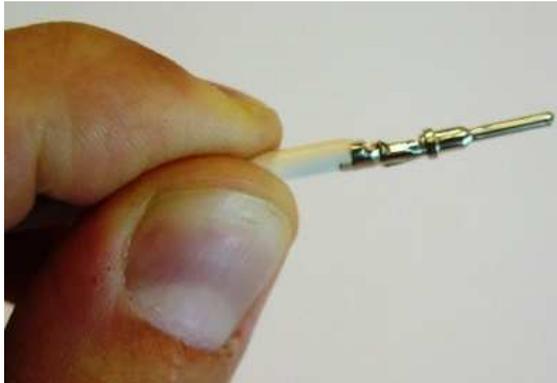




# XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

## PLUG AND RECEPTACLE ASSEMBLY

### TERMINAL INSERTION



1

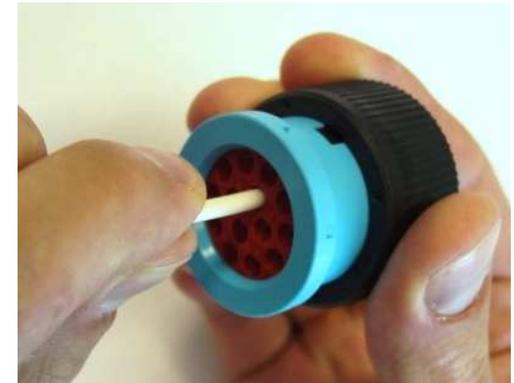
Grasp the terminal approximately 1 inch (25.4mm) behind insulation crimp.



2

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

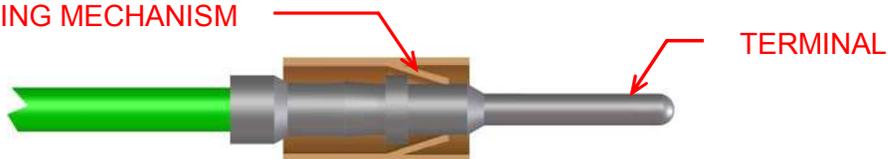
**Note:** For unused wire cavities, insert sealing plugs for full environmental sealing.



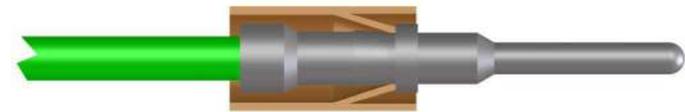
3

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

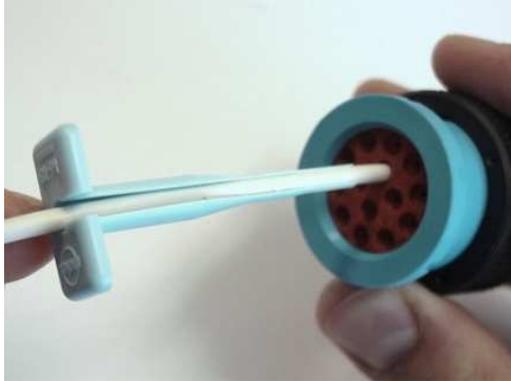
<u>REVISION:</u>  <b>A</b>	<u>ECR/ECN INFORMATION:</u> <u>EC No:</u> WNA2010-0052 <u>DATE:</u> 2009 / 07 / 22	<u>TITLE:</u> <b>ASSEMBLY INSTRUCTIONS          FOR XRC™ (EXTRA RUGGED CIRCULAR)          SEALED CONNECTORS</b>	<u>SHEET No.</u>  <b>1 of 4</b>	
<u>DOCUMENT NUMBER:</u> <b>AS-84501-001</b>		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



# 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.

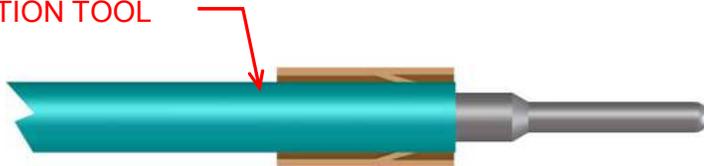
**Note:** Do not twist or insert tool at an angle.



