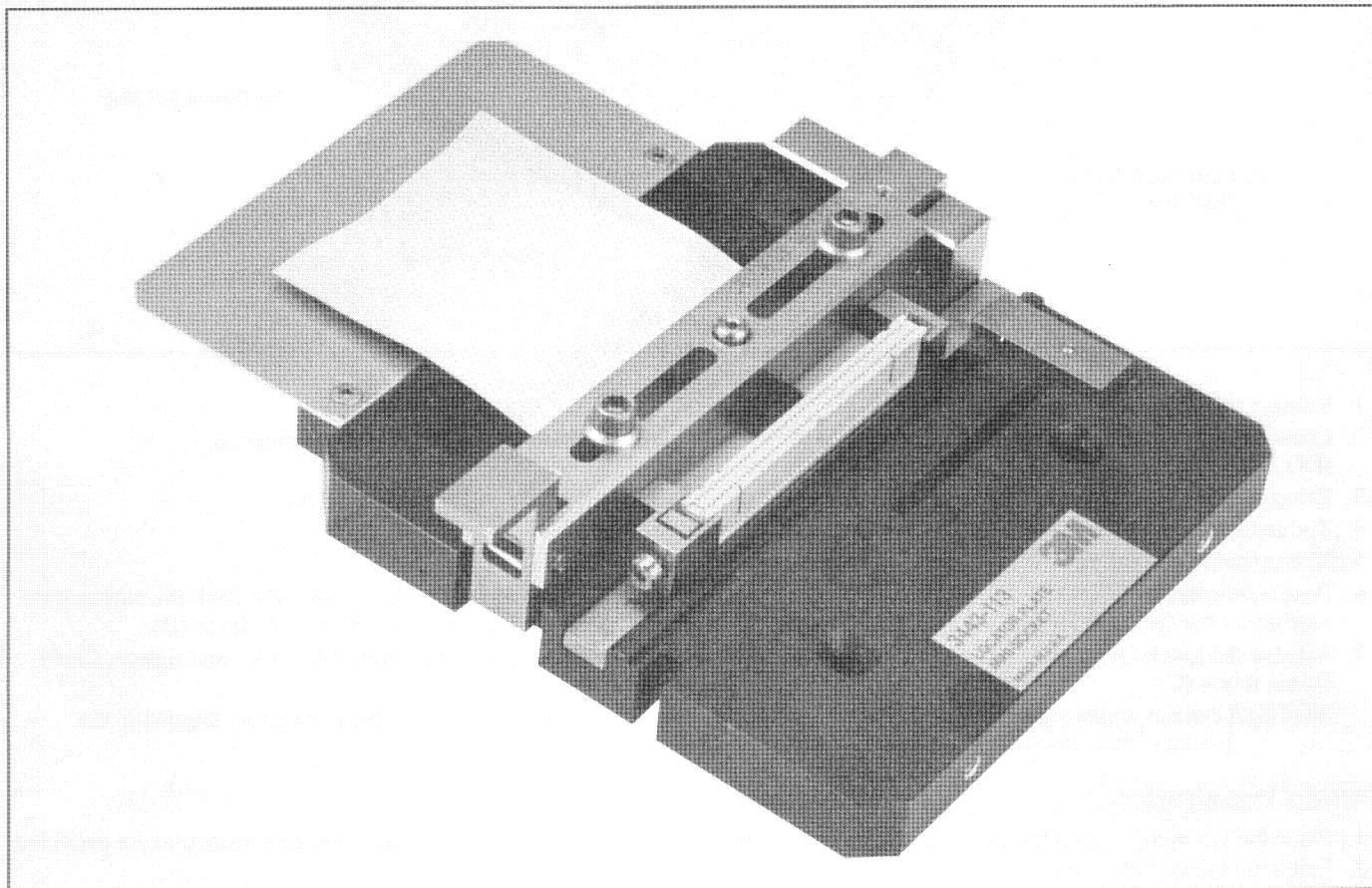


Instruction Sheet

3M

Mini Sockets

Assembly Using Locator Plate 3443-113



1

General

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

Locator Plate Includes:

