

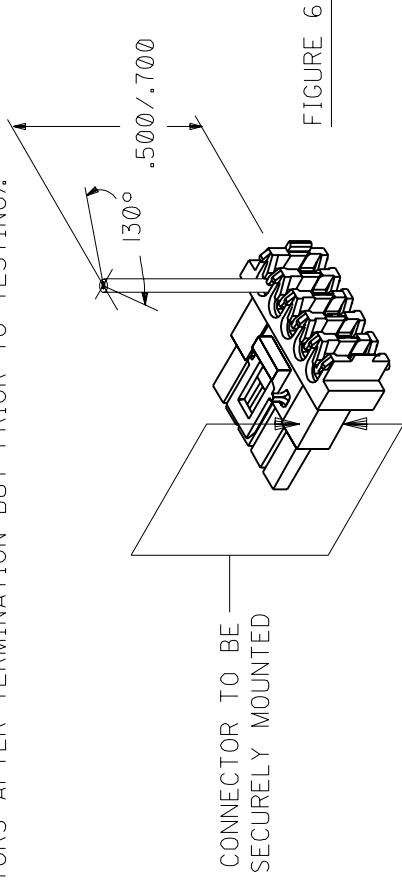


MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

WIRE TERMINATION SPECIFICATION

5.5 TORSIONAL RESISTANCE:

CONNECTOR MUST WITHSTAND A MAXIMUM TWIST ON A TERMINATED CABLE OF 130° WITHOUT DISTURBING THE INSULATION DISPLACEMENT INTERFACE IN THE PRIMARY OR SECONDARY SLOTS (SEE FIGURE 3) (NOTE CABLE MUST BE SLIT TO FORM INDIVIDUAL CONDUCTORS AFTER TERMINATION BUT PRIOR TO TESTING).



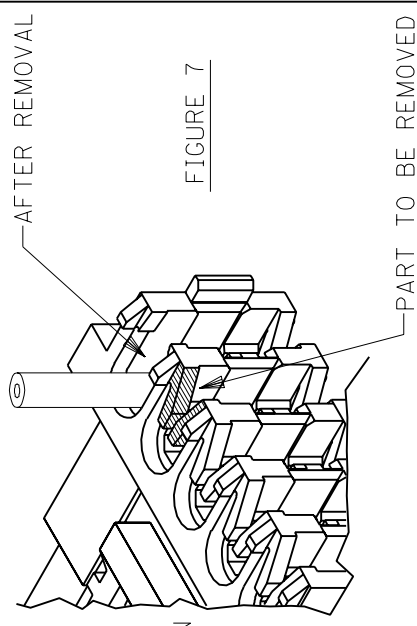
5.6 VISUAL INSPECTION:

AFTER TERMINATION, INSULATION DISPLACEMENT SECTION OF THE TERMINAL TO BE FREE OF TOOL MARKS FROM TERMINATION EQUIPMENT.

6.0 TERMINATION EVALUATION PROCEDURE:

STEP 1 - STRAIN RELIEF REMOVAL

REMOVE SHADED PORTION OF THE STRAIN RELIEF USING A RAZOR BLADE



STEP 2 - REMOVAL OF TERMINAL

INSERT THE REMOVAL TOOL (#HT60630A) INTO THE FRONT OF OF THE CONNECTOR (AROUND THE TERMINAL) TO DEPRESS LOCK TANGS. PUSH THE TERMINAL/WIRE OUT THE BACK OF THE CONNECTOR.

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DRWG. NO. SMES-71690-0000

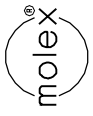
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FILE NAME	T71690X3			

REVISE ONLY ON CAD SYSTEM

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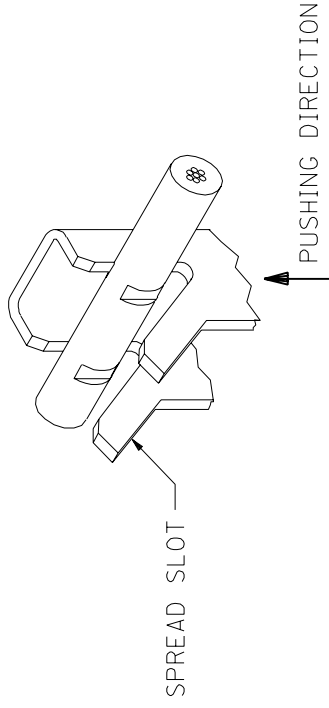
SHT. 3



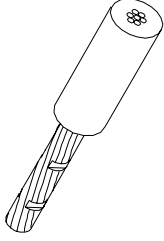
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WIRE TERMINATION SPECIFICATION

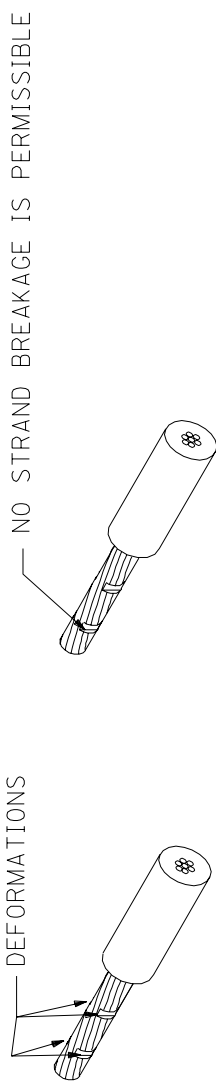
STEP 3 -CONDUCTOR REMOVAL
USING A SMALL PAIR OF PLIERS SPREAD THE I.D.T. SLOT
AND REMOVE CONDUCTOR BY PUSHING IN DIRECTION SHOWN



STEP 4 -REMOVING INSULATION
INSULATION TO BE REMOVED WITHOUT DISTURBING I.D.T. AREA



STEP 5 -CONDUCTOR INSPECTION
FOUR DEFORMATION POINTS MUST BE CLEARLY VISIBLE WHEN
USING 10X MAGNIFICATION



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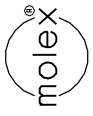
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WIRE TERMINATION SPECIFICATION

LTR.	REVISIONS
A	RELEASED PER ECR U51189 09/15/95 SAS
B	UPDATED PER ECR U70308 ELO 09/20/96

STEP 1 -REMOVAL OF TERMINAL

INSERT THE REMOVAL TOOL(*HT60630A) INTO THE FRONT OF OF THE CONNECTOR (AROUND THE TERMINAL) TO DEPRESS LOCK TANGS.
PUSH THE TERMINAL/WIRE OUT THE BACK OF THE CONNECTOR.

STEP 2 -WIRE GAGE PER CHART

ID LETTER	WIRE GAGE
D	18 AWG
C	20 AWG
B	22 AWG
A	24 AWG

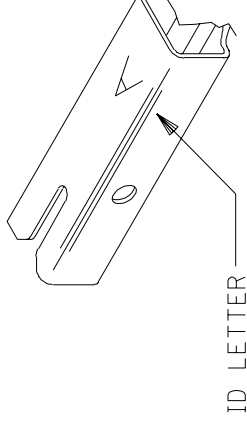


FIGURE 8

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