

1. Parts Name and Parts Number

1.1 Contact

Parts Name	AMP Parts Number	Wire Type (O:Applicable, X;Not Applicable)						
		Type	0.3	0.5	0.85	1.25	2	3
.060 Receptacle (Female Contact)	900293	AVSS/CAVUS or AVSSX/AESSX	O	O	O	X	X	X
.187 Receptacle (Female Contact)	175090		X	X	O	O	X	X
	175091		X	X	X	X	O	O

Fig. 1

1.2 Rubber Plug

Parts Name	Applicable Wire Size	AMP Parts Number
Rubber Plug for 060 Receptacle	0. 3~0. 5SQ	316867
Rubber Plug for 060 Receptacle	0. 85SQ	967067
Cap for 060 Receptacle	--	1473234
Rubber Plug for 187 Receptacle	--	None

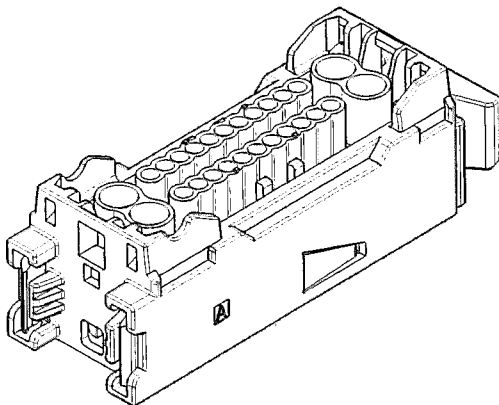
Fig. 2

1.3 Housing

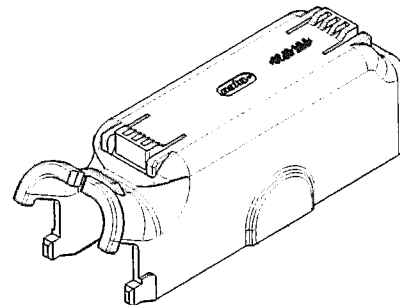
Positions	Parts Name	AMP Parts Number
26	PLUG HOUSING ASSY	1717471-1
	WIRE COVER	1612691-2

Fig. 3

1.4 ;Components View



Plug Housing Assembly



Wire cover

Fig. 4

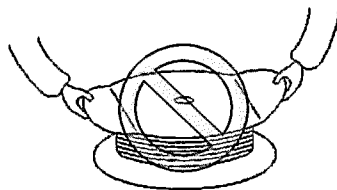
2. Customer Receiving Inspection

We conduct inspections according to our quality control regulations to maintain an over all lot control. In addition, the customers should conduct receiving inspections based on the specific customer drawings.

3.Storage and Carrying

3.1 Contact

- (1) Avoid leaving or carrying the contact reel in an open area without wrapping it in proper material.
- (2) Do not lift up and carry the contact reel by gripping one the side of reel, this may result in damage to the reel, and contacts before use. (See Fig.4)



Do not lift up laterally holding one side only.



Acceptable

Fig.5

- (3) Avoid storing the contact reel in a moist or dusty place. Stock the reel in a comparatively dry and clean place (5~35°C, 45~85%RH) away from direct sunlight.
- (4) When removing the contact reel from the machine, fasten the end of contact strip onto the edge of the reel with use of proper string or wire. (See Fig.5)

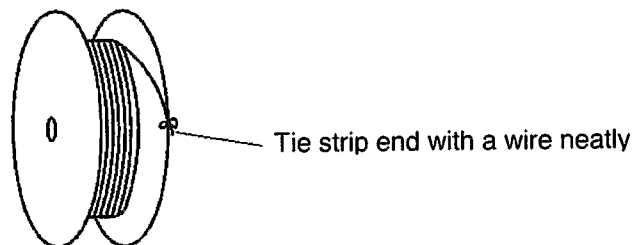


Fig.6

3.2 Housing

- (1) Avoid storing the contact reel in a moist or dusty place. Stock the reel in a comparatively dry and clean place (5~35°C, 45~85%RH) away from direct sunlight.
- (2) Avoid leaving or carrying the contact reel in an open area without wrapping it in proper material.
- (3) Do not drop or shock the housing when carrying it.

4. Crimping Operation

Any crimping of contacts must be performed by using appropriate AMP tools according to the applicable Instruction Sheet and Specification.

4.1 Wire

4.1.1 Applicable Wire

See Fig.2 for applicable wire.

