2 Inspection for Correct Heating

Heating requirements are as shown in Section 3.3.6 of the AS-4000 Instructions (H50089).