

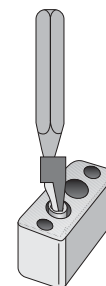


Assembly Instructions

Manual Insertion of Contacts

1. Affix proper connector holding block to stable surface (i.e. vice or table). See Connector Selection table,  page 5, for proper holding block.
2. If a jacket wire sealing boot is to be used, it must be slid up the cable (isopropyl alcohol will help in doing this).
3. Dip connector in isopropyl alcohol and place in holding block with the back end up (wire side).
4. Using proper contact insertion tool, (see Contact Selection table for proper tool):
 - A. place contact in groove of tool
 - B. make sure that end of the tool is up against the shoulder of the contact.
5. Insert contact into proper cavity of the connector body by applying constant pressure until contact snaps into place. Isopropyl alcohol will help in doing this. (Warning: Do not tilt the tool during the insertion).
6. Insert all remaining contacts. To insure environmental sealing of the connector any empty contact cavities must be filled with wire hole fillers (see Contact Selection table,  page 5, for proper wire hole filler).
7. Check mating side of the connector to be sure that all contacts are on the same plane (fully inserted).
8. If you are using jacket sealing boot, slide the boot down the cable and onto the connector.
9. Remove connector and wire assembly from holding block.



Pneumatic Automatic Insertion Tool (Leased)

CBIT-SS-150



The CBIT-SS-150 Sure-Seal® insertion machine is pneumatically powered, and microprocessor controlled. It is designed to insert pre-crimped wires into the standard Sure-Seal® plug and receptacle housings for moderate to high volume applications. This machine is used for SS2P/R through SS10P/R including the 120-1873-007 and 120-1874-007 rectangular style Sure-Seal® connectors.

The benefits of using this insertion machine are:

- Ease of operation
 - Low cycle time
 - High connector integrity
- Short operator training time
 - Reduces operator fatigue and insertion errors
 - Quick change over for different connectors sizes
 - Much faster than manual insertion
 - Lower chance of damaging the wire sealing ripples

Power Requirements: Electrical = 115 Vac, 60 Hz
Pneumatic = 80 PSI, 10 CFM dry oil free filtered air

Extraction of Contacts



1. Slide up any rear accessories (i.e. jacket cable sealing boots). Using isopropyl alcohol will help you slide these up your cable.
2. Grasp individual wire firmly and gently pull the contact out of the connector.

* Extraction tool available DRK32 & DRK152, please call.