4.1.2 Notes for Stripping of Wire End

Wire end must be stripped without nick, cutoff, or damage of wire strands.

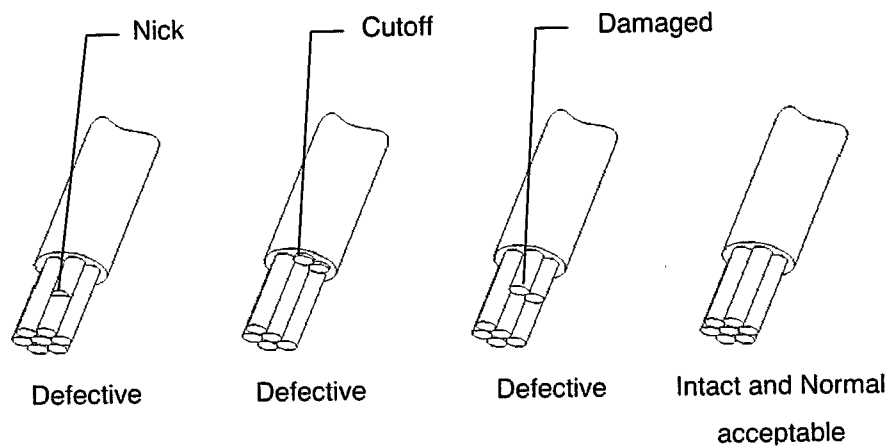


Fig.7

4.2 Storage and Handling of Crimped Products

- (1) Store the products in a clean, dry area, cover with proper sheet or paper when placed in an open area until the next day.
- (2) Crimped leads should be processed in bundles of less than 100 pieces.
Take care of the tangle and damage (Specially the lance of 060 Receptacle) on the products.
- (3) Avoid stacking and piling up the in-process products in large volume.
Contact failure and fall of retention force occur by deformation of the contact and specially 025 receptacle's lance.

4.3 Crimping Specification

See the following application specification.

060 Receptacle contact	114-5216
187 Receptacle contact	114-5126

5. Harness Making

5.1 Contact Loading in Plug housing

- (1) Check to confirm that the retainer is at Primary lock position. If the retainer is fully engaged and disengagement is required, please review section 5.3. Contact cannot be inserted into the housing cavity at Secondary lock position.

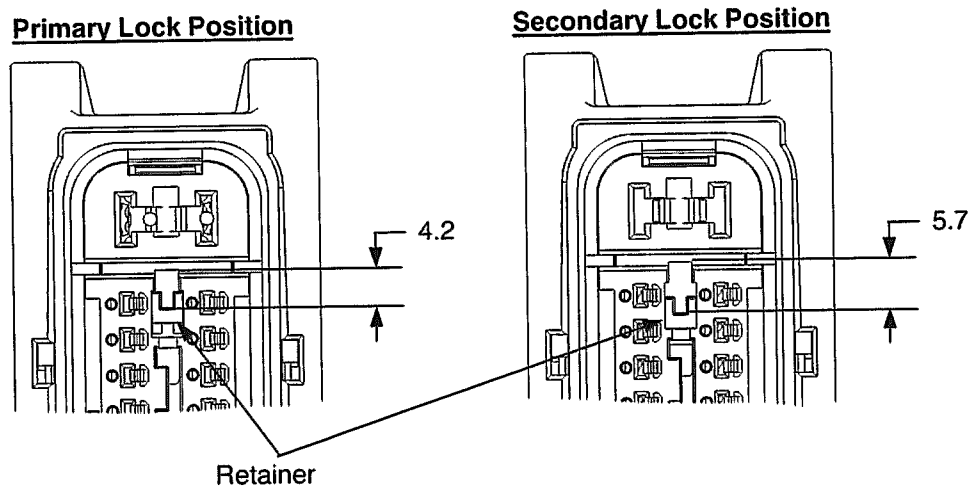


Fig. 8

- (2) Check to confirm the contact size. The contact size is distinguished by the housing cavity's shape.
- (3) Because the contact have an orientation with a direction ,the slide is on the right(see fig.9) and we suppose that vertical and horizontal are expressed.

.060 Receptacle Contact

Insert the contact on the condition of its dimple on one's right. Insert the contact in the back of cavity until a clicking sound is heard which is made by the action of the lance.

.187 Receptacle Contact

Insert the contact in the direction that top and down stabilizers are face to face. Insert the contact in the back of cavity until a clicking sound is heard which is made by the action of the lance.

