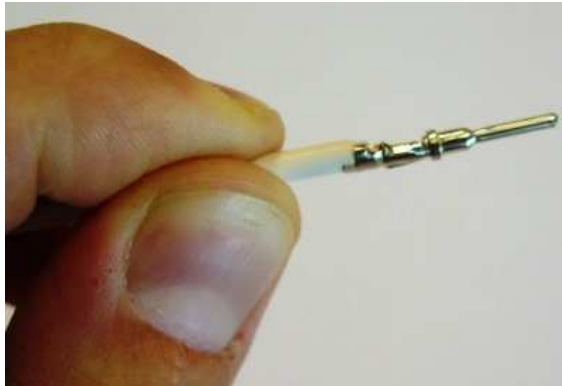




XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

PLUG AND RECEPTACLE ASSEMBLY

TERMINAL INSERTION



1

Grasp the terminal approximately 1 inch (25.4mm) behind insulation crimp.



2

Hold the connector with the wire seal grommet facing the terminal.

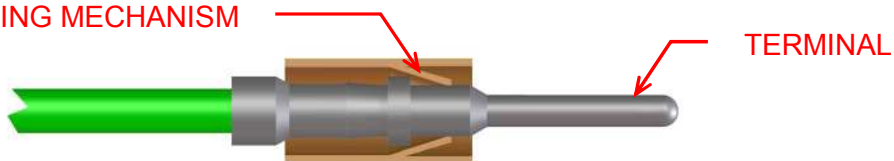
Note: For unused wire cavities, insert sealing plugs for full environmental sealing.



3

Push the terminal straight into the connector until a positive stop is felt. A slight tug will confirm that it is properly locked into place.

LOCKING MECHANISM



TERMINAL BEING PUSHED INTO THE LOCKING MECHANISM



TERMINAL LOCKED INTO POSITION

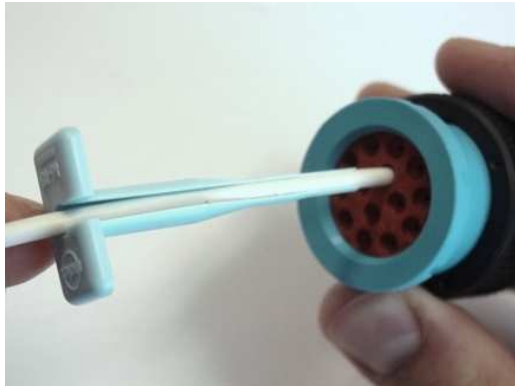
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|--|--|--|---|--|
| <u>REVISION:</u> A | <u>ECR/ECN INFORMATION:</u> <u>EC No:</u> WNA2010-0052 <u>DATE:</u> 2009 / 07 / 22 | <u>TITLE:</u> ASSEMBLY INSTRUCTIONS FOR XRC™ (EXTRA RUGGED CIRCULAR) SEALED CONNECTORS | <u>SHEET No.</u> 1 of 4 | |
| <u>DOCUMENT NUMBER:</u> AS-84501-001 | | <u>CREATED / REVISED BY:</u> W. LEUNG | <u>CHECKED BY:</u> T. MOELLER | <u>APPROVED BY:</u> D. TITUS |



XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

PLUG AND RECEPTACLE ASSEMBLY

TERMINAL EXTRACTION



1

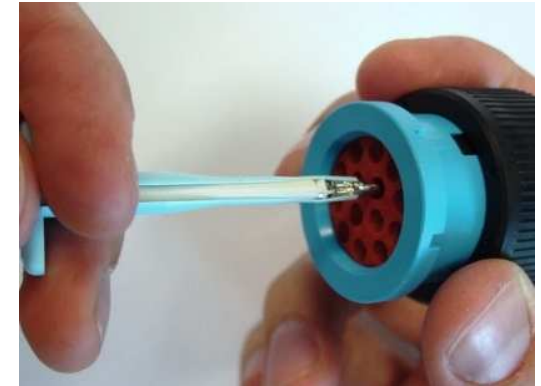
Hold the connector with the wire seal grommet facing the appropriate size extractor tool. Snap the tool onto the terminal wire.



2

Slide tool along the wire into the insert cavity until it engages the terminal and resistance is felt.

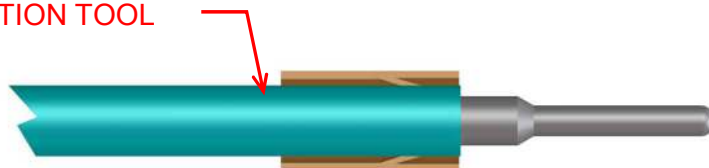
Note: Do not twist or insert tool at an angle.



