

This manual describes the wiring harness assembly Procedure of SUPER SEAL CONNECTORS.

1. NAME / CAT. NO. OF APPLICABLE PRODUCTS

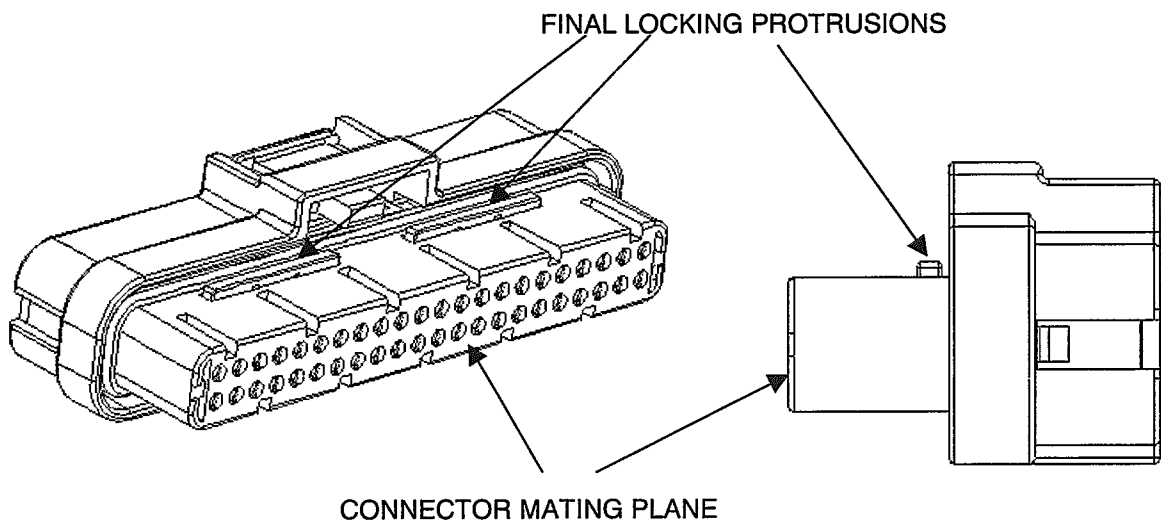
	Part Number	Old Part number
• Receptacle Contact ASS'Y	／ 3-1447221-3	3900187-01
	3-1447221-4	3900187-02
• Plug Housing ASS'Y	／ 2-1447232-6	3900281-441
	1376886-1	3900281-442
• Hole Plug	／ 4-1437284-3	3400130

2. CONTACT CRIMPING

- The contacts should be crimped in accordance with Crimping Specification 114-78011(Old PS-1191),114-78011-1(Old PS-1191-1).

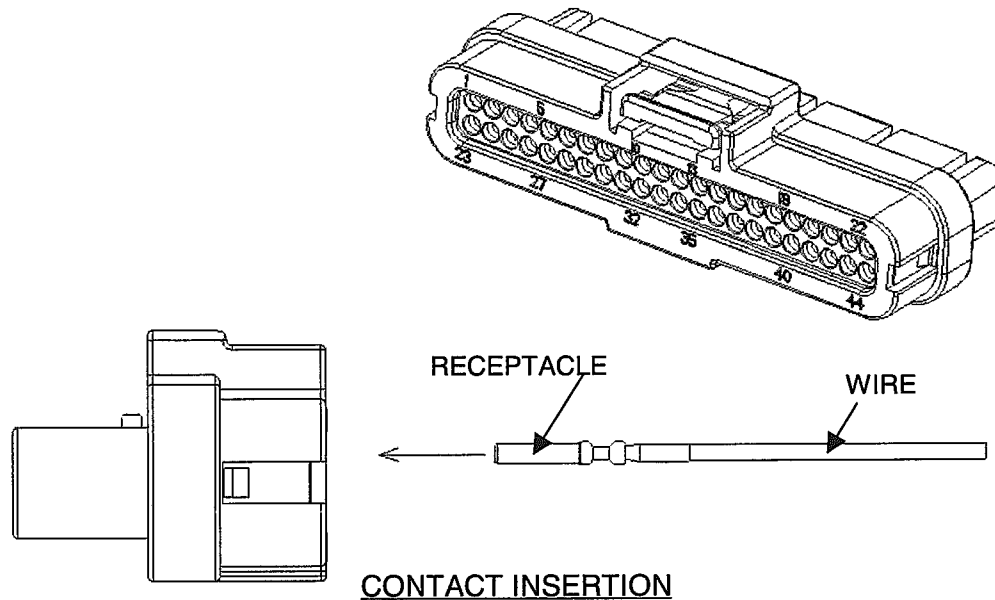
3. CONTACT INSERTION

- The contact should be protected from an unnatural external force so as not to be deformed or bent before it is inserted into the housing. (If the contact is deformed or bent, that contact should not be used and a new contact should be crimped.)
- It should be confirmed that two final locking "protrusions" of the housing protrude.

