Instructions for Assembly of the Mini-Delta Ribbon Wiremount Socket Connector to .050" Flat Cable

Instructions for the Assembly of the Mini-Delta Ribbon Wiremount Socket Connector to .050" Flat Cable using Model 10951 Harness Assembly Tool.

General:

The assembly tool 10951 was designed to aid in the assembly of the Wiremount Socket Connector in the Mini-Delta Ribbon family. This assembly tool is designed for positions 14, 20, 26, 36, 40, 50 and 68. The following set up and assembly instructions are based on termination procedures for harness assembly using the 10951 assembly tool.

Assembly Equipment:

The 10951 assembly tool is a unit package, designed with a sliding Locator Plate that is attached to the base of the press. Included with this unit is a platen and shut height gauge.

Refer to Figure 2 for steps 1-11

1. Slide the locator plate (F) toward the operator.
2. Unlatch both the right and left cable clamps (A) & (B), using the silver spring latches, and rotate each cable clamp to the back of the plate.
3. Set the four (4) cable guides (C), to the outer most position, two (2) to the front and two (2) to the back of the plate.

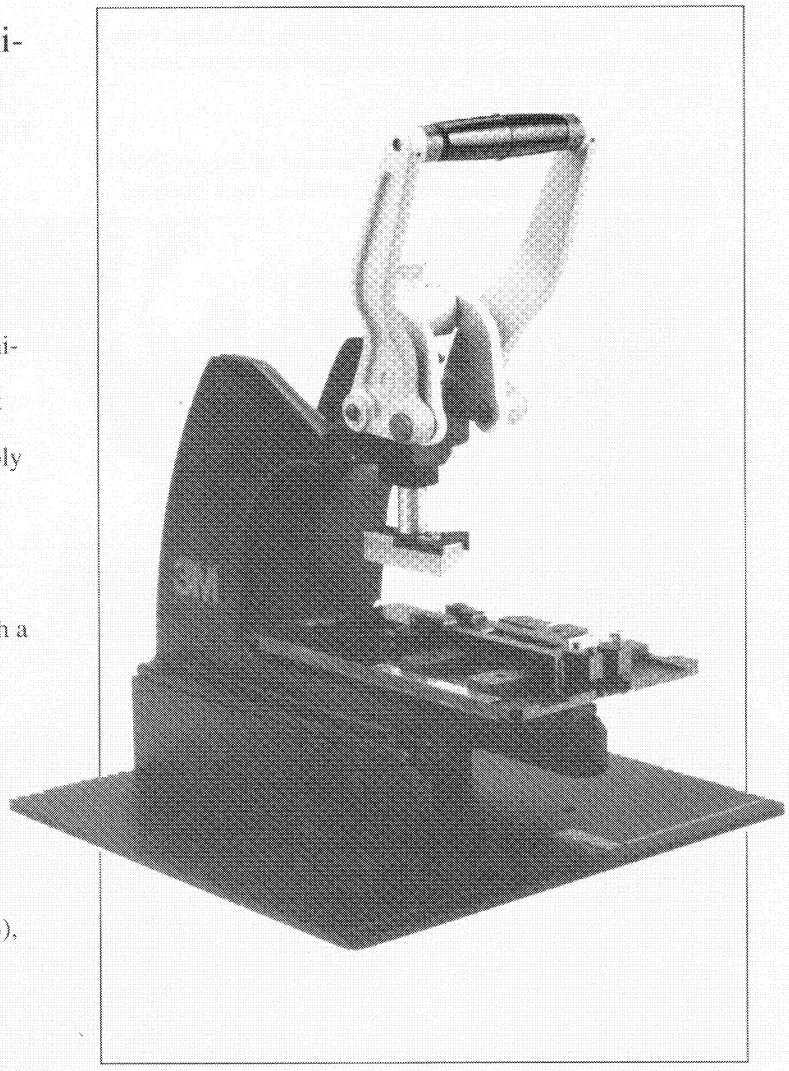

Figure 1

4. Slide the cover stop (D), to the back of the plate.

5. Place the shut height gauge (E), stored on the right side of the press, in the locator plate groove and between the cable guides. Slide the locator plate back into position so the shut height gauge is directly below the platen. Lower the press handle until the platen comes in contact with the shut height gauge. Adjust the knob on top of the tool until the platen is just contacting the locator plate when the handle is in its full downright position. Return the handle to the full upright position. Turn the adjustment knob clockwise one half revolution.

6. Slide the locator plate towards the operator and remove the shut height gauge. Store it back on the side of the press.

7. Move both the front and back cable guides (C), into position. The groove on the cable guides should line up with the corresponding connector position on the locator plate (F).

8. Put the cover of the connector to be assembled between the cable guides, making sure the smaller latch opening is OPPOSITE the operator and against the front cable guide.

