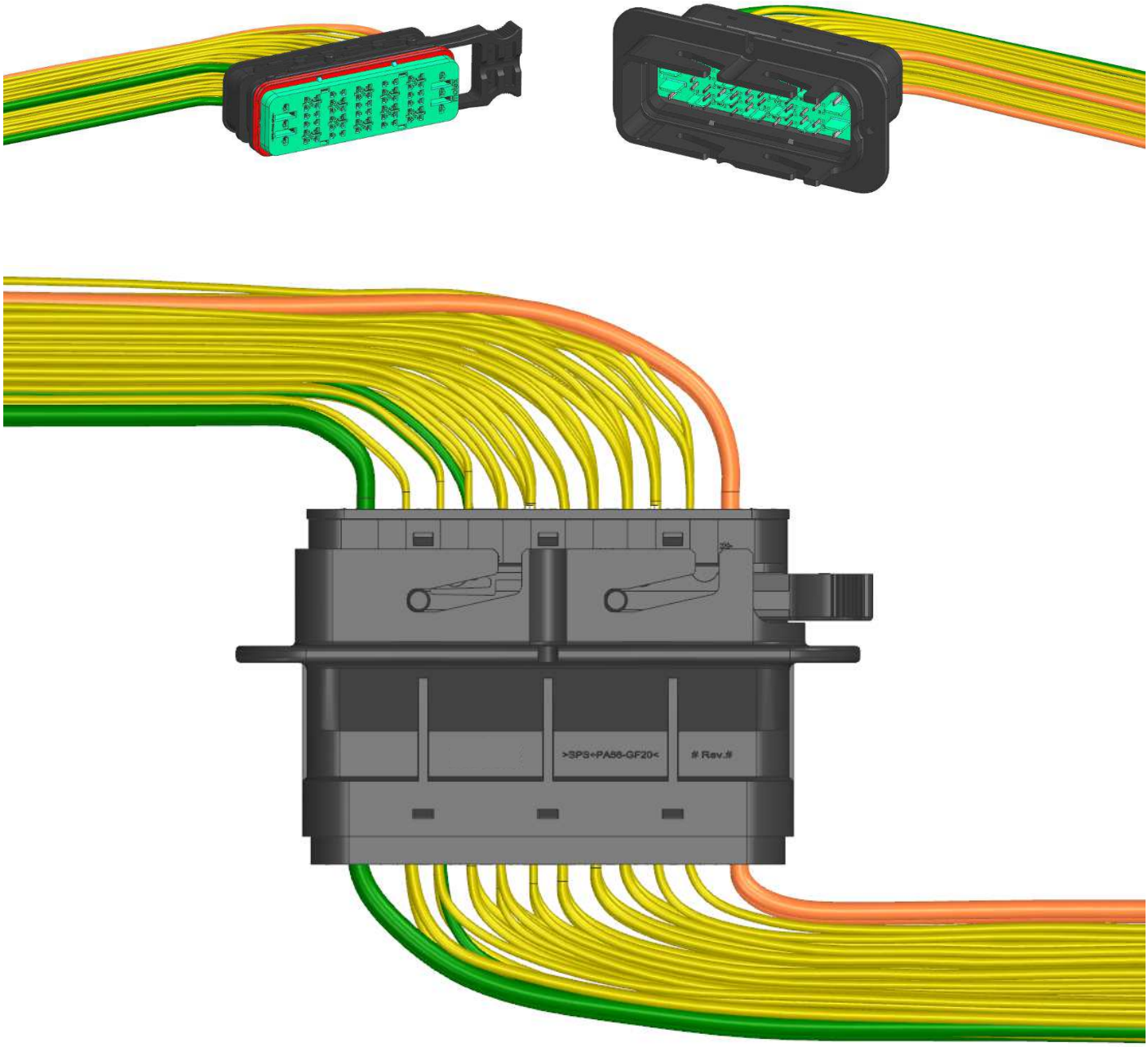
Assembly instructions for SRC



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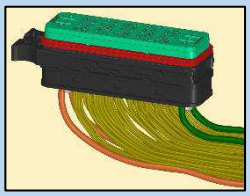

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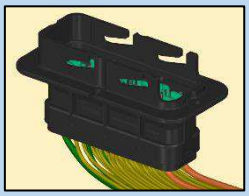

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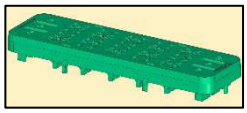

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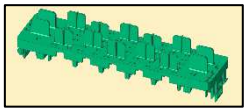

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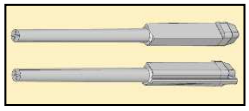

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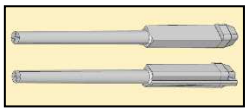

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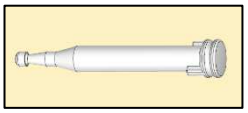

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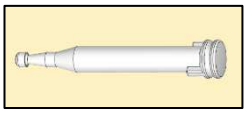

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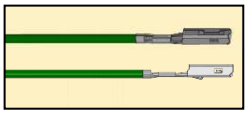

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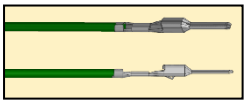

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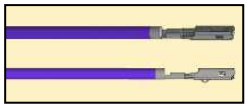

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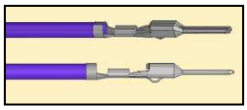

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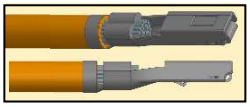

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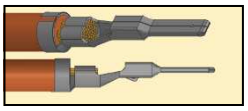

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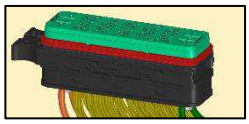

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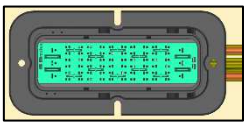

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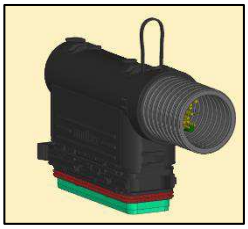

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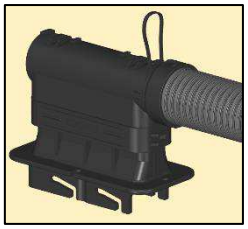

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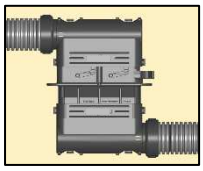

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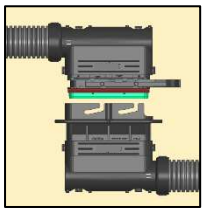

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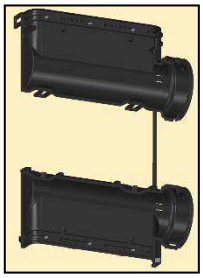

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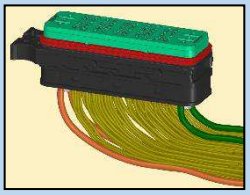

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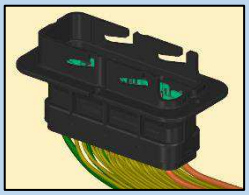

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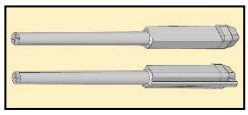

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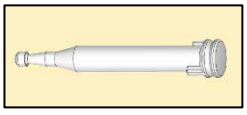

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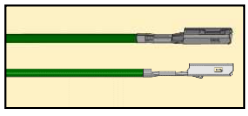

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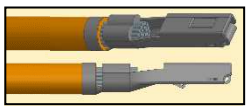

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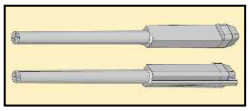

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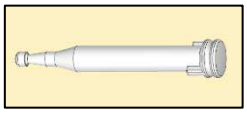

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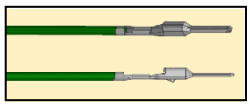

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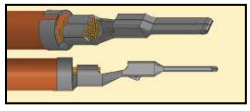

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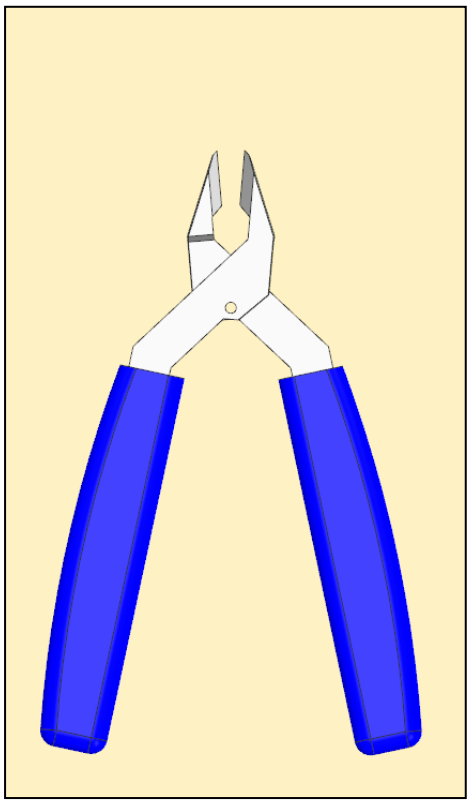
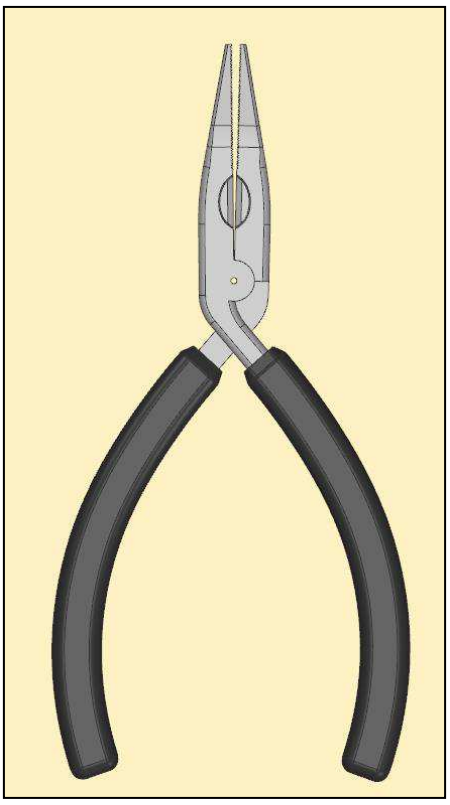
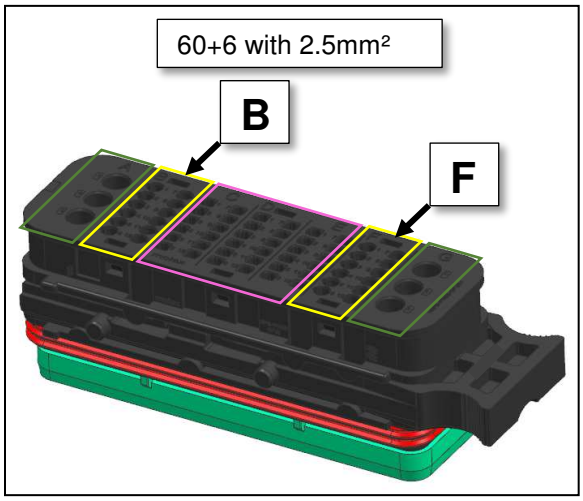
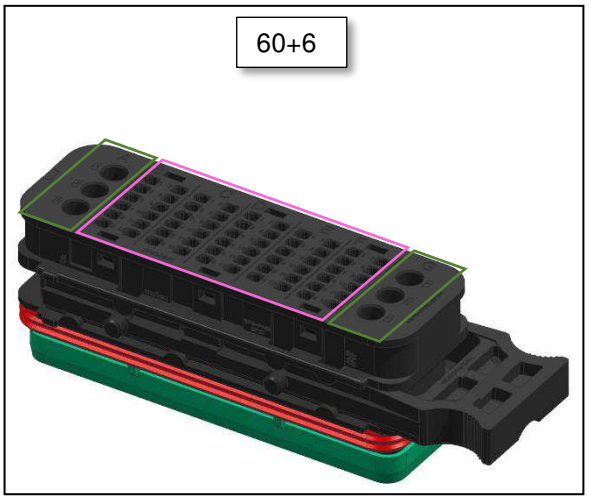


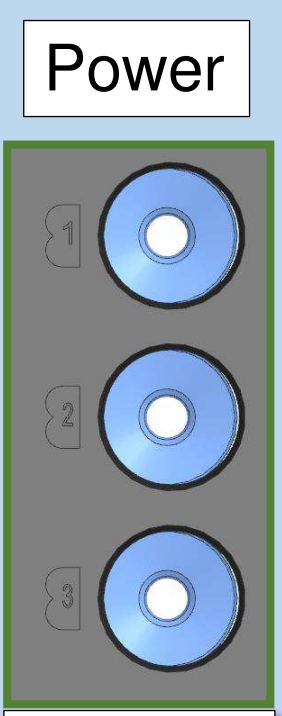


FEMALE ASSEMBLY OVERVIEW

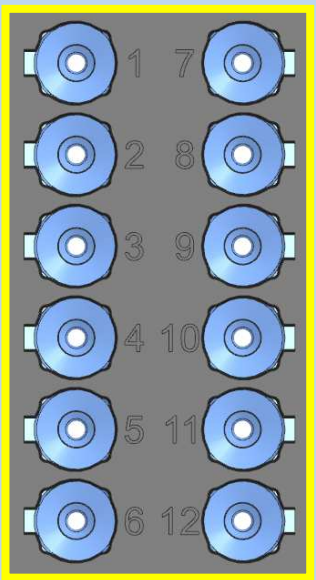




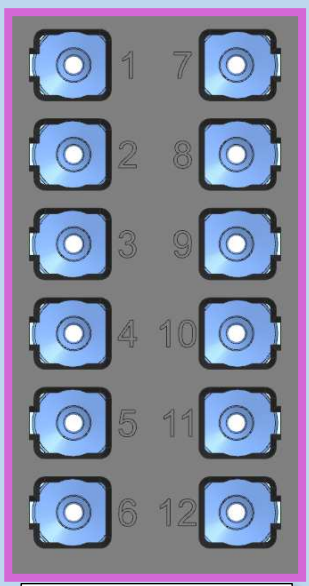
- 2.5mm² only available on some configurations and only in **B and F** locations as highlighted in yellow above
- For all configurations please see 2500000 thru 2500015



Power
Cable Insulation Diameter Range
3.0 – 5.0mm

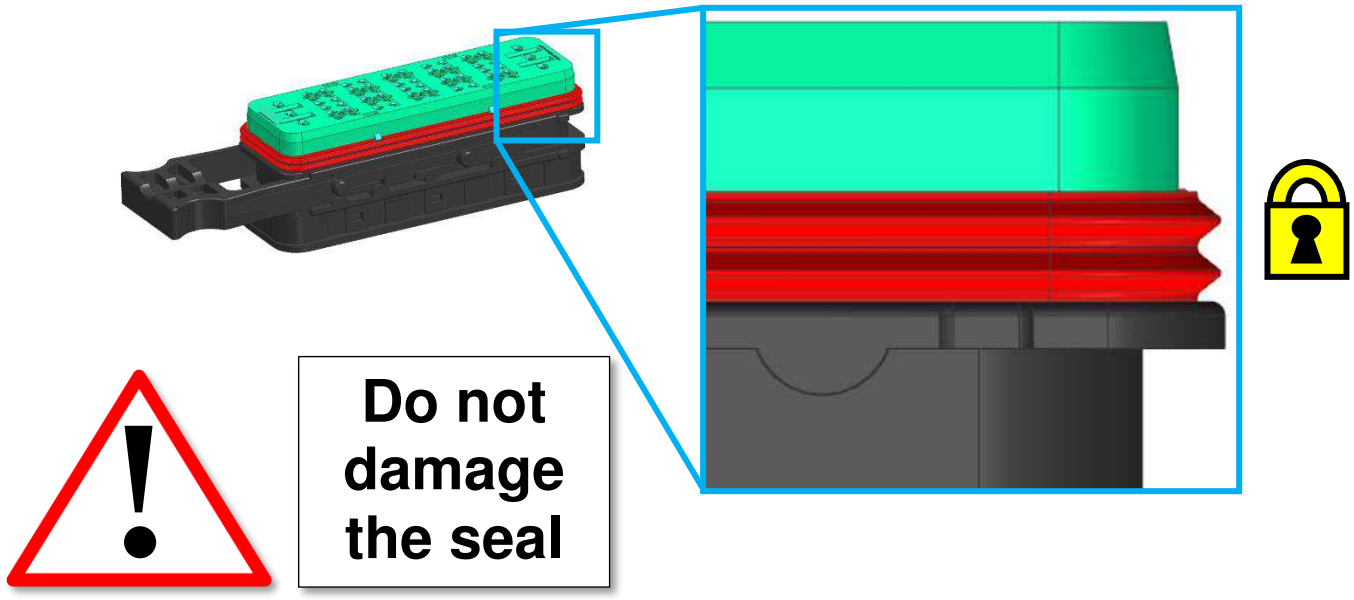


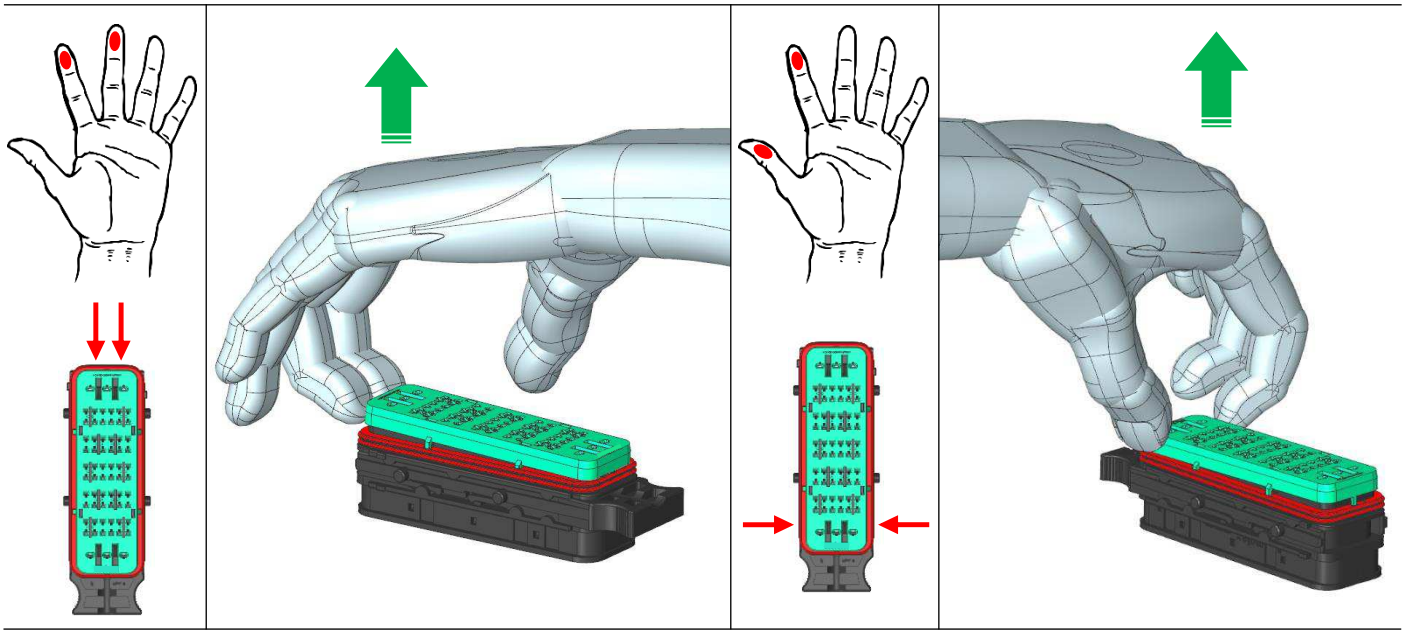
2.5mm²
Cable Insulation Diameter Range
1.5 – 3.0mm