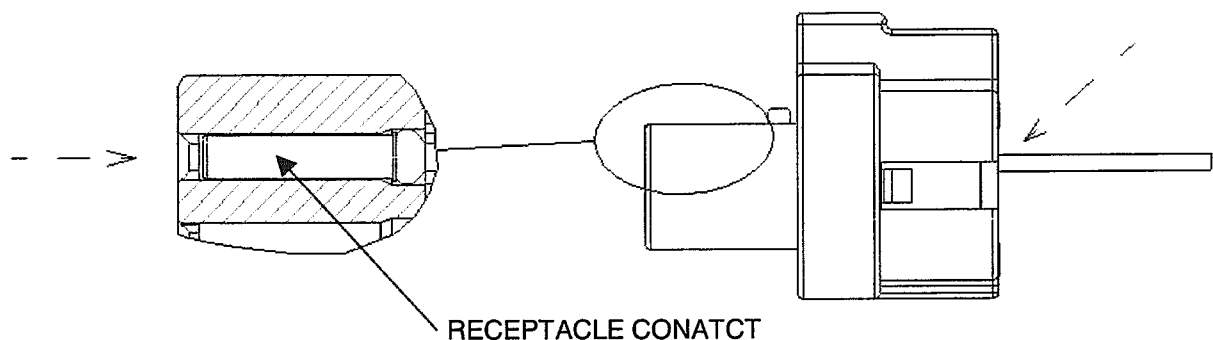


HOUSING CONFIRMATION

- As shown in the following figure, the contact should be held by the part near the crimping and inserted into the housing as vertically as possible. (The contact should be inserted as far as it hits the part of the housing to avoid the halfway insertion.)



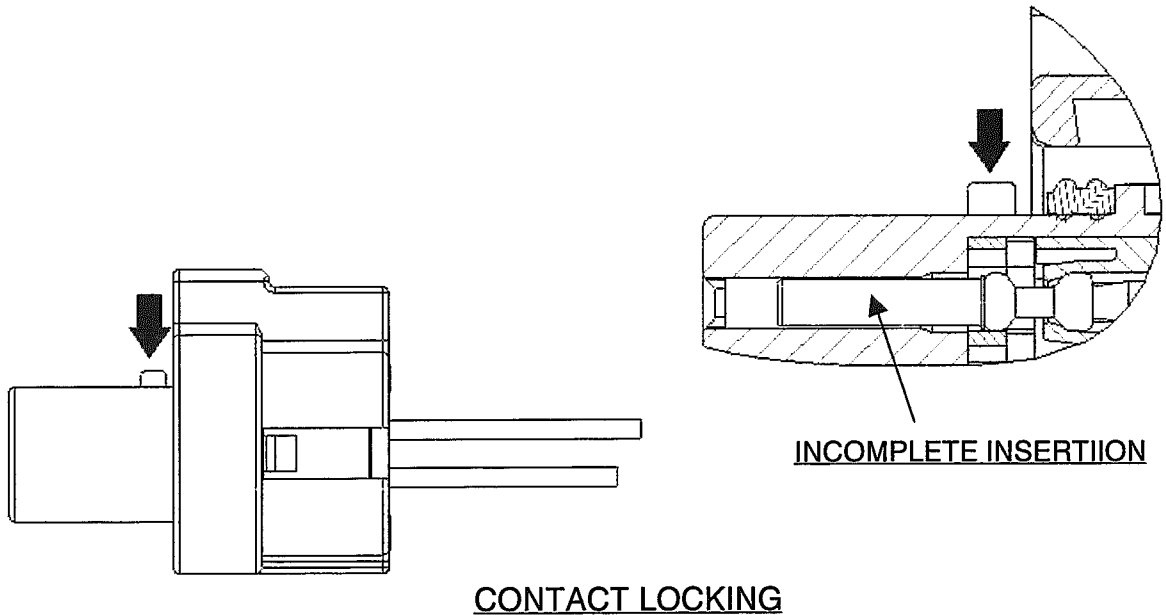
- It should be confirmed that the contact stays in a correct position from both the connectors mating plane and the contact insertion plane.
- If the contact is inserted into an incorrect position, the contact should be removed from the housing in accordance with the Sec. 5 of this manual and inserted again.



- When the insertion of the contacts is finished, it should be confirmed that the contacts are inserted into all the necessary positions. (The insertion of the hole plugs should be also checked.)

