

Instructions for the installation of 3481-3 through 3481-9 Connector Nests

General:

3481 Connector Nests are used with the 3316 Universal Press for the termination of round jacketed discrete wire cable, flat discrete wire cable or flat controlled pitch cable to mass termination-insulation displacement type connectors. The list below summarizes the Scotchflex connectors with which these Connector Nests are used:

Connector Nest 3M Part Number	For the Assembly of:
3481-3	Scotchflex Delta Ribbon Connectors
3481-4	Scotchflex Delta Connectors (socket)
3481-5	Scotchflex Delta Connectors (pin)
3481-6	Scotchflex .100"x.100" Socket Connectors
3481-7	Scotchflex .100"x.200" Socket Connectors
3481-8	Scotchflex .156 Card-Edge Connectors
3481-9	Scotchflex .100" Card-Edge Connectors

Shut Height Setting:

The shut height adjustment is next made. Place the shut height gauge block on the discrete wire block in either of two positions. The 1.750" length is used when adjusting for the Crimp Bar with cut-off blade, and the 1.400" width is used when adjusting for 3442-XX Platens. Position the gauge block directly beneath the press shaft. With the handle fully lowered, rotate the adjustment knob (clockwise to lower shaft, counterclockwise to raise it) until the end of the shaft touches the gauge block. It's in the proper position when a slight resistance is felt as you move the gauge block. Finally, raise the handle and remove the gauge block.

Set-Up:

Connector Nests 3481-3A and 3481-3B

- Determine the cable direction, location of conductor #1, position of contact #1 (Figure 2), and select Connector Nest A or B.
- Position the Connector End Guides for either the plug or socket connector. (Figure 1) Lift and slide each end guide to the end and rotate each 180° if necessary.
- Adjust the Connector End Guides for the desired number of contacts by lifting and sliding each end guide, aligning the end guide pins with the appropriate number on the label scale (Figure 1).

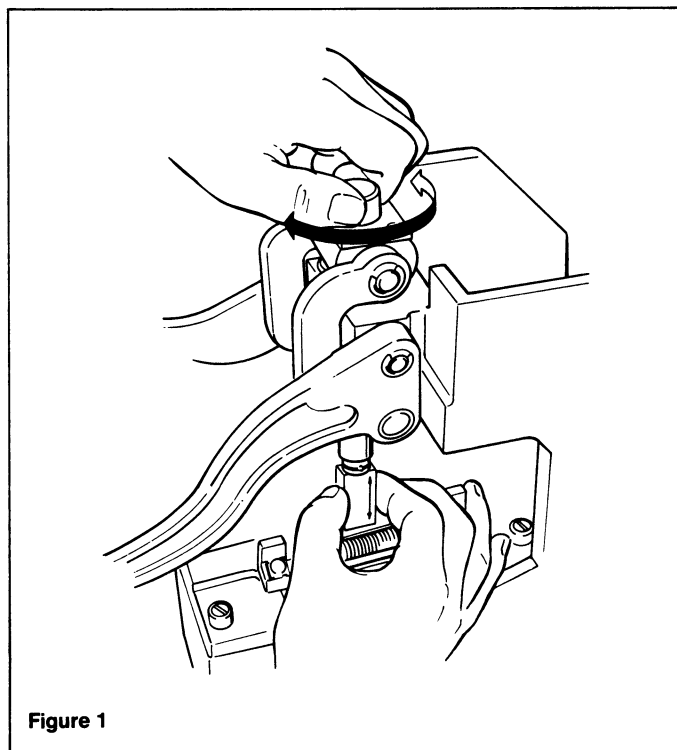


Figure 1

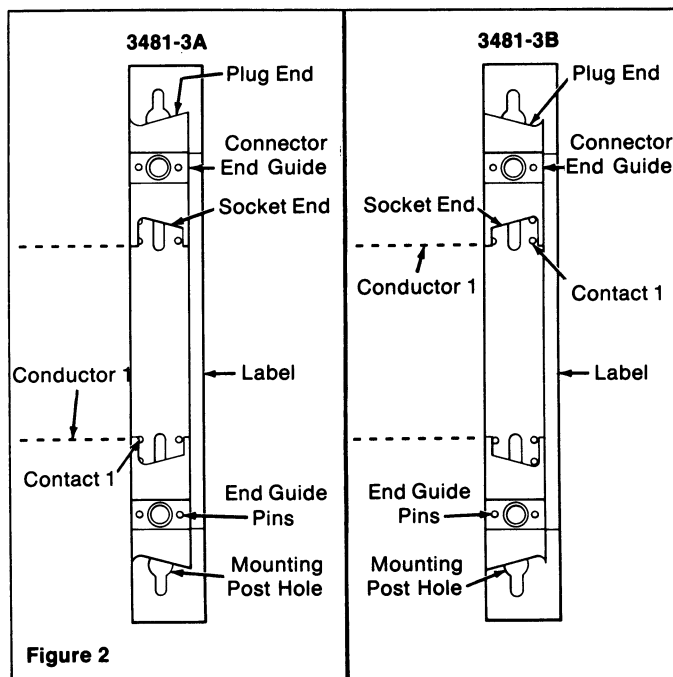


Figure 2

Connector Nests 3481-4A and 3481-4B

1. Determine the cable direction, location of conductor #1, position of contact #1 (Figure 3), and select Connector Nest A or B.
2. Adjust the Connector End Guides for the desired number of contacts by lifting and sliding each end guide, aligning the window with the appropriate number on the scale. (Figure 5)