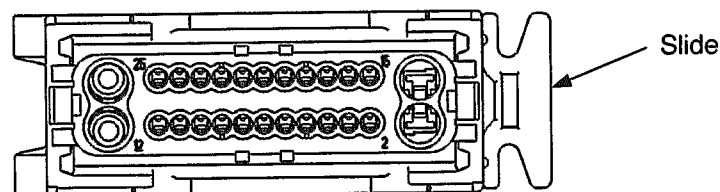


Fig. 9

By pulling the contact by 20N MAX, check to confirm that the contact can not be withdrawn.

NOTE When you insert contacts, you should have wire and take care the breakage of contact point.

5.2 How to Set Full Engagement of retainer

After all the contacts are correctly inserted into the connector cavities, the retainer is ready to be engaged per the following procedure:

Insert the watchmaker's screw driver of 1.2mm into the ditch of the retainer. Move the retainer to arrow and do on Secondary lock position.(See Fig.10) Moving Distance is 1.5mm.

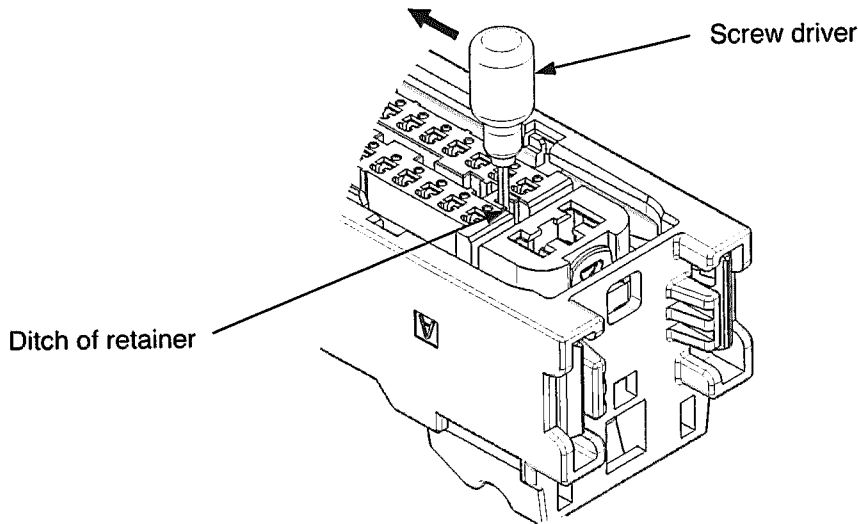


Fig. 10

When the retainer can not set full engagement for less than 29N, please stop to your operation.

As the half inserted contact is found, insert it to seated properly into the housing cavity, If the retainer forces to move to Secondary lock position, it makes deforming or defects of driver and connector.

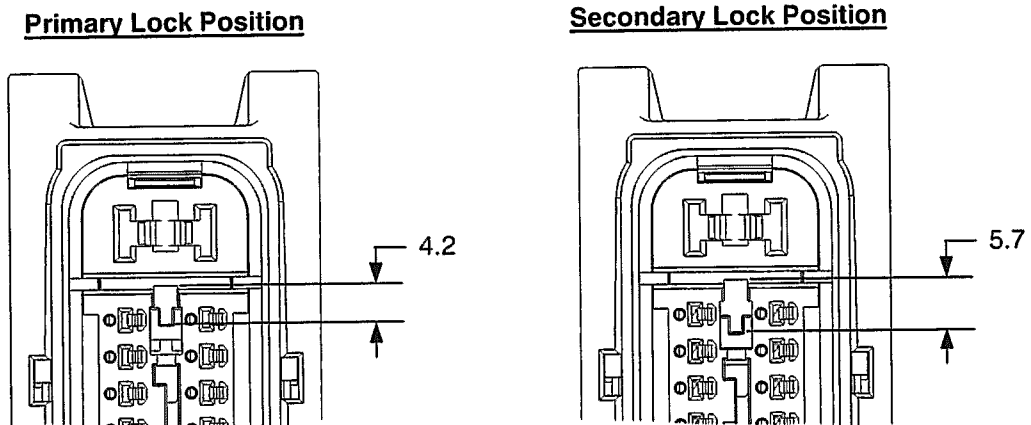


Fig. 11

5.3 How to return the retainer to primary set position

When the female terminal requires insertion or extension, check to confirm that the retainer is at Primary lock position.