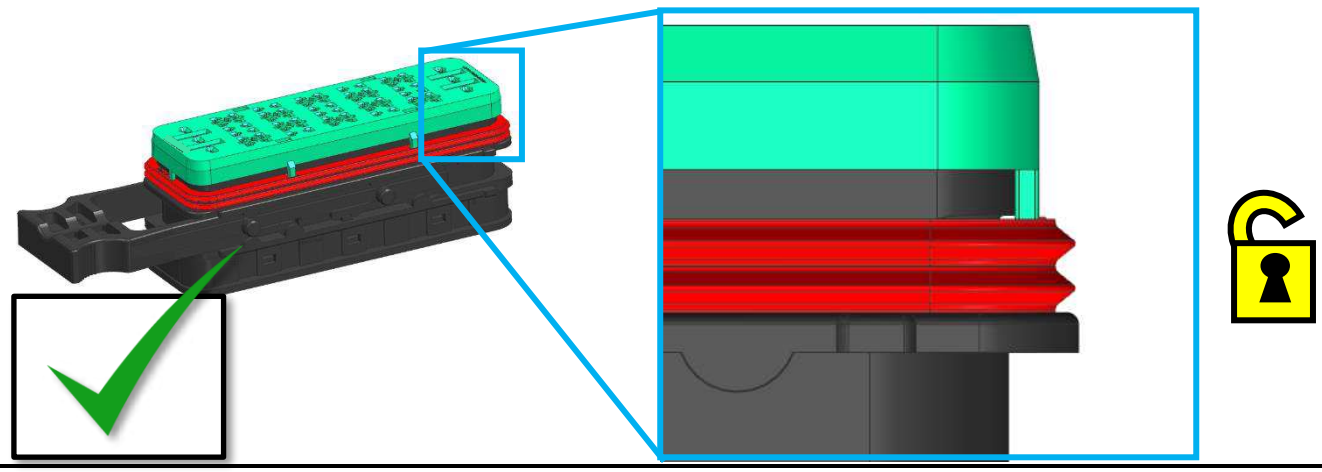


Signal
Cable Insulation Diameter Range
1.5 - 2.7mm

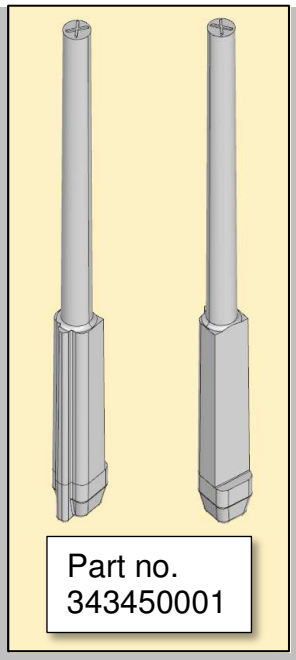
STEP 1 – OPEN TPA



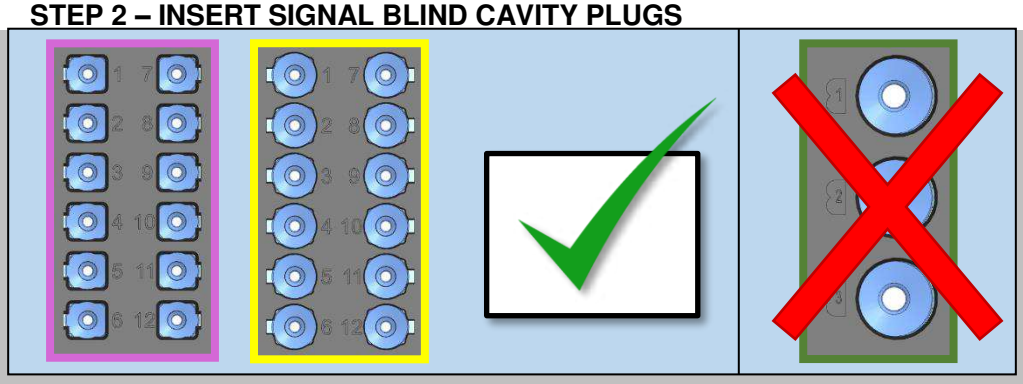


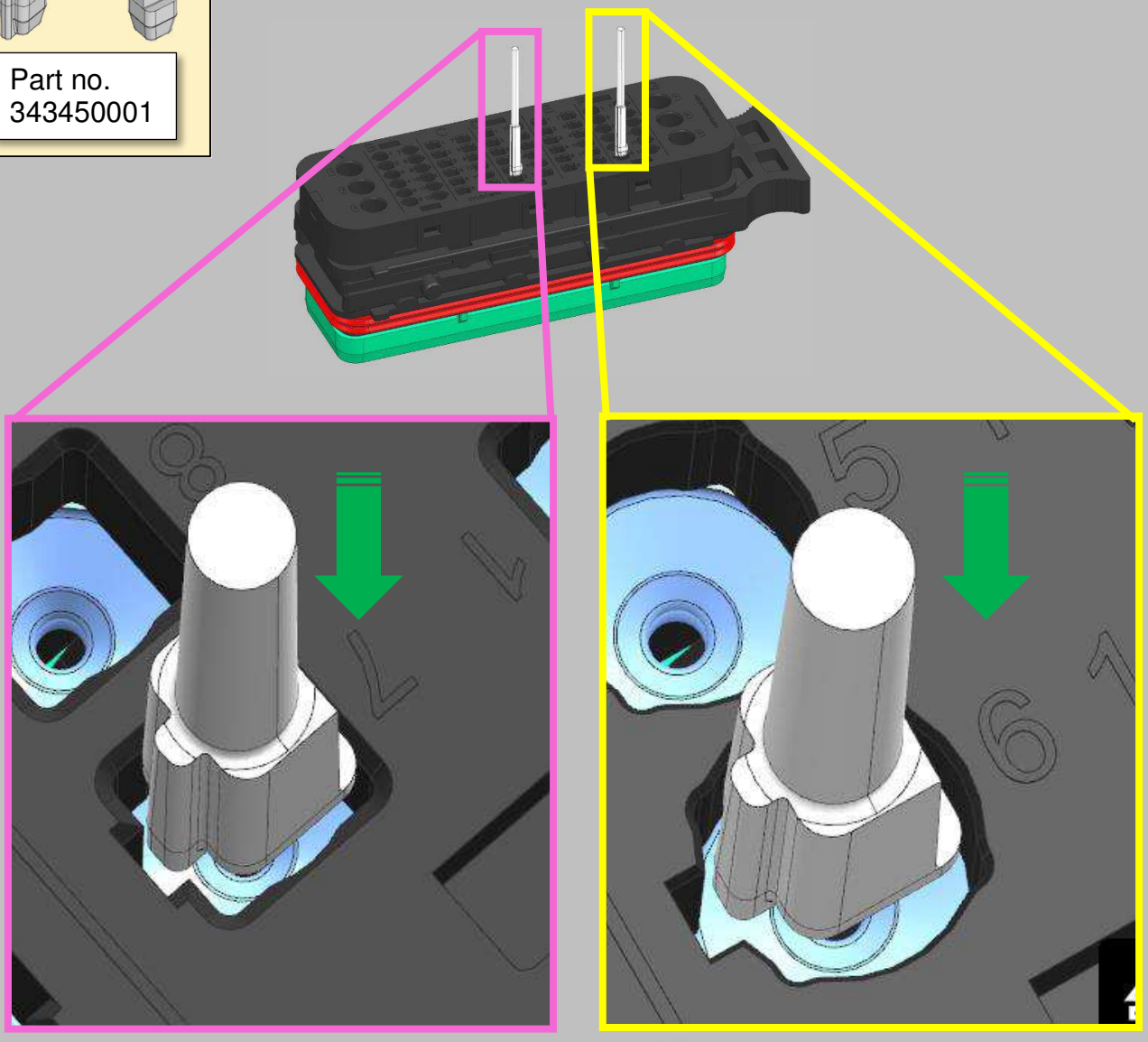


STEP 2 – INSERT SIGNAL BLIND CAVITY PLUGS



Part no.
343450001

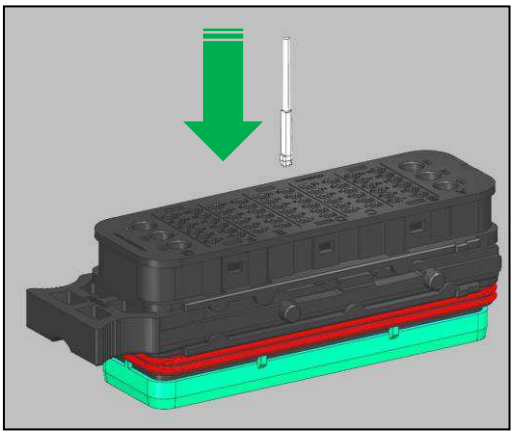


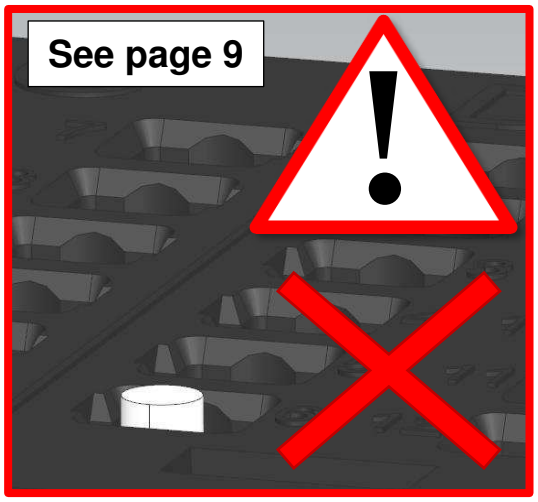


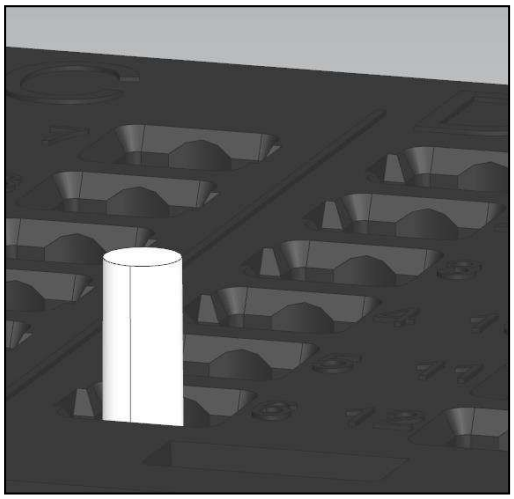
Demonstration example

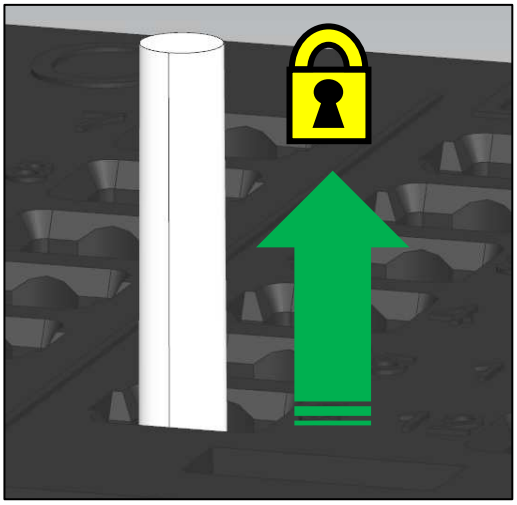
See next page

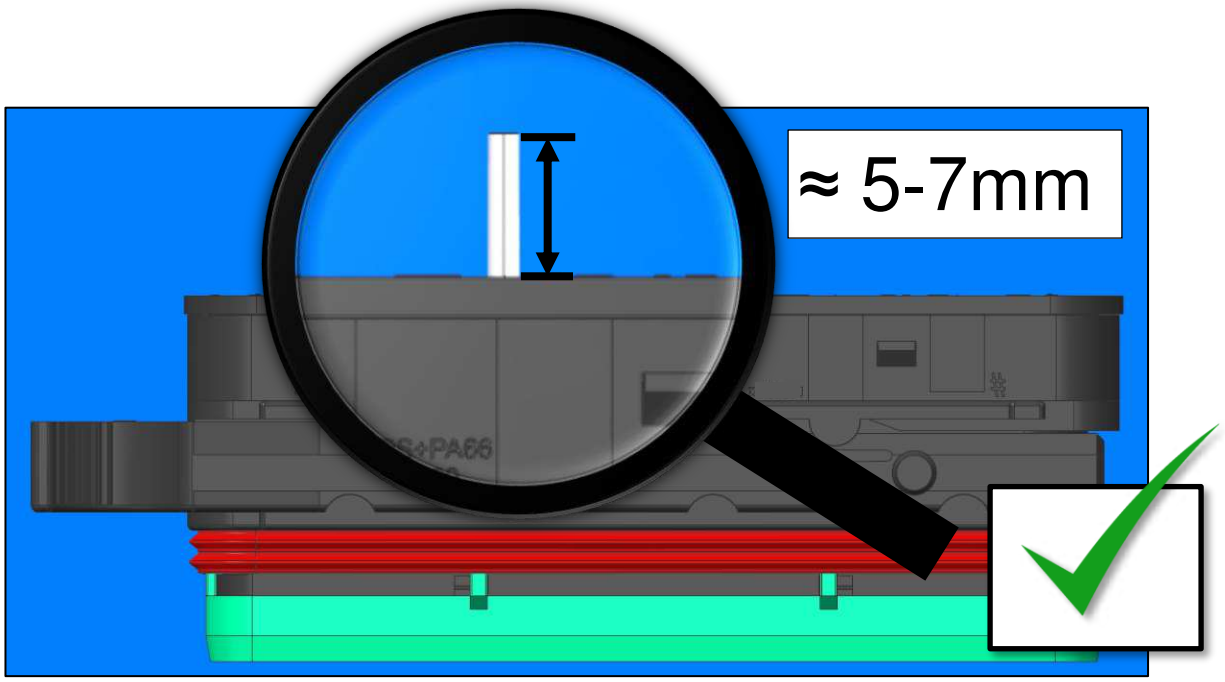
STEP 2 – INSERT SIGNAL BLIND CAVITY PLUGS





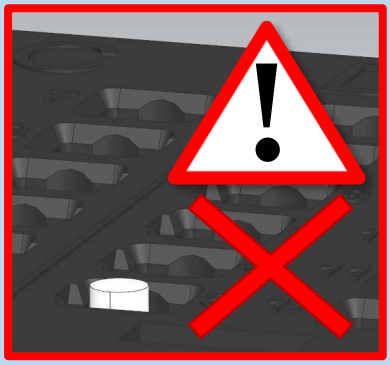




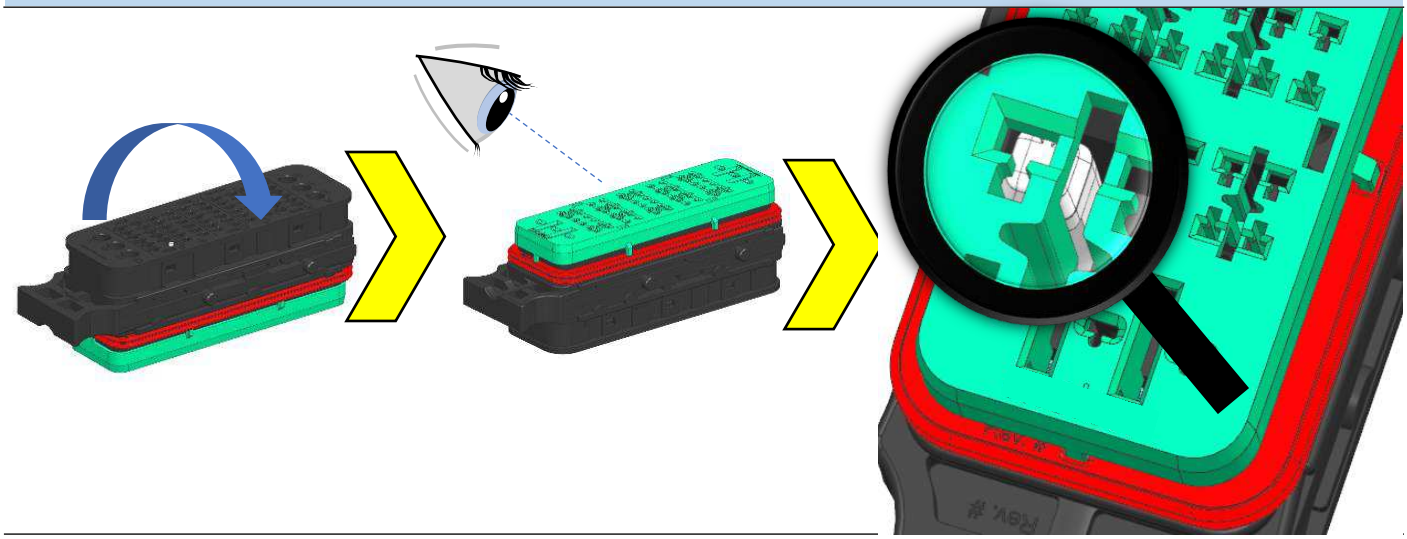


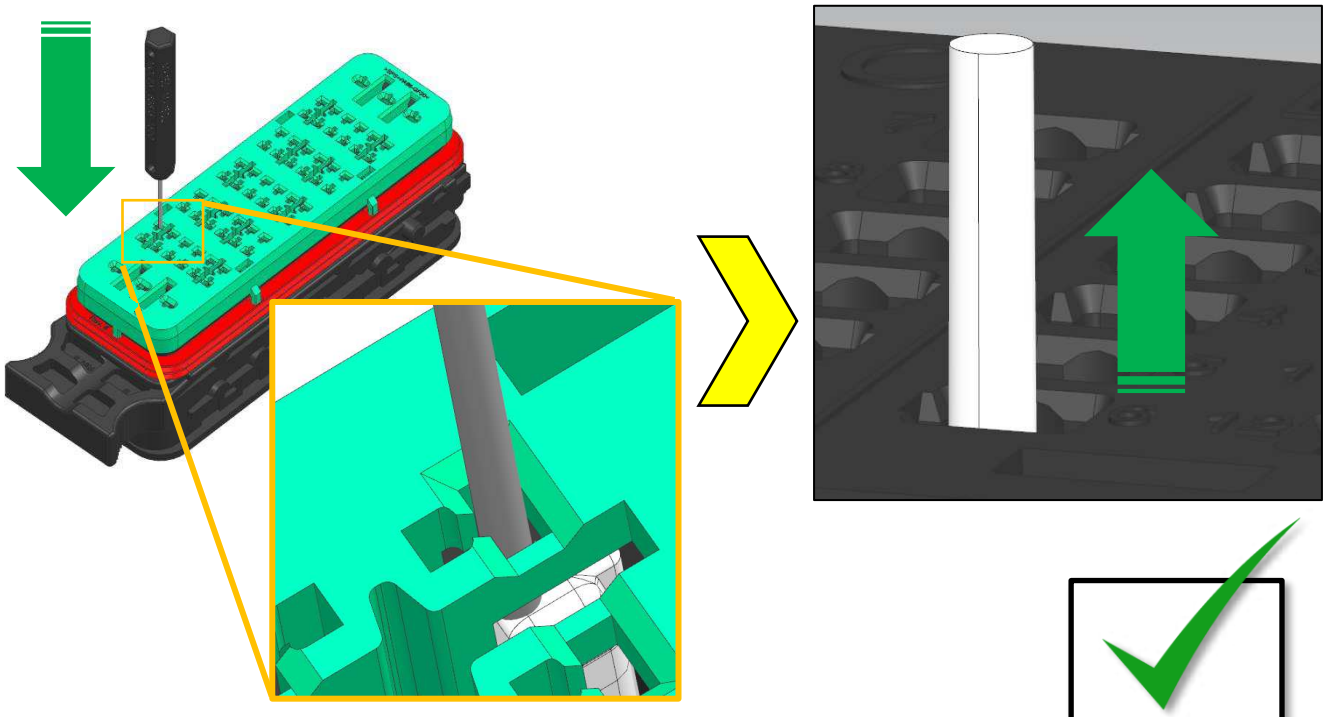
TOP TIP – ONLY FOR SIGNAL BLIND CAVITY PLUGS

If this happens

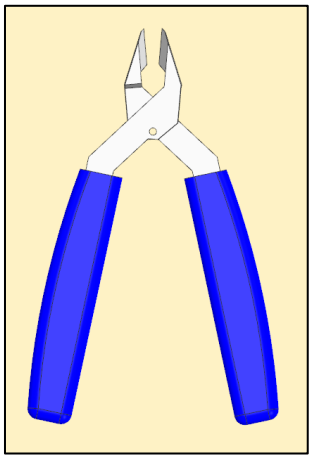


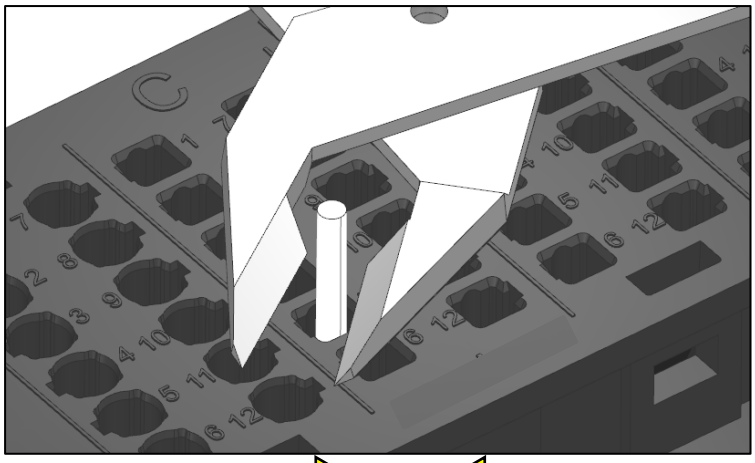
Tool required

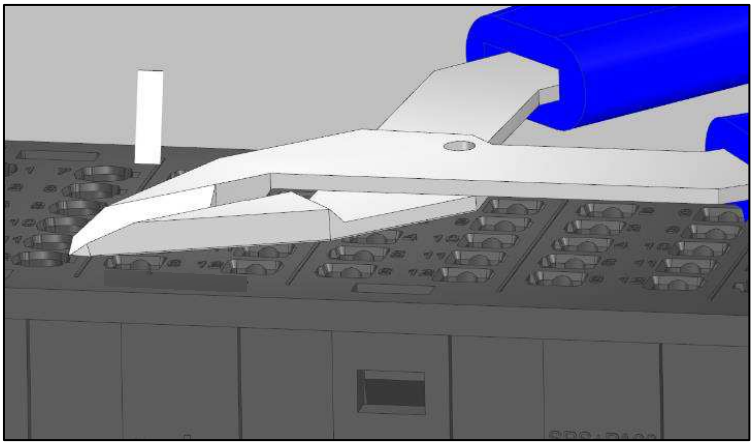


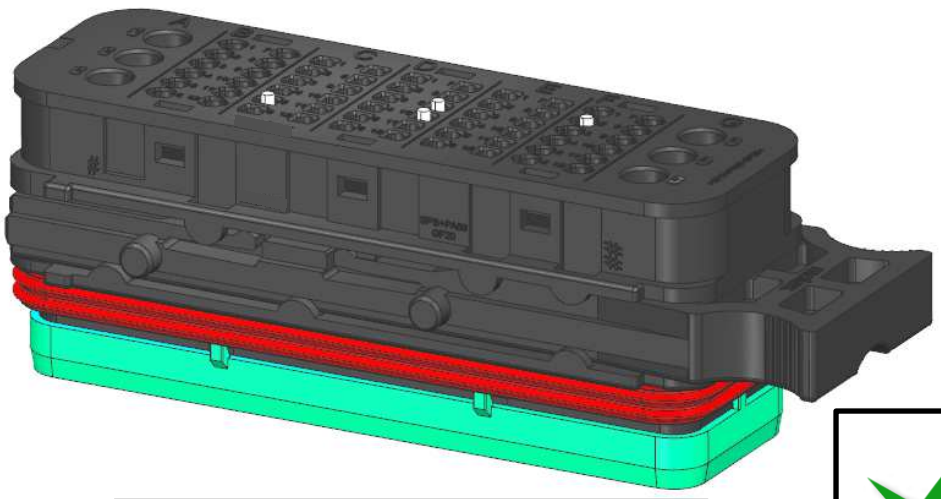


STEP 2.1 – TRIM SIGNAL BLIND CAVITY PLUGS (RECOMMENDED)



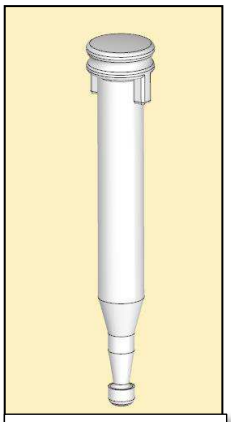




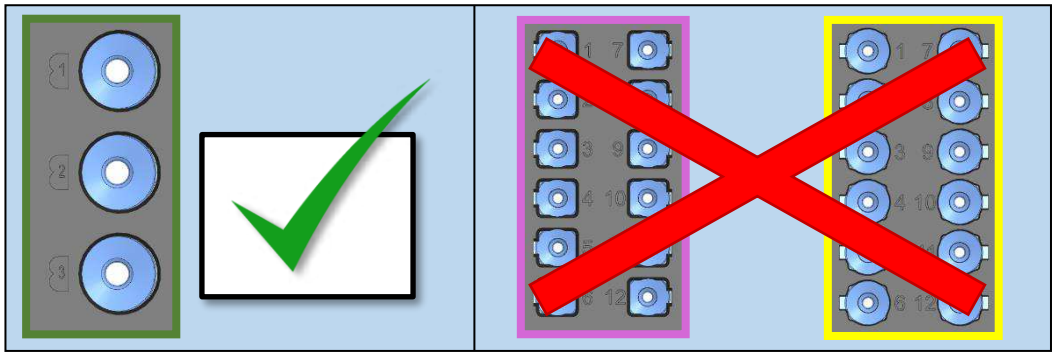


Demonstration example

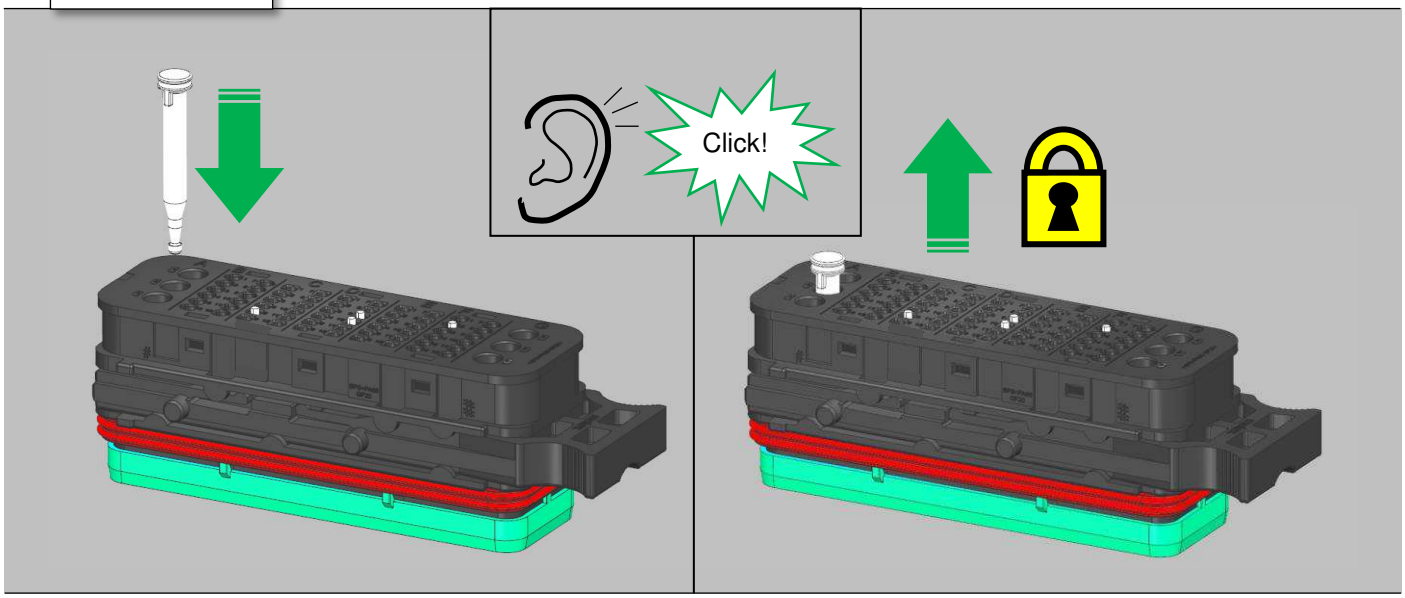
STEP 3 – INSERT POWER BLIND CAVITY PLUGS

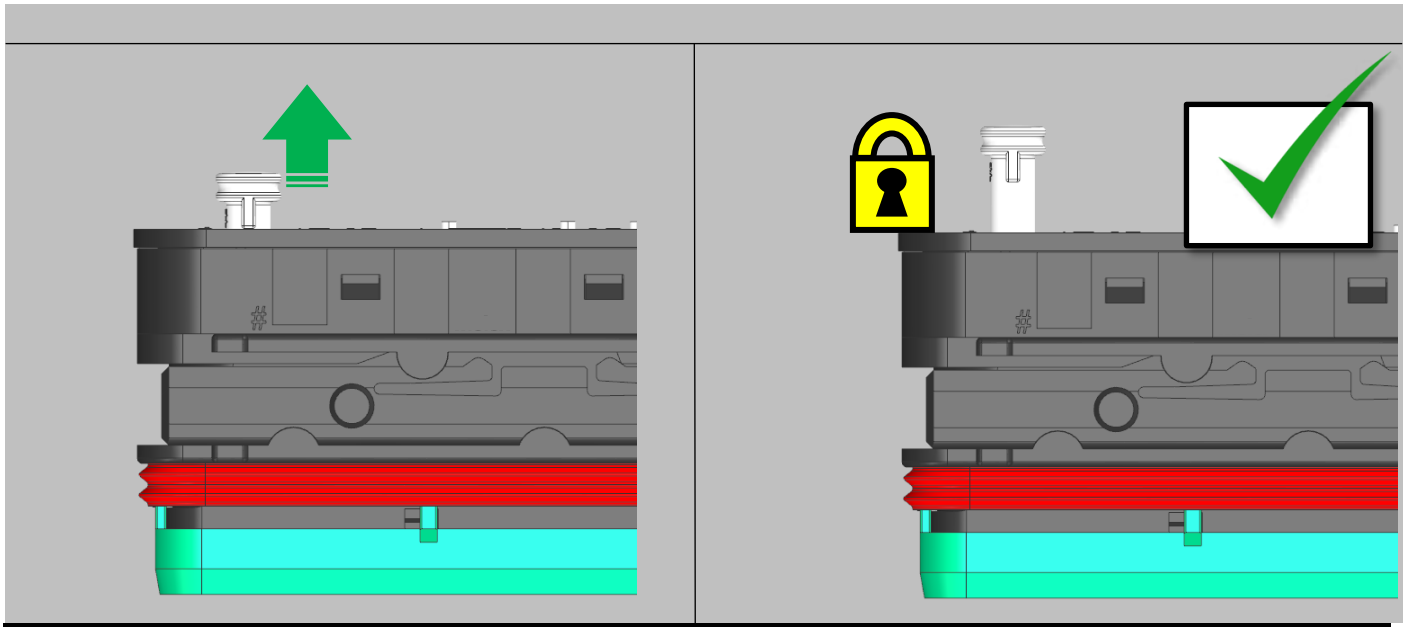


P/N:2500033-1
(Old P/N:
937320001)

