

Instructions for repairing Female connectors and shielding plates

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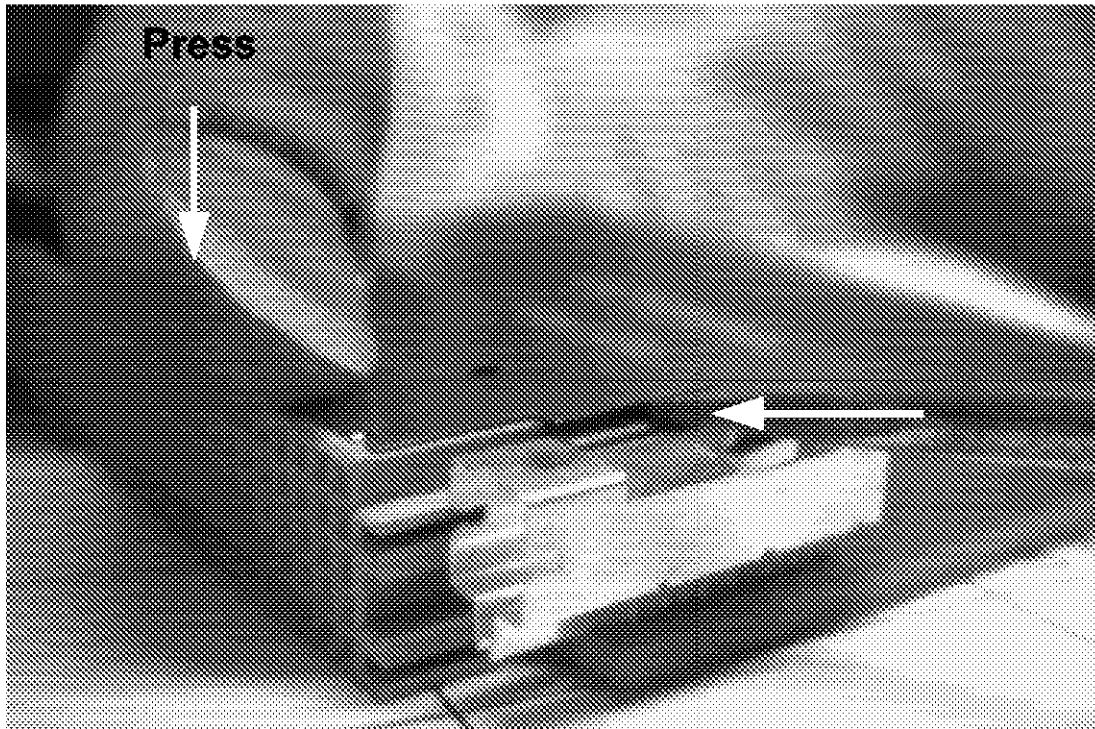
1. INTRODUCTION

Tyco has developed supplemental components for the 2,5-mm connector system under the name SIPAC based on the IEC 1076-4-100 connector standard and industry requirements. Their modular configuration concept and the continuous 2,5-mm grid offer a high degree of flexibility.