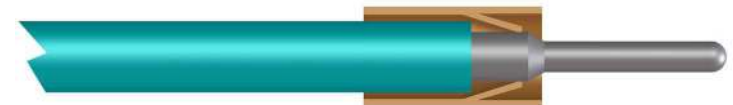
3

Pull the terminal wire lead along with the tool out of the connector.

EXTRACTION TOOL



**EXTRACTION TOOL INSERTED
TO UNLOCK TERMINAL**



TOOL AND TERMINAL BEING REMOVED

| | | | |
|--|--|--|--|
| <u>REVISION:</u> A | <u>ECR/ECN INFORMATION:</u> <u>EC No:</u> WNA2010-0052 <u>DATE:</u> 2009 / 07 / 22 | <u>TITLE:</u> ASSEMBLY INSTRUCTIONS FOR XRC™ (EXTRA RUGGED CIRCULAR) SEALED CONNECTORS | <u>SHEET No.</u> 2 of 4 |
| <u>DOCUMENT NUMBER:</u> AS-84501-001 | <u>CREATED / REVISED BY:</u> W. LEUNG | <u>CHECKED BY:</u> T. MOELLER | <u>APPROVED BY:</u> D. TITUS |

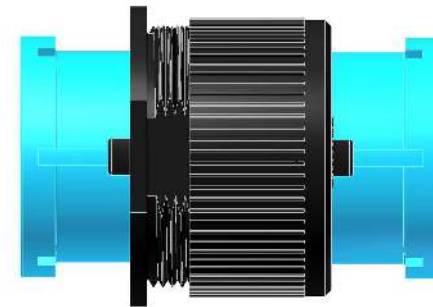
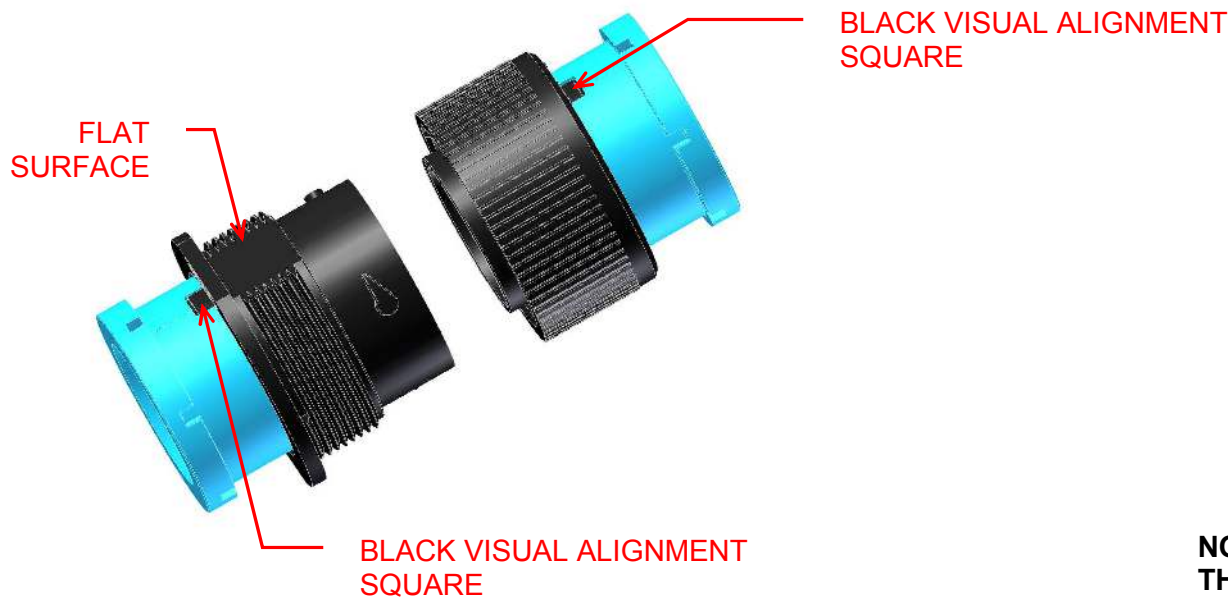


XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

MATING/UNMATING PROCEDURE FOR XRC™ 18-14 CONNECTOR

A. TO MATE THE PLUG TO THE RECEPTACLE –

1. LINE UP THE BLACK VISUAL ALIGNMENT SQUARE ON THE PLUG WITH EITHER THE FLAT SURFACE OR THE BLACK VISUAL ALIGNMENT SQUARE ON THE RECEPTACLE.
2. TURN THE COUPLING RING ¼ TURN CLOCKWISE UNTIL A POSITIVE STOP IS FELT.



NOTE:
THERE WILL BE A TACTILE AND AUDIBLE FEEDBACK WHEN MATED CORRECTLY.

