



## APPLICATOR 3739-CHGA AND CABLE CLAMP 3682-2

### Instructions for the assembly of CHG .100" WIREMOUNT SOCKET CONNECTOR TO NOTCHED FLAT CABLE

- CHG One Row (.100" Centers) Wiremount Socket
- CHG Two Row (.100" x .100" Centers) Wiremount Socket
- CHG Two Row (.100" x .100" Centers) Military & DIN Polarized Sockets

#### ASSEMBLY EQUIPMENT REQUIREMENTS

CHG Connector Style	*Cable Type	Assembly Presses	Cable Clamp
1 & 2 Row Stackable 1 & 2 Row Centerbump	8 127	3335 or 3316 and a 3458 Riser Block	3682-2
2 Row Military & DIN			

**Table 1**

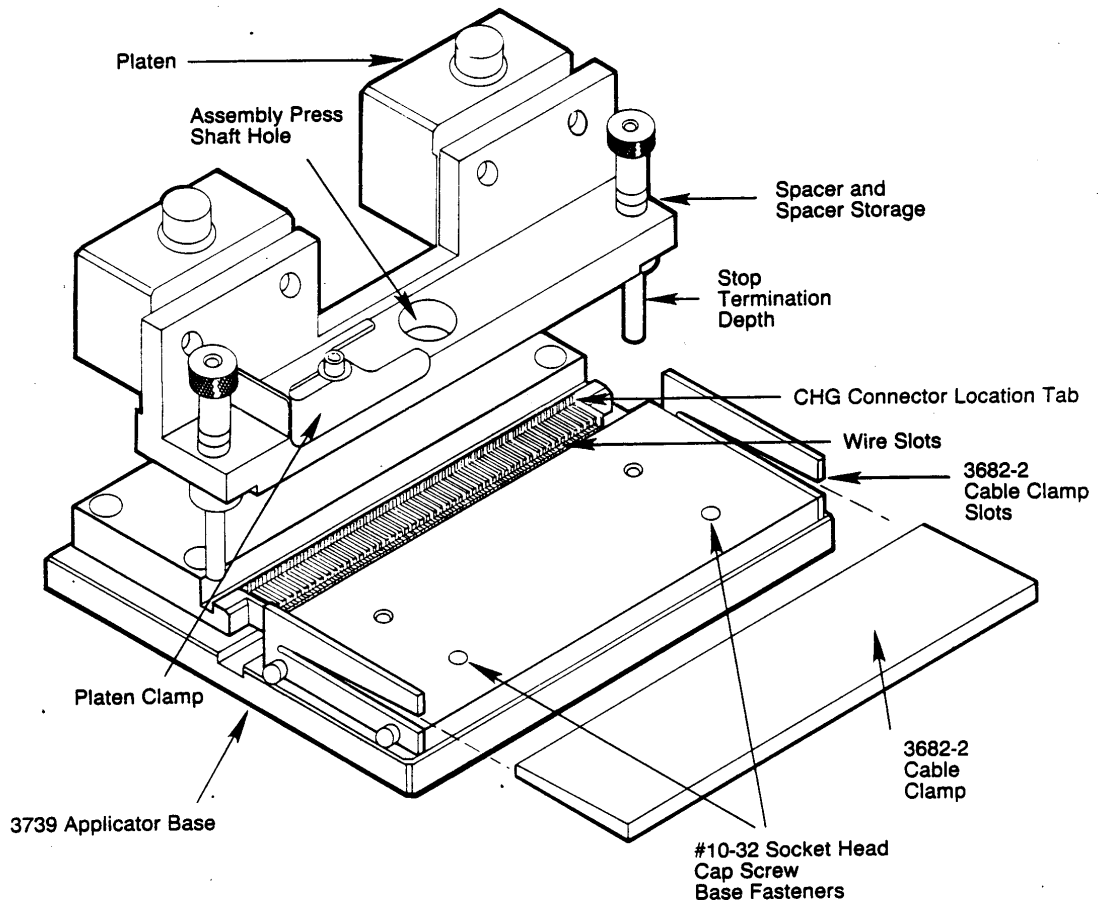
\*All cables require notch preparation before assembly.

#### General:

These instructions point out the assembly equipment required to assemble CHG socket connectors to notched flat cable. Assembly procedures and assembly quality guidelines for termination are explained.

# PROCEDURES FOR SET-UP:

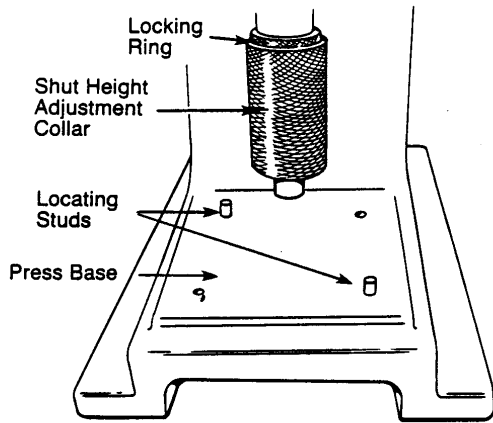
After mounting the 3739-CHGA to an Assembly Press Base, additional adjustments on the 3739-CHGA are required to obtain the correct termination depth. See Figure 1.



