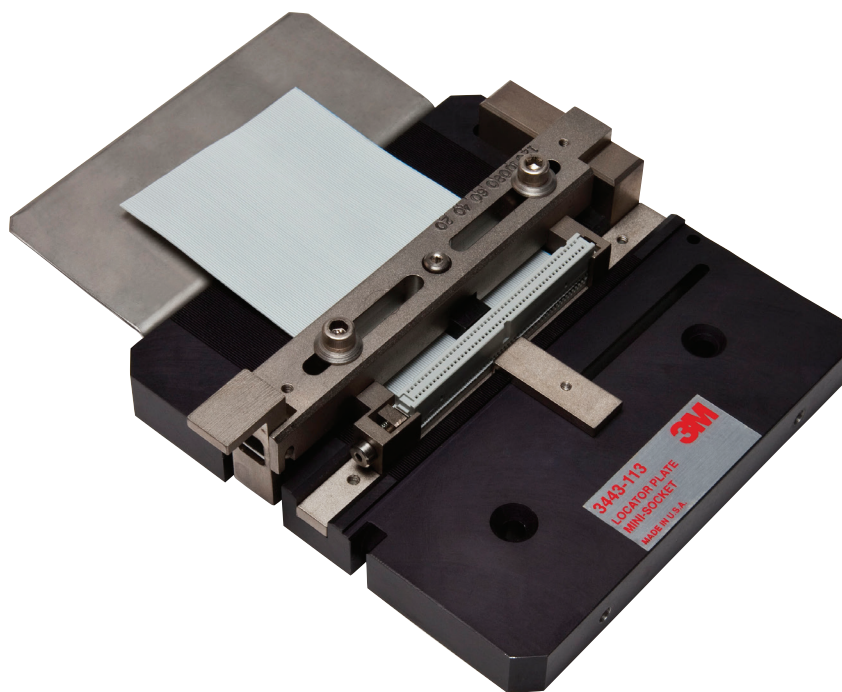


3M™ Locator Plate 3443-113

Instructions for the Assembly of 3M™ Tripolarized Wiremount Sockets



1.0 General

The 3M Locator Plate 3443-113 was designed to aid in the assembly of the 3M Mini Socket Connector .50 x .100 inch. End terminations, as well as daisy chain terminations can be made. Set up and assembly instructions are based on termination procedures with the 3M™ Manual and Pneumatic Presses.

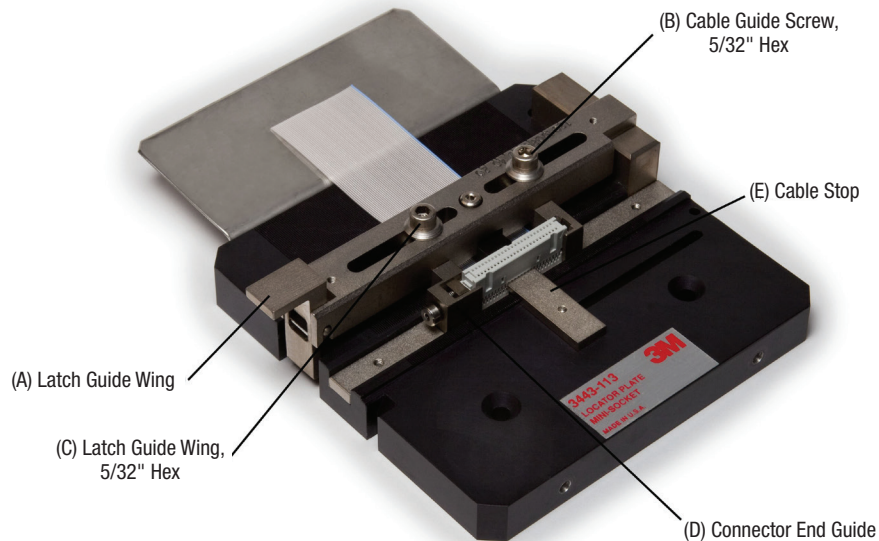
The 3M Locator Plate kit includes:

- Instruction Sheet
- Three Mounting Screws
- 3M™ Shut Height Gauge 3436-1H

Note: The locator plate 3443-113 does not include platen or pleated foil accessories. These items must be ordered separately.

2.0 3M™ Locator Plate 3443-113 Adjustment

Adjustments to the 3M Locator Plate should be made before being mounted on the 3M™ Assembly Press.



3M™ Locator Plate 3443-113

- 2.1 Release the latch (A) on the guide wing.
- 2.2 Loosen the cable guide screw (B) and move it to the number corresponding to connector to be terminated. **(DO NOT TIGHTEN)**
- 2.3 Bring the guide wing to the down position and latch by pushing down on the top of the latch (A).
- 2.4 Tighten cable guide screw (B). (5/32" Hex wrench).
- 2.5 Loosen cable guide screw (C), nearest the latch.
- 2.6 Position the cable to be used on the grooved side of the locator plate and up against cable guide (B). Push the cable all the way under the guide wing and over the center of the plate. make sure cable is in contact with cable guide (B).
- 2.7 Release the latch (A). Position the loose cable guide (C) against the cable. Latch the guide wing (A), and tighten cable guide screw (C).

Note: Check to make sure cable is in contact with both cable guides (B) & (C) and cable conductors aligned in the locator plate grooves.

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. The 3M™ Press 3335 is adjusted with the collar on the press shaft, and 3M™ Press 3830 is self-adjusting. Use the 3M™ Shut Height Gauge 3436-1H with the 3M™ Locator Plate 3443-113.