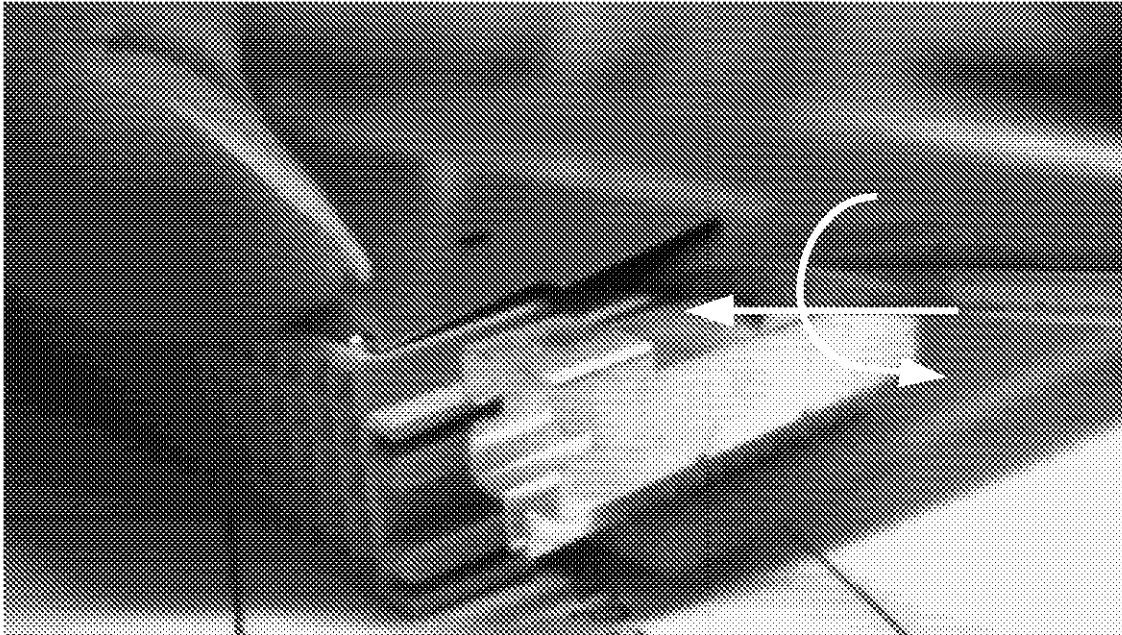
By repair of the SIPAC female connector, you don't need to press out the entire connector.

2. REMOVAL OF SHIELDING PLATES

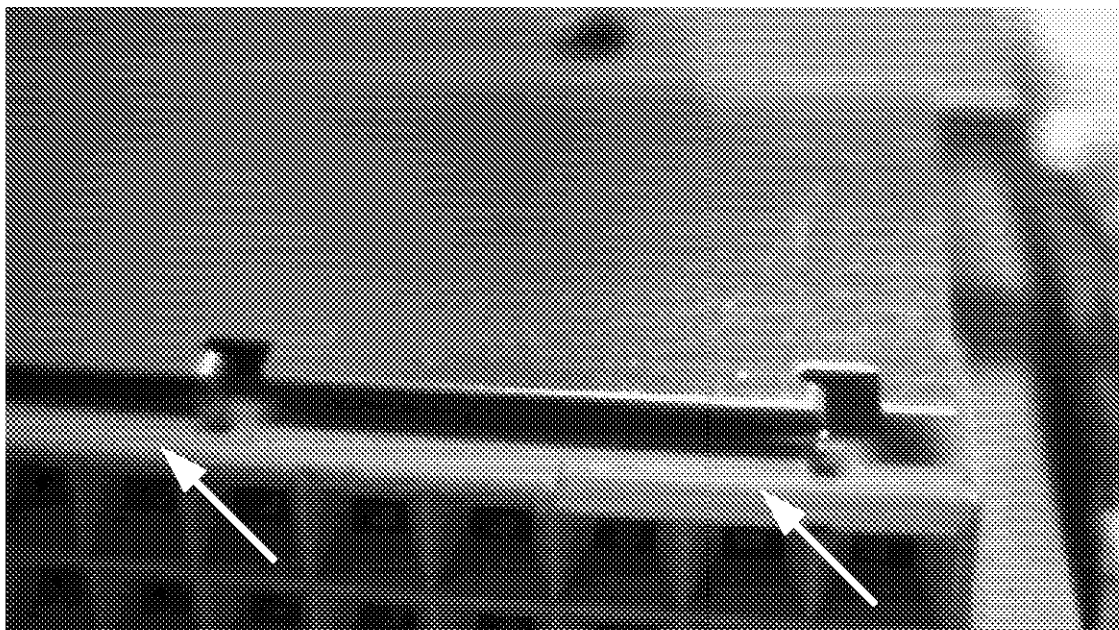
- 2.1. Press on the front edge of the connector and put a screwdriver (width min. 5 mm) between the shielding plate and the spring segments.



