

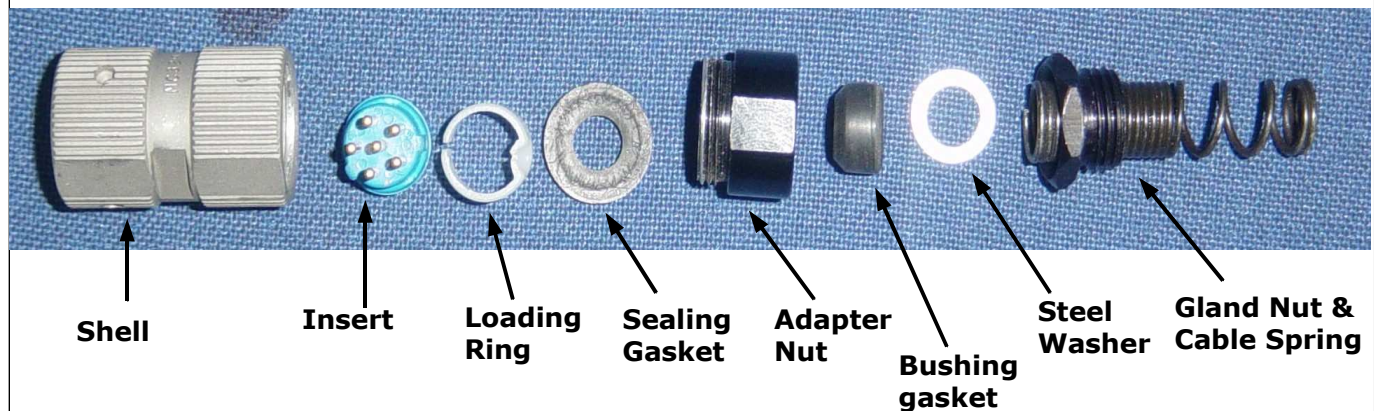
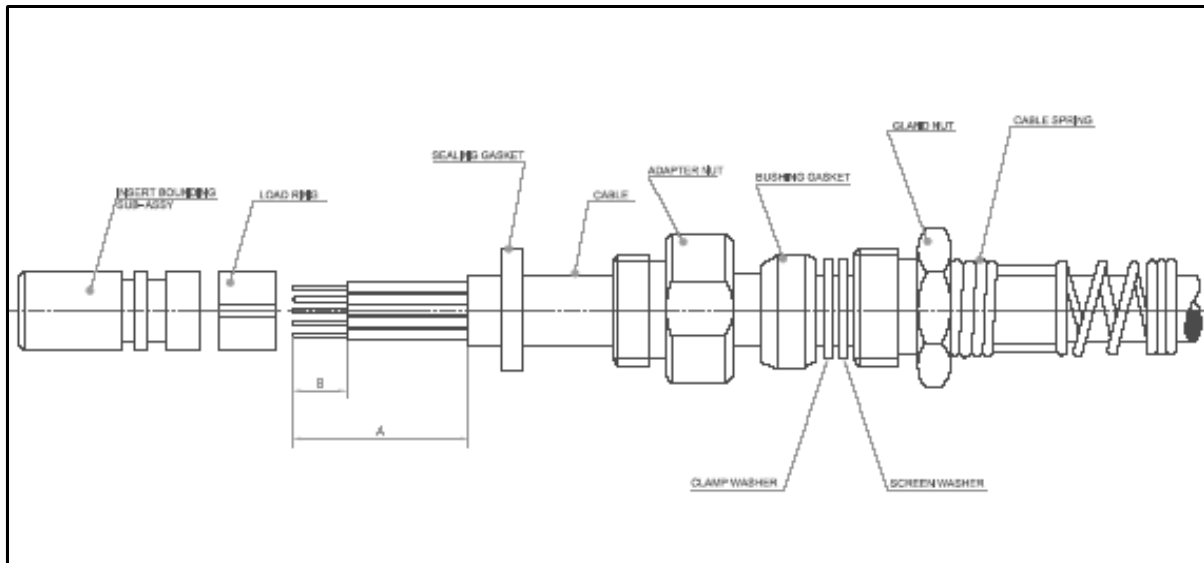
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TITLE- Cable Assembly of 164 Series Plug Connector

Objective- This document defines the operation of cable assembly of 164 series plug connector with necessary inspection instructions.

