

ASSEMBLY INSTRUCTIONS

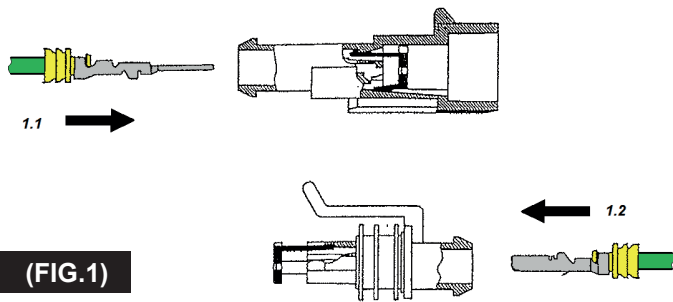
FOR SERIES 1.5 HOUSINGS

1) Harness assembly operation (FIG.1)

1.1) Insertion of crimped contacts into tab housing

1.2) Insertion of crimped contacts into plug housing

Contacts can be inserted into housing cavities in one position only. The correct placing is shown below.

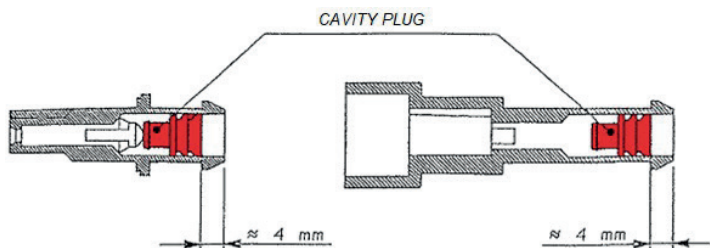


(FIG.1)

After insertion of a contact, pull back the wire lightly to check if the contact is securely locked in position.

1.3) Insertion of cavity plug. (FIG.2)

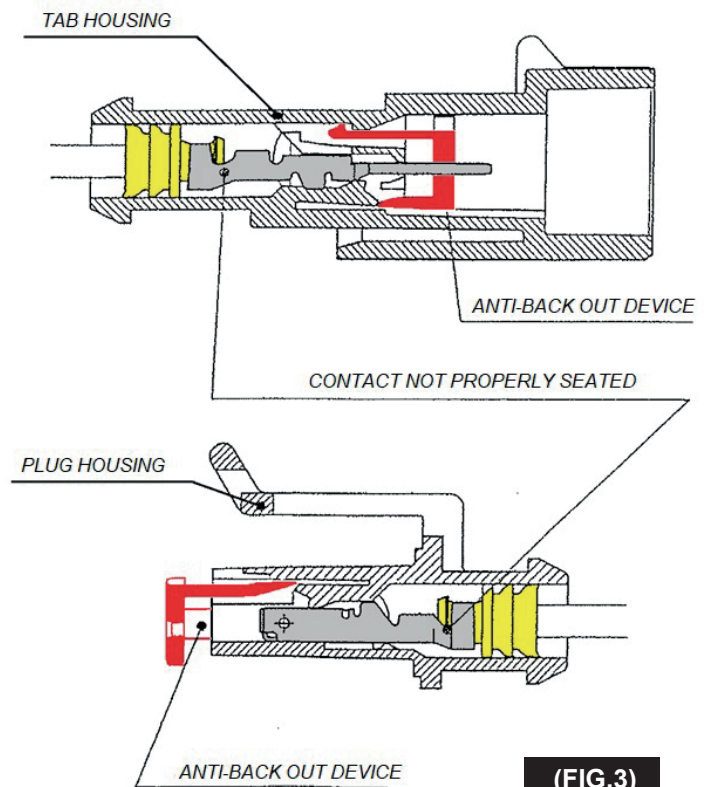
Red cavity plug must be used when some cavity is not loaded with contacts, to prevent the ingress of water. Insert it deeply into the cavity by means of a pin as shown. (FIG.2) If necessary, it can be removed by a pin point.



(FIG.2)

1.4) Positioning of anti-back out device

The 1.5 series connectors are supplied with an anti-back out device, pre-assembled on both receptacle and tab housings. After loading of all crimped contacts, these devices must be pushed in closed position. If one contact is not properly seated in the cavity, the plastic locking lance remains deflected, the anti-back out device can't be closed. This condition is a warning for the user. Moreover, with this device not closed, the mating with the counterpart can't be completed.