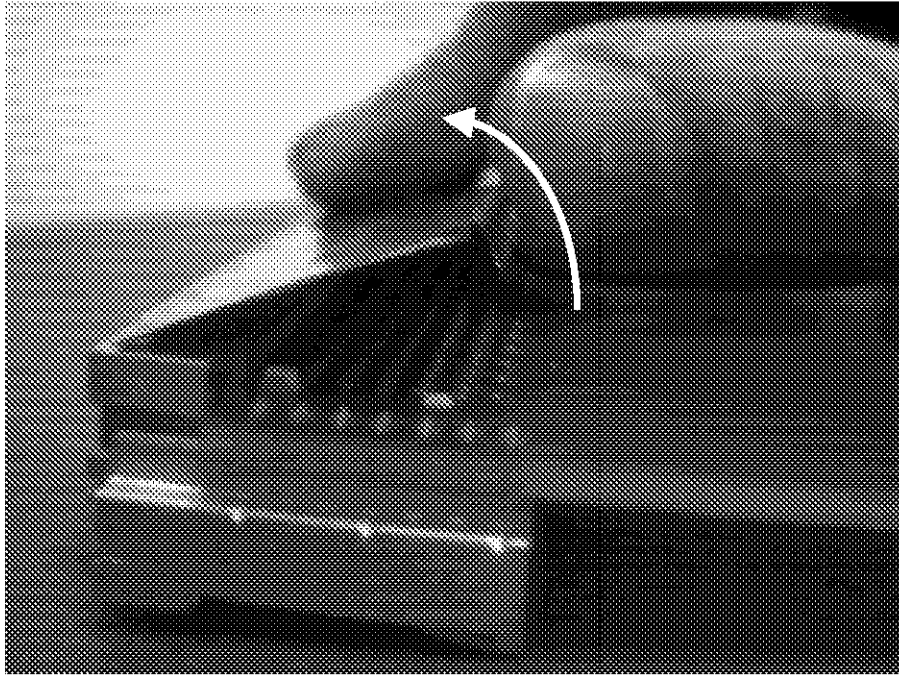
- 2.2 Put the screwdriver further between the shielding plate and the spring segments and pull the metal plate out of the PCB while turning.



- 2.3 On re-using the plastic parts, be sure not to damage the grid holes in the body.