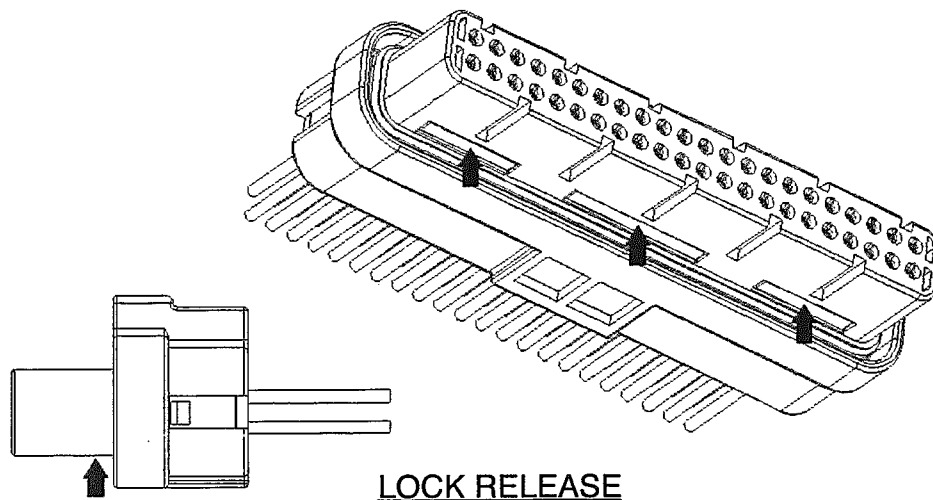
4. FINAL LOCKING OF CONTACT

- After all the contacts are inserted, two final locking “protrusions” are pushed simultaneously into the housing by fingers for locking (latching feeling should be confirmed). If the nails are blocked halfway, it means that the halfway insertion of the contact is detected. In such case, therefore, it should be checked again whether the contact stays in the correct position or not without applying further pushing force.

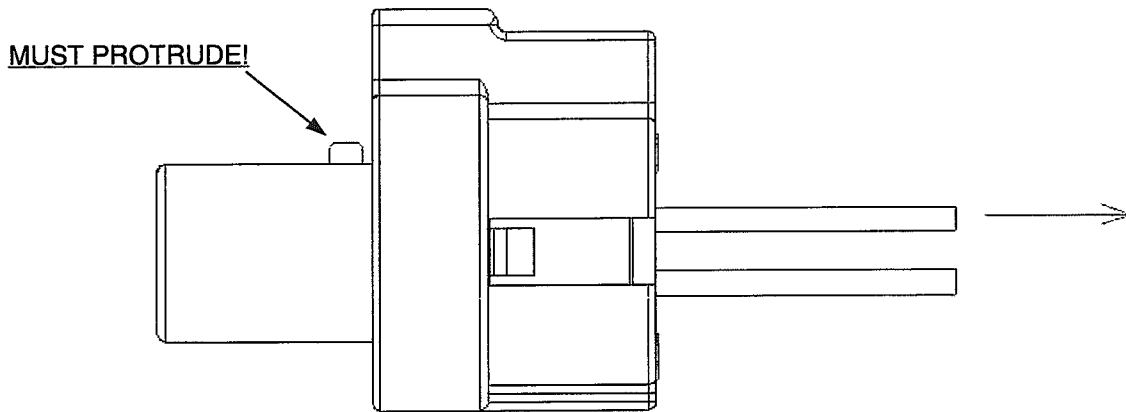


5. CONTACT REMOVAL

- If the final locking protrusions have already been pushed into the housing, the releasing side (one position) of the final lock is pushed up by a finger nail or a tool such as a minus driver. (Latching feeling should be confirmed. The release of the final lock should not be repeated more than 10 times.)



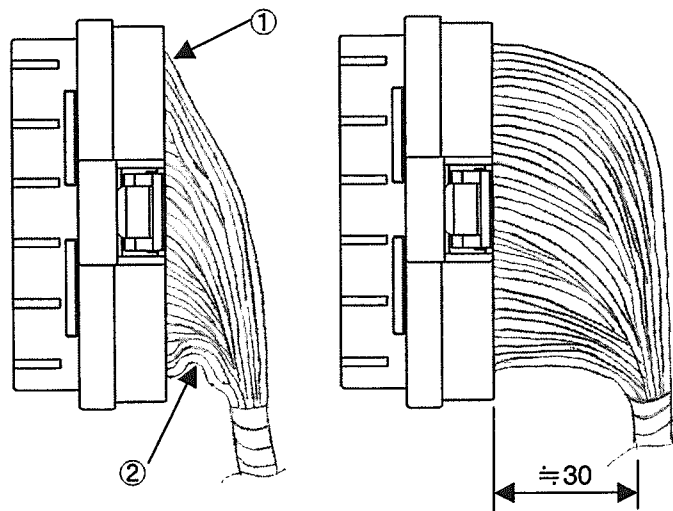
- If it is confirmed that both the final locking “protrusions” protrude, the wire crimped with the contact to be removed is drawn out as vertically as to the housing. (The removal of one position should not be repeated more than 3 times.)



CONTACT REMOVAL

6. OTHERS

- When the wires are bundled (by taping, etc.), care should be taken not to apply a tensile force to one arbitrary wire.
- If the wires are bent approximately 90 degrees, the bent position should be approximately 20mm apart from the connector and the bending form, the bundling position, etc. should be considered.
 - ① in order not to apply a tensile force to the wire outside the bend.
 - ② In order not to apply a compression load to the wire inside the bend and deform the wire.
- The housing should not be dismantled.



BEND OF WIRES

- The housing should not be dismantled.