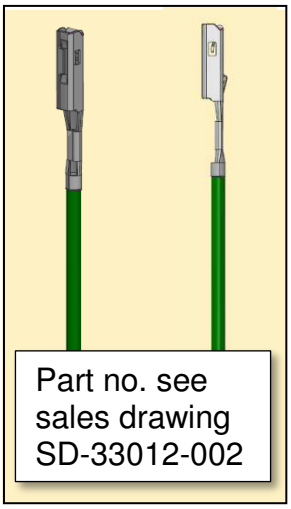


Demonstration example

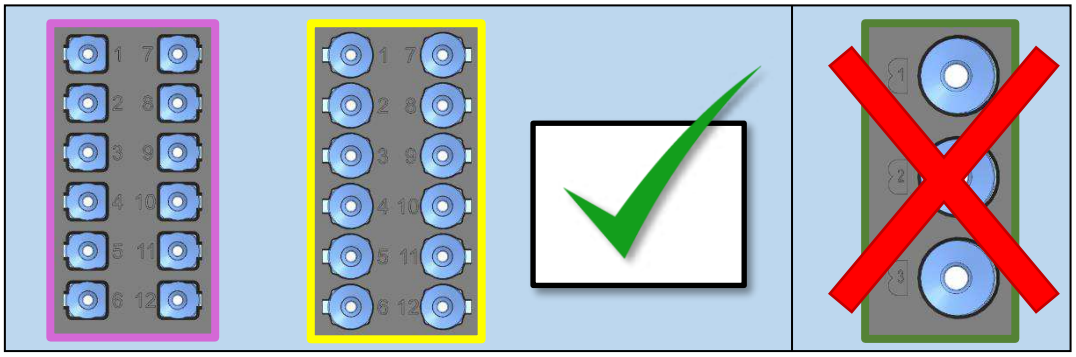




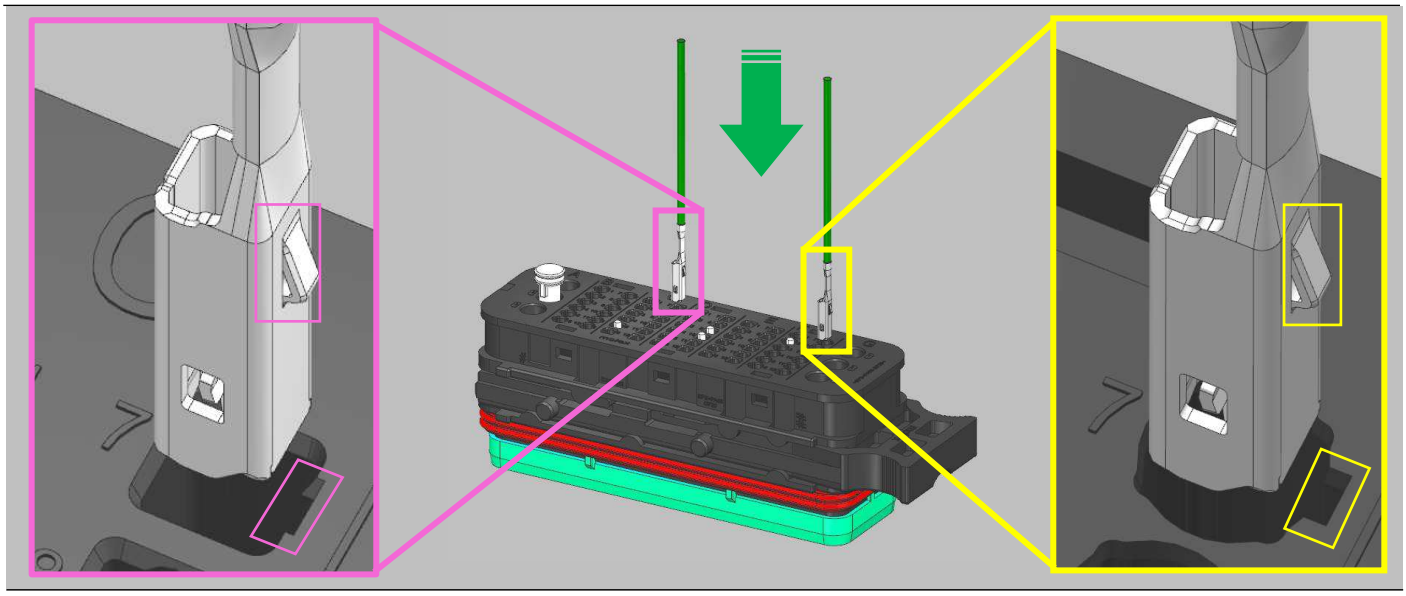
STEP 4 – INSERT SIGNAL TERMINALS



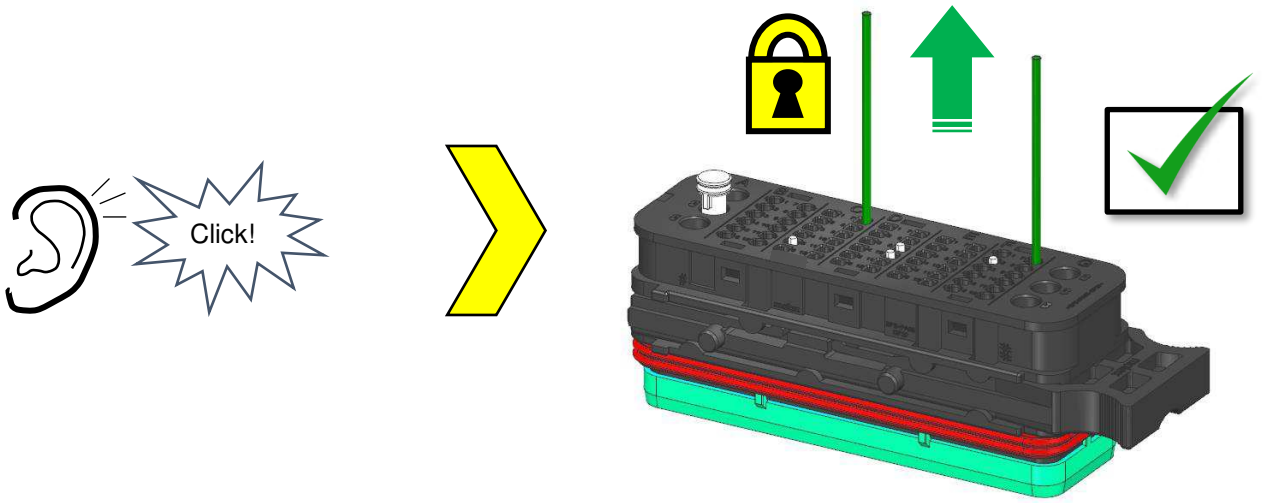
Part no. see sales drawing SD-33012-002



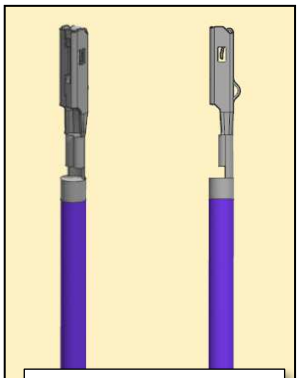
Signal
Cable Insulation Diameter
Range 1.5 - 2.7mm



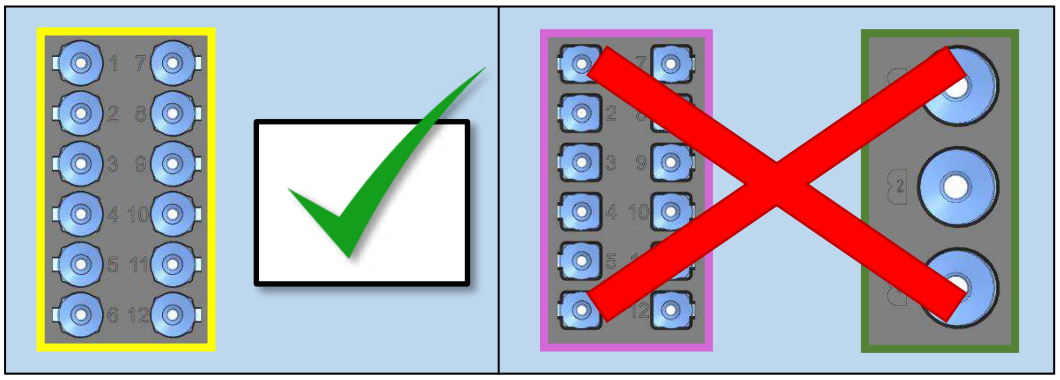
Demonstration example



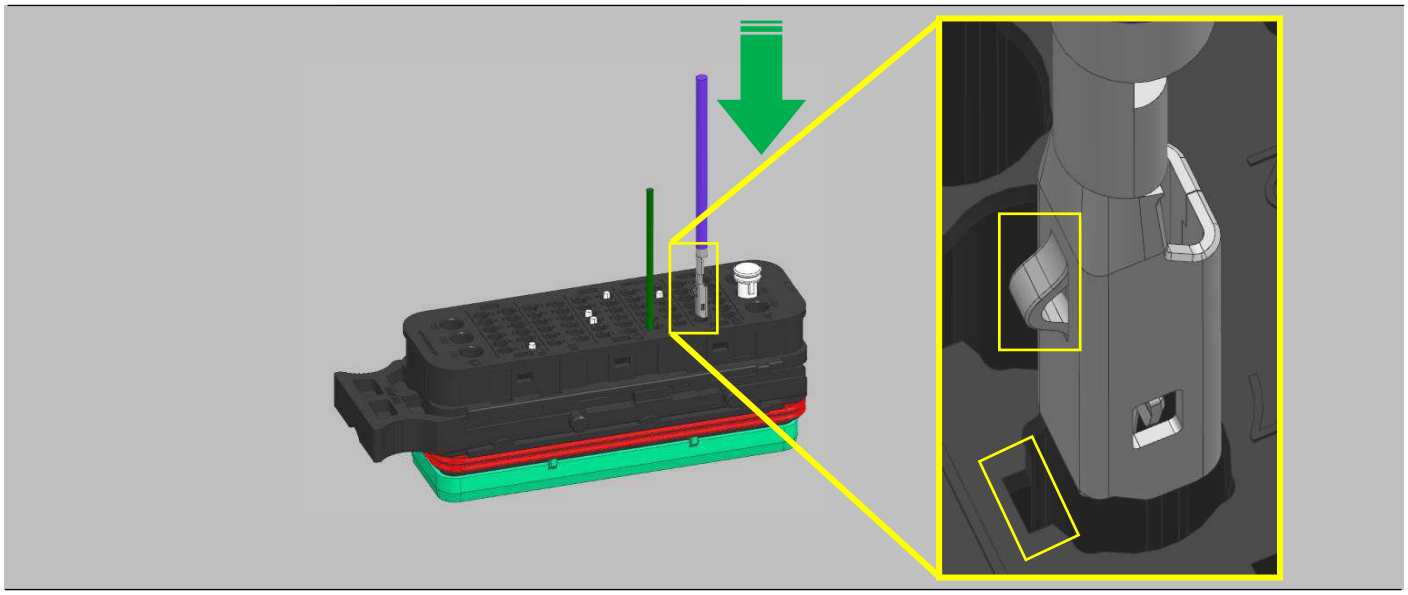
STEP 5 – INSERT 2.5MM² (13AWG) TERMINAL



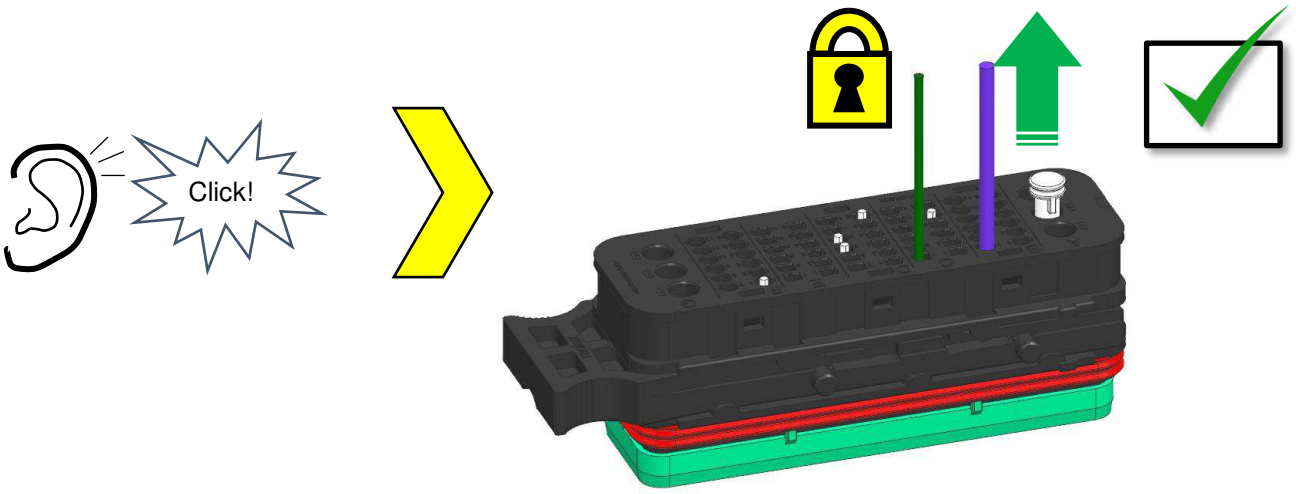
Part no. see sales drawing 936430010 PSD



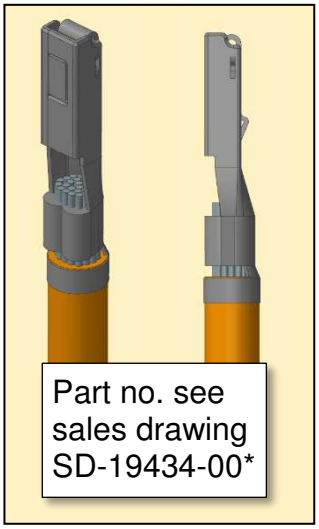
2.5mm²
Cable Insulation Diameter
Range 1.5 – 3.0mm



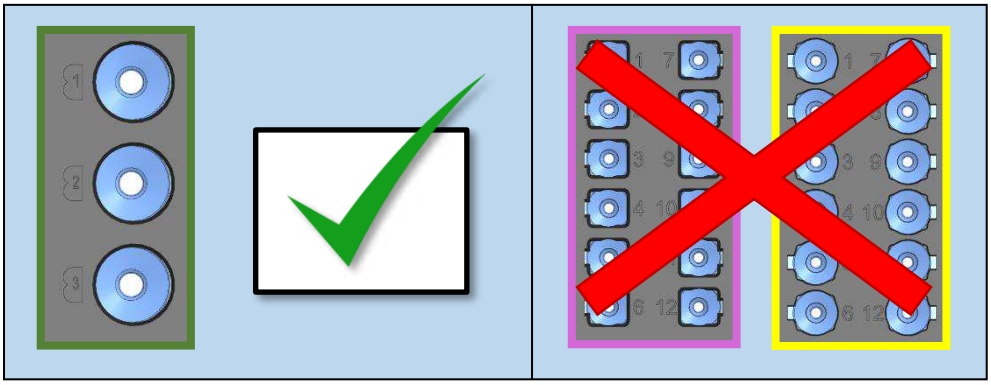
Demonstration example



STEP 6 – INSERT POWER TERMINALS

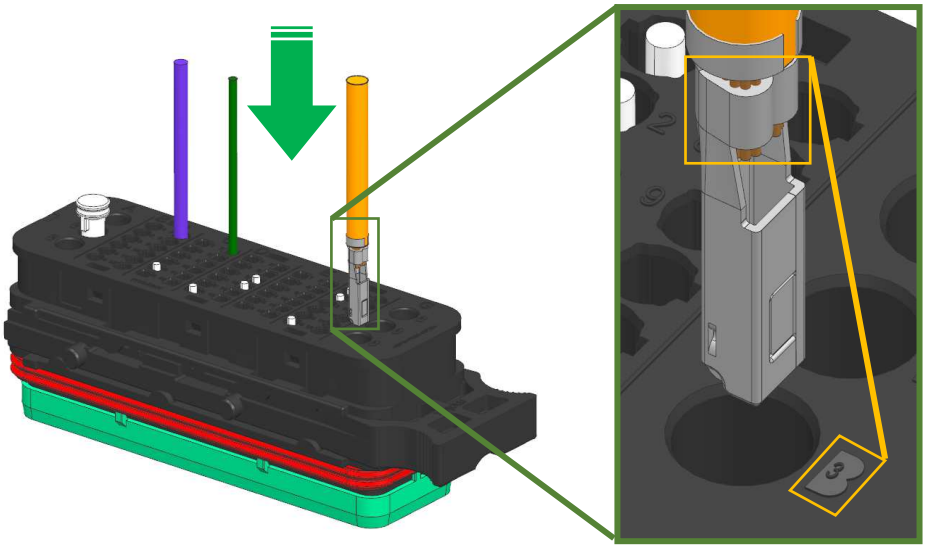


Part no. see sales drawing SD-19434-00*

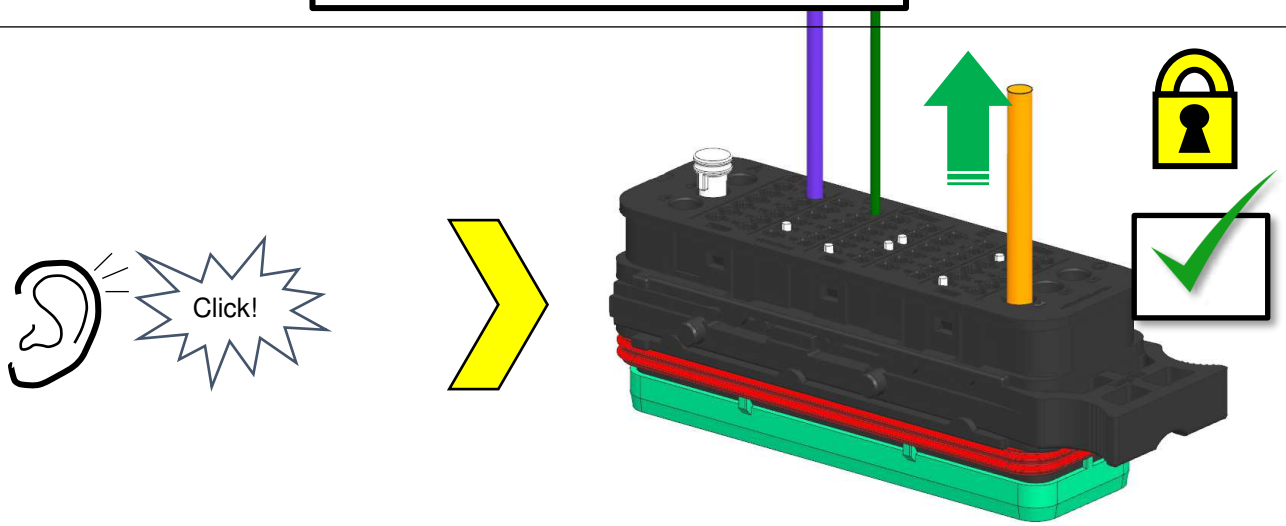


Power
Cable Insulation Diameter
Range 3.0 – 5.0mm

Insert terminal nose carefully through seal opening

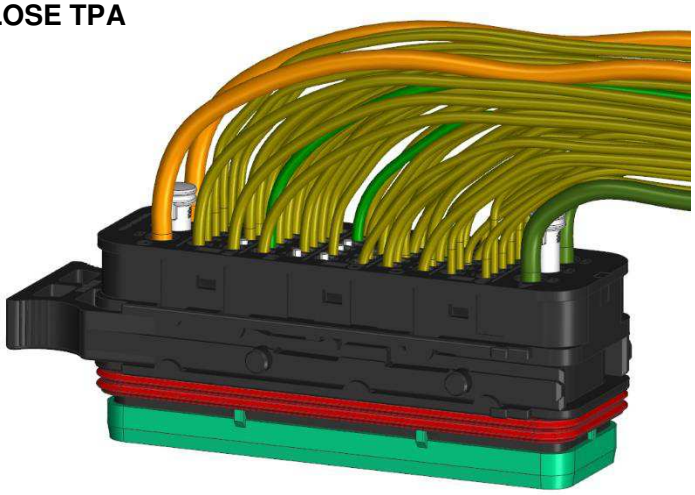


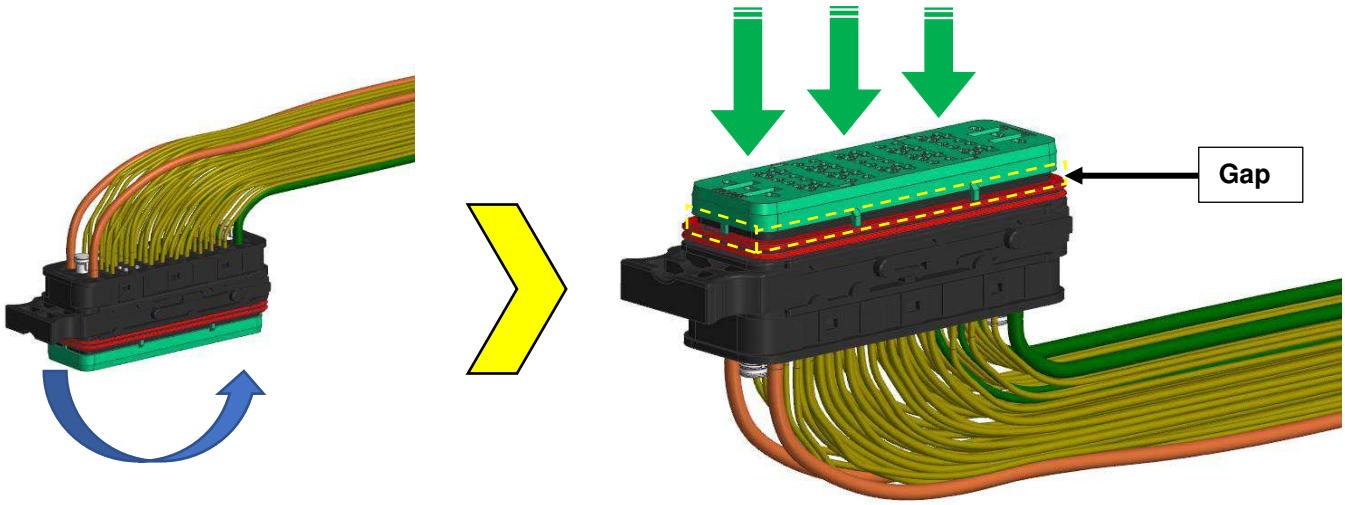
Demonstration example

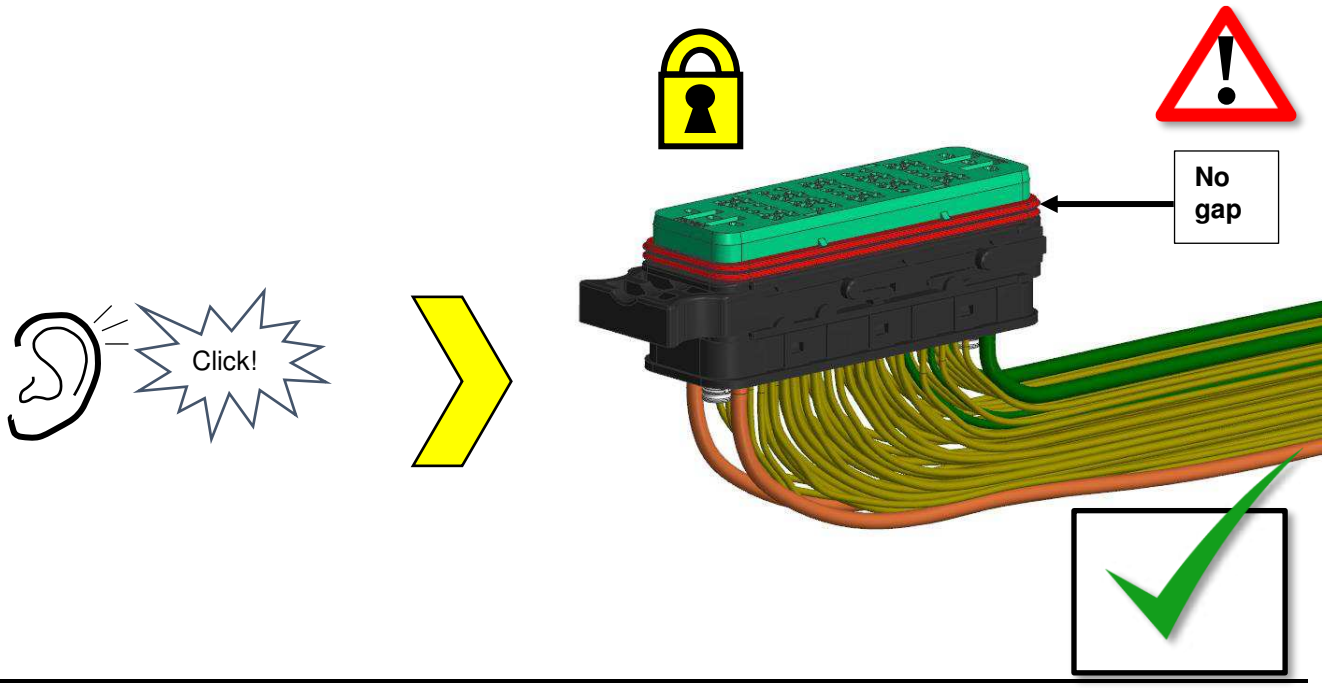


STEP 7 – CLOSE TPA

Populate connector fully no holes left empty



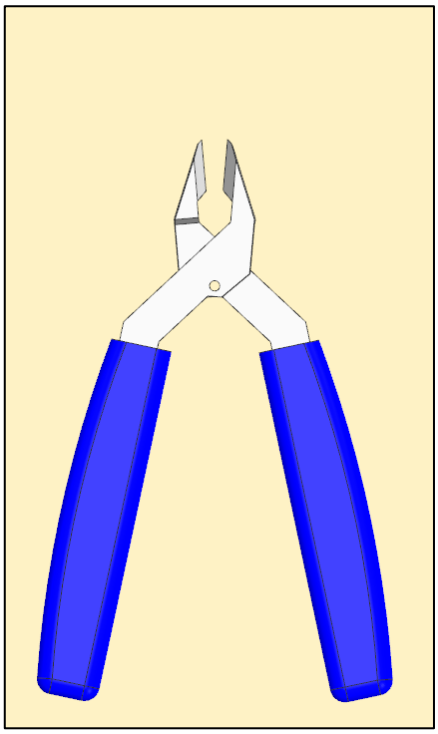




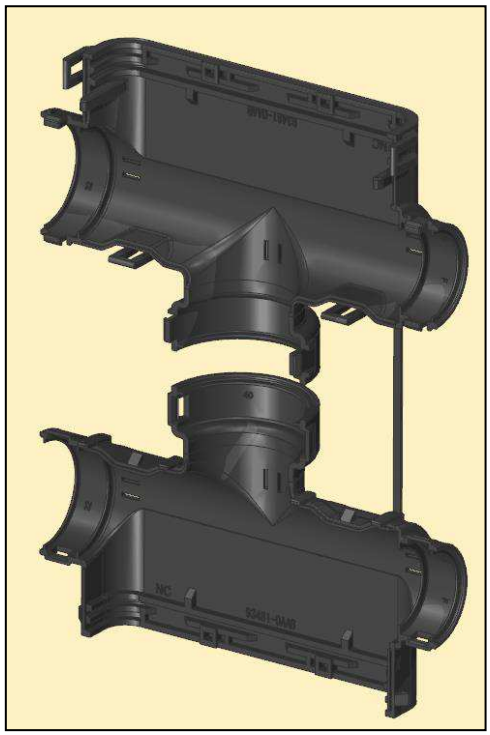
STEP 8 – APPLY WIRE DRESS/CONDUIT INTERFACE

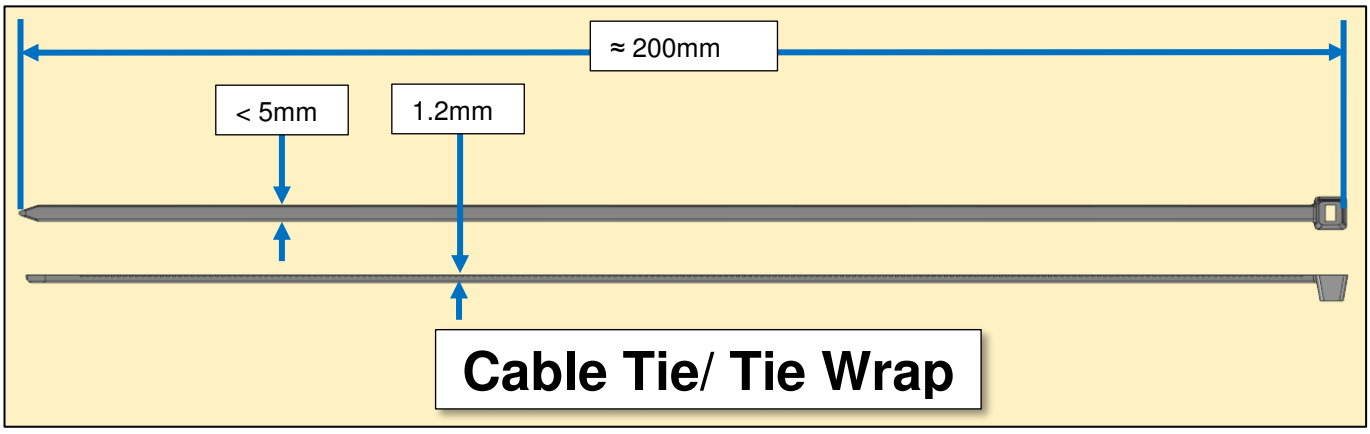
- Various configurations of wire dress available.
  - 1 – 3 open exits
  - 4 different exit sizes
- See sales drawing: 2500034
- Appropriate conduit must be used with wire dress
- Example shown for demonstration only
- Direction of exit(s) per wiring diagram