2.4 Remove the lower shielding plate from the bottom of the PC board

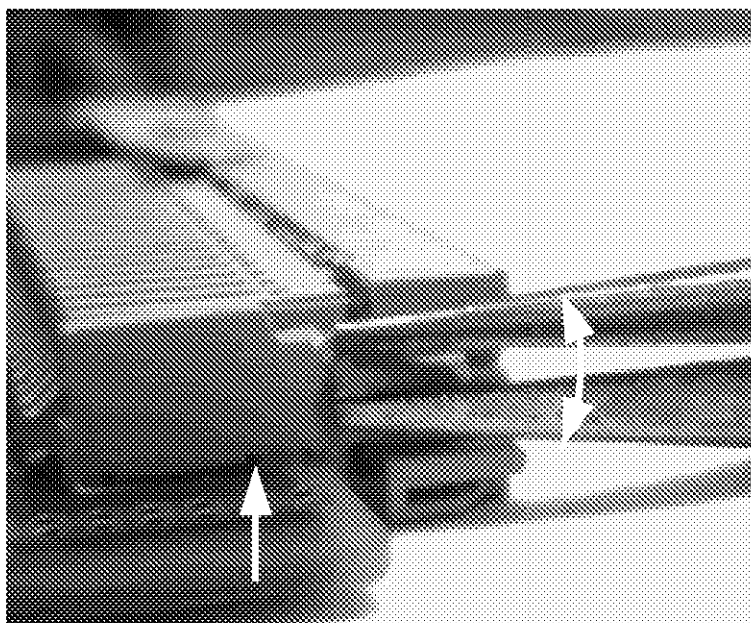


3. REPAIRING FEMALE CONNECTORS

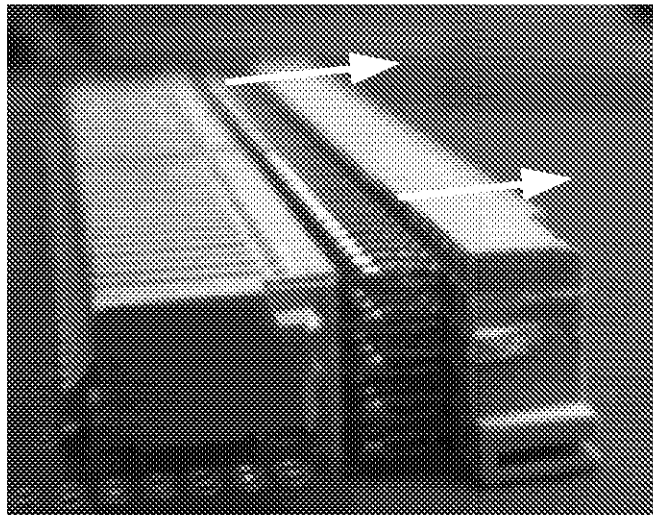
- 3.1. Cut the plastic parts with cutting tool 6-1393490-9 (old tool nr.:V23599-M5025-E5).



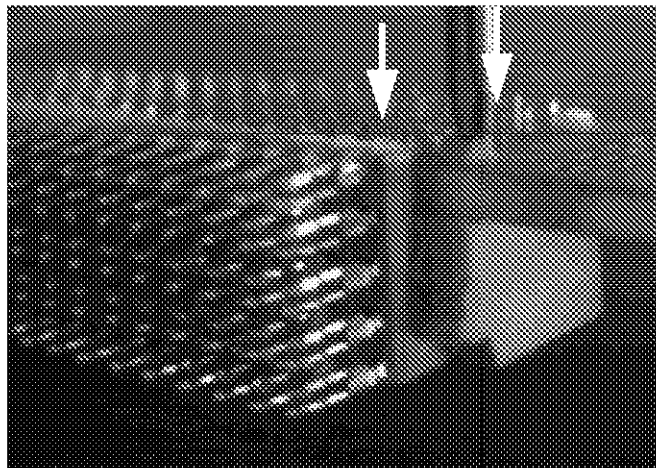
- 3.2. Break off the plastic peg with thin universal plier.



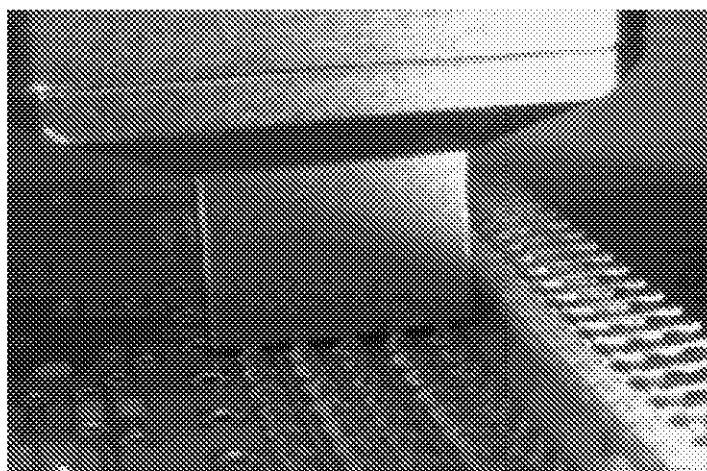
3.3 Removal of the plastic part.