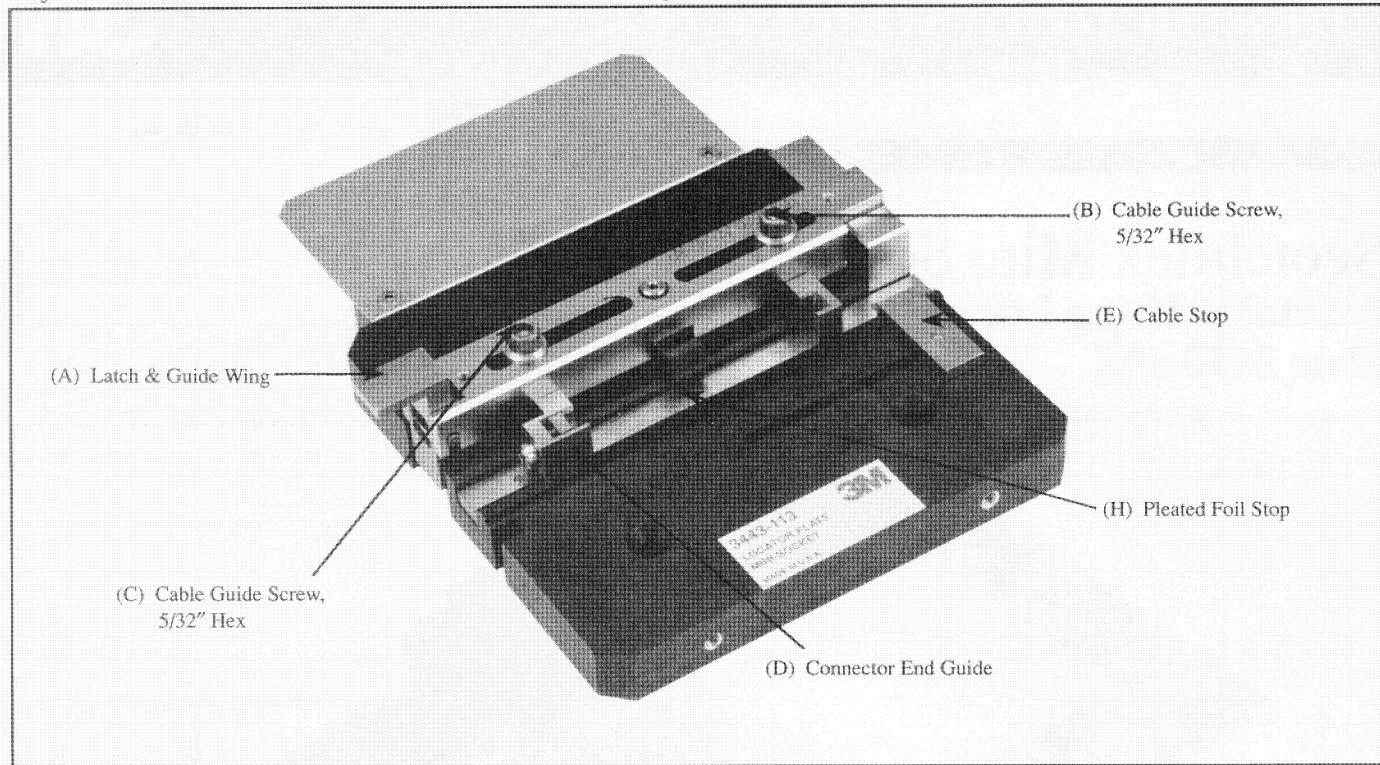
Instruction Sheet
3 Mounting Screws

Note:

The 3443-113 Locator Plate does not include Platens and Pleated Foil accessories. These Items must be ordered separately.

Locator Plate Adjustment

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



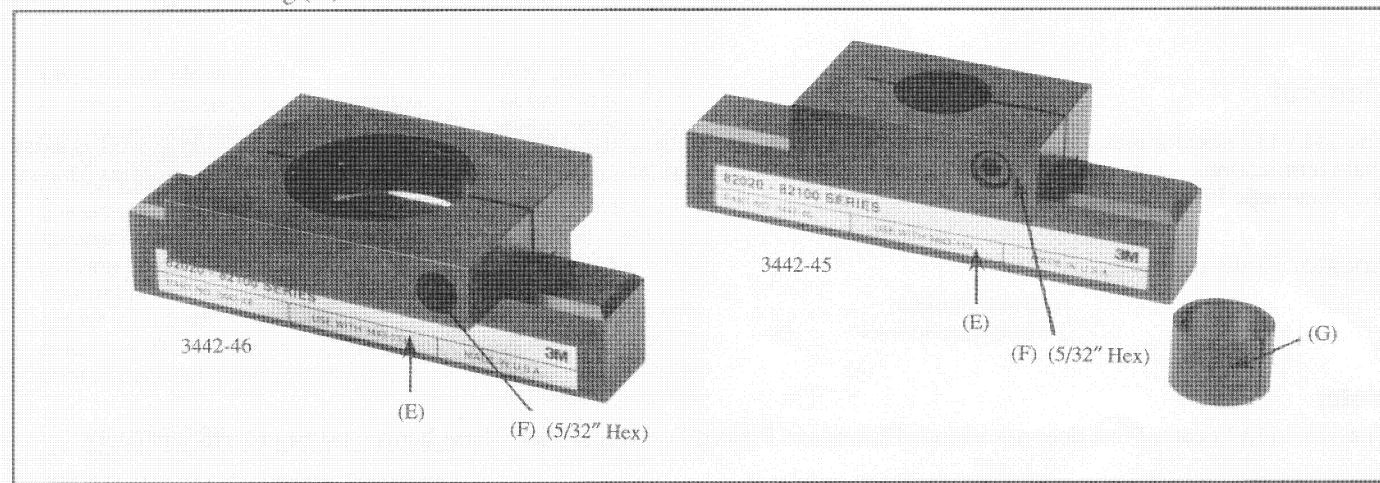
2

1. Release the latch (A) on the Guide Wing.
2. Loosen the cable guide screw (B) and move it to the number corresponding to connector to be terminated. (DO NOT TIGHTEN).
3. Bring the Guide Wing to the down position and latch by pushing down on the top of the Latch (A).
4. Tighten cable guide screw (B). (5/32" Hex wrench).
5. Loosen cable guide screw (C), nearest the latch.
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).
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.

