3M™ Locator Plate 3443-119

Instructions for the Assembly of Series 158 2 mm x 2 mm Socket Connectors

1.0 General
The Locator Plate 3443-119 is designed for rapid assembly of all available pin count positions of the 158 Series connector family. End to end as well as daisy chain assemblies can be made (minimum daisy chain length 24 mm).

Note: Staging platform is optional (Part no. 3767-0005). Locator plate includes: 2 mounting screws and an instruction sheet.

2.0 Procedures for Set Up
2.1 Mount the handle (1) on the guiding wing (2) and secure by locking screw (3). Make sure that the plastic ball is facing towards the operator.
2.2 Adjust the air pressure for the 3M™ Assembly Press 3830 or the shut height for Manual Press 3640.
2.3 Place the locator plate on the press and secure with the two locking screws included.

Note: If the staging platform (optional) is used, refer to its instruction sheet for mounting instructions.

Figure 1
3.0 Procedures for Adjusting Shut Height

The shut height should be adjusted from the base before the locator plate is put into place. 3M™ Presses 3316 and 3640 are adjusted with a knob at the top of the press. 3M™ Press 3335 is adjusted with the collar on the press shaft, and 3M™ Press 3830 is self-adjusting. 3436-1F is the shut height gauge to be used with 3443-119 locator plate. Use the 15.5 shut height gauge dimension which correspond to a 1.175" (29.85 mm) distance between the press base and press shaft.

3.1 The shut height adjustment is made from the base of the assembly press without the locator plate or platen in place.

3.2 Lower the handle of the press until the handle casting makes contact with the press casting. (Figure 2)

3.3 Place the shut height gauge across the press base. (Figure 2)

3.4 Rotate the shut height to lower or raise adjustment feature until the bottom of the shaft contacts the shut height gauge. (Figure 3)

3.5 Install the locator plate and the appropriate platen on the press. The platen should be positioned parallel with the connector body and cover.
4.0 Procedures for Adjusting Locator Plate

4.1 Cut required cable length using one of the 3M™ cable cutting tools. Cable end should be cut square and clean.

4.2 After the cable is prepared it is ready for termination.

4.3 Loosen the left cable guide hex screw (4). Lift the guiding wing (2) and slide the left cable guide (4) into the position dependant on connector size to be used. Connector pole sizes are indicated on guiding wing (2). Lower the guiding wing (2) and make sure that the serrations on the base plate (5) and the cable guide (4) are fully aligned. Tighten the cable guide locking screw (6).

4.4 Insert the appropriate cable (10) under guiding wing (2) and adjust the right cable guide (6) so that the base plate (5) and cable guide (6) serrations are aligned and that the right cable guide (6) is as close as possible to the cable (10). Tighten the right cable guide hex screw (6).
5.0 Procedures for Assembly of bulk packaged or pre-assembled sockets for end to end cable assembly.

5.1 Snap cover onto body to the pre-assembled position. Note, you may have purchased the socket with the cover already pre-assembled.

5.2 Slide the socket into slot with cover facing down. Insure correct orientation of socket depending on your desired finished orientation.

5.3 Slide cable (10) between left and right cable guides (4 and 6) while firmly pressing down on cable to ensure alignment with serrations. Slide cable through the connector until it firmly contacts cable stop. The end of the cable should be flush with the outside edge of the cover.

5.4 Initiate press.

5.5 Inspect connector. If the cover is not fully latched or large gaps are seen between the cable and the socket body then increase the termination depth by tightening the press screw. If cracked plastic is visible on the socket body or cover then decrease the termination depth by loosening the press screw. Termination should be snug and firm but not damaging to the connector.

5.6 Lift up handle (1) and remove the connector.

6.0 Procedure for Assembly of sockets with adhesive laminated to the cover

6.1 Remove cover from adhesive strip. Maintaining

6.2 Align cover to end of cable and press firmly to adhere. Cable should be flush with outside edge of cover.

6.3 Snap socket body onto cover.

6.4 Open the guiding wing and slide the cable and socket into position. Close the guiding wing.

6.5 Initiate press

6.6 Inspect connector. If the cover is not fully latched or large gaps are seen between the cable and the socket body then increase the termination depth by tightening the press screw. If cracked plastic is visible on the socket body or cover then decrease the termination depth by loosening the press screw. Termination should be snug and firm but not damaging to the connector.

6.7 Lift up handle (1) and remove the connector.

7.0 Notes for daisy chain termination

7.1 For daisy chain termination move the cable stop (9) to the side.
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