**3739 APPLICATOR**  
**3682-2 CABLE CLAMP**

Figure 1

- I. To mount the 3739-CHGA to an Assembly Press Base:
  - A. Remove the two locating studs from the Assembly Press Base.
  - B. Place the 3739-CHGA on the Assembly Press Base facing the operator.
  - C. Lower the Assembly Press Shaft into the Shaft Hole on the 3739 Platen.
  - D. Slide the Platen Clamp onto the Assembly Press Shaft.
  - E. Fasten the two No. 10-32 Socket Head Cap Screws to the base of the Press. Use a 5/32 Hex Key Wrench. **NOTE:** The two #10-32 Socket Head Cap Screws are captive screws located in the two holes indicated on Figure #1.



3335 Assembly Press  
Figure 2

## II. STOP ADJUSTMENT

- A. The "Stop Adjustment" provides specific cable termination depth control.
- B. Included with the 3739-CHGA Applicator are black and silver stops and black and silver spacers.
- C. Using the "Termination Depth Control" chart, select the correct

combination to obtain the correct termination depth with the desired cable/connector combination.

- D. Change the Stop Variables, by turning the knurled top off, counter clockwise. Arrange the specific stop and spacer as pictured in the "Termination Depth Control" Chart. **Make the setup to the stops on both sides of the Applicator Platen.**

TERMINATION DEPTH CONTROL SET-UP			
3M CABLE STYLE NO.	CHG SINGLE ROW	CHG TWO ROW	CHG 2 ROW MIL-DIN POLARIZED
8127 #28 Awg			

Figure 3

## F. Shut Height Adjustment:

To raise or lower the adjustment feature:

F.1. On the 3316 Assembly Press turn the Adjustment Knob as shown. See Figure 4.

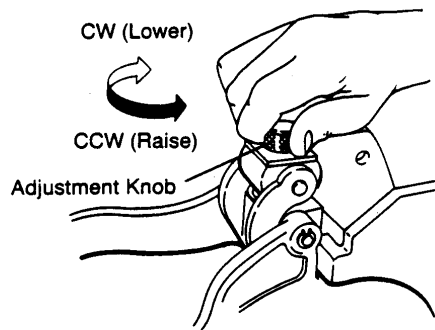
F.2. On the 3335 Heavy Duty Assembly Press turn the Adjustment Collar as shown. See Figure 5.

F.3. The Adjustment Shaft or Collar may have to be raised and lowered to satisfy point F.4.

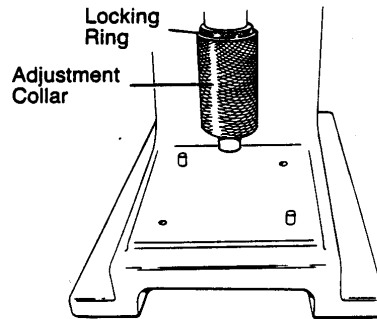
F.4. Lower the handle of the Assembly Press until the Assembly Press Handle makes contact with the Assembly Press Frame. The **end of the "Stop"** should not touch the Applicator Base at this time.

F.5. Now adjust the Adjustment Knob or collar so that the "Stops" make contact with the Applicator Base.

F.6. Raise the Assembly Press Handle and continue adjusting the "Stops" down by turning the Adjustment Knob or Collar an additional 1/2 turn C.W.



3316 Assembly Press  
Figure 4



3335 Assembly Press  
Figure 5

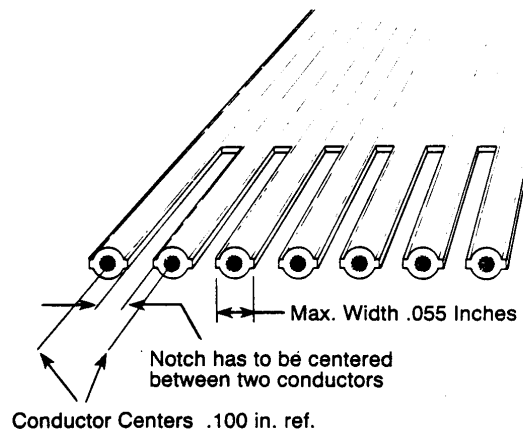
ab

mp

## PROCEDURES FOR CONNECTOR/CABLE ASSEMBLY

1. All cable must be notched.

A. Notch features are shown in Figure 6 and must be the proper size and placement on the cable.



Cable Preparation  
Figure 6

3. Center the Notched Cable:

- A. In the center of the applicator,
- B. To the back of the cable groove pockets and touching the face of the location tabs.
- C. Insert each conductor firmly into the Cable Groove Pocket and to the bottom of each pocket.