B. TO UNMATE THE PLUG FROM THE RECEPTACLE, REVERSE THE ABOVE PROCEDURE.

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|--|--|--|--|
| <u>REVISION:</u> A | <u>ECR/ECN INFORMATION:</u> EC No: WNA2010-0052 DATE: 2009 / 07 / 22 | <u>TITLE:</u> ASSEMBLY INSTRUCTIONS FOR XRC™ (EXTRA RUGGED CIRCULAR) SEALED CONNECTORS | <u>SHEET No.</u> 3 of 4 |
| <u>DOCUMENT NUMBER:</u> AS-84501-001 | <u>CREATED / REVISED BY:</u> W. LEUNG | <u>CHECKED BY:</u> T. MOELLER | <u>APPROVED BY:</u> D. TITUS |

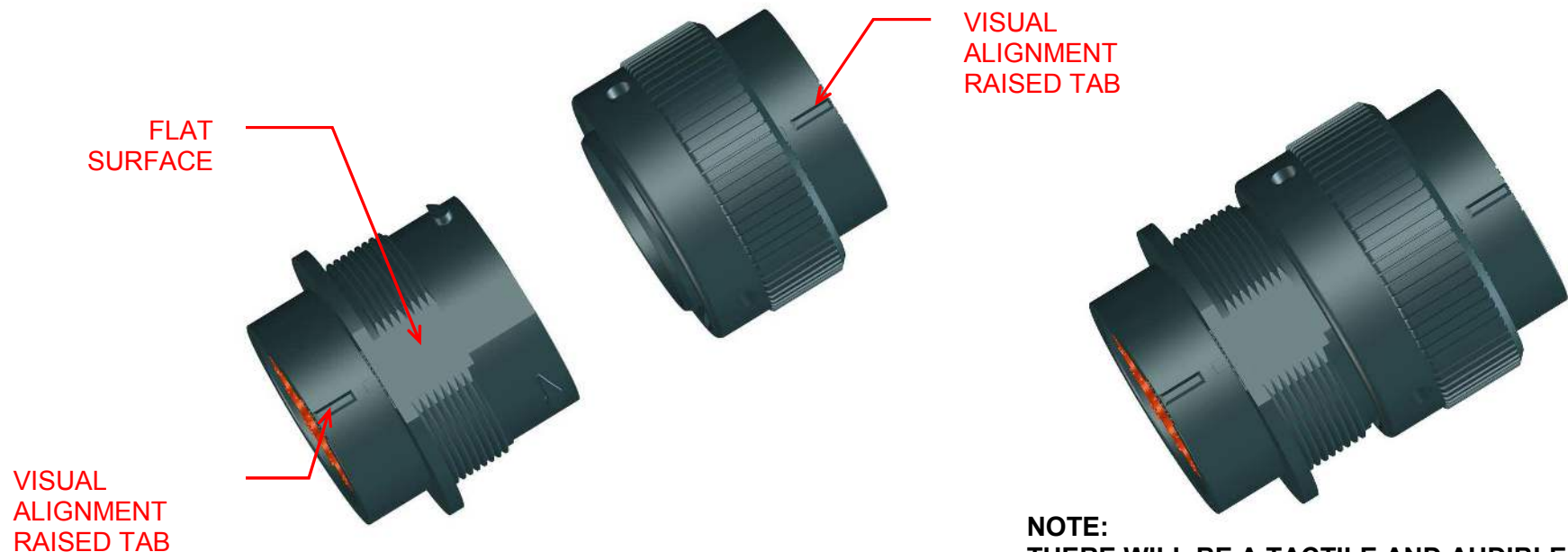


XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

MATING/UNMATING PROCEDURE FOR XRC™ 24-31 CONNECTOR

A. TO MATE THE PLUG TO THE RECEPTACLE –

1. LINE UP THE VISUAL ALIGNMENT RAISED TAB ON THE PLUG WITH EITHER THE FLAT SURFACE OR THE VISUAL ALIGNMENT RAISED TAB ON THE RECEPTACLE.
2. TURN THE COUPLING RING ¼ TURN CLOCKWISE UNTIL A POSITIVE STOP IS FELT.



NOTE:
THERE WILL BE A TACTILE AND AUDIBLE FEEDBACK WHEN MATED CORRECTLY.

B. TO UNMATE THE PLUG FROM RECEPTACLE, REVERSE THE ABOVE PROCEDURE.

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| REVISION: A | ECR/ECN INFORMATION: EC No: WNA2010-0052 DATE: 2009 / 07 / 22 | TITLE: ASSEMBLY INSTRUCTIONS FOR XRC™ (EXTRA RUGGED CIRCULAR) SEALED CONNECTORS | SHEET No. 4 of 4 |
| DOCUMENT NUMBER: AS-84501-001 | CREATED / REVISED BY: W. LEUNG | CHECKED BY: T. MOELLER | APPROVED BY: D. TITUS |