Assembly Procedure-

- 1) Remove the connector carefully from the packing bag.
- 2) Dis assemble the connector for assembly of cable with insert.



3)



Take out the insert from the dis assembled connector separately for soldering.

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4)



Solder the cable with the contacts in the insert properly
Check for proper soldering.
Check that no excess solder metal is spread around outer periphery of Contact
Clean insert subassembly with IPA (Isopropyle Alcohol)

Inspection-
Check for Insulation Resistance as per standard
Check for Break down voltage as per standard

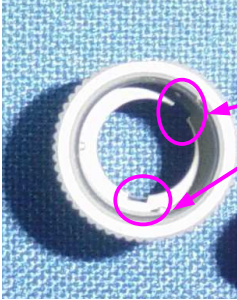
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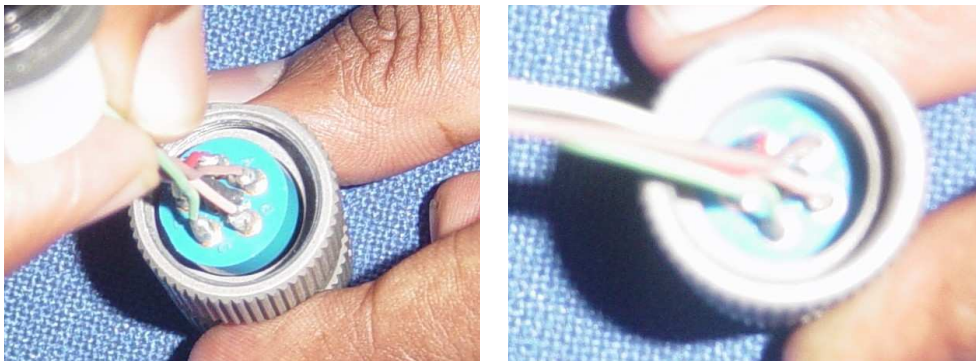


Assemble all the parts of connector through cable as per sequence of assembly.



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- 6)
- 
- Broaching
Keys of
shell
- Keys of Insert
- 
- 
- Matching Keys of Shell
& Insert*
- Match the Key ways of the shell & Insert
Press the insert in the shell.
Fit the insert properly in its position in the shell



- 7)
-

Assemble & press remaining parts in the shell
Check that all parts are located properly inside the shell

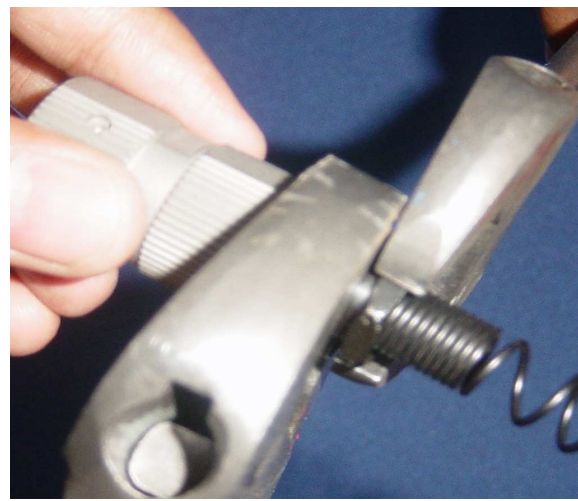
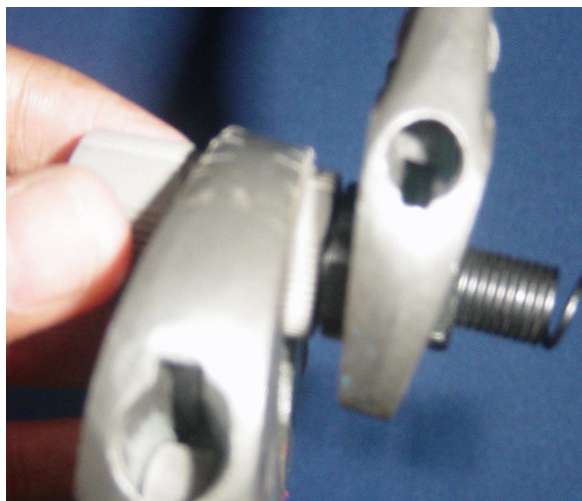
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8)



Lock adapter nut & other accessories to the shell.



Use proper size spanners for tightening of adapter nut & Gland Nut
Use appropriate torque while tightening.

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