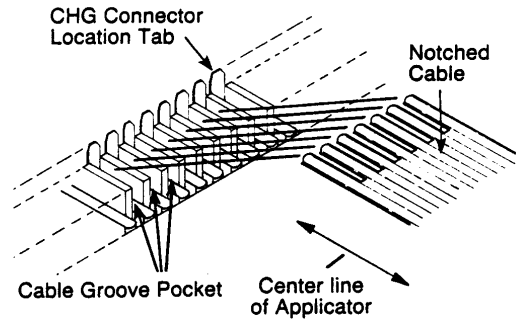


Figure 7

4. After the cable is positioned, wedge the 3682-2 Cable Clamp in place to provide holding assistance of the cable during termination. See Figure 8.

5. Place the CHG Connector Body with:

- A. The open side to be terminated, down, on top of the cable, with the open crimp towards the operator.
- B. The closed side of the Connector Body should be in contact with the Stop Surface and "straddling" the Location Tabs.

6. Lower the Press Handle firmly to complete the Cable/Connector Assembly. The "Stop Pin" must contact the 3739 Applicator Base for proper termination of the cable to the connector. See Figure 9.

7. Raise the Press Handle, remove the Cable Clamp and remove the Terminated Harness Assembly.

8. Repeat steps 3 through 7 if the CHG connector is a two row product.

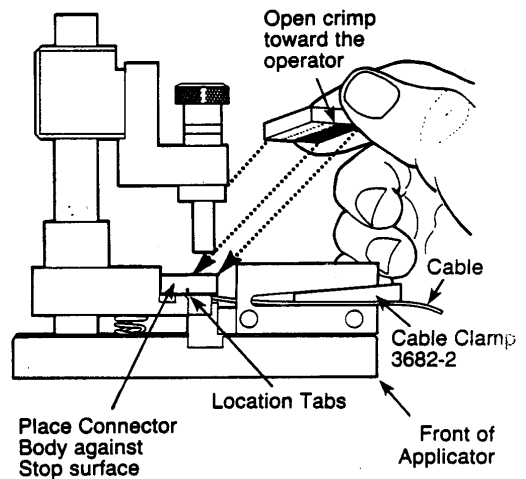


Figure 8

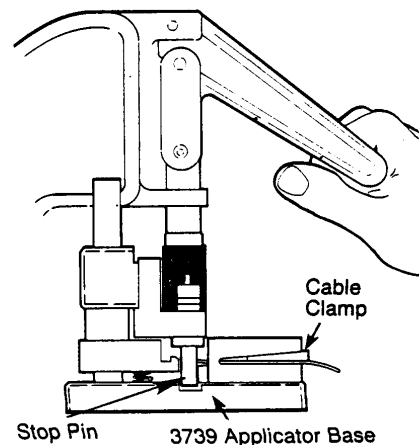


Figure 9

# TERMINATION QUALITY

All terminations should be inspected for the following:

1. Wire termination should be seated in the first and second set of contact.
2. End of wire should be "set back" from the plastic body wall. See Figure 10.
3. Insulation crimp should be complete with both strain reliefs bent over.
4. Wire insertion depth should be measured at Section A-A.
5. Check for connector body damage. If the depth is not within the tolerance given in the reference chart Table 2, a depth adjustment must be made. Refer to the Stop Adjustment Section II for instructions.

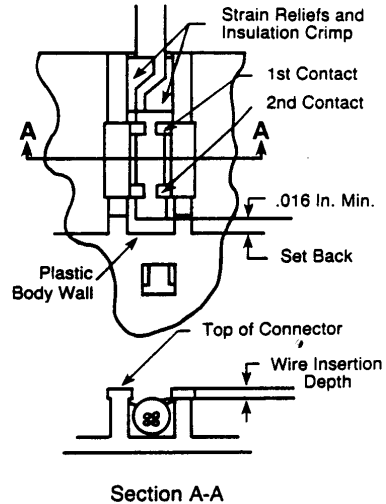


Figure 10

TABLE 2

*WIRE INSERTION DEPTH			
CABLE STYLE	CHG 1 row	CHG 2 row	CHG MIL/DIN
8127	.040	.040	.058

\*The wire insertion depths stated are guide lines. The depth of wire termination are pre-determined by the mechanical stops.

**Important Notice to Purchaser:**

All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed, and the following is made in lieu of all warranties expressed or implied.

Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use or the inability to use the product. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith.

No statement or recommendation not contained shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