Platen Installation

1. Place the Locator Plate on the Press, positioning it on the studs or securing it with the two flat head screws that are provided.
2. Latch the Guide Wing (A).



3

Assembly Press 3335

- a. Install the 3442-46 Platen on the press shaft with the Label (E) and Clamping Screw (F) facing the Locator Plate Guide Wing (A).
- b. Bring the Assembly Press handle to the down position with the platen parallel to the Guide Wing (A) and in contact with the Connector End Guides (D).
- c. Adjust the Press Shaft by turning the lower adjust nut in a clockwise direction until it is seated in the platen.
- d. Secure the Platen to the shaft by tightening the Clamp Screw (F).
- e. Secure the lock nut on the Press Shaft to prevent the platen from rotating and raise the Press Handle.

Assembly Press 3316

- a. Remove the Split Ring (G) from the 3442-45 Platen.
- b. Install the 3342-45 Platen on the press shaft with the Label (E) and the Clamping Screw (F) facing the Locator plate Guide Wind (A).
- c. With the Platen parallel to the Guide Wing (A), and the Platen resting on the Connector End Guides (D), lower the Press handle to the full downward position.
- d. Adjust the shaft using the adjustment knob at the top.
- e. When the Shaft is fully seated in the platen, secure it to the shaft by tightening the Clamping Screw (F).

Assembly Press 3640

- a. Insert the Split Ring (G) into the 3442-45 Platen.
- b. Follow the instructions for the 3316 Assembly Press.

Assembly Press 3830

- a. Turn off the air supply to the press.
- b. Install the 3442-45 Platen with the Split Ring (G) removed.
- c. Orient the Platen as mentioned in Step b of the 3316 Assembly Press instructions.
- d. Manually pull the Press shaft down and seat it in the 3442-45 platen.
- e. Secure the Platen with the Clamping Screw (F).
- f. Return the Platen and shaft to the starting position, and adjust the air pressure to 100 psi.

Harness Assembly

When making assemblies with connector spaced 1.50 and **greater** the following instruction should be followed. For assemblies with connector spacing between .62 and 1.50 inches refer to the pleated foil cable assembly method omitting steps 7 & 10.

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.

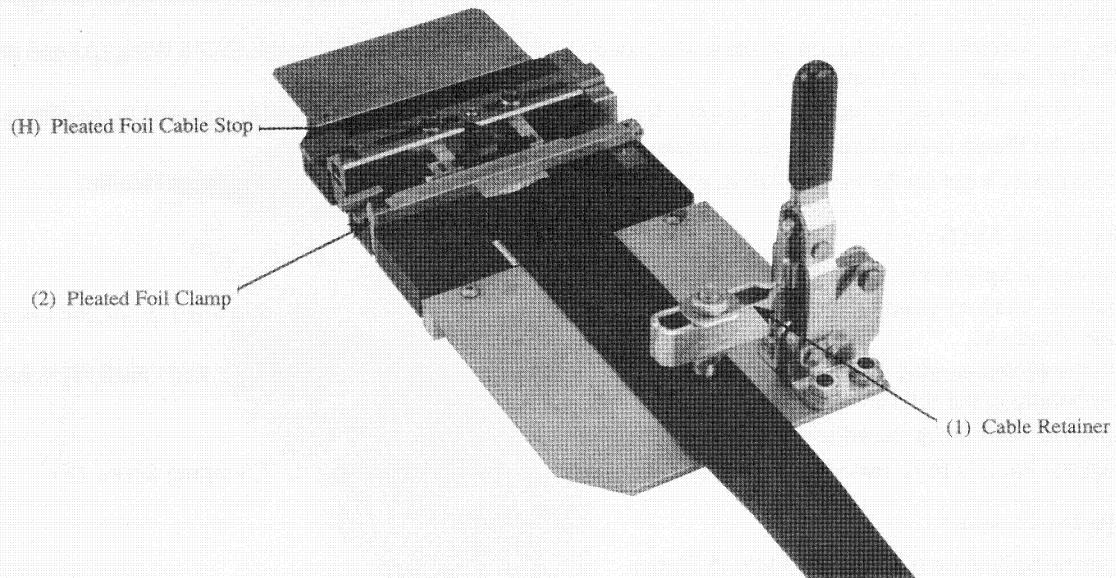
NOTE: Check if the metal latches are fully seated. If adjustment is required, repeat the steps in the Platen Installation section.

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



4

1. Attach the 3682-6 Pleated Foil Extension tray 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 inches of cable has to be exposed for 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.

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