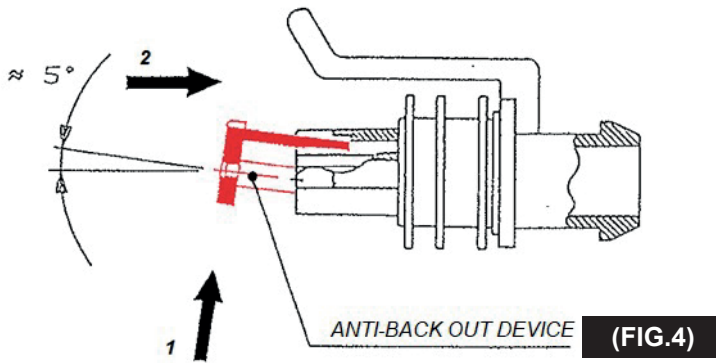
(FIG.3)

1.4.1) Closing the anti-back out device of plug housing

Montage manuel (FIG.4)

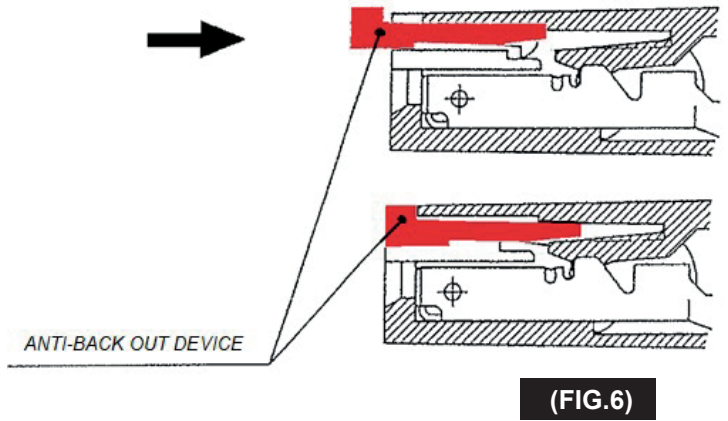
For 2 or more positing plugs, the sequence is:

- Rotate the device to deflect the central lances inwardly (1)
- Then push till to the locking of the side arms (2).



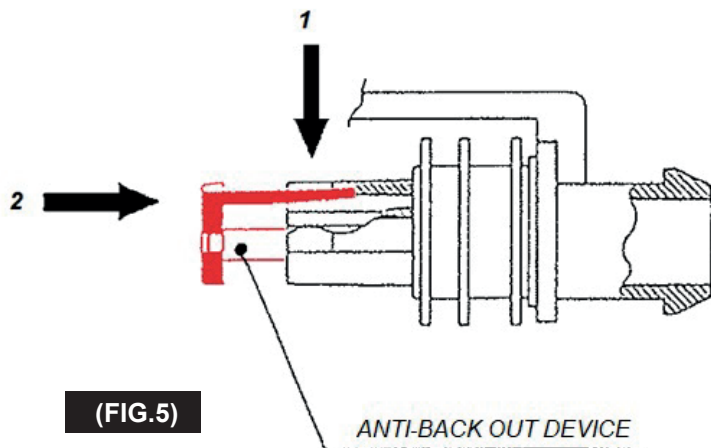
For 1 position plug housing (FIG.6)

- Push the device till its upper end is at the same level of the housing mating face.



Assembly by harness maker machine (FIG.5)

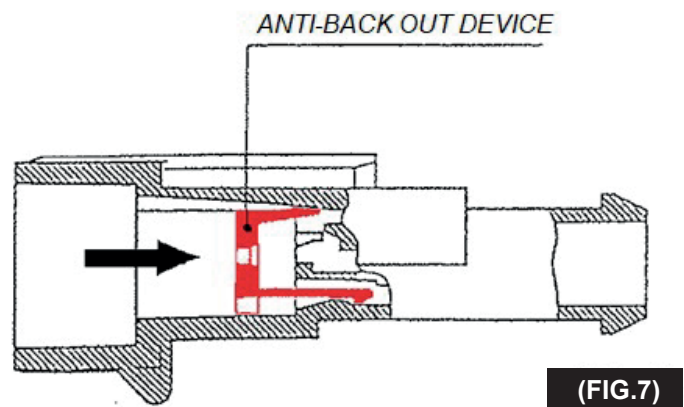
- For 2 or more positing plugs, the sequence is:
- Push inwardly the lances (1)
- Then push till to the locking of the side arms (2)



1.4.2) Closing the anti-back out device of tab housing

For 1 to more position, manually or machine operated:

- Push the device by a jig till the stop. (Different jigs are requested for 1 and 2 position housings and to 3 and more position housings).