9. Slide the cover stop (D), forward until it rests against the back of the cover.

10. Rotate the right cable clamp (B), to the front and lock it down by turning the silver spring latch counter-clockwise. Set the connector end guide (G), located on the cable clamp so the back of the connector end guide is in line with the back of the rear cable guides. Unlatch the cable clamp and rotate it to the back.

11. Rotate the left cable clamp (A), to the front and lock it down by turning the silver spring latch clockwise. Align the outside of the connector guide (H), with the outside of the front cable guides. Unlatch the cable clamp and rotate it to the back.

NOTE: THE CHAMFERED (ANGLED) SIDE OF THE CONNECTOR GUIDES MUST BE FACING TOWARD THE INSIDE OF THE NEST.

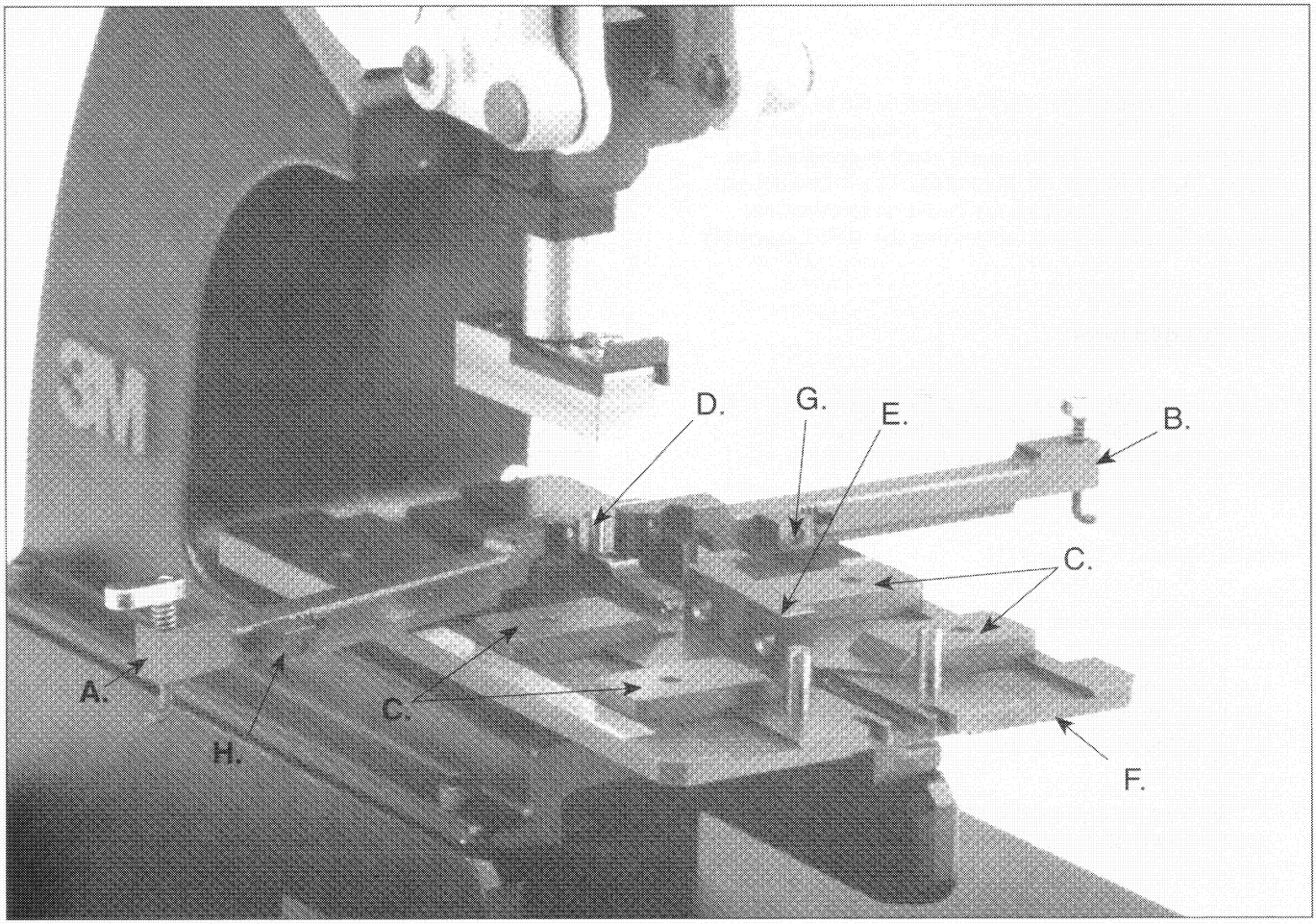

Figure 2

Assembly procedure

1. Place the two cables through the slots in the cover allow each cable to extend at least one (1) inch past the cover. Fold the extended portion of the cable 90 degrees allowing each cable to rest on the inside of the cover.