Connector Nests 3481-5A and 3481-5B

1. Determine the cable direction, location of conductor #1, position of connector contact #1 (Figure 4), and select Connector Nest A or B.
2. Select the proper connector cavity for the appropriate number of contacts.

Connector Nests 3481-6, 3481-7 and 3481-9

Adjust the Connector End Guides for the desired number of contacts. Lift and slide each end guide, aligning the window with the appropriate number on the scale. (Figure 5)

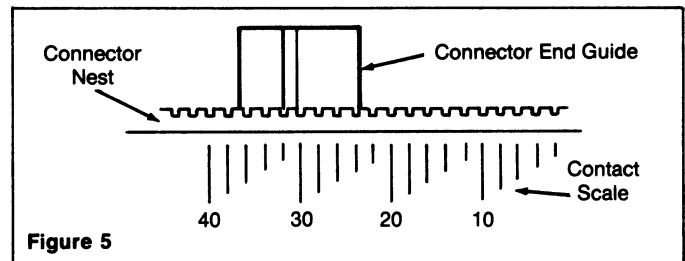
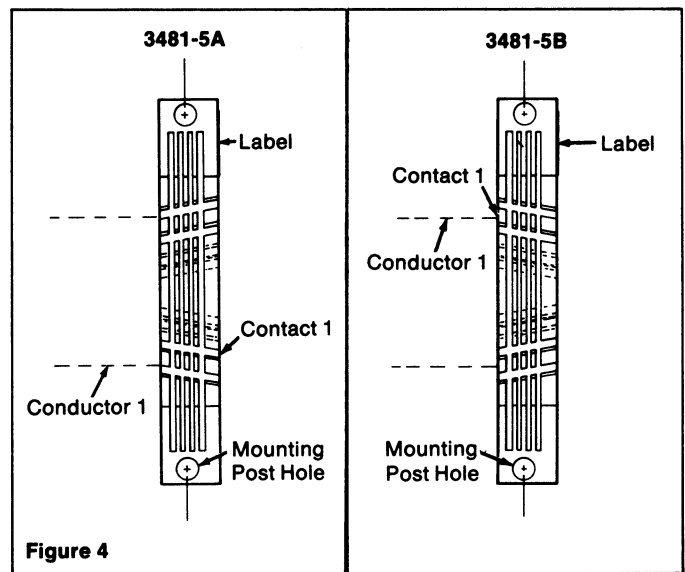
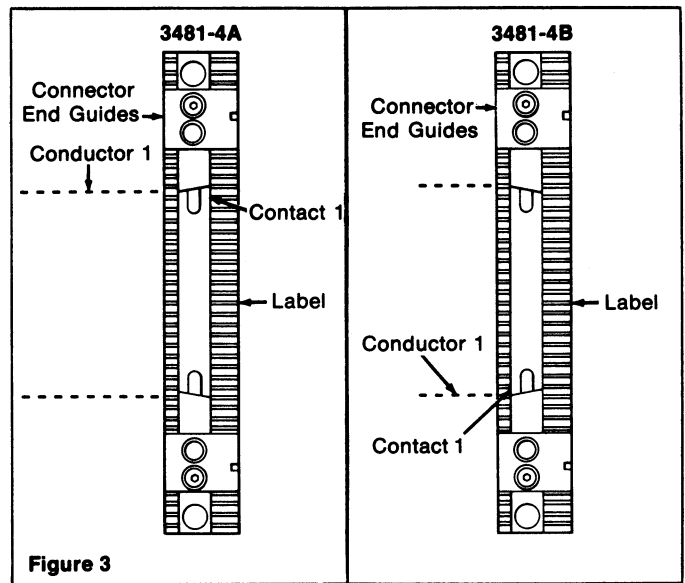
Connector Nest 3481-8

No Set-up is required.

Installation:

1. Install the connector nest on the Discrete Wire Block over the mounting posts. Note the mounting posts allow positioning of the nest only one way.
2. Install the platen on the press shaft, parallel with the connector nest. See Instruction Sheet for specific connector to select appropriate platen.

Use a 3442-9 Platen for the assembly of 50 and 60 position, .100" x .100" grid sockets — **supplied** with 3481-6 Connector Nest.



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