Tool & parts needed



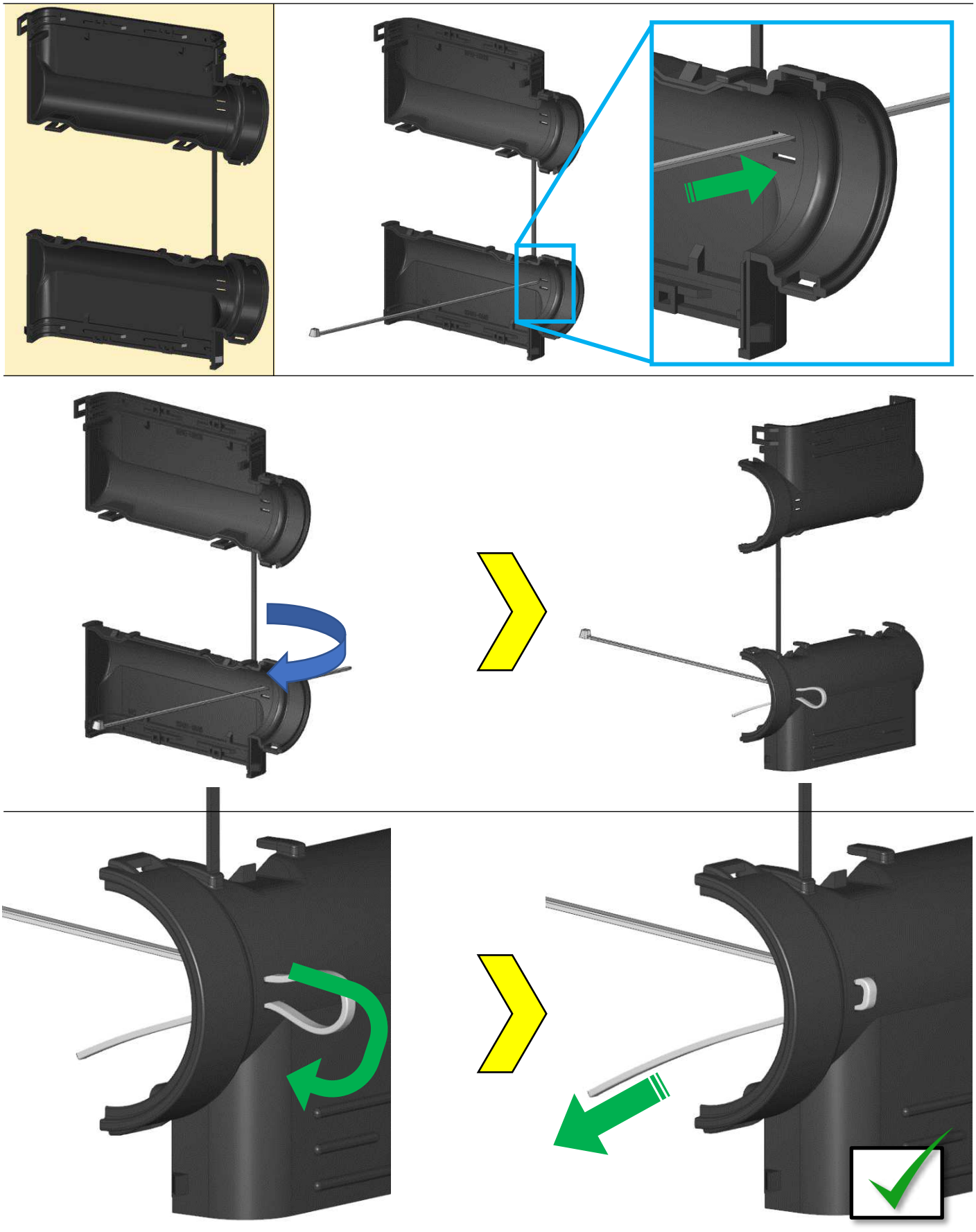
Conduit



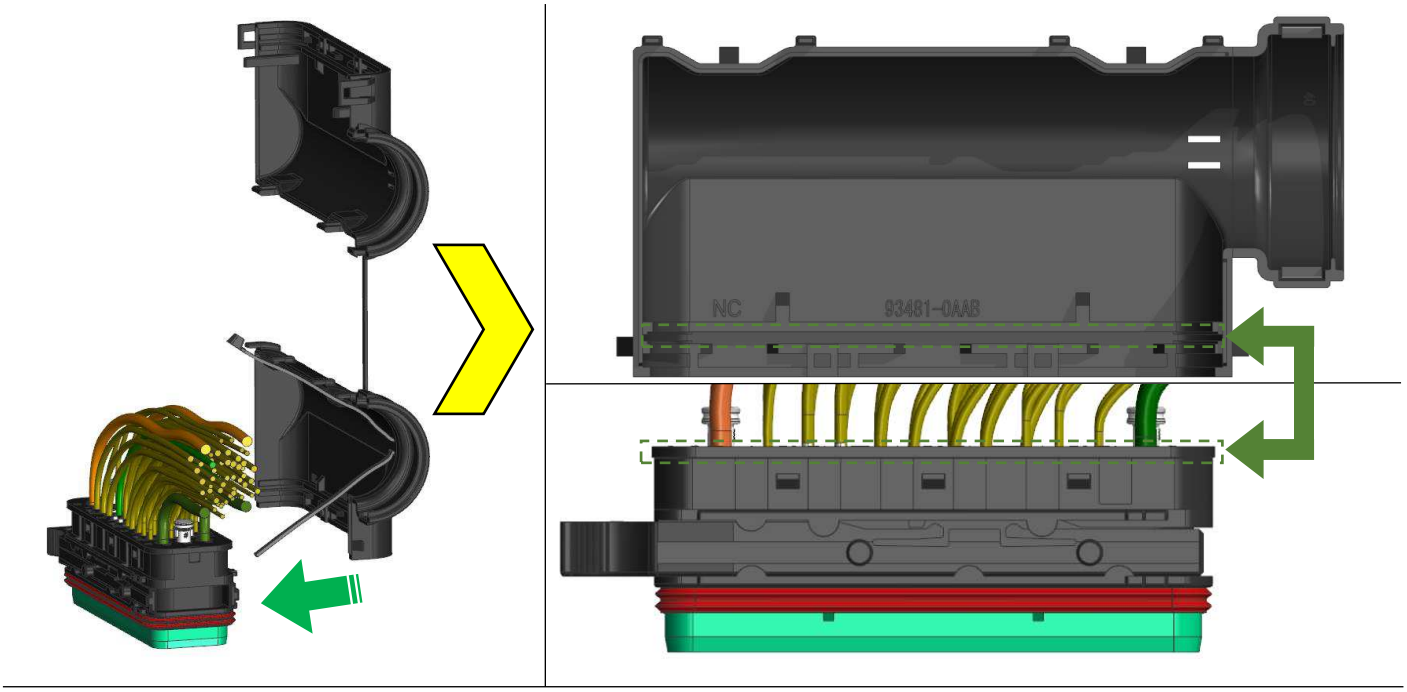


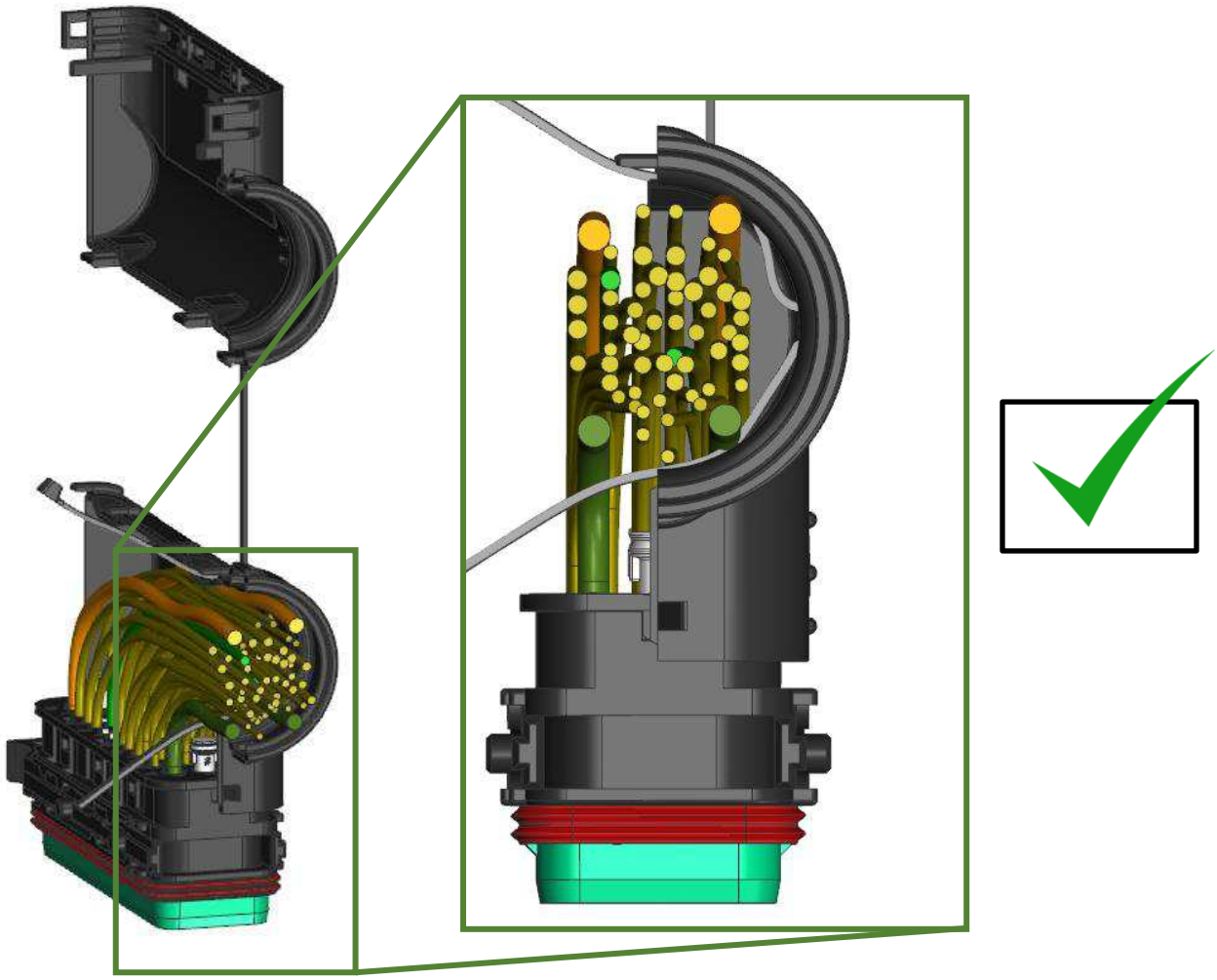
Cable Tie/ Tie Wrap

RECOMMENDED ASSEMBLY SEQUENCE

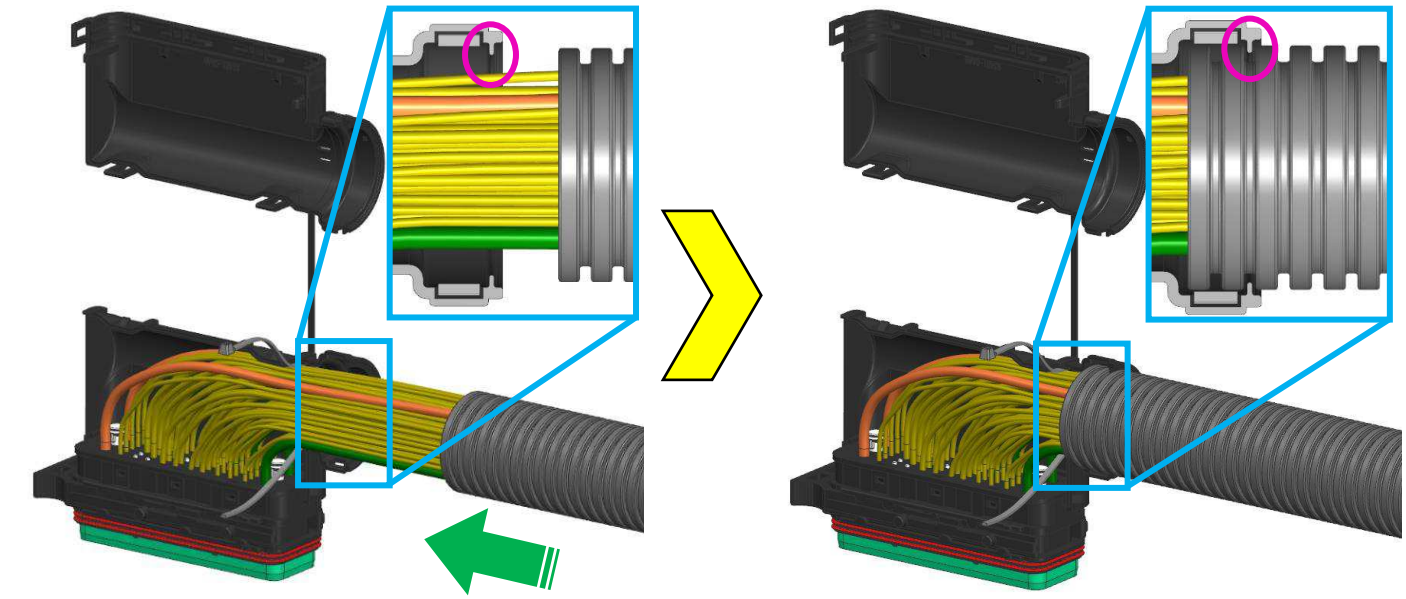


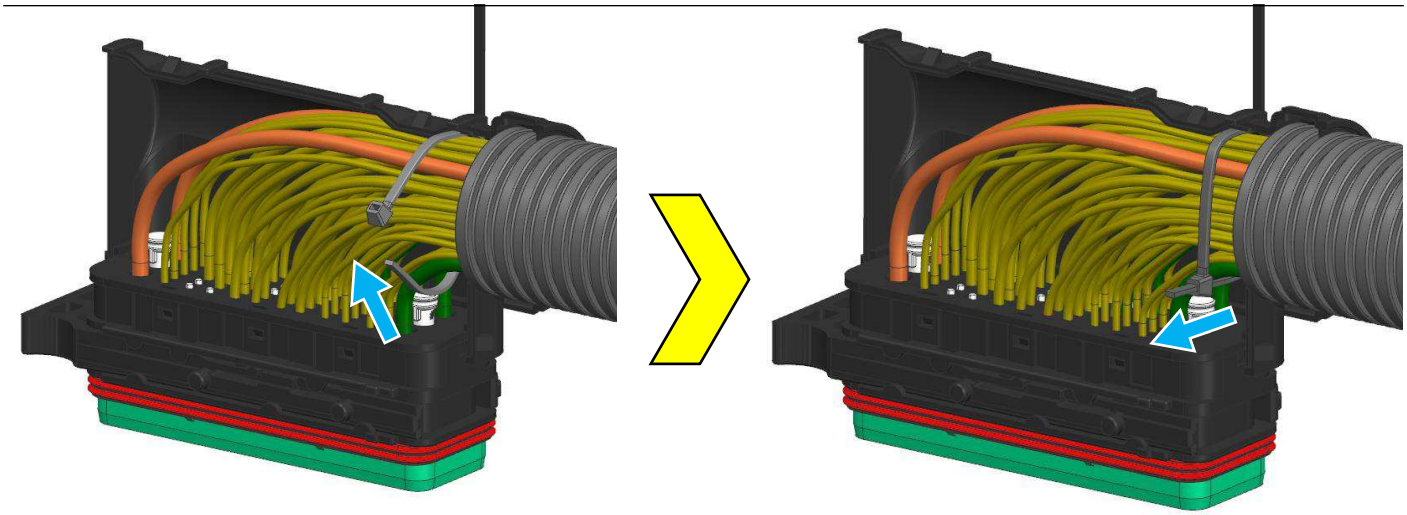
RECOMMENDED ASSEMBLY SEQUENCE

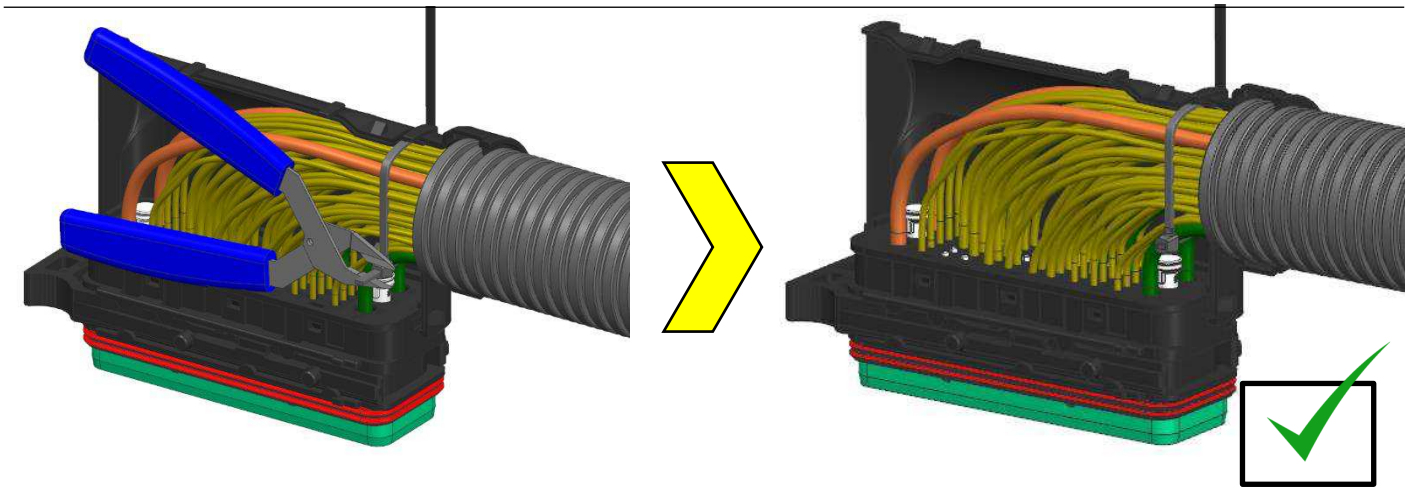




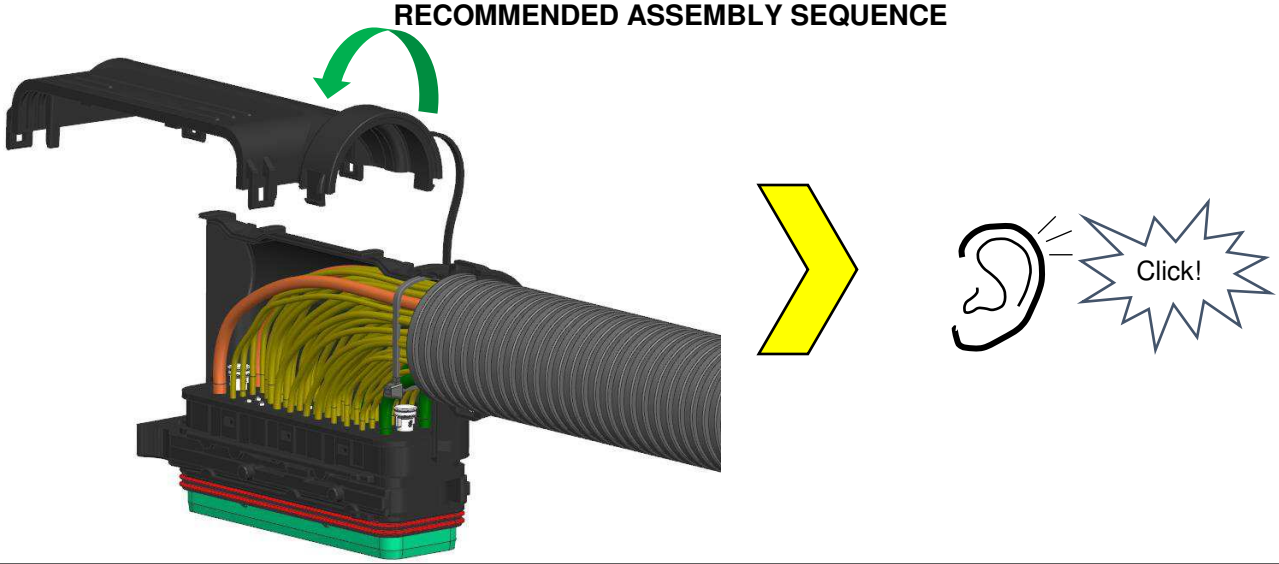
RECOMMENDED ASSEMBLY SEQUENCE

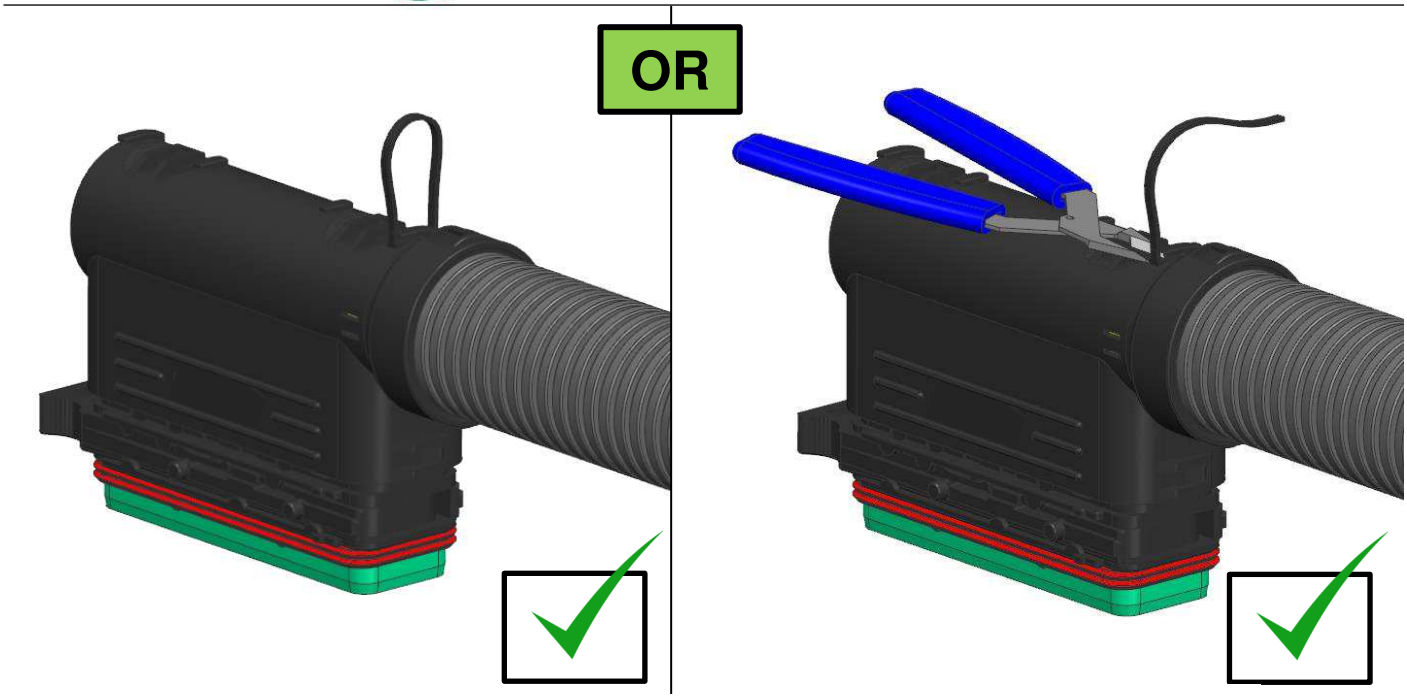


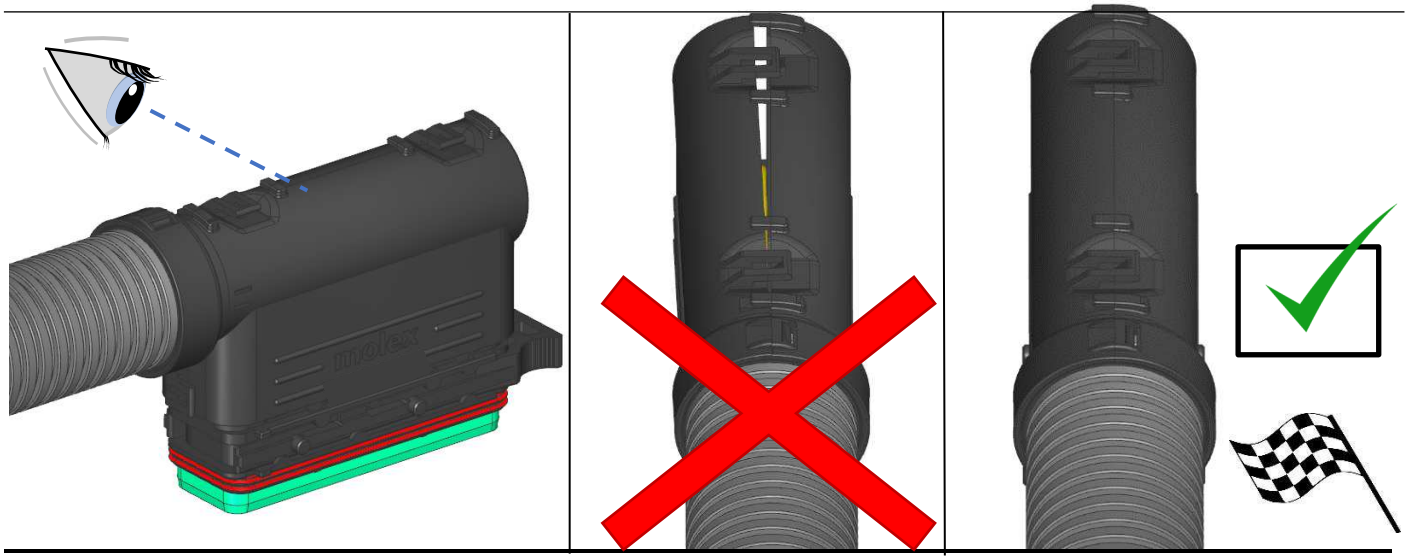




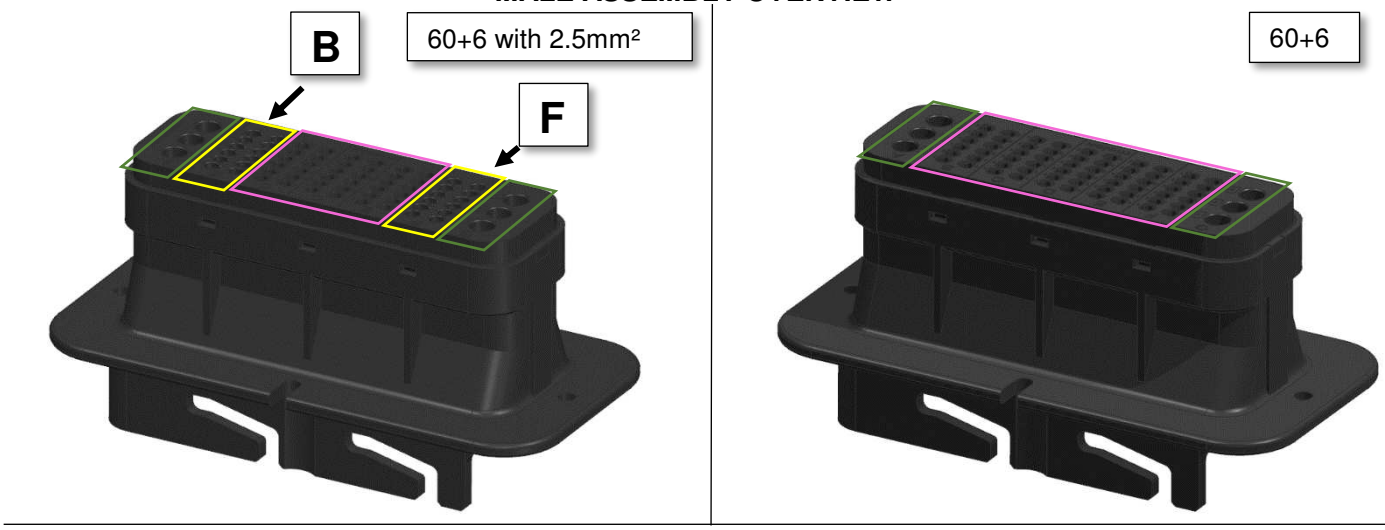
RECOMMENDED ASSEMBLY SEQUENCE



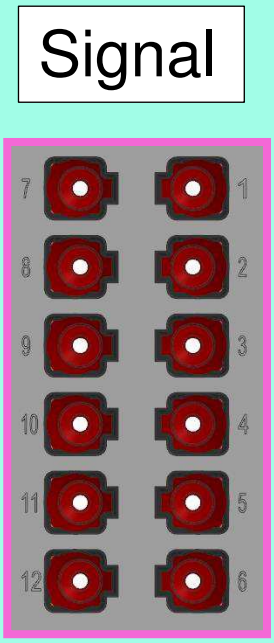




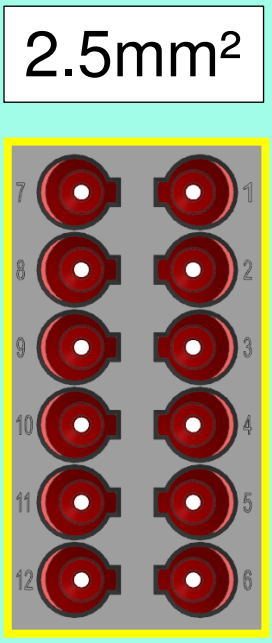
MALE ASSEMBLY OVERVIEW



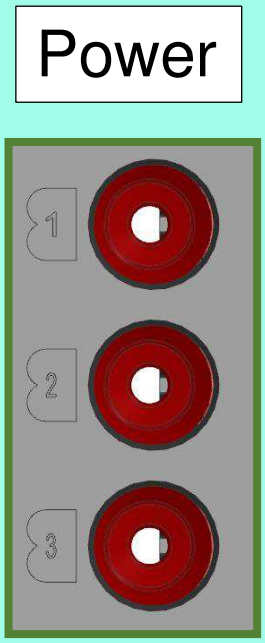
- 2.5mm² only available on some configurations and only in **B and F** locations as highlighted in yellow above
- For all configurations please see 2500016 thru 2500031