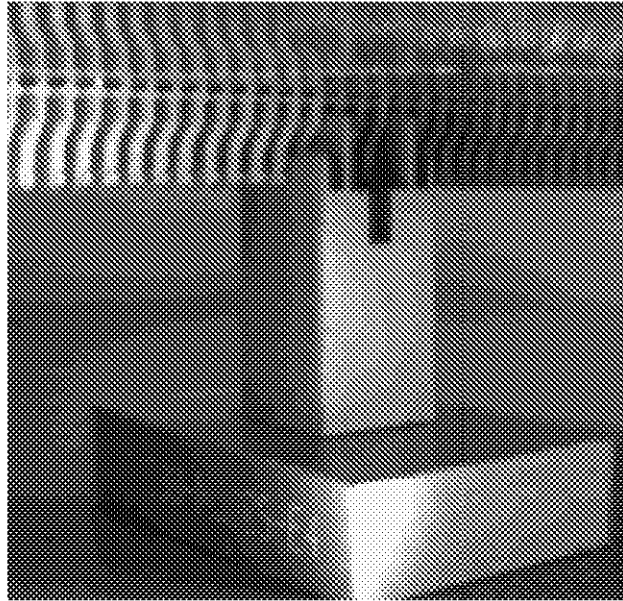


3.4 Press out the plastic pegs with a universal needle Ø 2,5 mm.

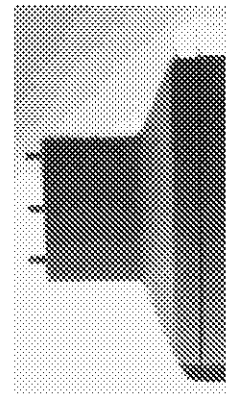
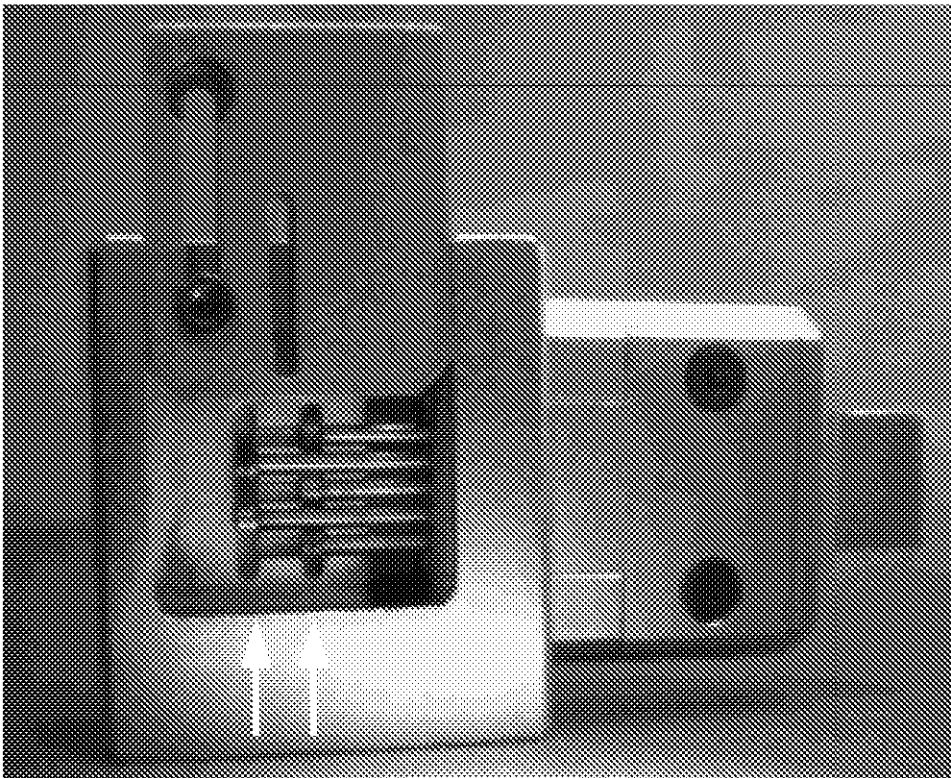


3.5 Press out the spring segments with the removal tool 7-1393490-2 (old tool nr.:V23599-M5025-E8) and the removal support 6-1393490-8 (old tool nr.:V23599-M5025-E4).

