

Instructions for the Assembly of .125" x .125" (20 and 24 Position) Socket Connectors Using Locator Plate 3443-88

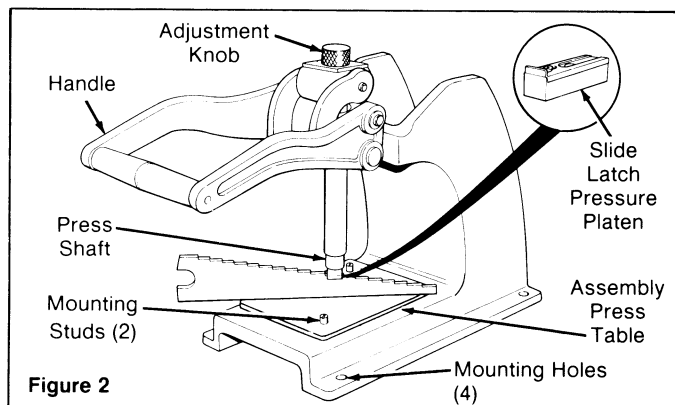
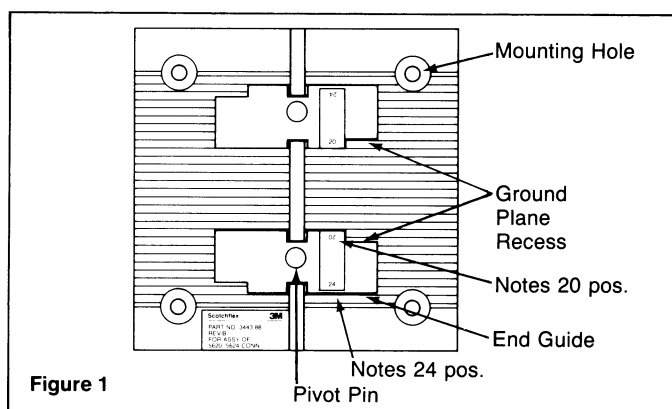
General

Assembly aids are offered by 3M to improve productivity and reduce error. Assembly Presses 3640, 3335 series, and 3339 series; Locator Plate 3443-88; and Cable Shear 3320 are recommended minimum assembly aids. See Individual Instruction Sheets for more detail on the adjustment and set-up of each Scotchflex press.

Contact Quantity	3M Connector Part Number	Strain Relief	Keying Plug	Pull Tab	Locator Plate Number	Platen Part Number	Adj. Setting Presses 3440, 3440A 3640	Adj. Setting Presses 3335, 3335-1 3339, 3339-1 3316
20	5620-XXXX	3448-5620					17 1/2	18
			3435-0000	3490-2	3443-88	3442-1A		
24	5624-XXXX	3448-5624					17 1/2	18

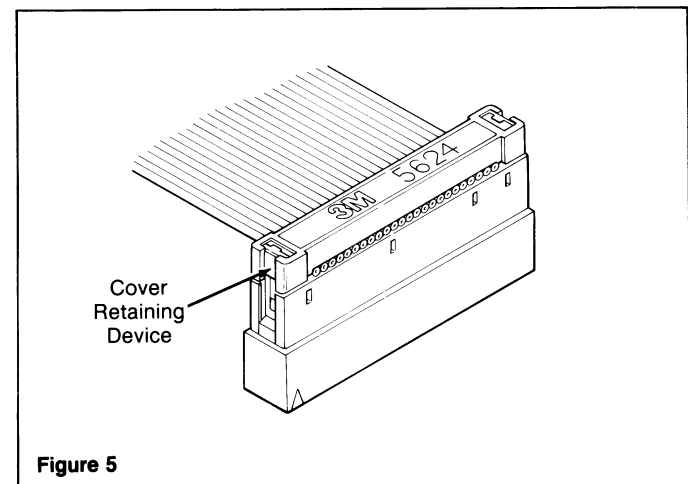
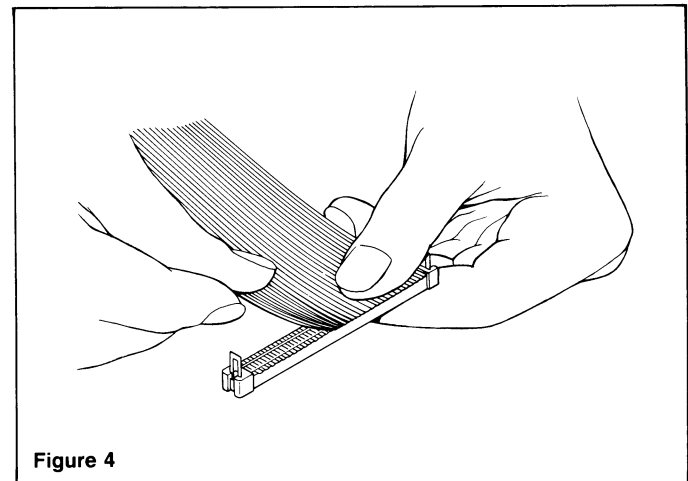
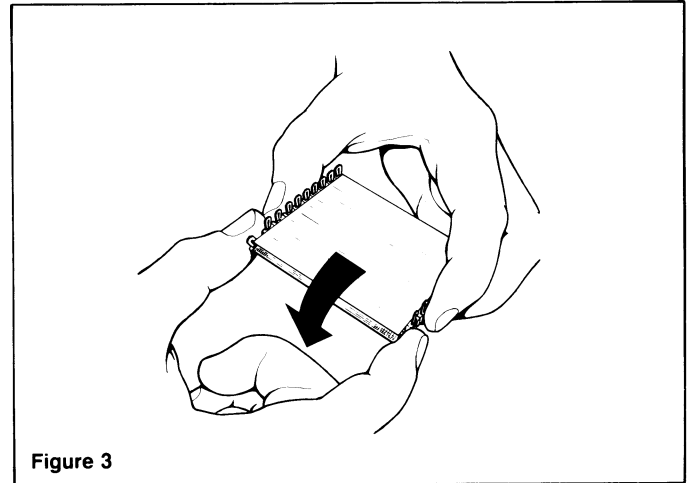
Set-Up