Signal
Cable Insulation Diameter Range
1.5 - 2.7mm

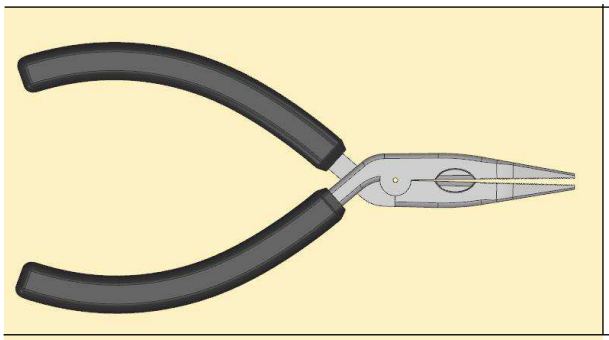


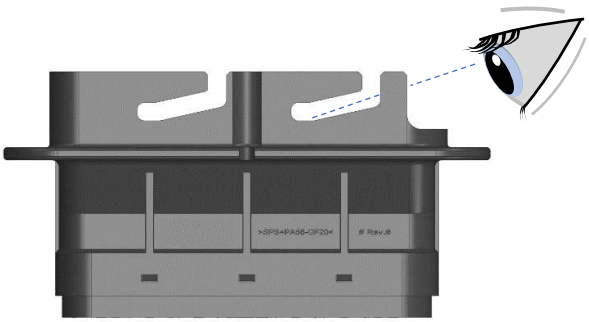
2.5mm²
Cable Insulation Diameter Range
1.5 – 3.0mm

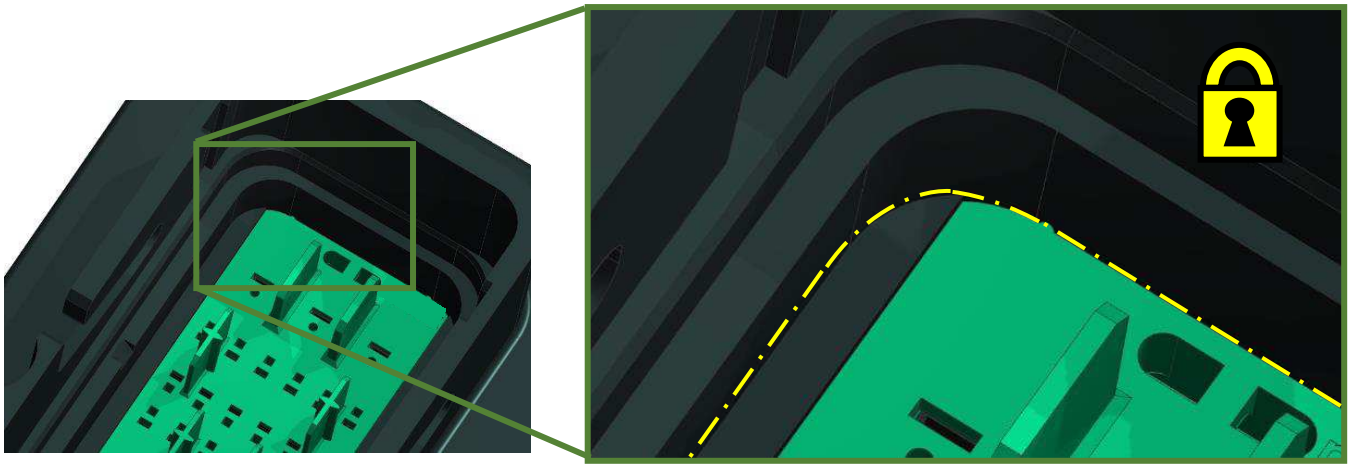


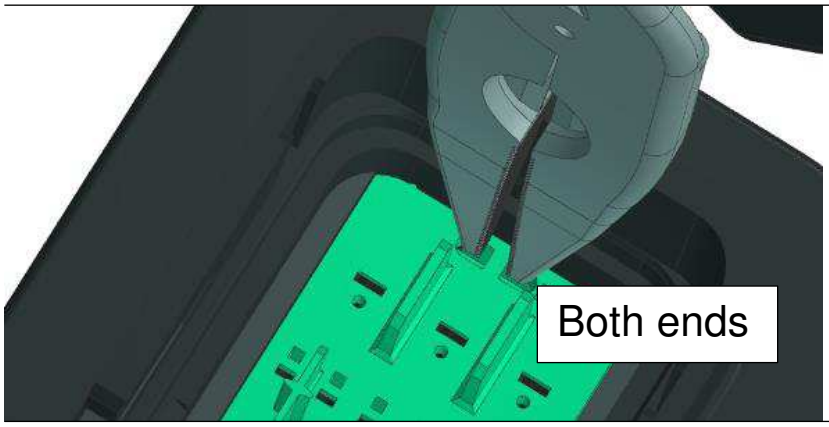
Power
Cable Insulation Diameter Range
3.0 – 5.0mm

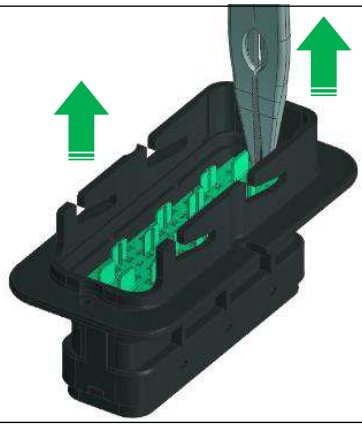
STEP 1 – OPEN TPA

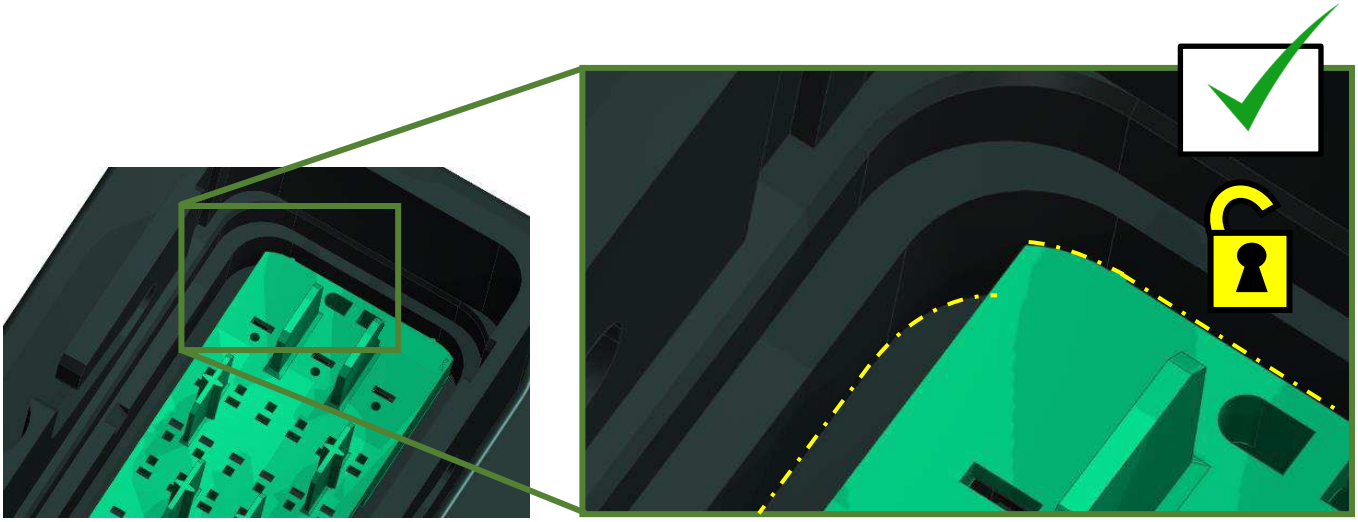




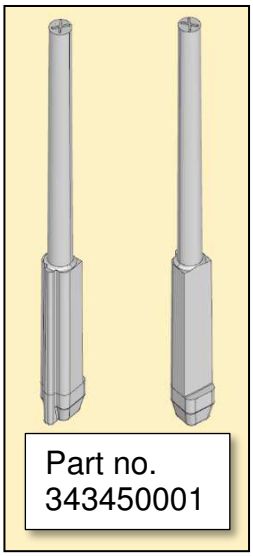


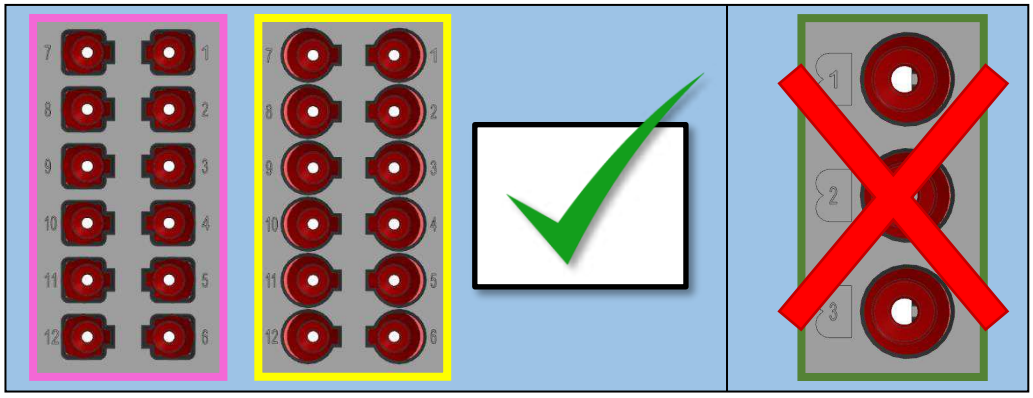




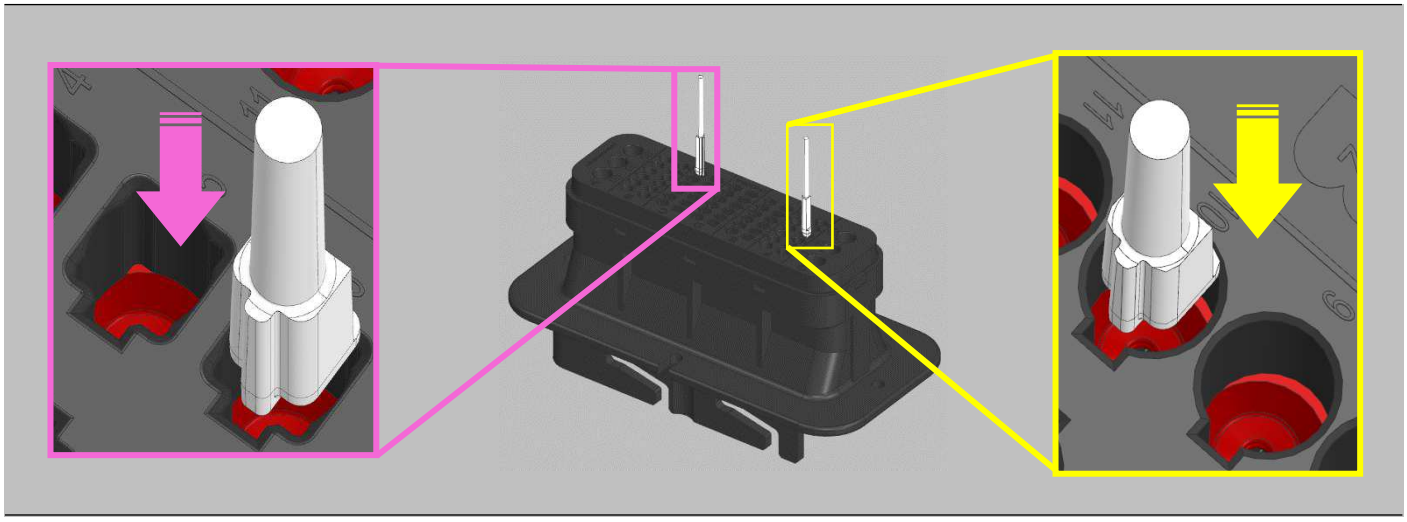


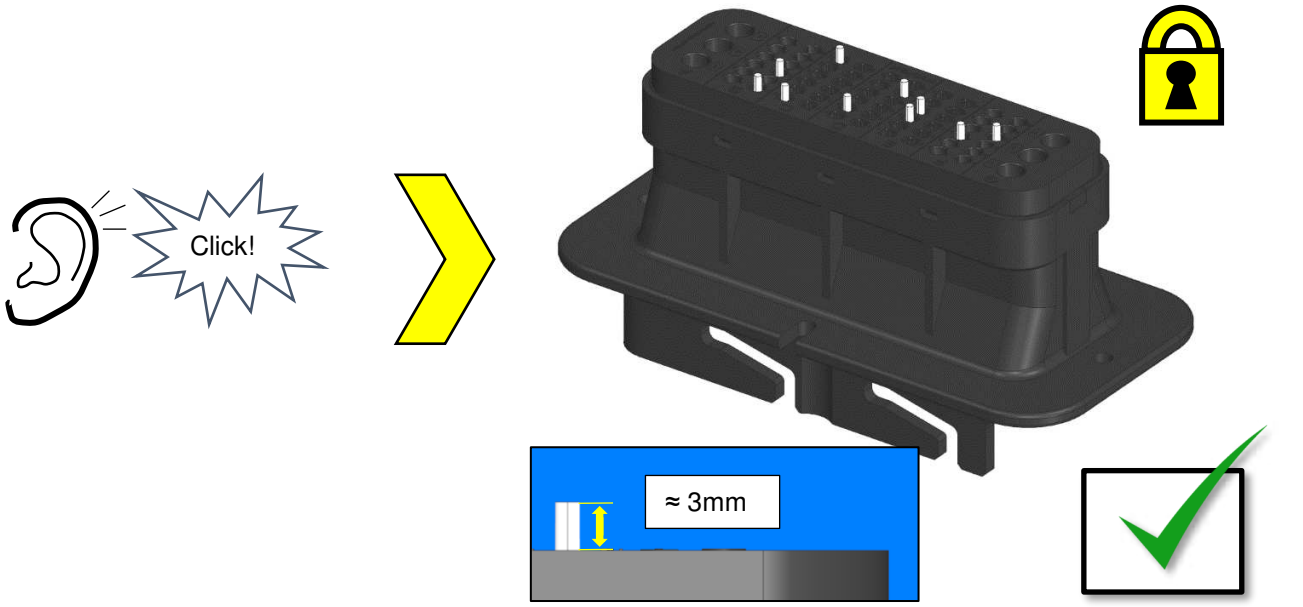
STEP 2 – INSERT SIGNAL BLIND CAVITY PLUGS



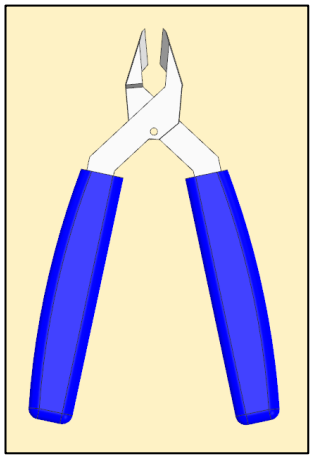


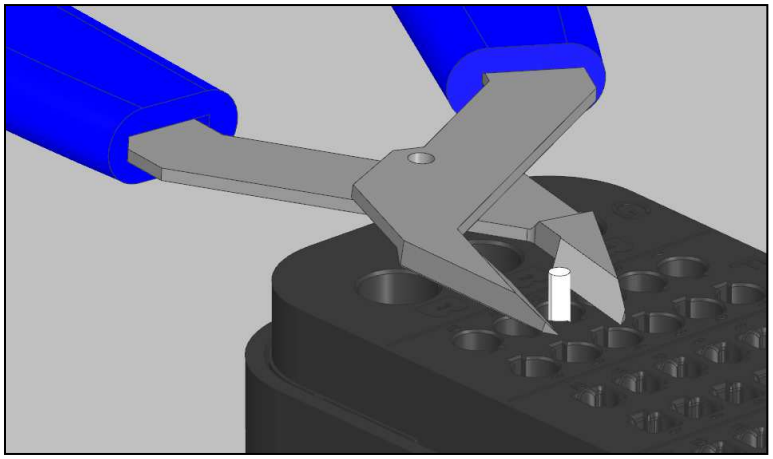
Demonstration example

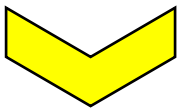


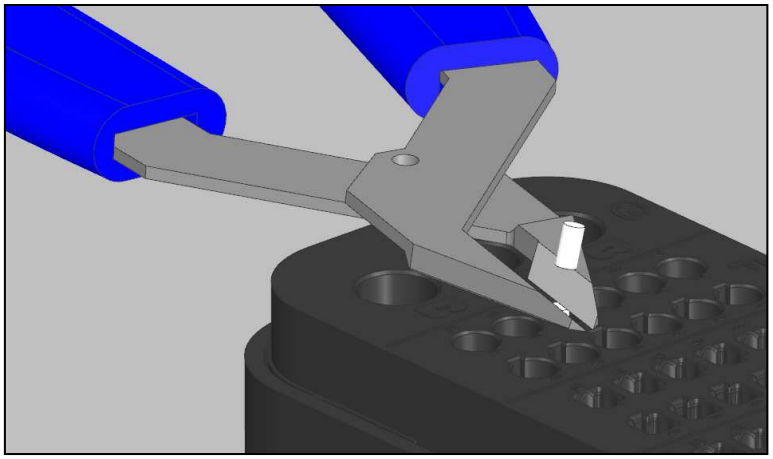


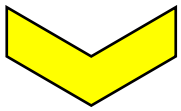
STEP 2.1 – TRIM SIGNAL BLIND CAVITY PLUGS (RECOMMENDED)





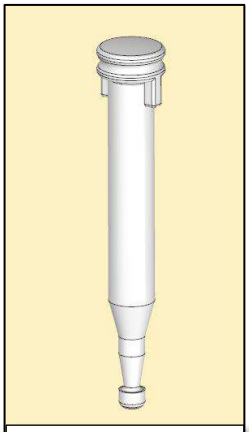




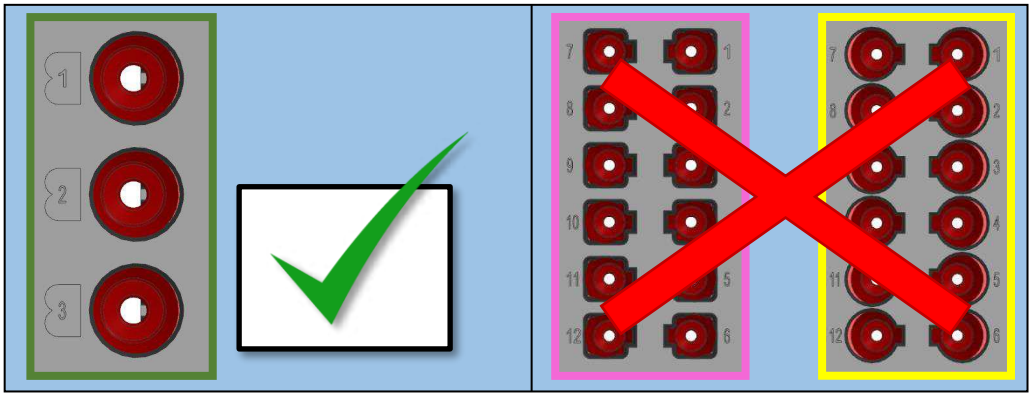


Demonstration example

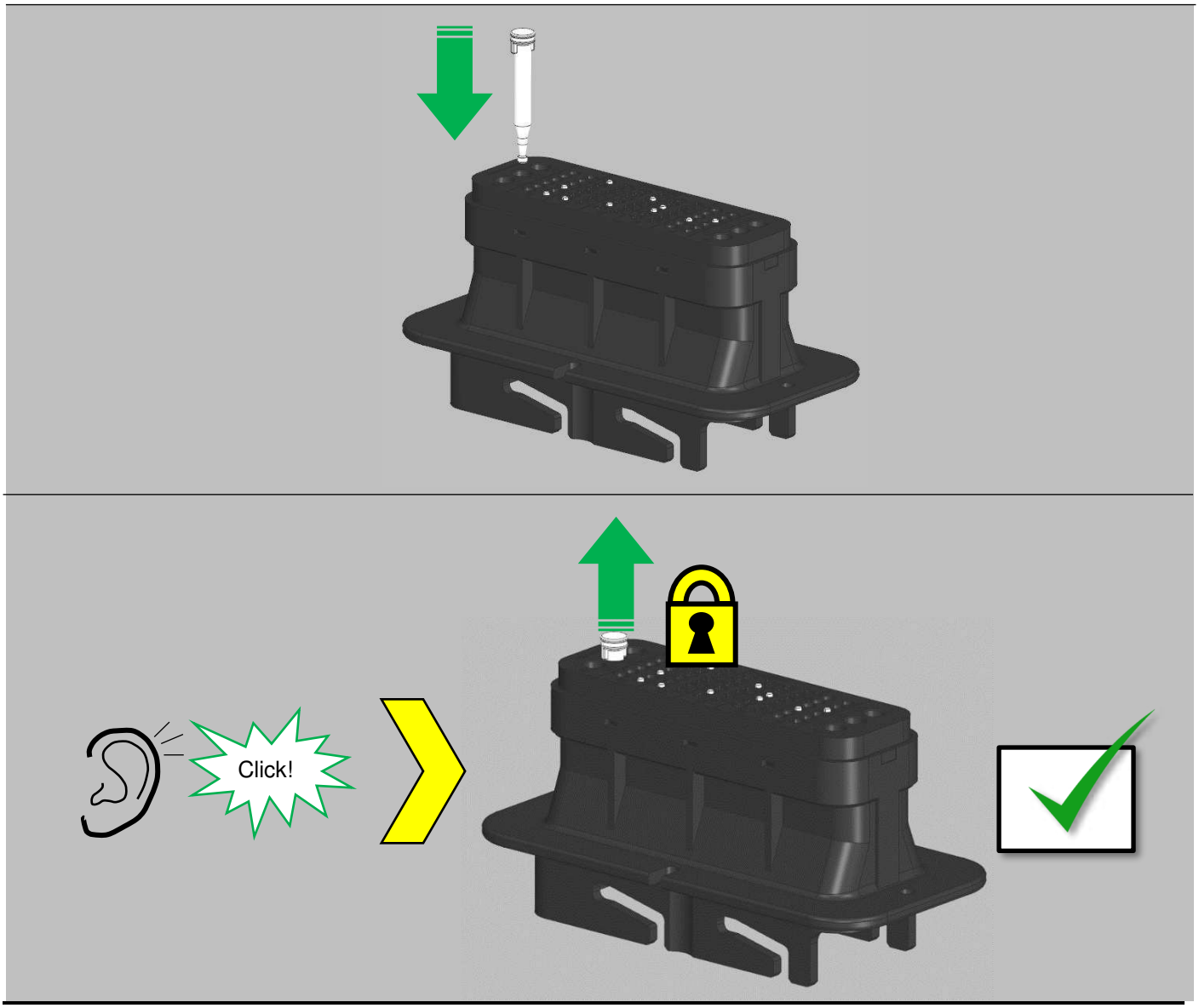
STEP 3 – INSERT POWER BLIND CAVITY PLUGS



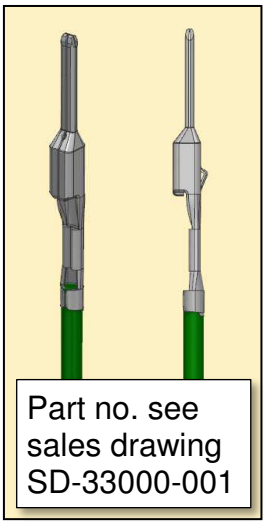
P/N:2500033-1
(Old P/N:
937320001)