Contact cannot be inserted into the housing cavity or removed at Secondary lock position.

In such cases, you need to know how to return the retainer to primary lock position according to the following sequence. (See Fig.12)

- (1) Insert a watchmaker's screw driver of 1.2mm flat width into the ditch of retainer
- (2) Move the retainer to arrow and return to Primary lock position.

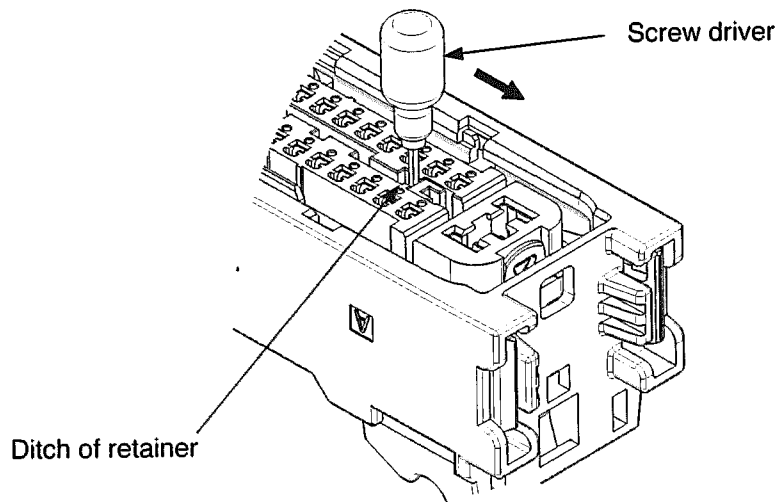


Fig. 12

Secondary Lock Position

Primary Lock Position

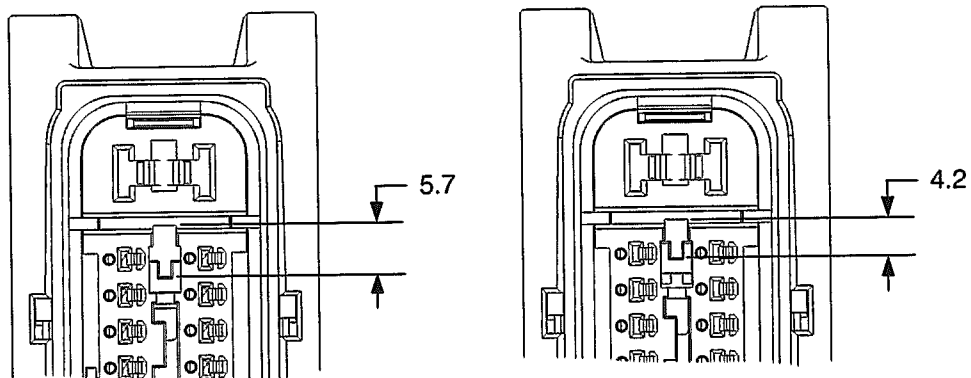


Fig. 13

5.4 Remove of Contact from Housing:

- (1) Set the double lock plate in the primary set condition, per the procedure described in section 5.3.
- (2) Push back the wire lead of the contact you wish to remove from the housing to relax the engagement, and hold it in position.
- (3) Keeping the wire lead in the push-in position, insert the tip end of watchmaker's screw driver between the locking lance end and contact while raising the locking lance in the direction of the arrow as indicated below. Avoid levering up the lance on the contact. This will cause deformation or bending of the contact. Raise the tool gently, just enough to unlock the lance.
- (4) At this point, pull back the crimping wire lead and the contact can be removed.