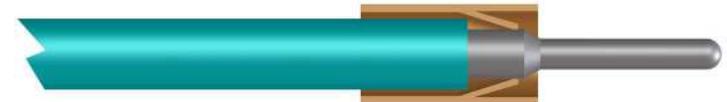
3

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

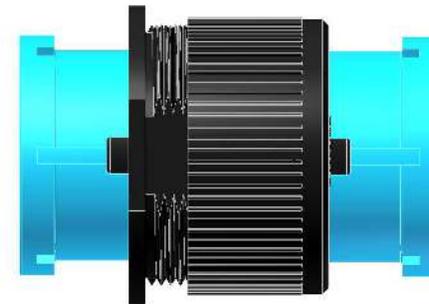
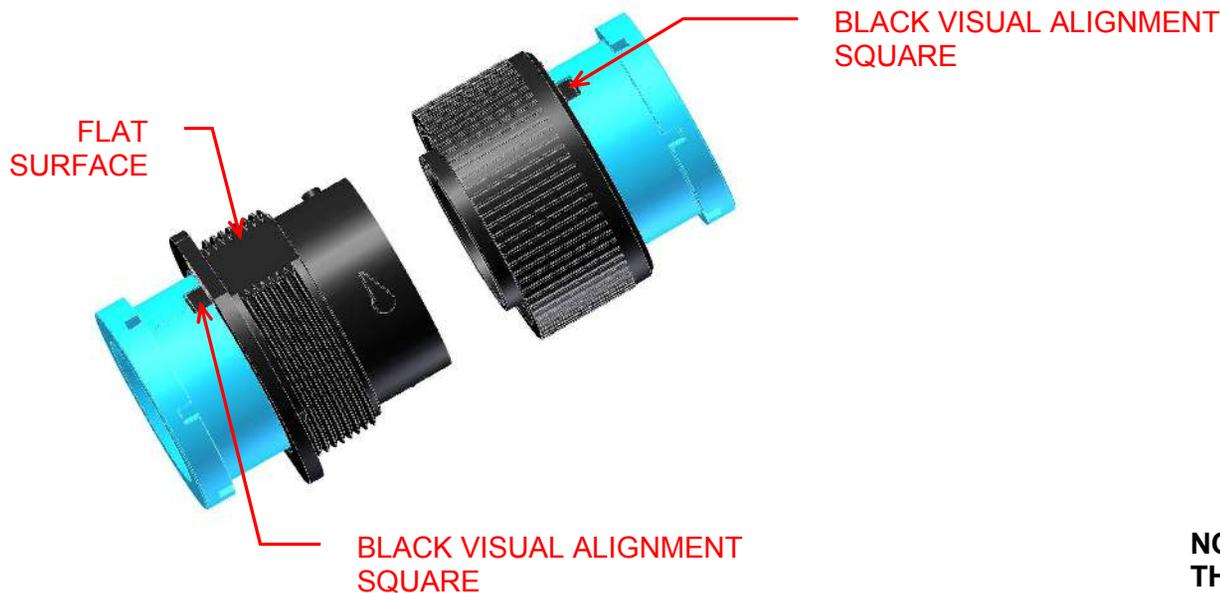


# XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

## 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.

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

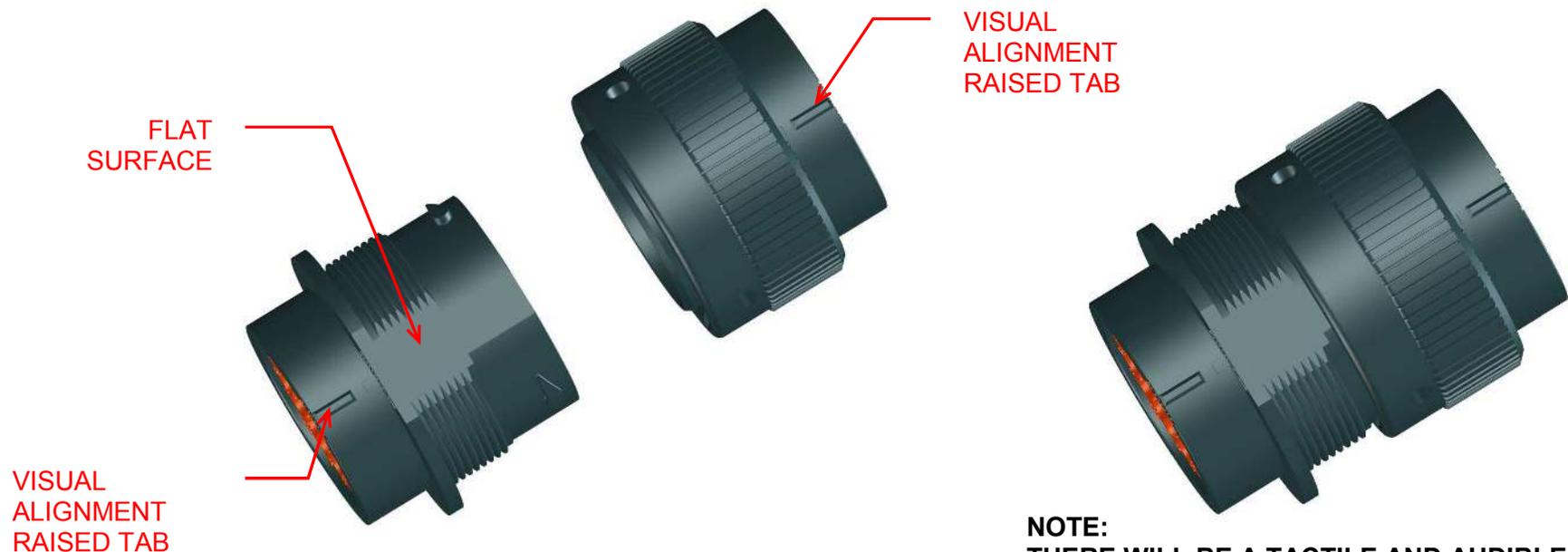


# XRC™ CONNECTOR ASSEMBLY INSTRUCTIONS

## 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.

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