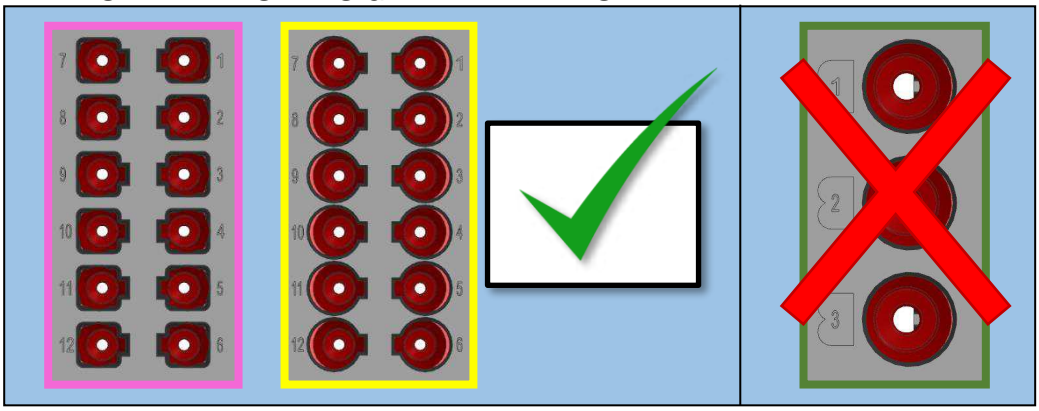
Demonstration example



STEP 4 – INSERT SIGNAL TERMINALS



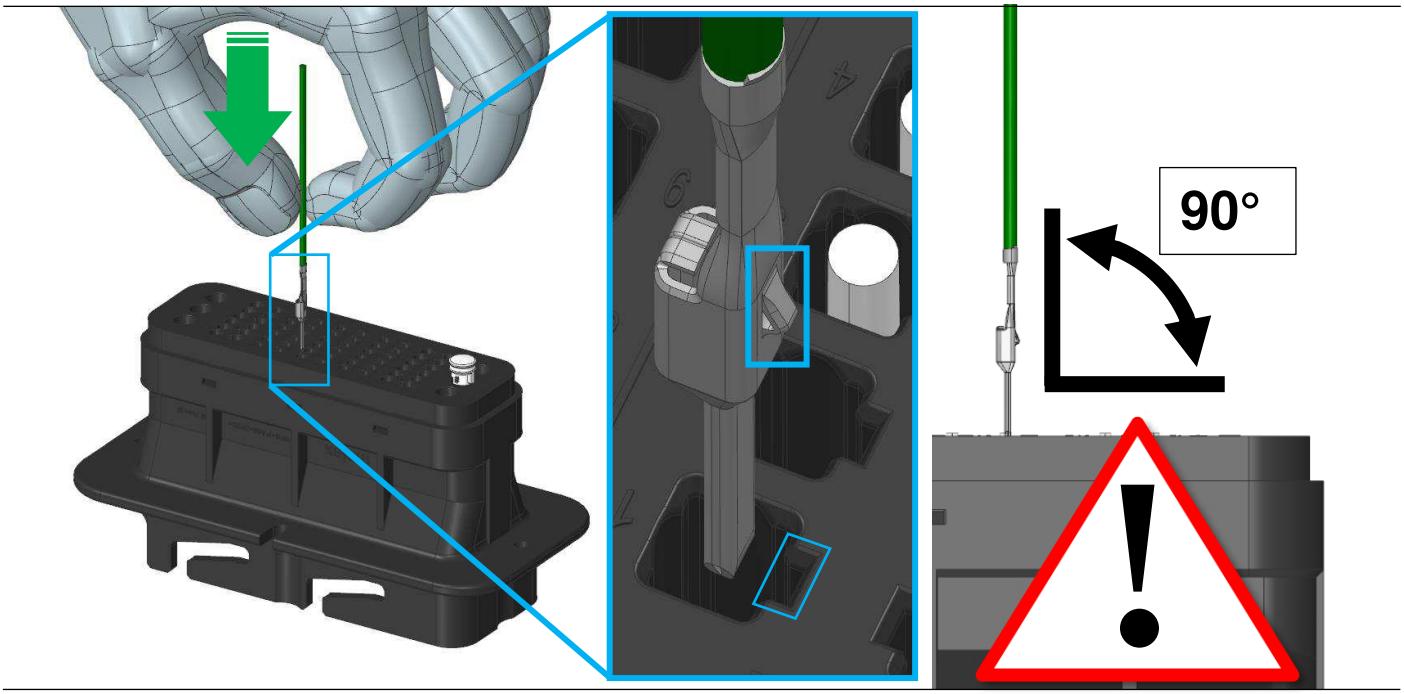
Part no. see sales drawing SD-33000-001



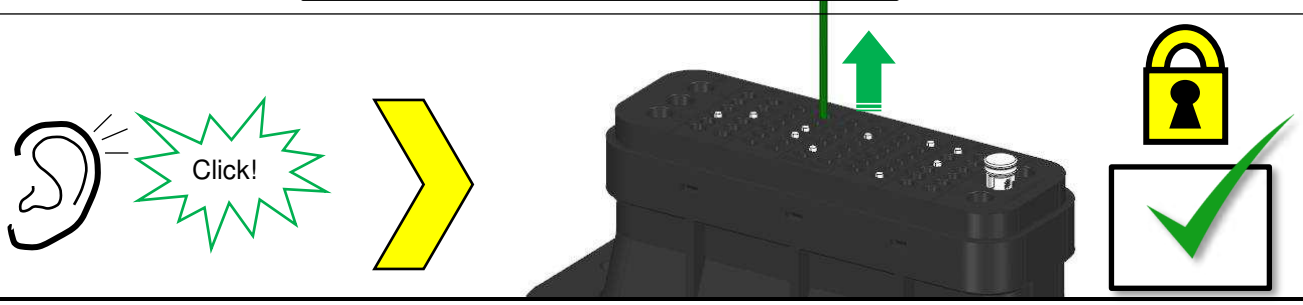
Signal
Cable Insulation Diameter
Range 1.5 - 2.7mm

Important:

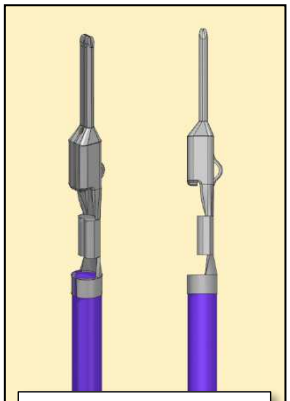
- **Hold cable while putting in male terminals**
- **Insert terminals 90° to the rear cover**
- **Insert terminal nose carefully through seal opening**



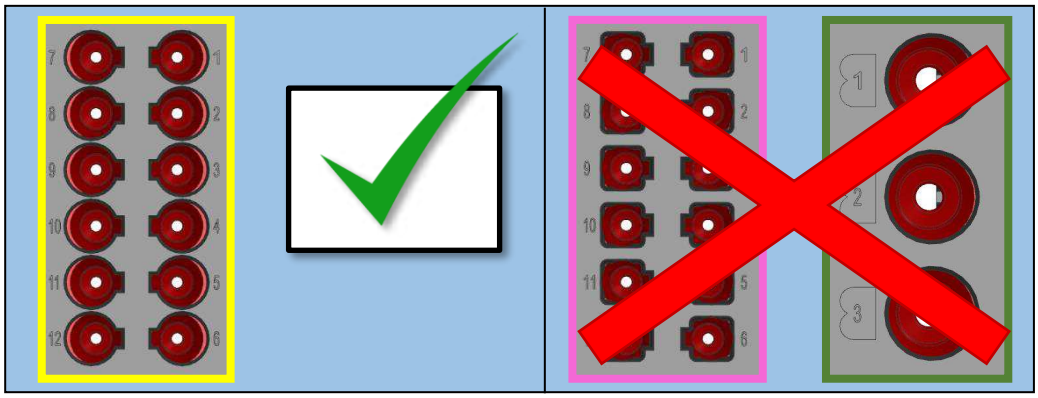
Demonstration example



STEP 5 – INSERT 2.5MM² TERMINALS



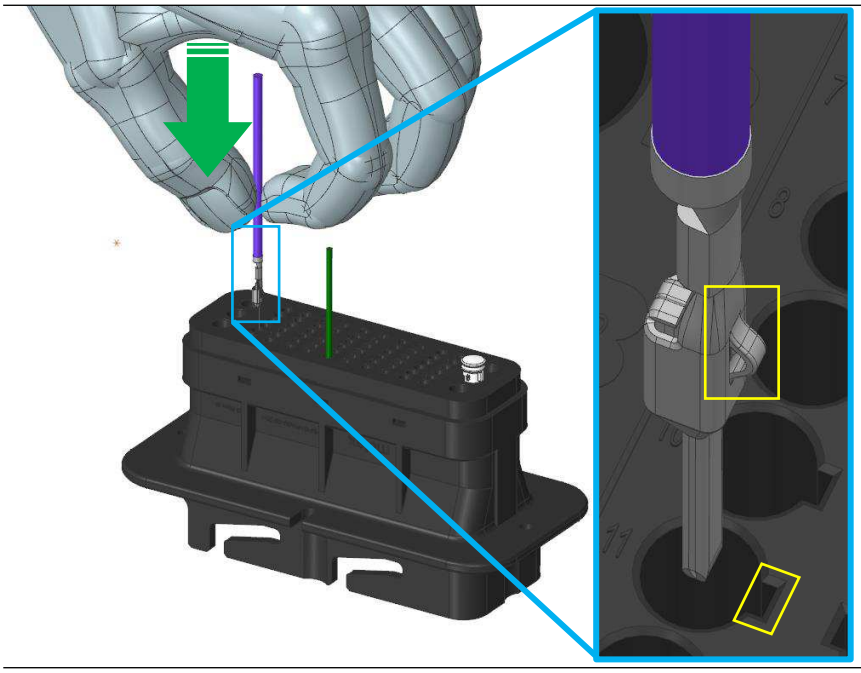
Part no. see sales drawing 936420010 PSD

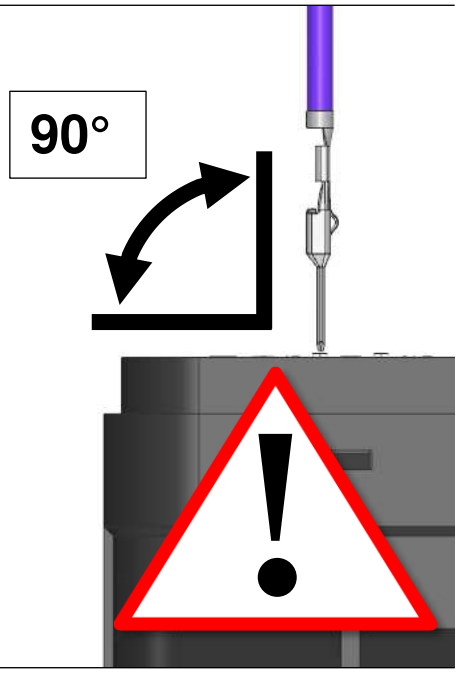


2.5mm²
Cable Insulation Diameter
Range 1.5 – 3.0mm

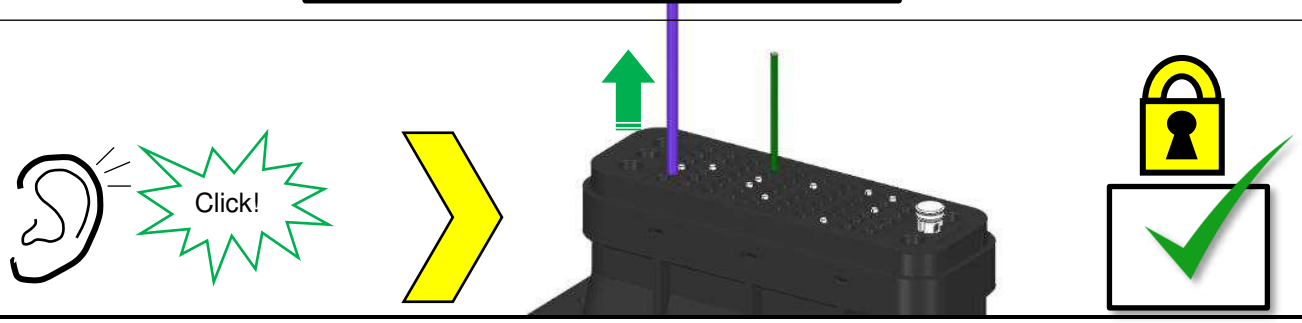
Important:

- **Hold cable while putting in male terminals**
- **Insert terminals 90° to the rear cover**
- **Insert terminal nose carefully through seal opening**

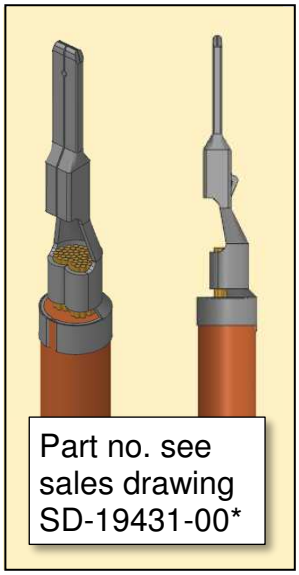




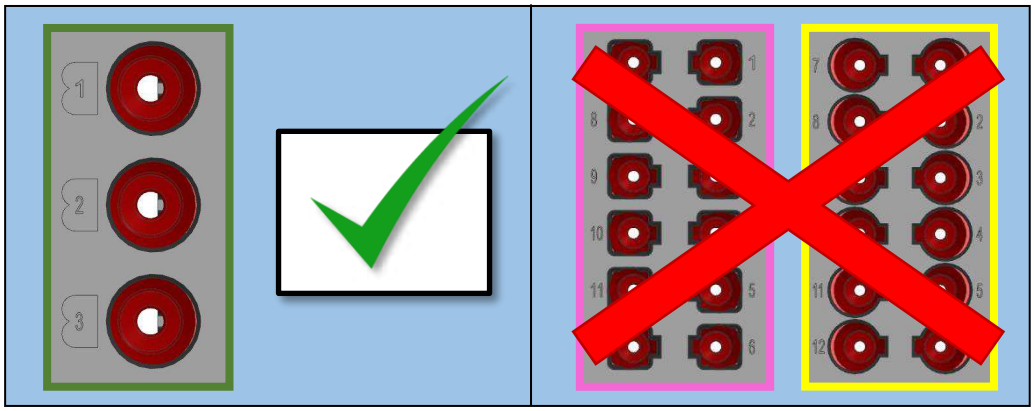
Demonstration example



STEP 6 – INSERT POWER TERMINALS



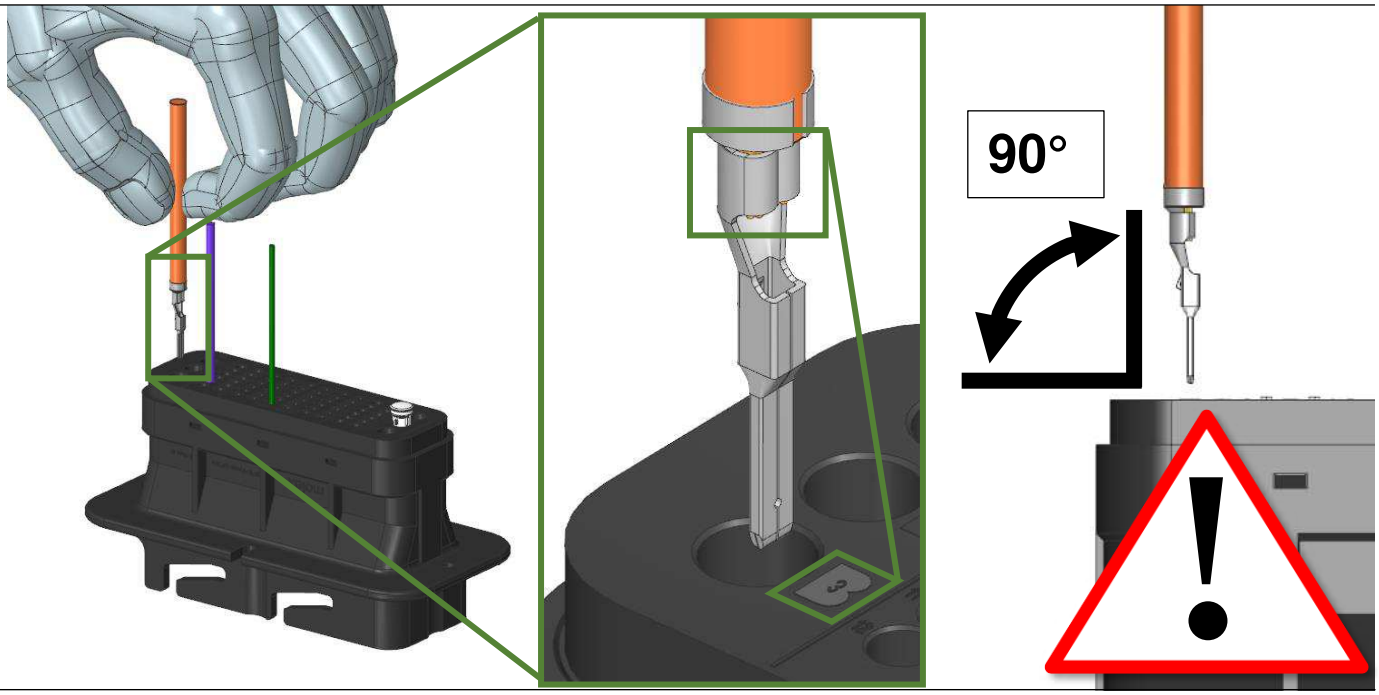
Part no. see sales drawing SD-19431-00*



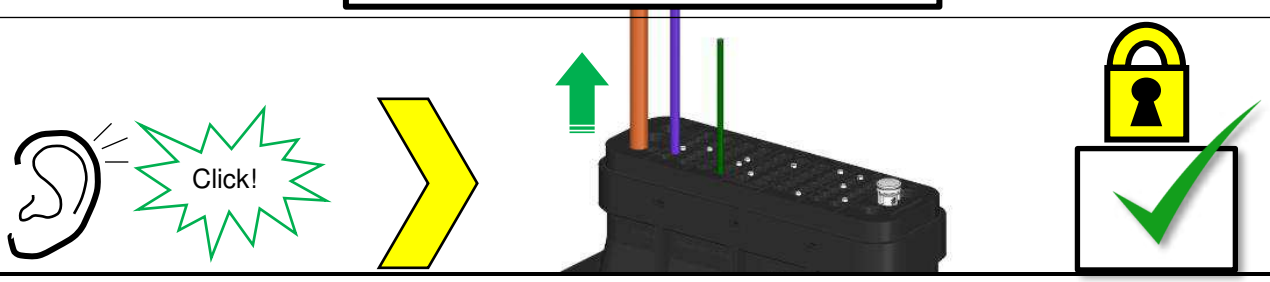
Power
Cable Insulation Diameter
Range 3.0 – 5.0mm

Important:

- **Hold cable while putting in male terminals**
- **Insert terminals 90° to the rear cover**
- **Insert terminal nose carefully through seal opening**

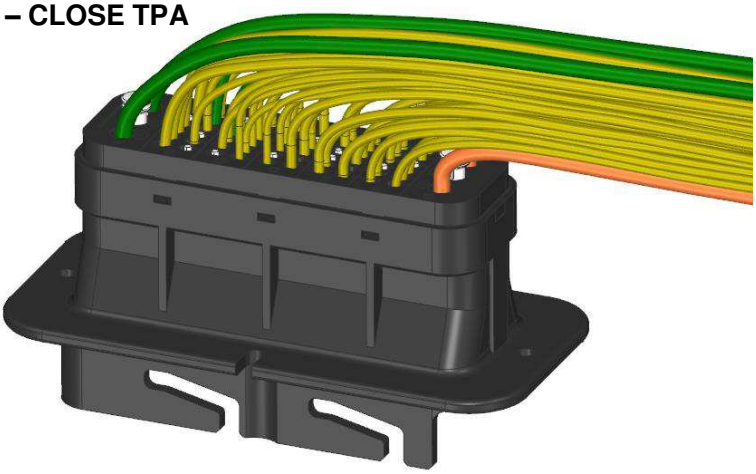


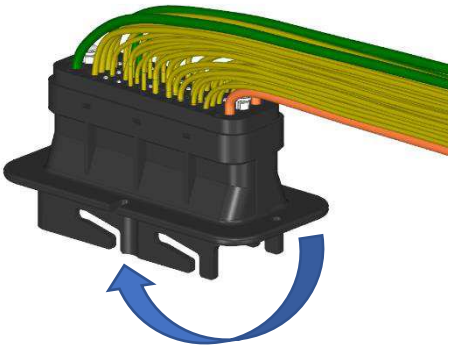
Demonstration example



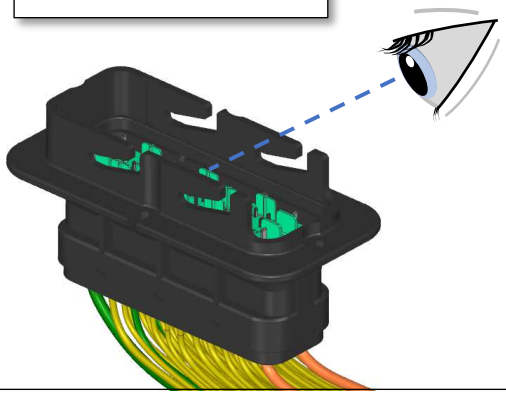
STEP 7 – CLOSE TPA

Populate connector fully
No holes left empty





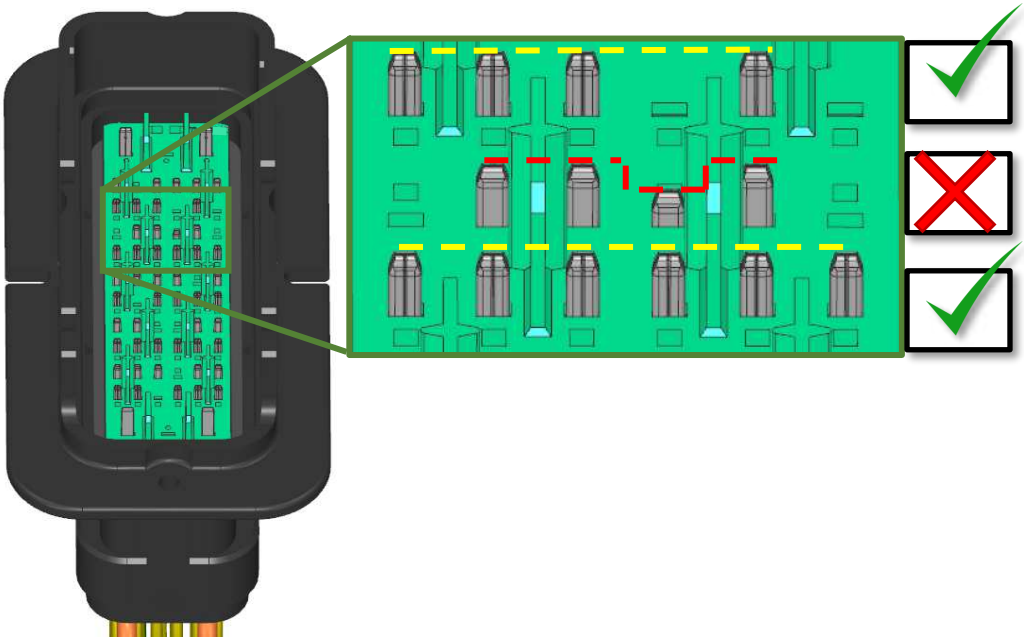
Final Check



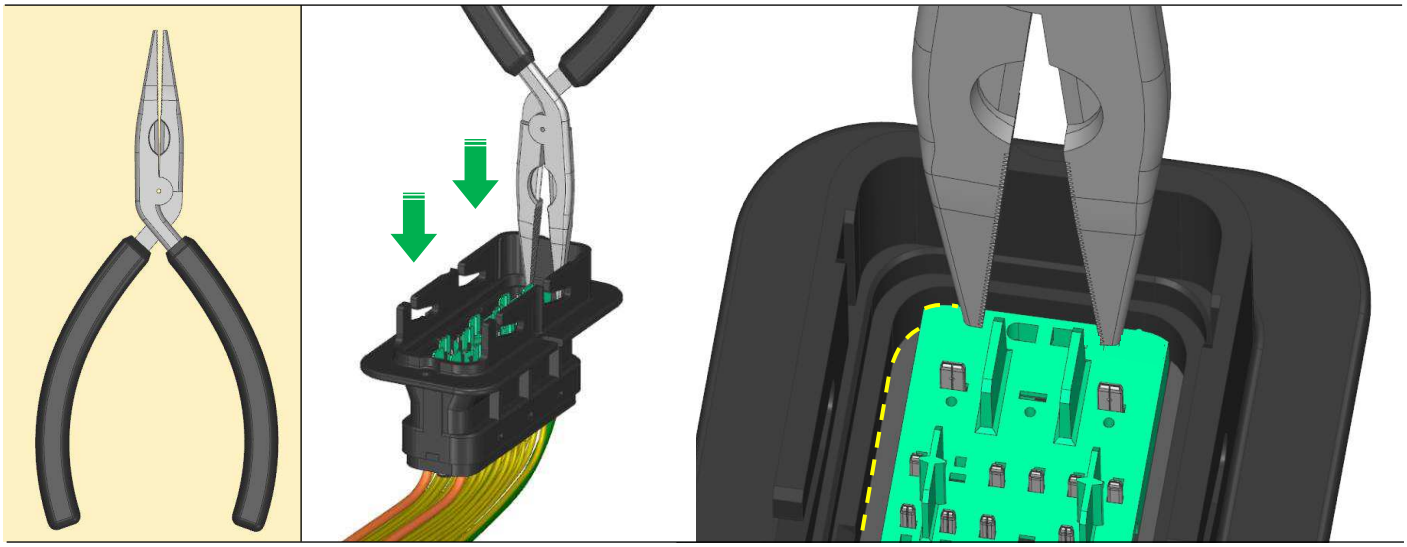
Note: Where terminals are not shown, blind cavity plugs have been used