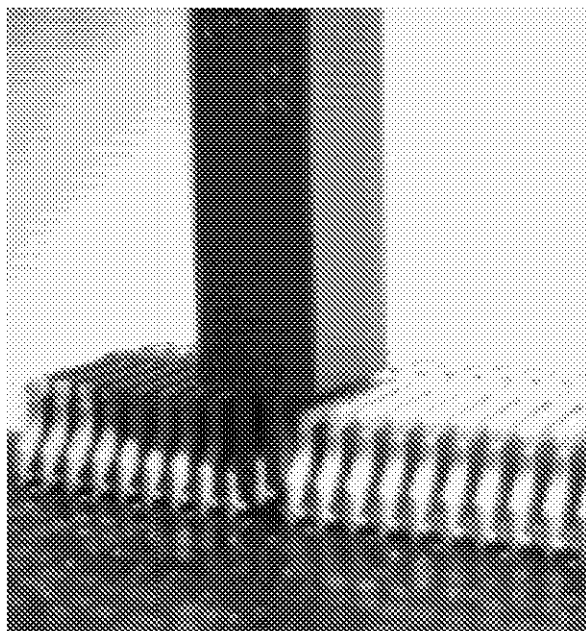




Switch on and switch off the removal peg of the removal tool 7-1393490-2 (old tool nr.:V23599-M5025-E8) according to the number of holes on the PC board.

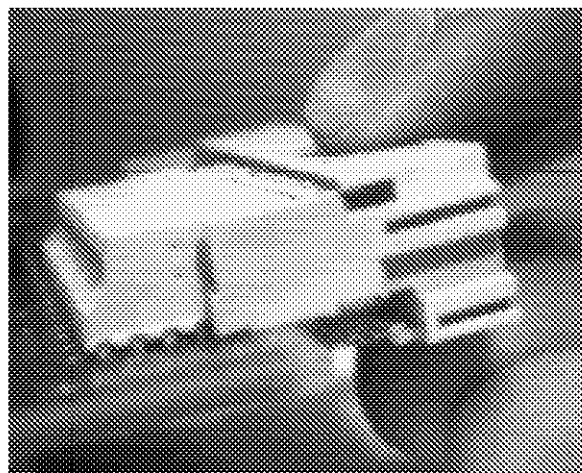


3.6 Mounting new spring segments with assembly tool 6-1393490-7 (old tool nr.:V23599-M5025-E3), removal support 6-1393490-8 (old tool nr.: V23599-M5025-E4) or a stamp insert from the press-in machine can be used as an anvil.



3.7. Mounting the repair plastic parts without plastic peg.

Repair plastic-parts SIPAC female connectors.

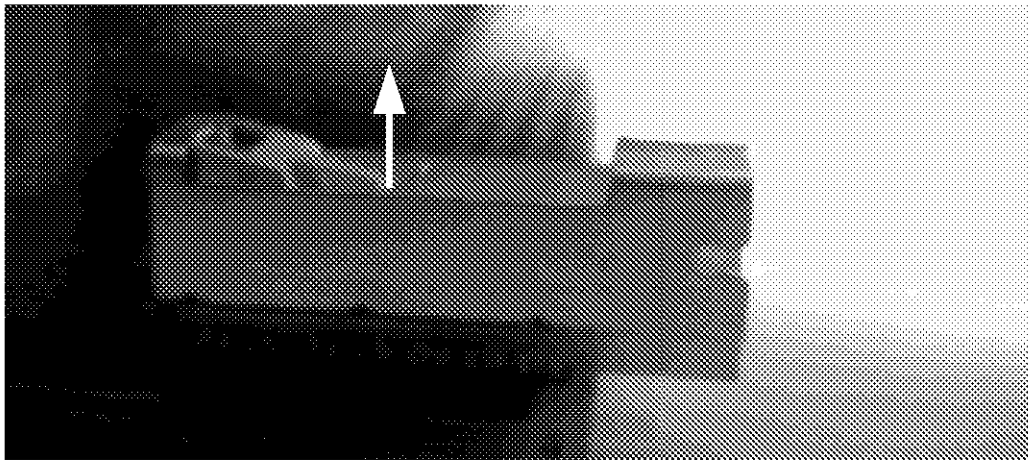


| Size | Order designation | Old part nr. |
|-------|-------------------|-------------------|
| 10 SU | 1393704-6 | (V23552-A1071-S1) |
| 2 SU | 1-1393704-6 | (V23552-A1271-S5) |
| 4 SU | 2-1393704-8 | (V23552-A1471-S4) |
| 9 SU | 3-1393704-9 | (V23552-A1971-S1) |

