

4

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PRODUCT NO
TA-924

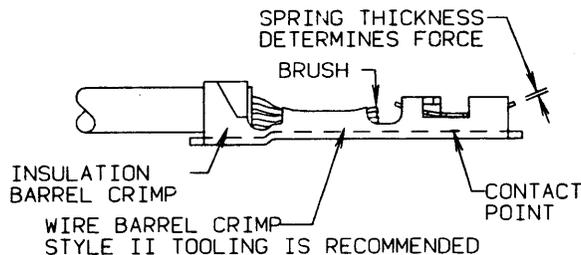
REVISIONS

REV	DESCRIPTION	BY	DATE
A			

STEP 5 CON'T

MINI P.V. PART NUMBERS

WIRE AWG	STANDARD CONTACTS	HIGH SPRING FORCE CONTACTS
20	75691-001	75691-002
22-26	75691-004	75691-005
28-30	75691-007	75691-008

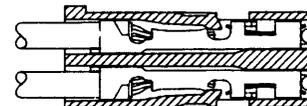
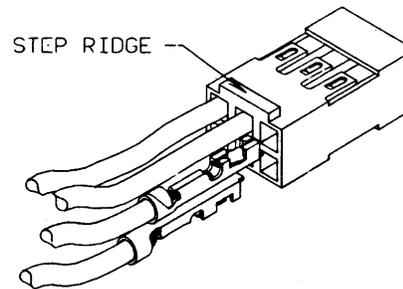


AUTOMATIC & SEMIAUTOMATIC STRIPPER/CRIMPERS ARE AVAILABLE FROM DUPONT'S. ELECTRONICS DEPARTMENT.

MACHINE NAME	DESCRIPTION	RATE
P.V.272	STRIPPER/CRIMPER	1800 CRIMPS/HR
P.V.250A	CRIMPER ONLY	1000 CRIMPS/HR
H.T. XX	HAND TOOL, CRIMPER ONLY	200-500/HR

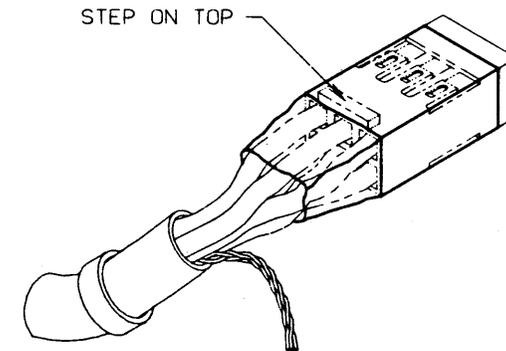
STEP 6

LOAD THE INDIVIDUAL P.V. CONTACTS IN THE MINI LATCH HOUSING. USE THE STEP RIDGE ON TOP OF THE HOUSING AS THE ORIENTATION FEATURE.



STEP 7

COVER THE MINI LATCH HOUSING LATCH OPENINGS WITH 3/4 INCH KAPTON TAPE. POSITION TAPE SO THAT SEAM IS ON THE BOTTOM AND SO THAT IT OVERHANGS THE BACK OF THE MINI LATCH HOUSING. THIS OVERHANG WILL PROTECT THE CONDUCTOR INSULATION FROM SOLDERING HEAT IN A LATER STEP.



ORIENT THE CONTACTS AS SHOWN, WITH SPRINGS FACING OUT, TOWARD LATCHES. PUSH WITH FINGERS UNTIL P.V. CONTACT AND SPRING FIT IN FRONT OF LATCH.

CUSTOMER COPY

CODE IDENT 22526

DuPont Electronics



SHEET INDEX	ISSUE SH NO	DO NOT SCALE DRAWING										TOLERANCE UNLESS OTHERWISE NOTED	INCH/MM	MATL	DR	DATE
		THIRD ANGLE PROJECTION														
												.00±.01/.0±.3		-	M. CLOUSER	7/29/91
												.000±.005/.00±.13			D. HORCHLER	7/29/91
												.0000±.0020/.000±.051			D. HORCHLER	7/29/91
												ANGLES 0° ±2°			D. HORCHLER	7/29/91

TITLE ASSEMBLY INSTRUCTIONS FOR LATCH-N-LOK CABLE ASSEMBLIES

SCALE	SIZE	DWG NO	CAD
//	B	TA-924	SHEET 2

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FORM E-3066C REV. 12/89

PRODUCT NO
TA-924

SIZE

DIM E
REF

REVISIONS

REV	DESCRIPTION	BY	DATE
A			

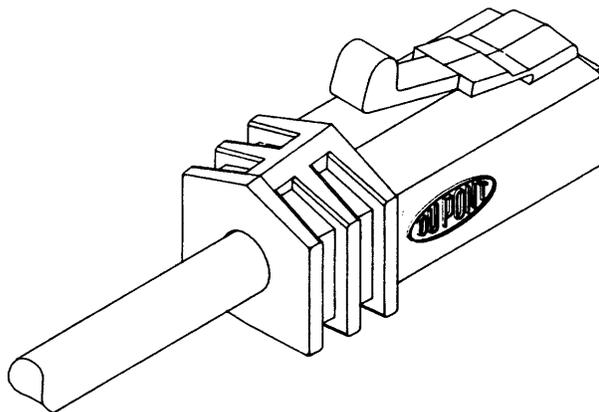
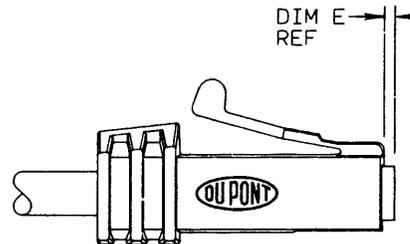
1X4, 1X6, 1X8, 1X10	.034/.86
2X3, 2X6, 2X8, 2X10	.043/1.10
2X4	.055/1.40

STEP 11

SLIDE PLUG OVER FRONT OF ASSEMBLY. POSITION CRIMP RING ON SIDE EXITS. MOVE BACK CAP INTO POSITION. ALL PRIMARIES SHOULD BE SOMEWHAT RELAXED INSIDE THE PLUG. ULTRASONICALLY WELD TOGETHER THE TWO OUTER PLASTIC PARTS. WELDER SETTINGS VARY WITH THE SURROUNDING ENVIRONMENT. IT IS RECOMMENDED TO SET UP WELDER WITH EMPTY PLUG/CAP SAMPLES.

STEP 12

ELECTRICALLY TEST ASSEMBLIES FOR SHORTS, OPENS AND MISS WIRES. PLUG BOTH ENDS INTO TESTER INTERFACE AND FOLLOW THE DIRECTIONS FOR PROGRAMMING AND USING THE TESTER SYSTEM.



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CODE IDENT 22526			
DR	M. CLOUSER	DATE	7/29/91
CHK	D. HORCHLER	DATE	7/29/91
ENGR	D. HORCHLER	DATE	7/29/91
APPD	D. HORCHLER	DATE	7/29/91
TITLE		ASSEMBLY INSTRUCTIONS FOR LATCH-N-LOK CABLE ASSEMBLIES	
SCALE	SIZE	DWG NO	CAD
//	B	TA-924	SHEET 5

SHEET INDEX	ISSUE SH NO	DO NOT SCALE DRAWING				TOLERANCE UNLESS OTHERWISE NOTED	INCH/MM	MATL	DR	DATE
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