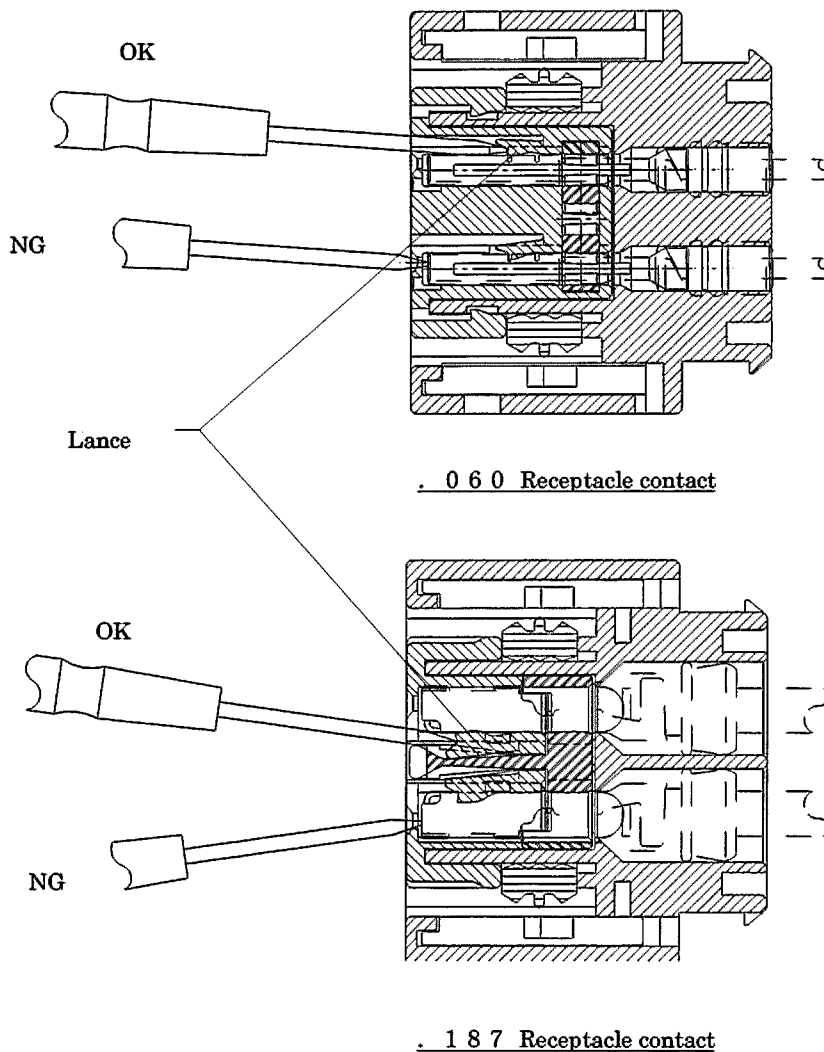


Fig. 14

5.5 Control of Harness

5.5.1 Handling

Don't apply excess force or shock to the connector and wire

5.5.2 Taping up wire

Tape up the wire at intervals of more than 30mm from the end of housing, not apply excess force to the wires.

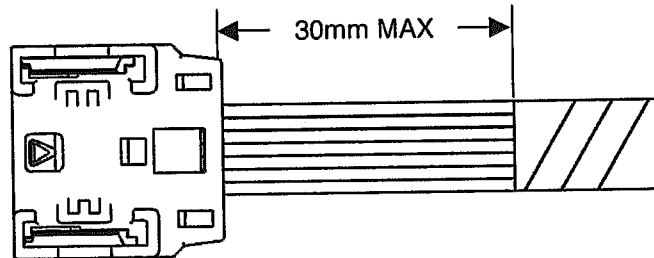


Fig. 15

5.5.3 Inspection of Electric Circuit

.060 Receptacle Contact

For inspection of electric circuit, use the hole by the probe pin.(See Fig.16)

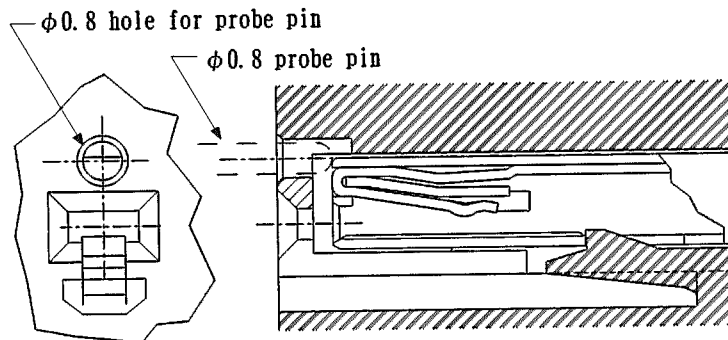


Fig. 16

.187 Receptacle Contact

For inspection of electric circuit, use checker pin.(See Fig.17)

Also don't apply that checker pin is inserted in the hole of cavity.

In this case ,the electrical performance of contact is not brought out.

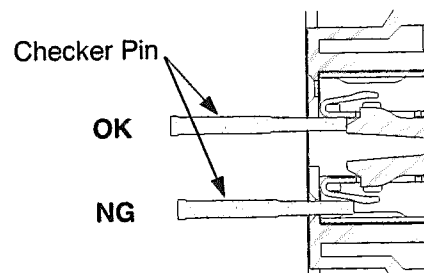


Fig. 17

NOTE Exchange the contact, if insert the probe pin into the female contact.