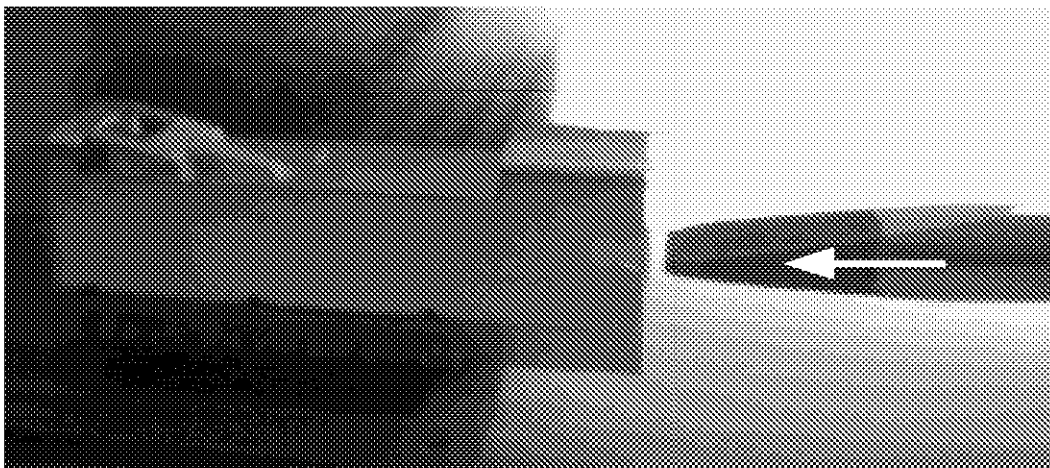
3.8. The PC board can be re-used.

4. REMOVAL OF CODING BOX FROM PRINTED CIRCUIT BOARD

4.1. To remove a coding box from the printed circuit, you take a screwdriver or a thin plier.



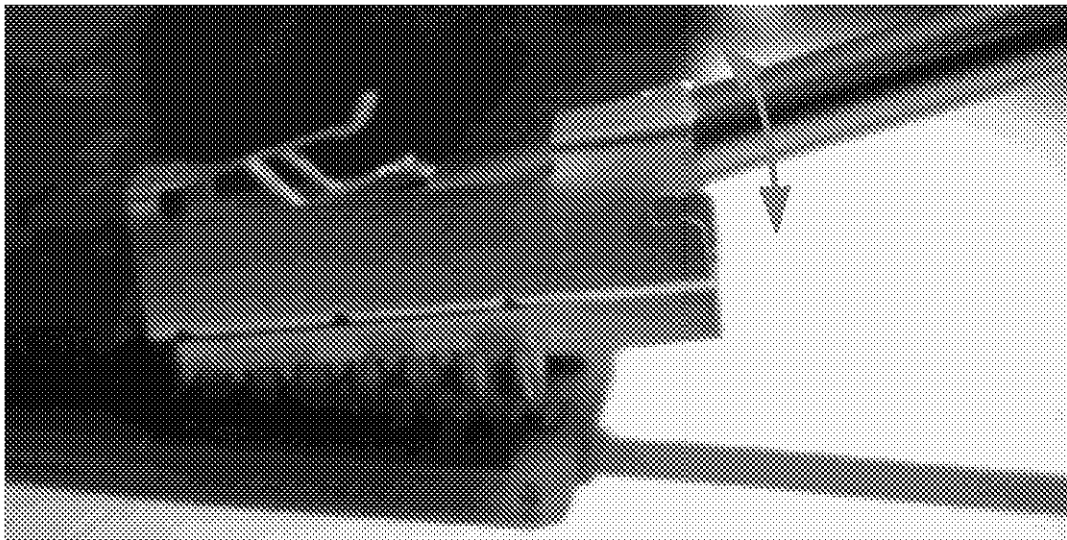
4.2. Put the screwdriver in the coding box



4.3. Push the screwdriver about 2mm past the end of the coding box.



4.4 Pull the coding box out of the shielding plate by moving it up- and downwards.



4.5 Press in a new coding box.