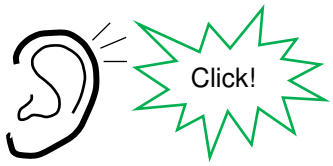
Demonstration example

Ensure all cables are pushed forward fully

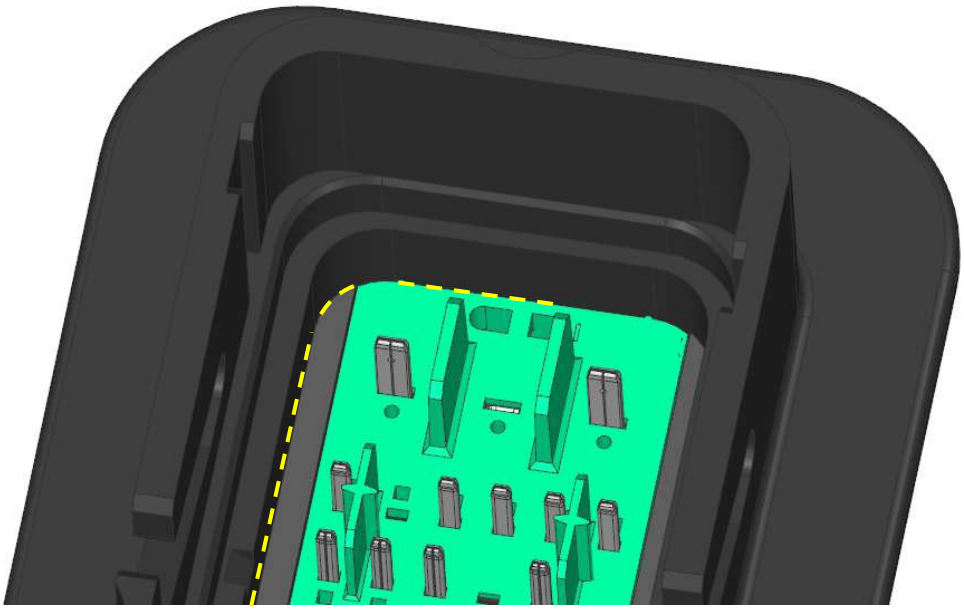


STEP 7 – CLOSE TPA





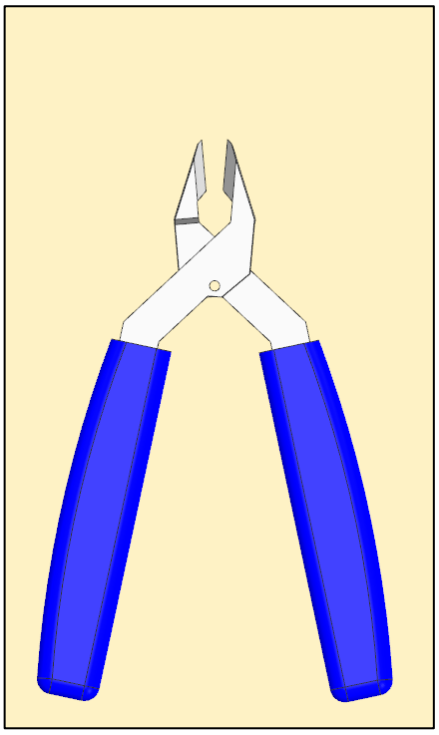
Note: Where terminals are not shown, blind cavity plugs have been used



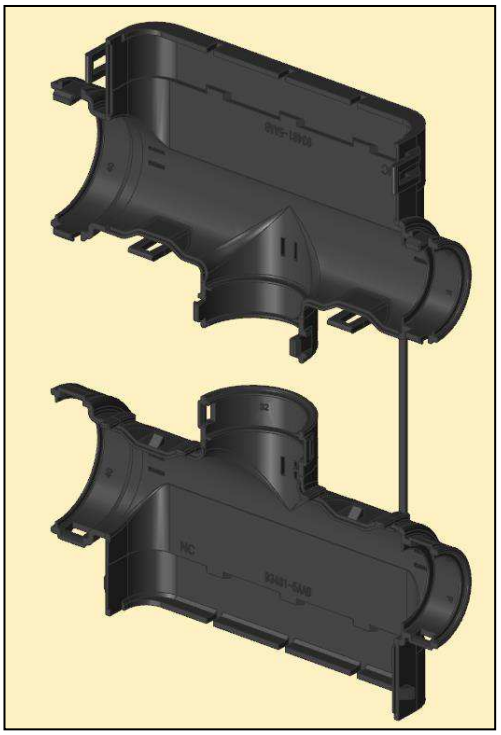
STEP 8 – APPLY WIRE DRESS/CONDUIT INTERFACE

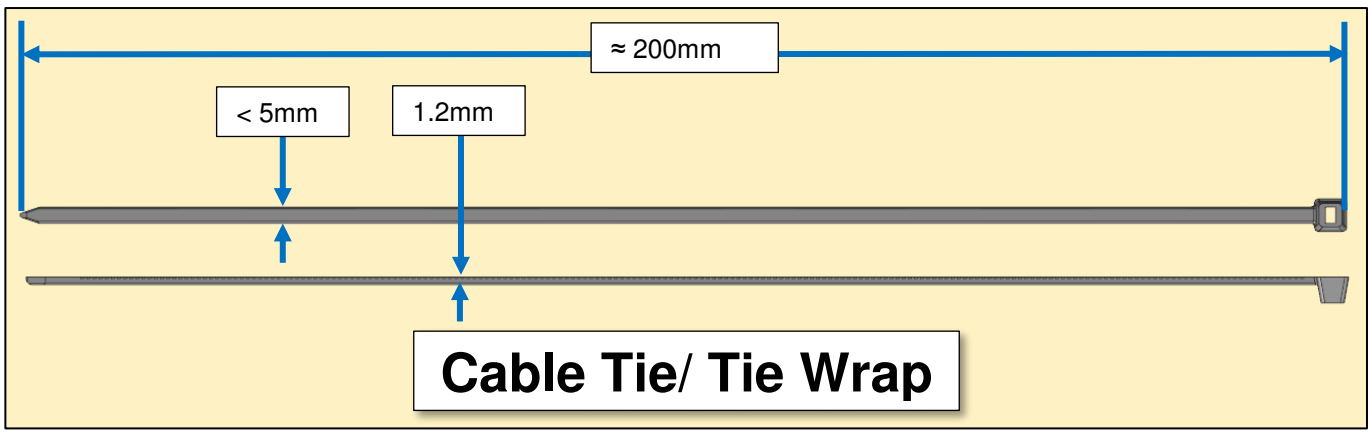
- Various configurations of wire dress available.
  - 1 – 3 open exits
  - 4 different exit sizes
- See sales drawing: 2500035
- Appropriate conduit must be used with wire dress
- Example shown for demonstration only
- Direction of exit(s) per wiring diagram