1. Adjust the connector/cable end guides on Locator Plate 3443-88 so that the correct contacts count on the end guide label is positioned correctly.
2. Remove the platen from the press and adjust the press shut height to a setting of 17 1/2 for presses 3440 series or 3640, and 18 for presses 3335 or 3339 series, **referencing from the press table**. Use Shut Height Gauge 3436-1A. (Figure 2)
3. Replace the platen on the assembly press shaft parallel with the connector's length.
4. Install the locator plate on the assembly press table, over the mounting studs. Position for right or left cable entry and for the type of cable. Standard and color coded cable is guided by the flush cable edge guide. Ground plane cable is guided by the recessed cable edge guide.



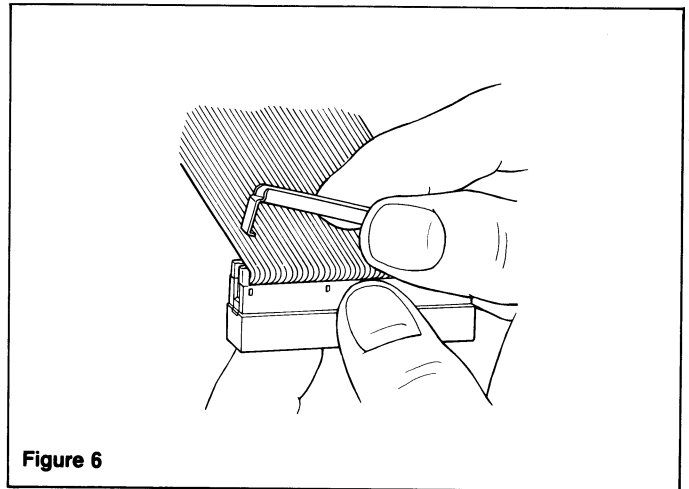
Assembly

1. Rub paper liner on connector cover for maximum adhesive transfer. Grasp a socket cover strip between thumb and forefinger of both hands, with the liner facing you. Snap the outermost cover down against the adjacent cover on the strip, breaking it from the liner. Pull laterally away from the strip, leaving a clean adhesive edge on the removed cover. (Figure 3)
2. Firmly press ribbed side of cable into alignment grooves on cover. Adhesive will help it to stay in place. (Figure 4)
3. Visually inspect to insure that:
 - a. Cable is properly aligned in cover grooves.
 - b. Cable end is flush with the cover for end terminations or perpendicular to cover for midspan terminations.
4. Place the cable/cover sub-assembly between the guides on the locator plate, cover side down.
5. Position and orient connector body, contacts down, over the cable/cover sub-assembly, engaging cover retainer devices with the body slots.
6. Lower the assembly press handle fully to complete the connection.
7. Raise press handle and remove completed assembly. Visually inspect to insure that: (Figure 5)
 - a. Cover is fully seated and parallel with the body.
 - b. Cable is properly aligned with the cover grooves.
 - c. Cover retaining devices are completely engaged with the body.