1.5) Removal of contacts

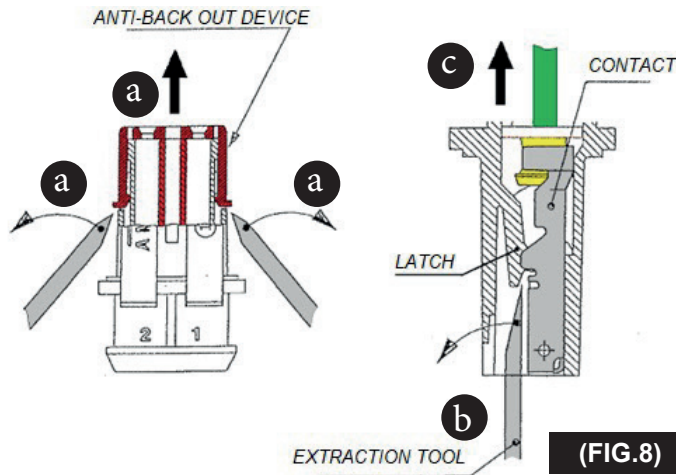
Since the locking lance of contacts can be reached from the mating side of the housings, it is necessary firstly to remove the anti-back out device.

1.5.1) Removal of receptacle contact (FIG.8)

(a) Deflect the side arms of anti-back out device and pull it away.

(b) Insert the contact extraction tool between contact and lance nose, then rotate it slightly as shown.

(c) Pull the wire.



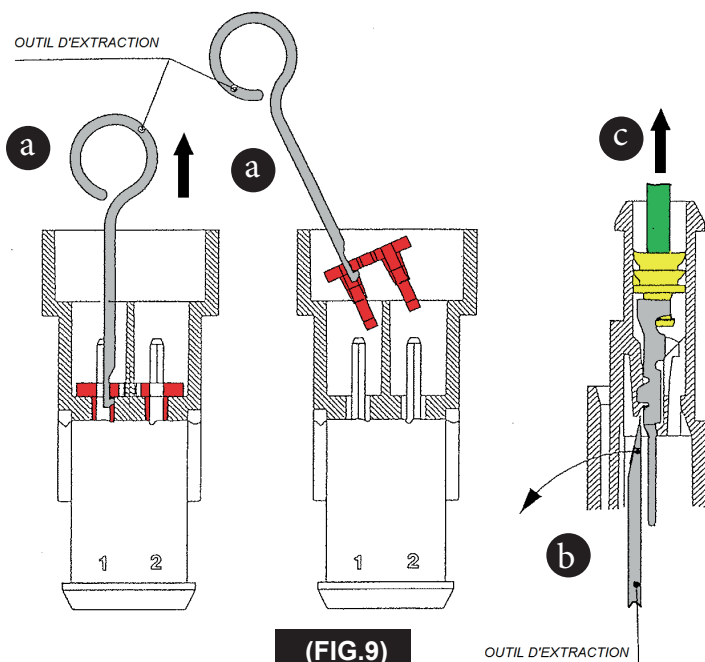
Caution: be careful not to insert the extraction tool in the contacting area of receptacle.

1.5.2) Removal of tab contact (FIG.9)

(a) Insert the extraction tool in one of central holes of anti-back out device and pull it away

(b) Insert the contact extraction tool between contact and lance nose, then rotate it slightly as shown.

(c) Pull the wire.



Caution: rotating the extraction tool, be careful not to deform the tab.

2) Repair and maintenance

During repair and maintenance operation of wirings, replacement of contacts may occur. In such cases, the following procedure is recommended.

- Cut off the wire of defective contact you have to remove.
- Strip the wire insulation for the length requested by application specification, according to the section of wire itself.
- Slide the new wire seal over the wire.
- Crimp the new contact.

3) Panel mount option (FIG.10)

The tab housings are provided with two (L) shaped guides in which can be inserted a special elastic clip, allowing the panel mounting of the connector.

(see P/N below)

- 11138 for 6.2x12.2 mm oblong punched hole mounting



- 12703 for Ø 6.5 mm punched hole mounting