NOTE: The cable should enter the cover through the bottom (C of Fig. 3), with the extended portion exiting upwards and resting in the cable grooves.

2. With the narrow latch opening OPPOSITE the operator, insert the cable/cover sub-assembly into the cutout in the locator plate until the cover seats between the cable guides (D of Fig. 3).

3. Using the left hand to hold the cable/cover in place, rotate the right cable clamp, forward and lock it in position over the cable.

4. Repeat the same operation with the left cable clamp.

5. Place the connector body, with narrower connecting latch OPPOSITE the operator (E of Fig. 3), in the nest between the connector guides.

6. Push the locator plate away from the operator, back to the shuttle stop and in line under the platen.

7. Pull the press handle down completing the assembly.

8. Raise the press handle and pull the locator plate towards the operator.

9. Release the cable clamps and remove assembly from the nest.

NOTE: DO NOT DISTURB THE SETTINGS ON THE LOCATOR PLATE.

10. Inspect the harness assembly to insure both latches are latched. If not, place assembly back in the nest and adjust press down by rotating adjustment knob clockwise a quarter turn. Repeat steps 7-9.

NOTE: BOTH LATCHES HAVE TO BE COMPLETELY LATCHED TO MAKE A QUALITY TERMINATION.

Cable Cutter

To trim the excess cable from the assembly, use the cable cutter Model 10952. This tool is not included with the harness assembly tool and must be separately ordered.

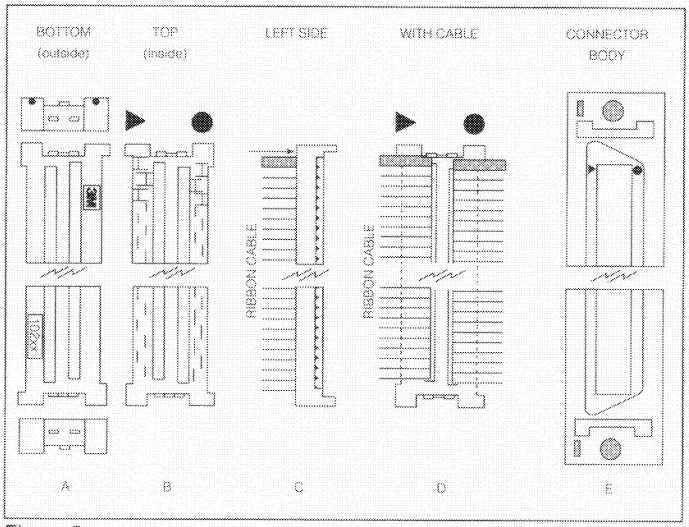

Figure 3

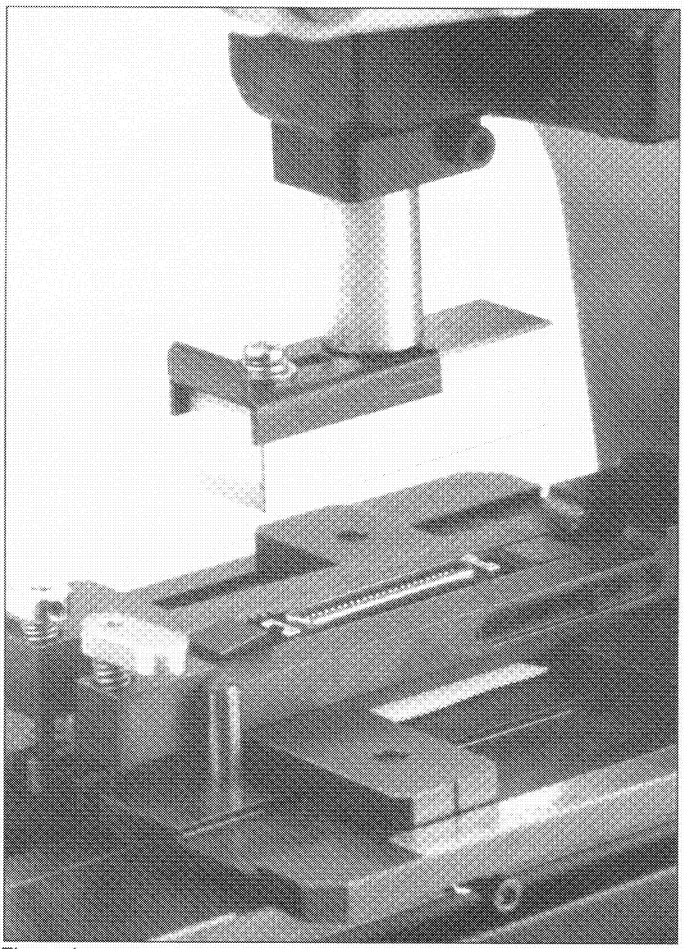
Figure 4

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