5.5.4 Storage

Avoid storing the connector in a moist or dusty place. Stock the connector away from direct sunlight

5.5.5 Shipping and Carrying

The connector should be used with the proper packaging to prevent the ingress of dust, moisture, etc.

6. Mating and Unmating of connector

6.1 Mating of connector

- (1) Check the condition of contact inserted into housing, the position of taping up wire, and the lock of retainer. If the retainer is Primary lock position, move the retainer to Secondary lock position. (Refer to 5.2)
- (2) Check the defects, deformation, discoloration, damage, rust, crack, deficit, etc. of housing and contact.

NOTE Exchange the connector, if any defects are found.

- (3) Pull out the slide of plug housing to arrow till it stops.
Connector can not be mated, if the slide is not pull out to the end.

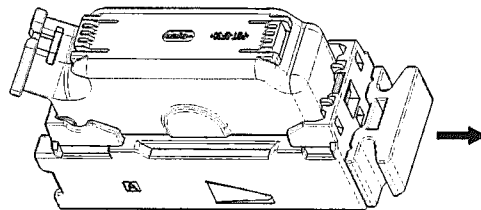


Fig. 18

NOTE When the slide is pull out to the end once ,don't apply to get back the slide till connector is mated. If the slide is gone back by constraint ,conector is damaged.

- (4) Insert the plug housing straight into the cap housing and mate the plug housing till it hustles against the cap housing.
Then ,move the slide to arrow till it hustles against the plug housing with holding in the plug housing's lift.
The operation is finished, if you can look at the slide from dints of plug housing. (See Fig.18)

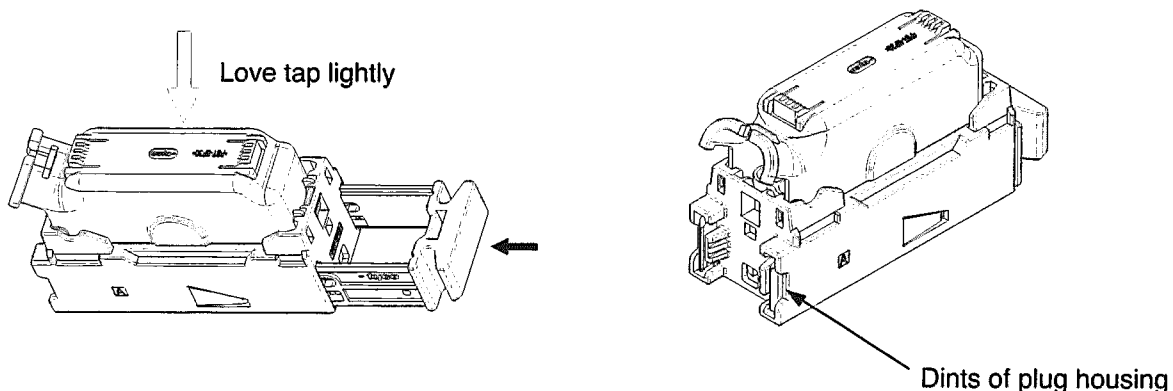


Fig. 19

NOTE Connector can not be mated, if the plug housing is mated till it hustles against the cap housing. Don't apply excess force, if you can't insert into the male housing, and check the items of (1)(2).

NOTE Don't apply excess force without the insertion direction at inserting.

6.2 Unmating connector

Pull out the slide of plug housing to arrow till it stops.

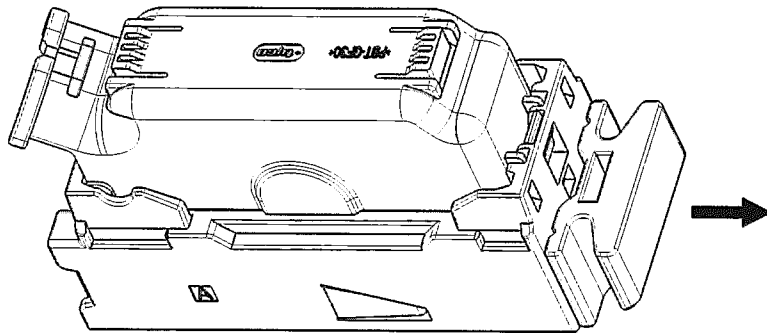


Fig. 20

6.3 General Attention Matters

- (1) Don't mate and unmate the connector unnecessarily.
- (2) Don't insert any objects except the proper connector.
- (3) Don't apply unnecessary force or shock to the wire and connector at mating and unmating operation.