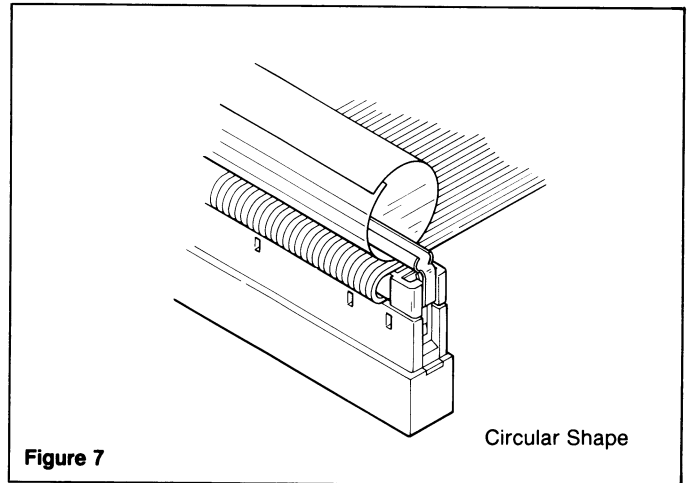


Strain Relief

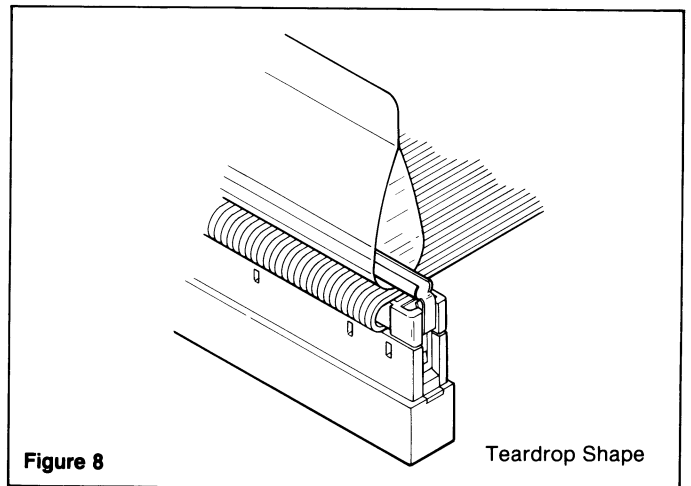
1. Fold cable back over cover.
2. Engage one leg of strain relief onto recess at end of cover. Use controlled finger pull on opposite leg to partially engage other end of strain relief. (Figure 6)



3. Insert pull tab beneath the strain relief.

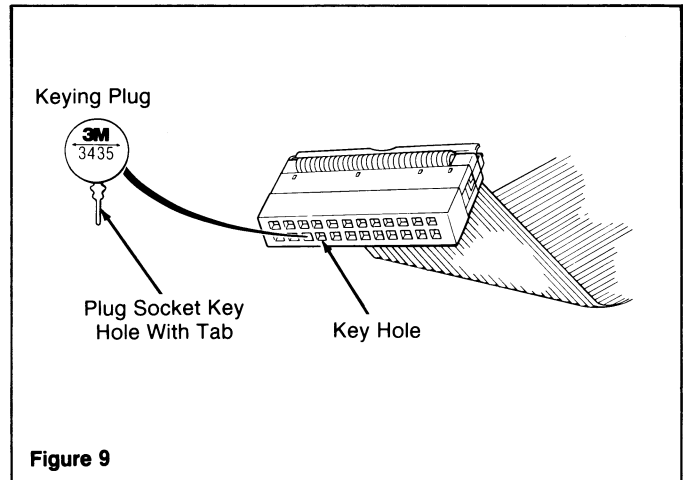


4. Invert Connector and press strain relief against hard surface. Push against the Connector, and snap "opposite" (strain relief) leg onto cover.
5. Apply finger pressure if needed to set strain relief legs flush with cover ends.
6. Remove protective liner from pull tab. Bring ends together to form circle or tear-drop shape. (Figures 7 & 8)

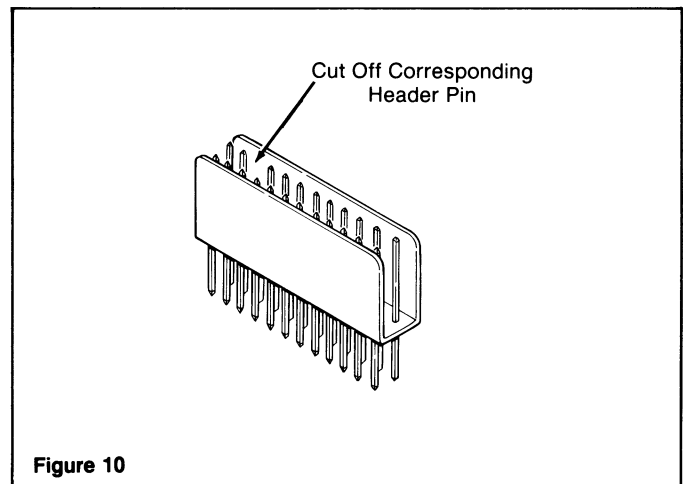


Keying Plug

1. Cut off selected metal header pin and discard. (Figure 9)



2. Insert a **3435 Keying Plug** into the corresponding socket key hole. (Figure 10)
3. Break off the round insertion tab and discard.



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