- 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)

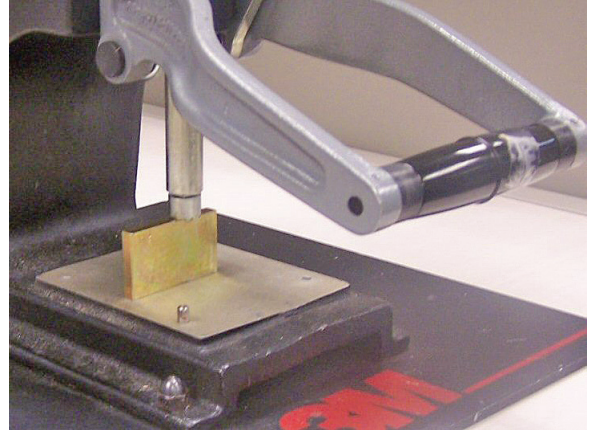


Figure 2

- 3.4 Rotate the shut height to lower or raise adjustment feature until the bottom of the shaft contacts the desired position on the shut height gauge. (Figure 3 and 4)

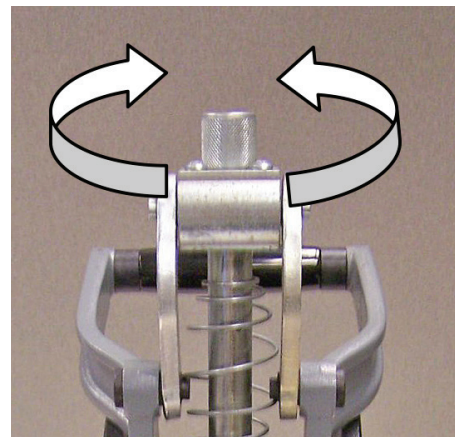


Figure 3 — 3M™ Press 3640
Shut Height Adjustment Knob
CW — Lower
CCW — Raise

- 3.5 Install the locator plate and 3M Platen 3442-9 on the press. The platen should be positioned parallel with the connector body and cover.

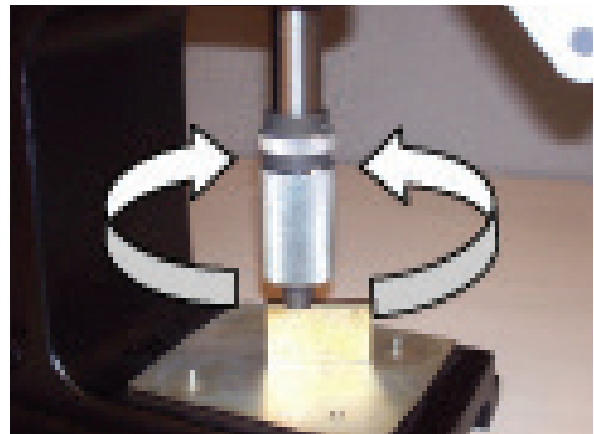


Figure 4

4.0 Harness Assembly

When making assemblies with a connector spaced 1.50" and greater, the following instructions should be followed. For assemblies with a connector spaced between .62 and 1.50", refer to the pleated foil cable assembly method omitting steps seven and ten.

End Termination

1. Release the latch and raise the guide wing (A).
2. Position the cable stop (E) midway between the cable guides (B & C), and latch the guide wing into position (A).
3. Load the connector cover in the slot between the connector end guides (D).
4. Insert cable between the cable guides (B & C) and push until the cable comes in contact with the cable stop (E). Push down on the center of the cable making sure the cable conductors are aligned with the grooves in the locator plate.
5. Place the connector body between the connector end guides (D), and push down until it contacts the cable.
6. Bring the platen to the full down position to complete the assembly.
7. Hold the terminated connector down while releasing the latch (A), and raising the guide wing (A).
8. Remove the assembly connector.

Note: Check if the metal latches are fully seated. If adjustment is required, repeat the steps in the platen installation section.

Daisy Chain Termination

Terminate Mid-Span Connectors Prior to End Termination.

1. Release the latch (A) and raise the guide wing enough to slide the cable stop to the outermost location.
2. Latch the guide wing.
3. Load the connector cover in the slot between the connector end guides (D).
4. Feed the cable under the guide wing (A) over the cover to the location where the connector is to be assembled.
5. Place the connector body between the connector end guides (D), and push down until it contacts the cable.
6. Bring the platen to the full down position to complete the assembly.
7. Hold the terminated connector down while releasing the latch and raising the guide wing.
8. Remove the assembled connector.

Pleated Foil Cable

1. Attach the 3M™ Pleated Foil Extension Tray 3682-6 with the cable retainer (1) attached, with the two screws provided.
2. Attach the pleated foil clamp (2), with the screw provided.

Cable Preparation

A minimum of .50" of cable has to be exposed to termination.

Cable Assembly

1. Release the latch (2), on the PF clamp and pivot it out of the way.
2. Release the latch and raise the guide wing (A), enough to slide the cable stop (E), to the end of the locator plate.
3. Latch the guide wing (A).
4. Load the connector cover in the slot between the connector end guides - (D).
5. Place the prepared cable up against the pleated foil stop (H) and between the connector end guides - (D).
6. After checking the alignment of the cable, rotate the PF clamp (2) - over the cable and latch it in place by pressing down on the top of the latch.
7. Latch the cable retainer (1) over the extending cable jacket.
8. Place the connector body between the connector end guides (D) - and push down until it contacts the cable.
9. Bring the assembly press to the full downward position terminating the assembly.
10. Release the latch on the cable retainer (1) and rotate it out of the way.
11. Release the latch on the PF clamp (2) and rotate it out of the way.
12. Remove the assembled connector by lifting upward.

Customer and Technical Service

Within the U.S.:

Customer Service: 800-225-5373

Technical Support: 512-984-6703

Outside of the U.S.:

For customer service and technical support, please contact your local 3M Electronic Solutions Division representative.

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