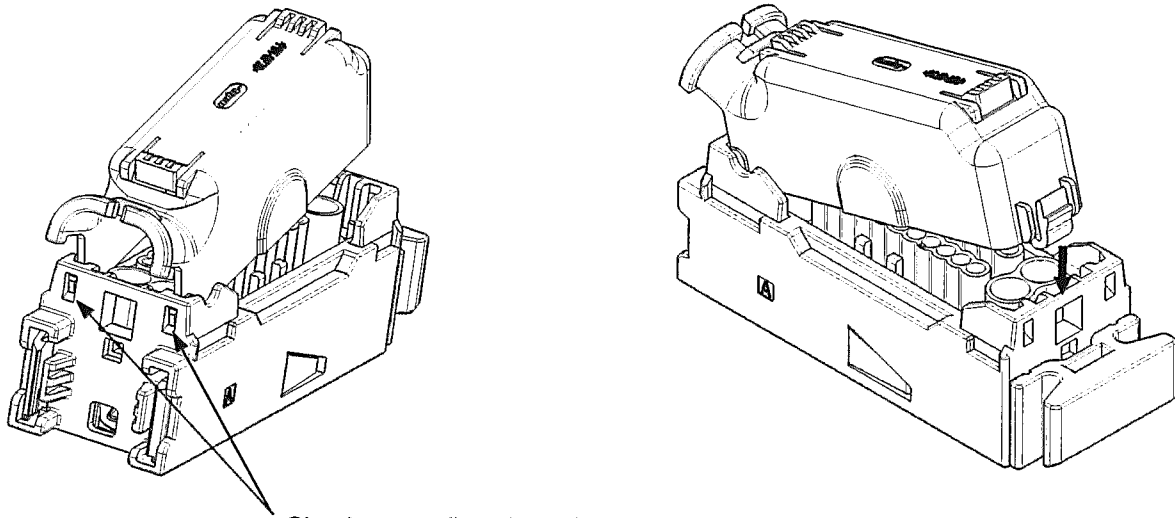
7. Wearing and taking off the Wire cover

7.1 Wearing the wire cover

The latches of wire cover is held on plug housing and lock the wire cover. (See Fig.20)

The operation is finished, if you can hear the lock sound and the wire cover can not be moved.

(See Fig.18)



Check to confirm that wire cover's two latches were locked to plug housing.

Fig. 21

7.2 Taking off the wire cover

Remove the wire cover from plug housing while pressing the lock of wire cover with screw driver. (See Fig.21)

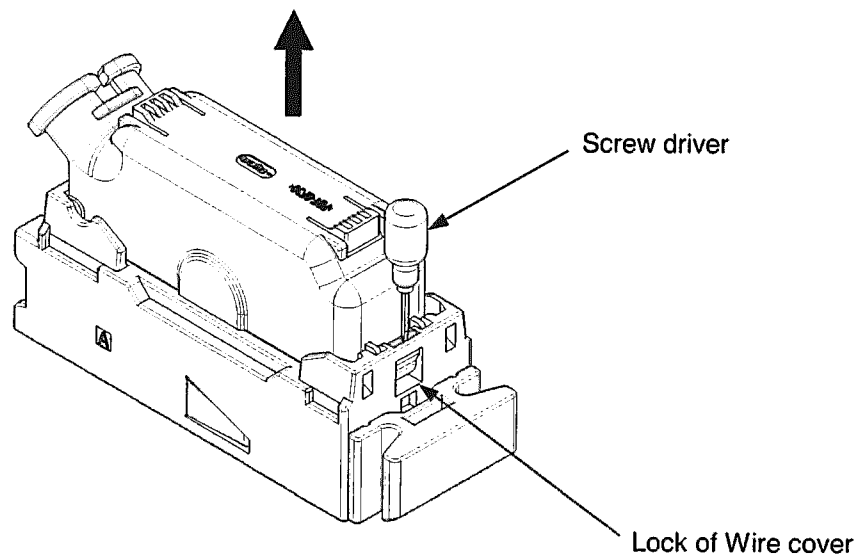


Fig. 22