Tool & parts needed



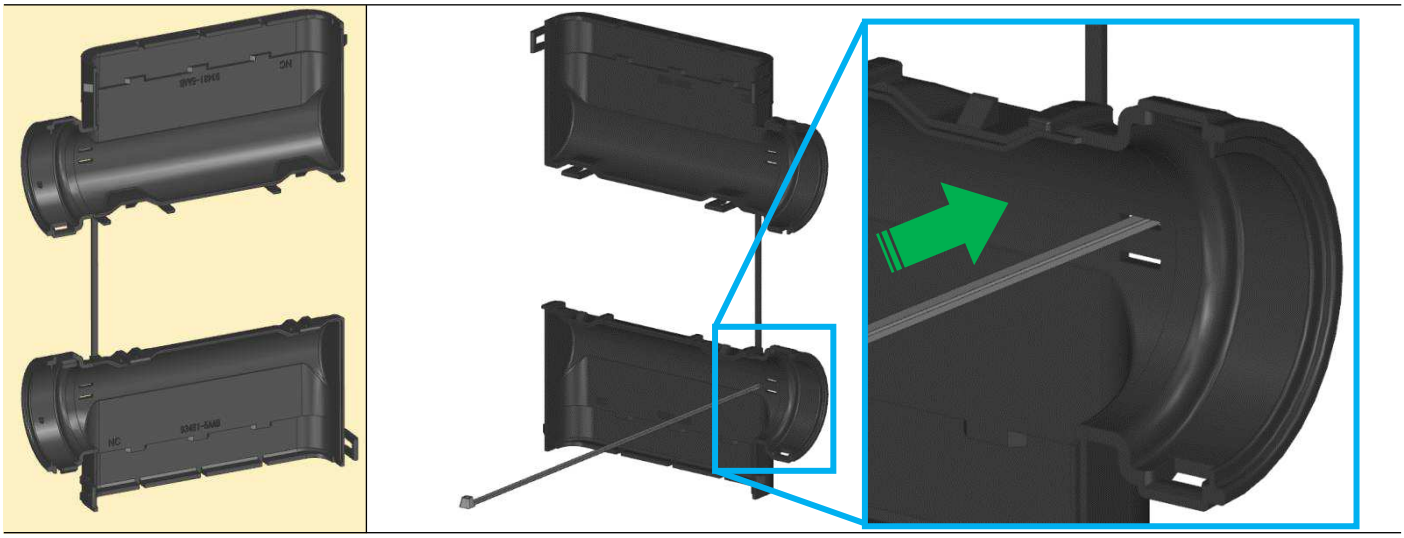
Conduit

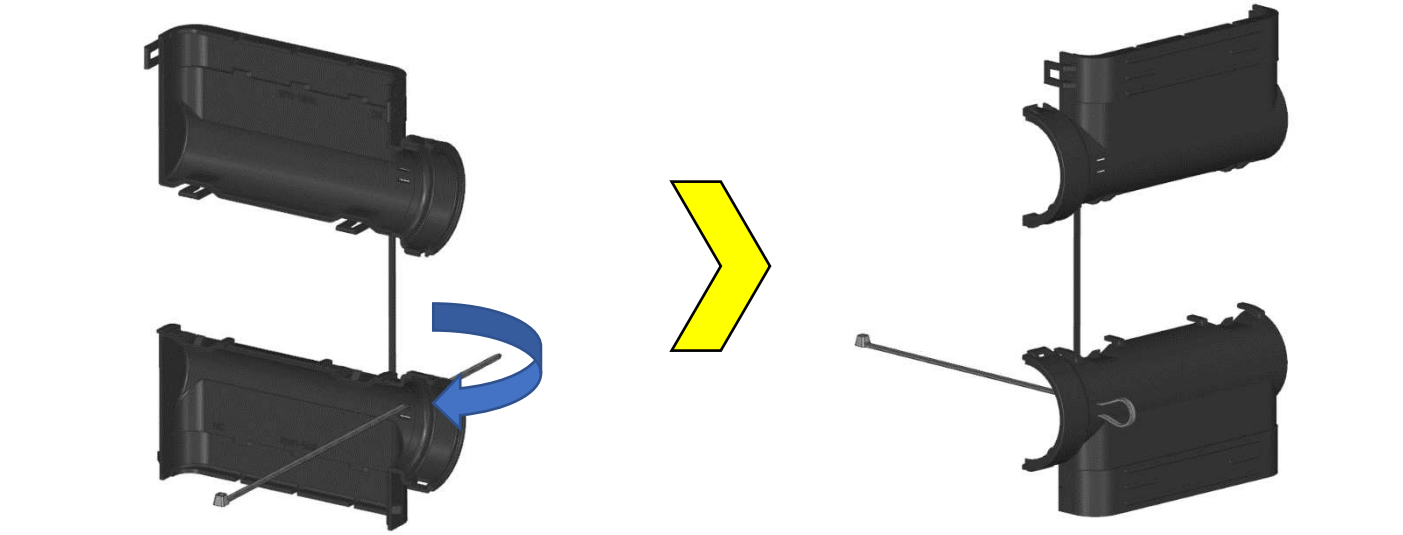


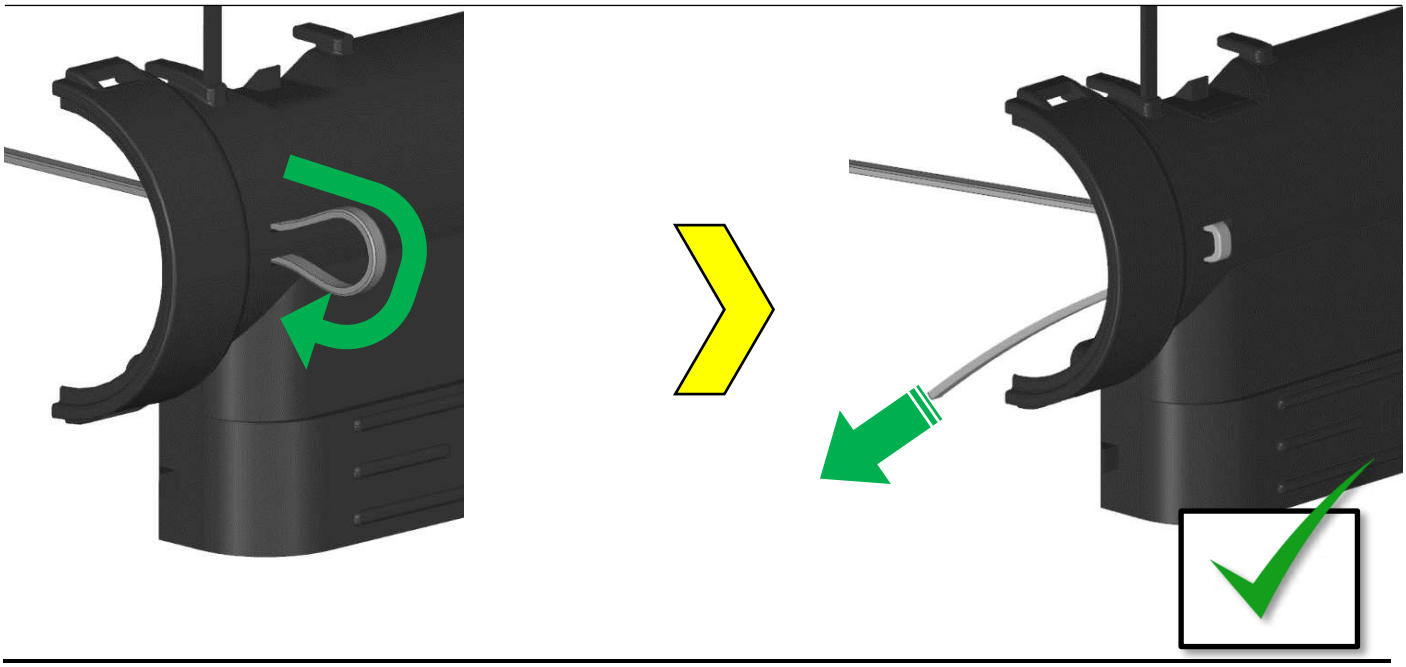


Cable Tie/ Tie Wrap

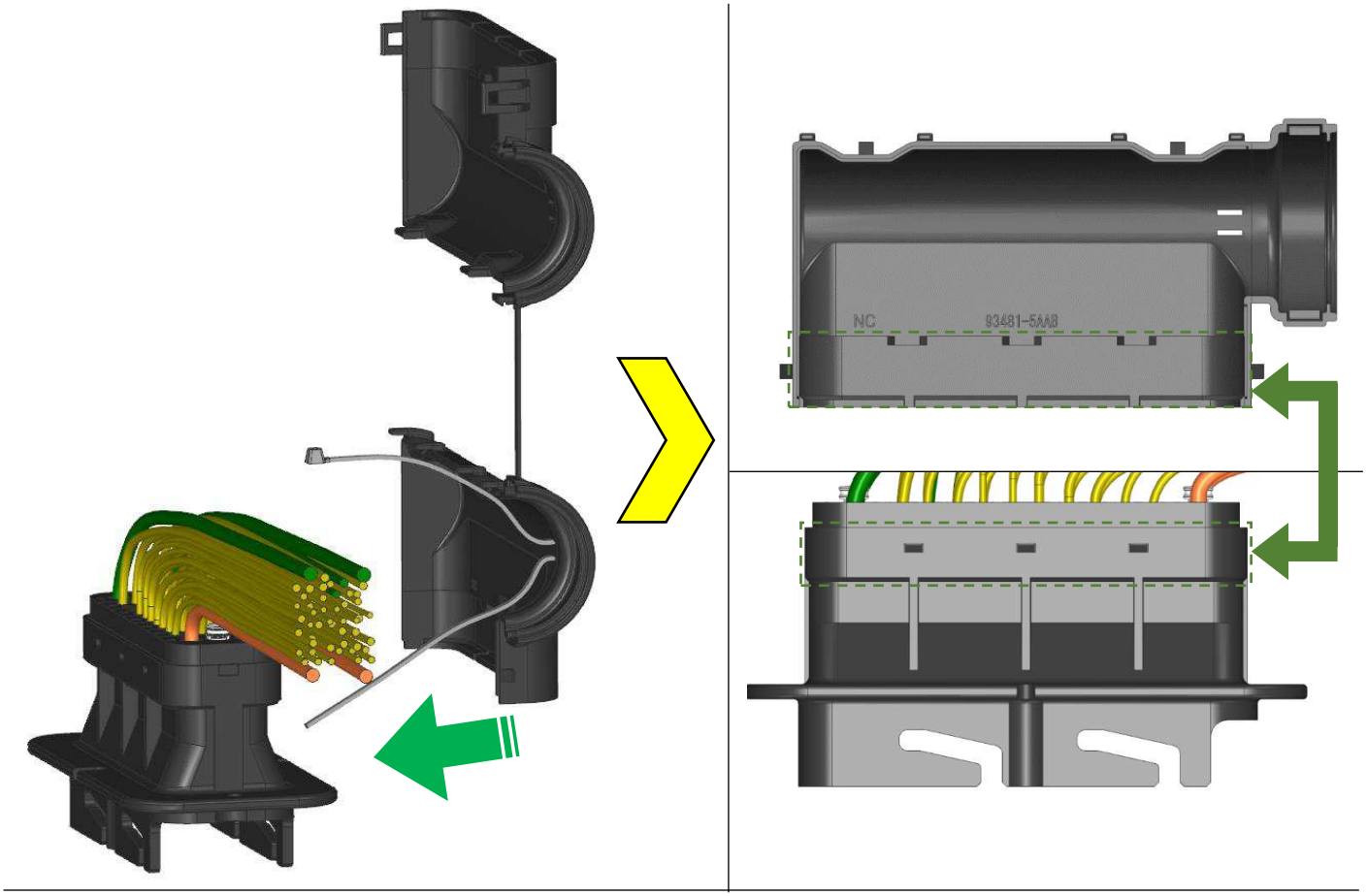
RECOMMENDED ASSEMBLY SEQUENCE

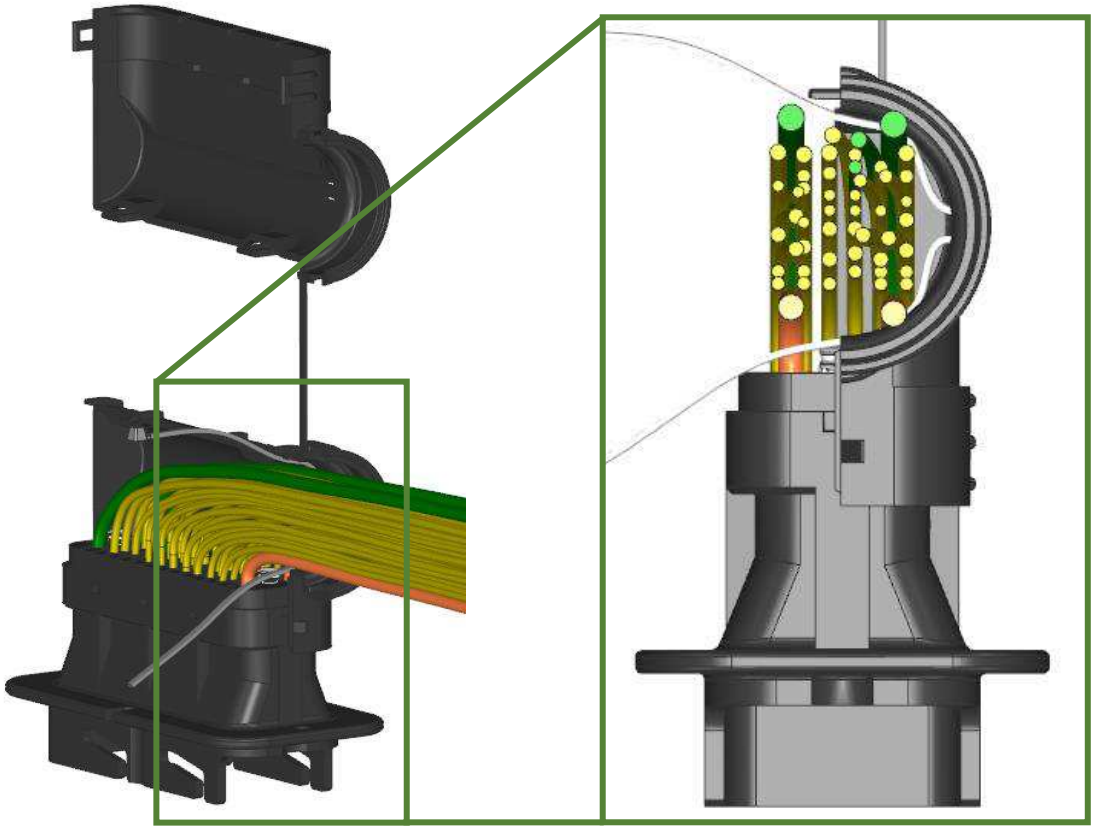




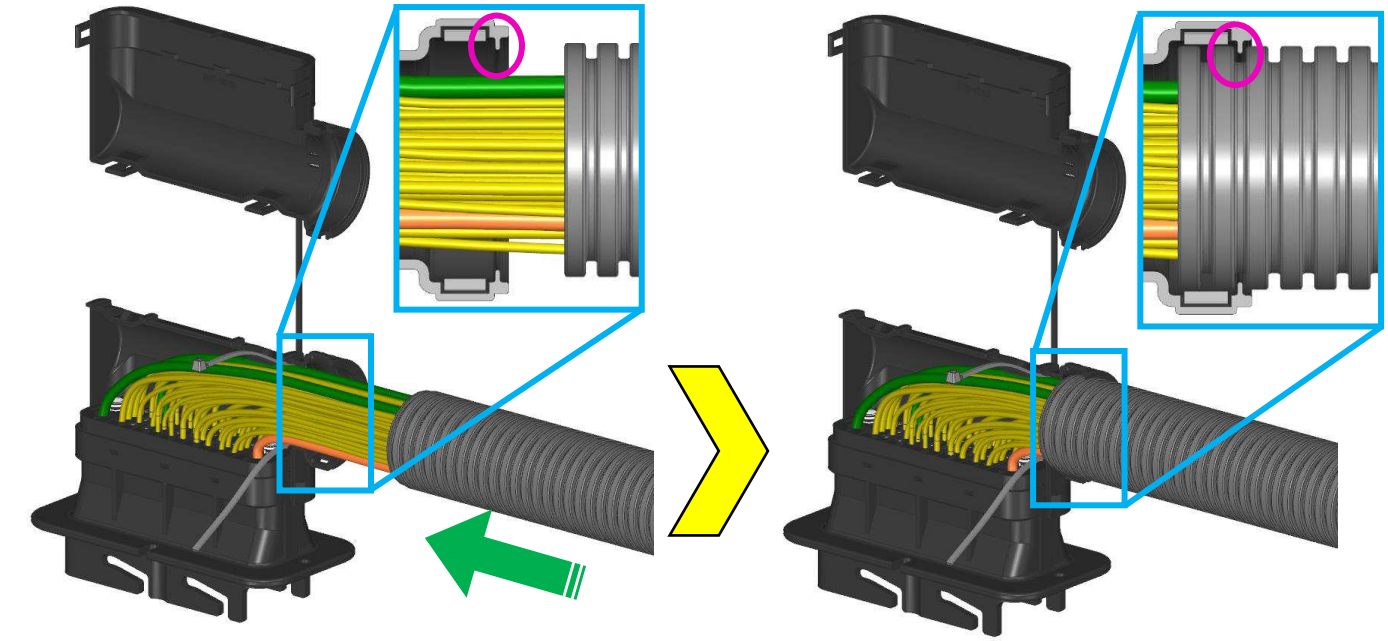


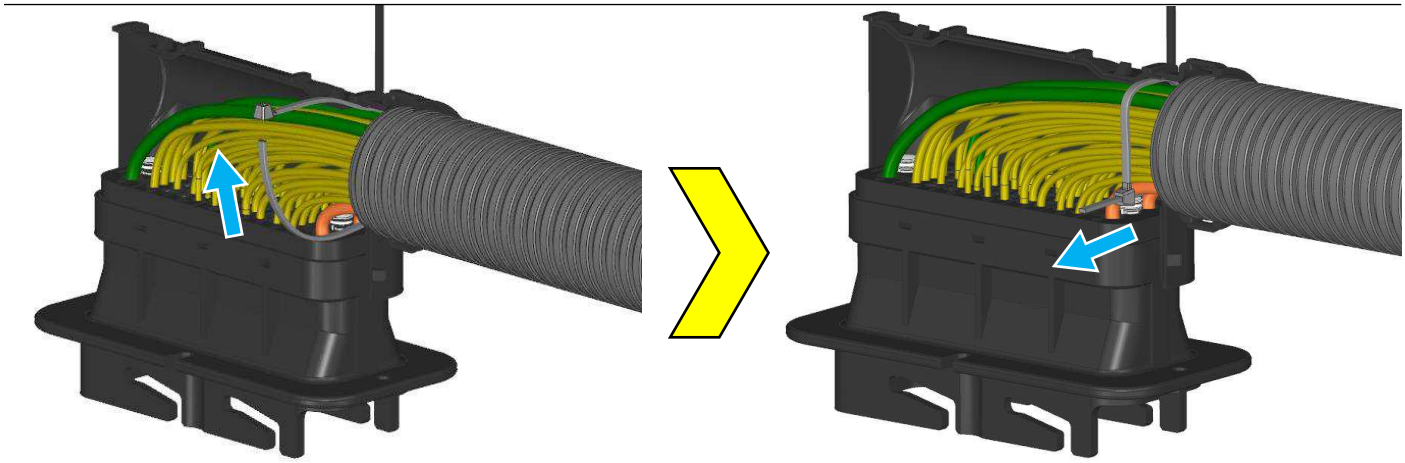
RECOMMENDED ASSEMBLY SEQUENCE

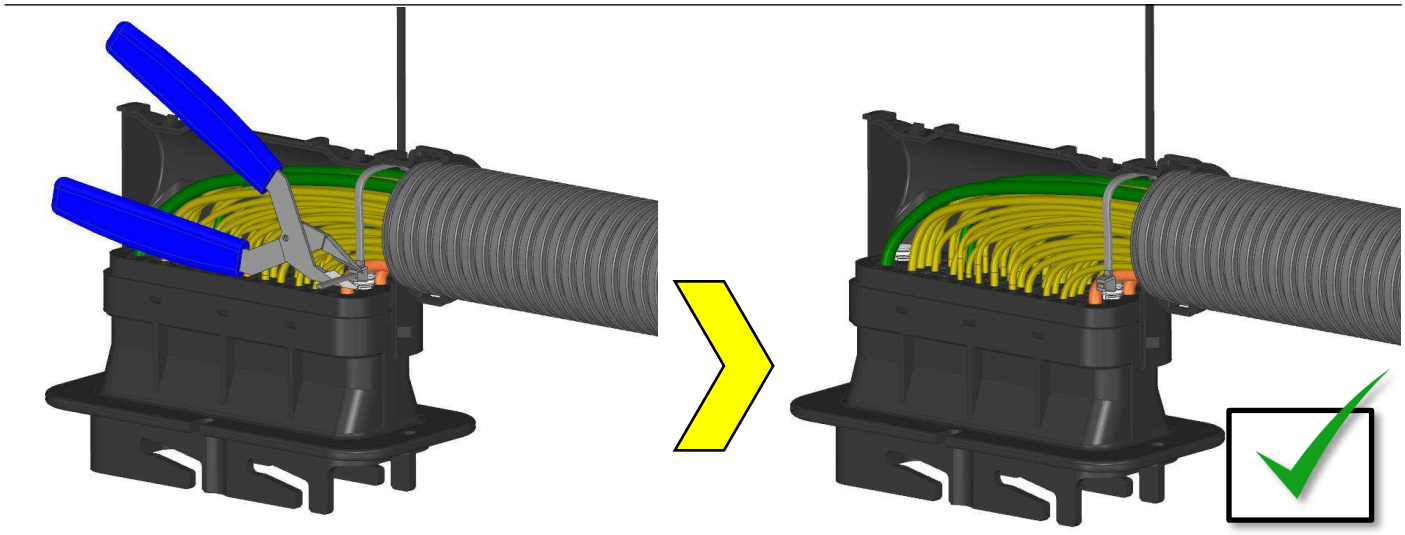




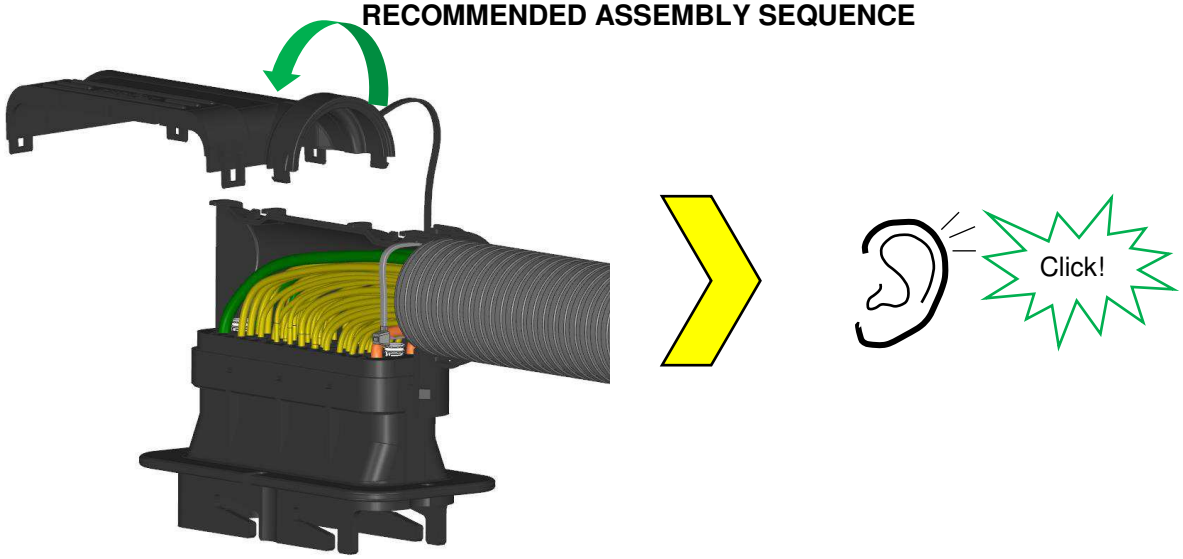
RECOMMENDED ASSEMBLY SEQUENCE

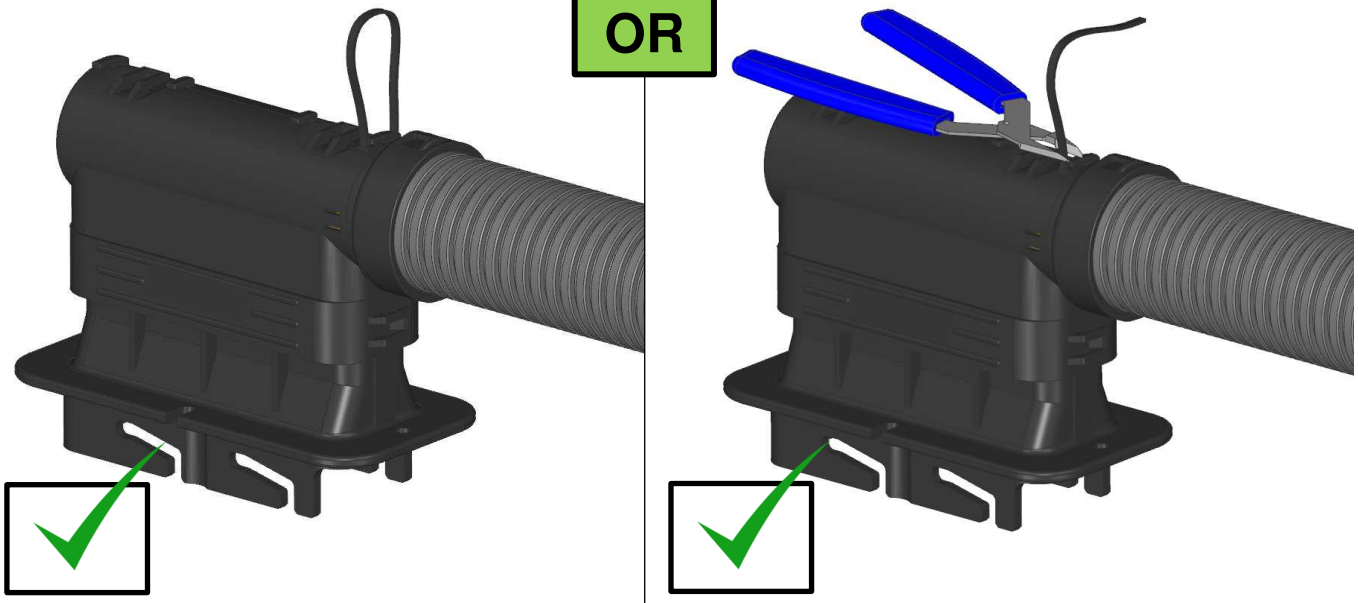


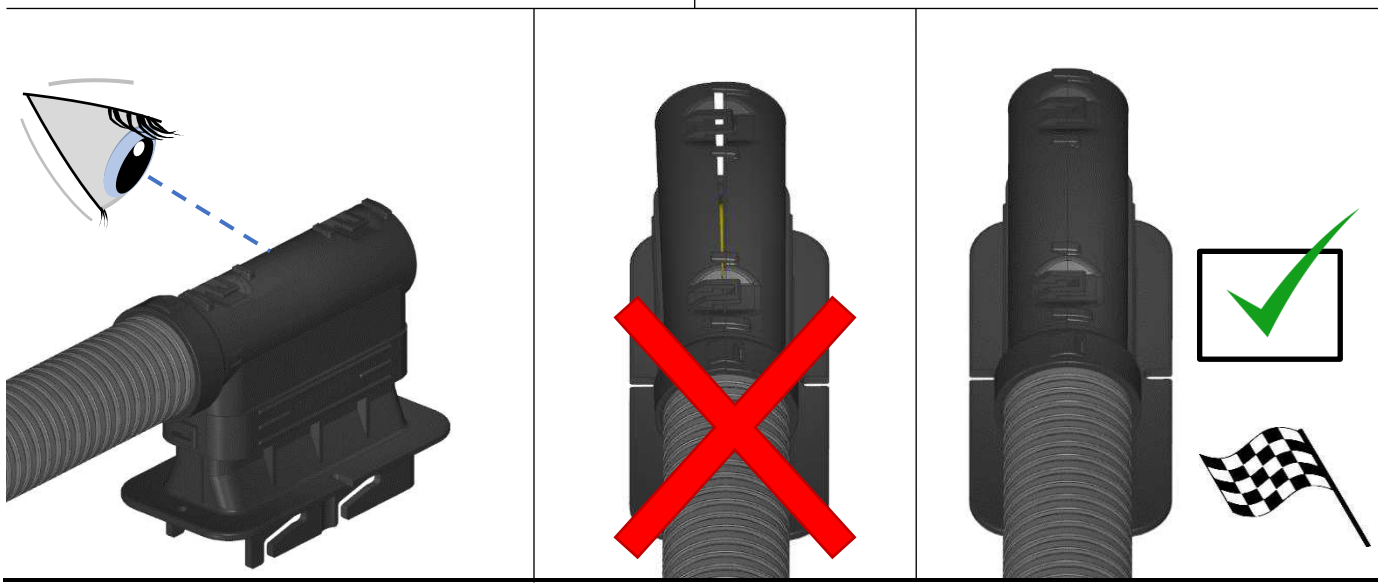




RECOMMENDED ASSEMBLY SEQUENCE

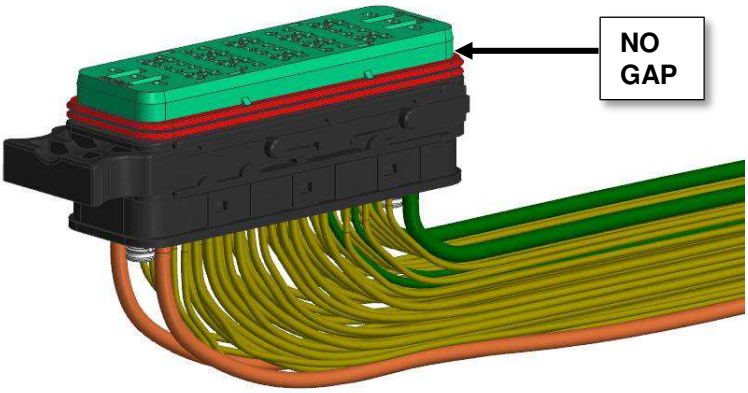




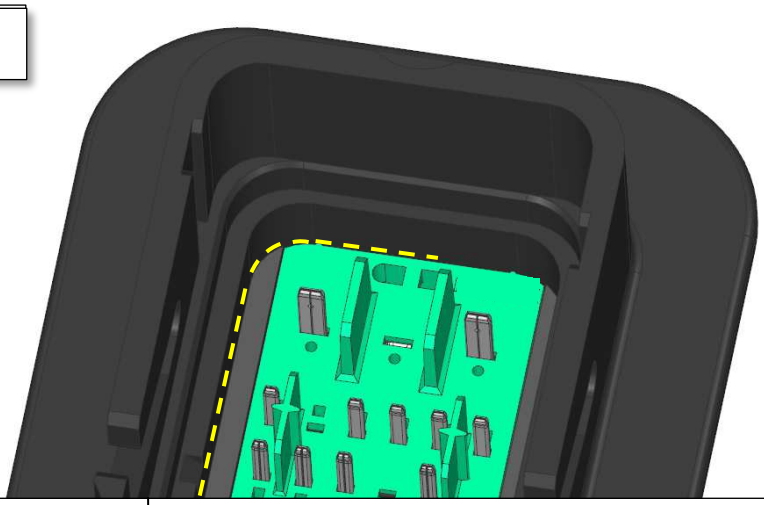


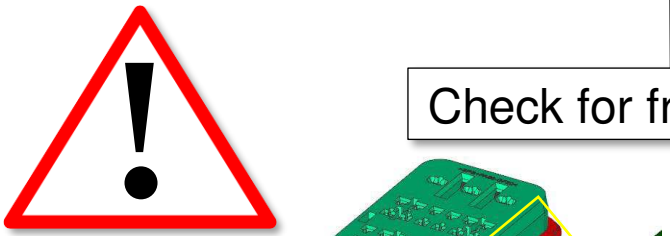
RECOMMENDED CHECKS

Female TPA is closed

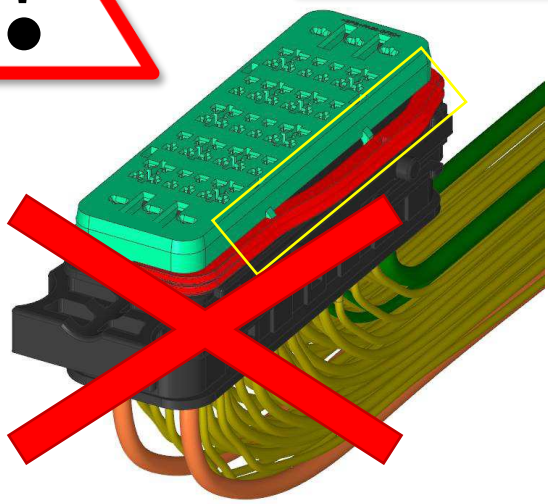


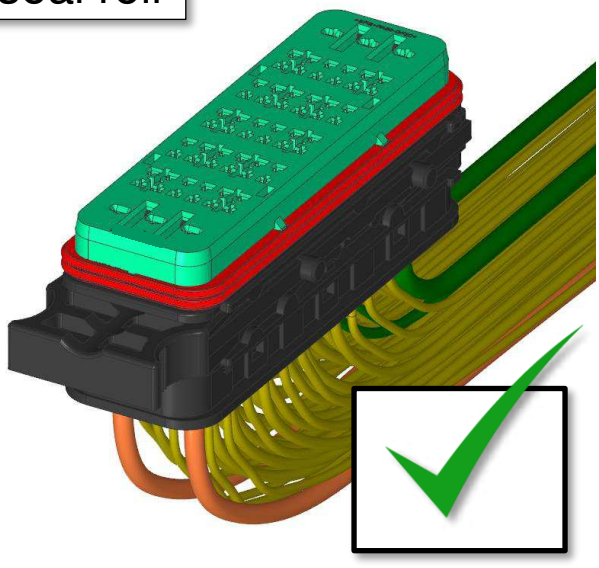
Male TPA is closed



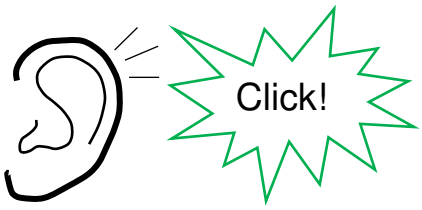


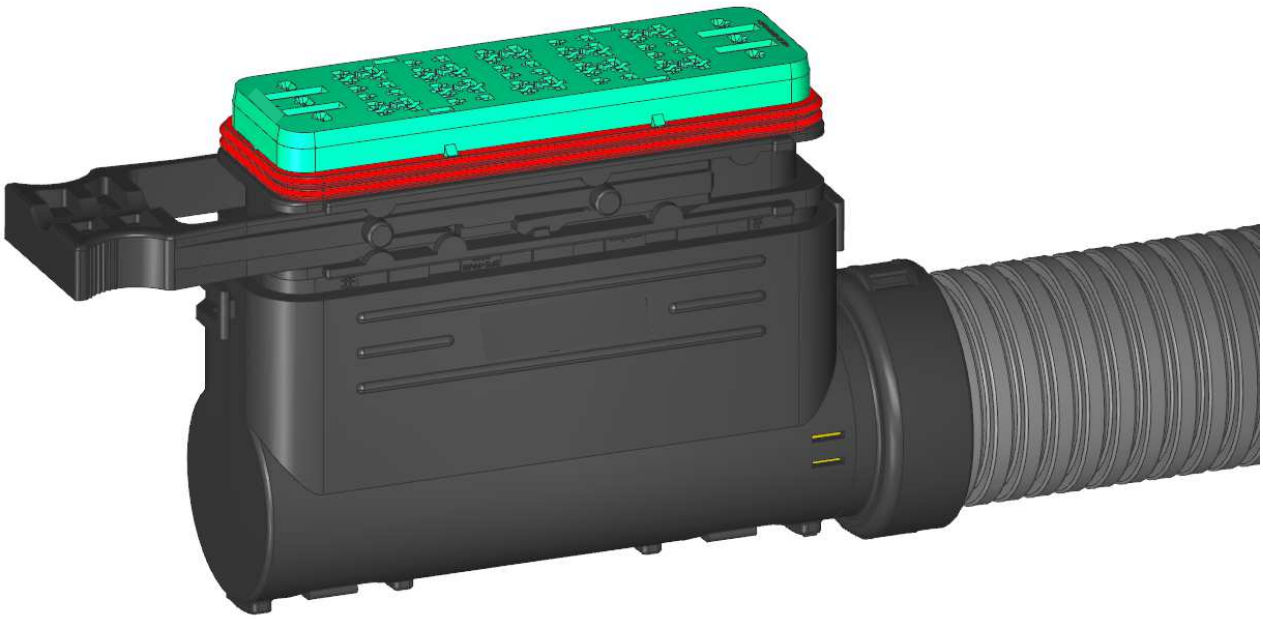
Check for front seal roll



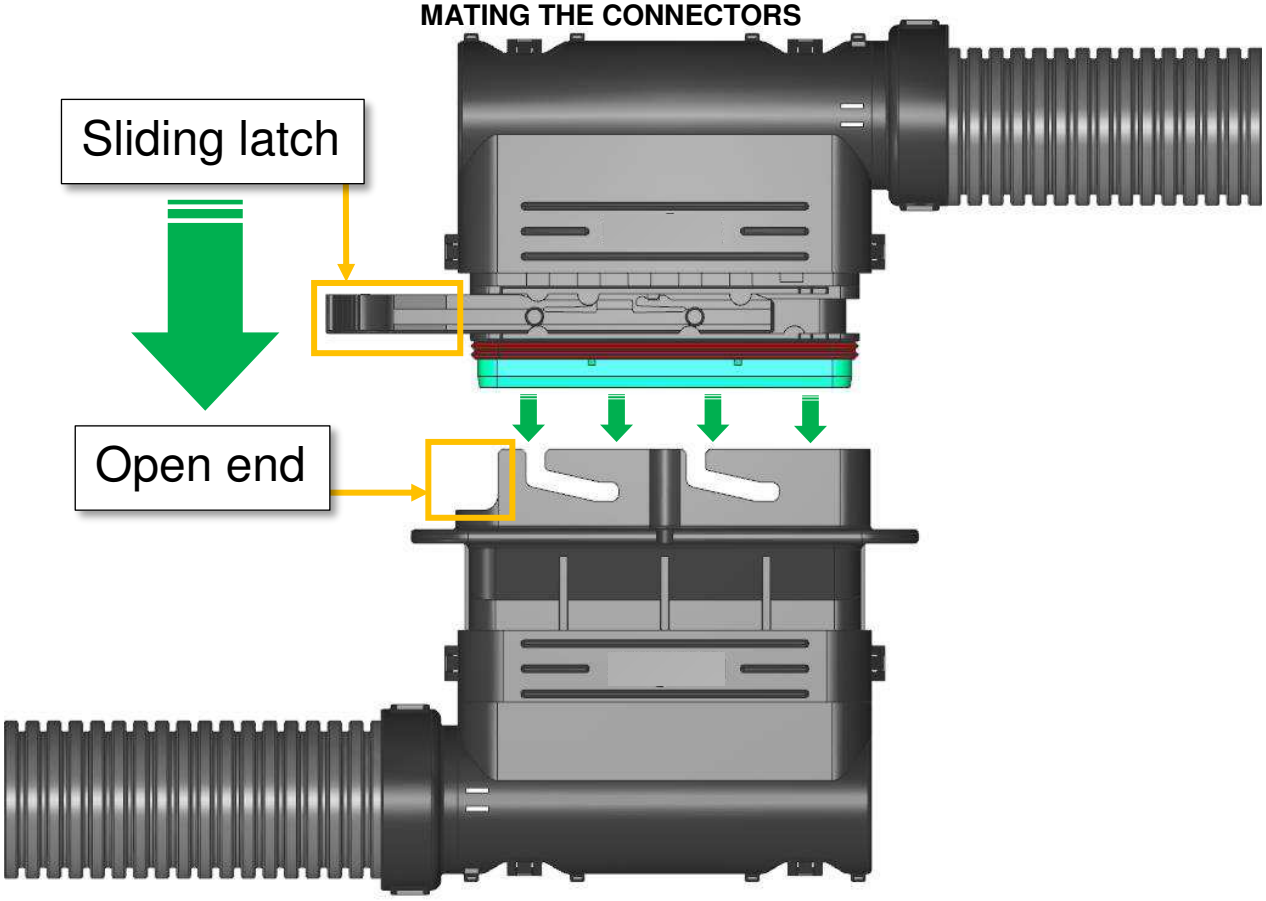


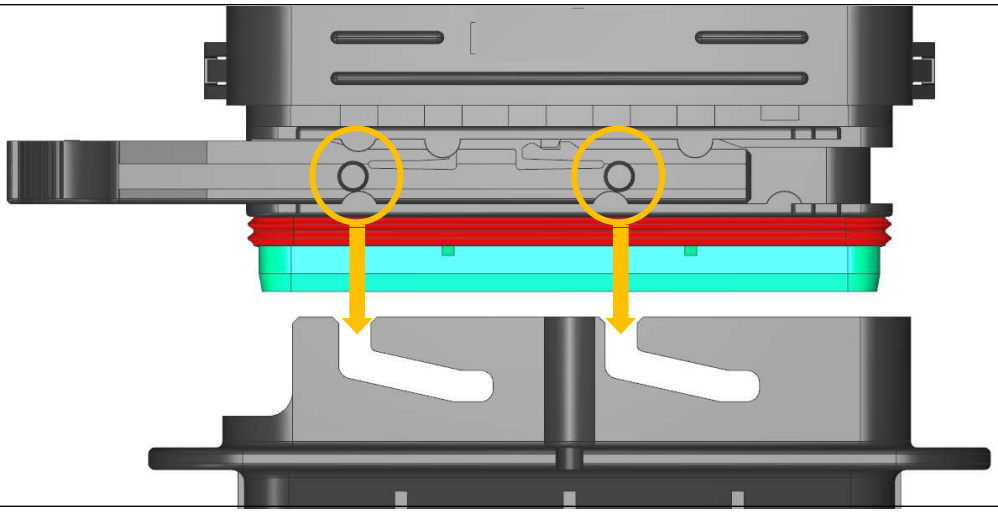
MATING THE CONNECTORS

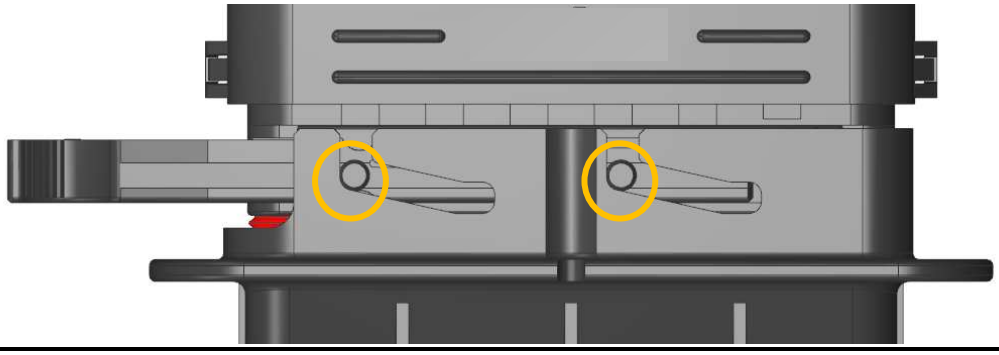




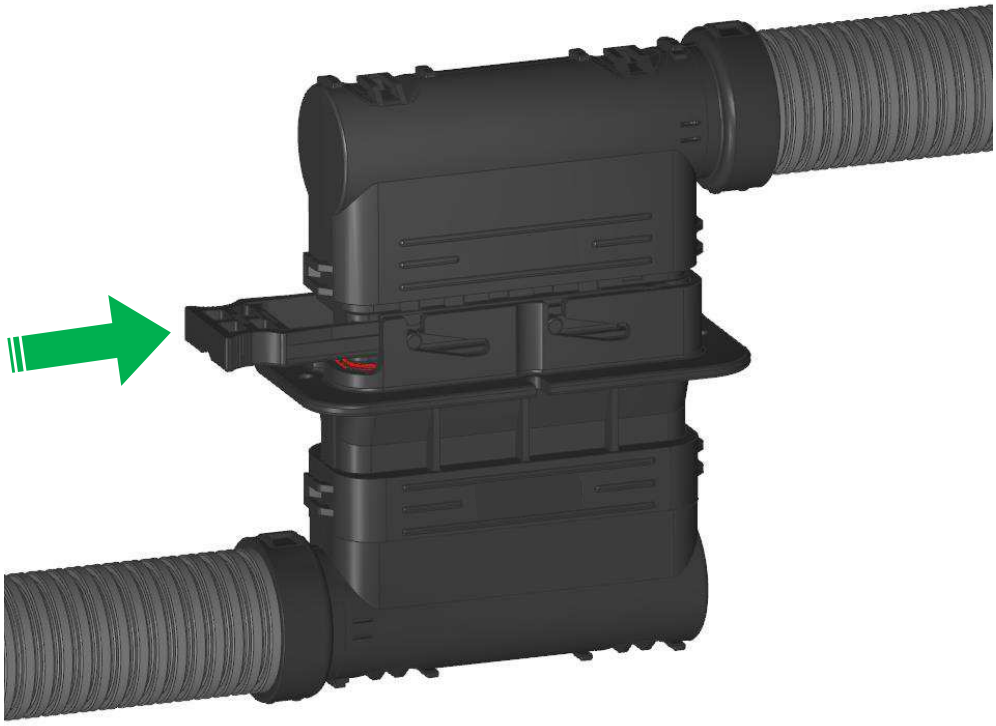
MATING THE CONNECTORS

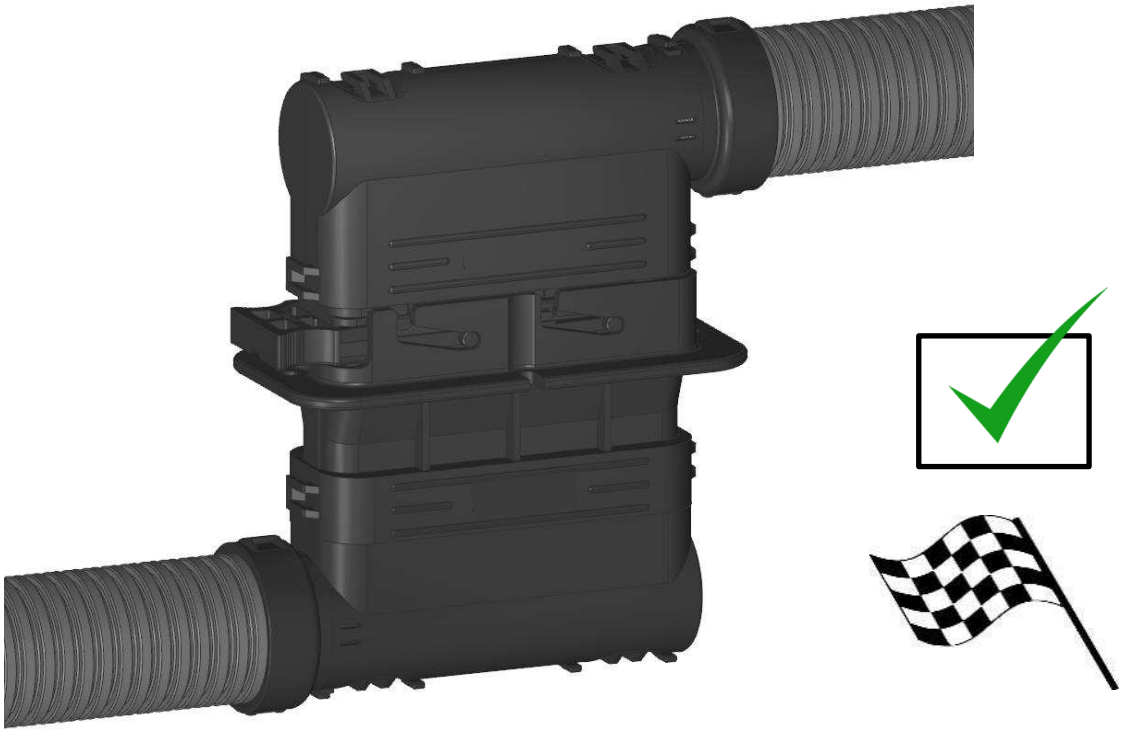




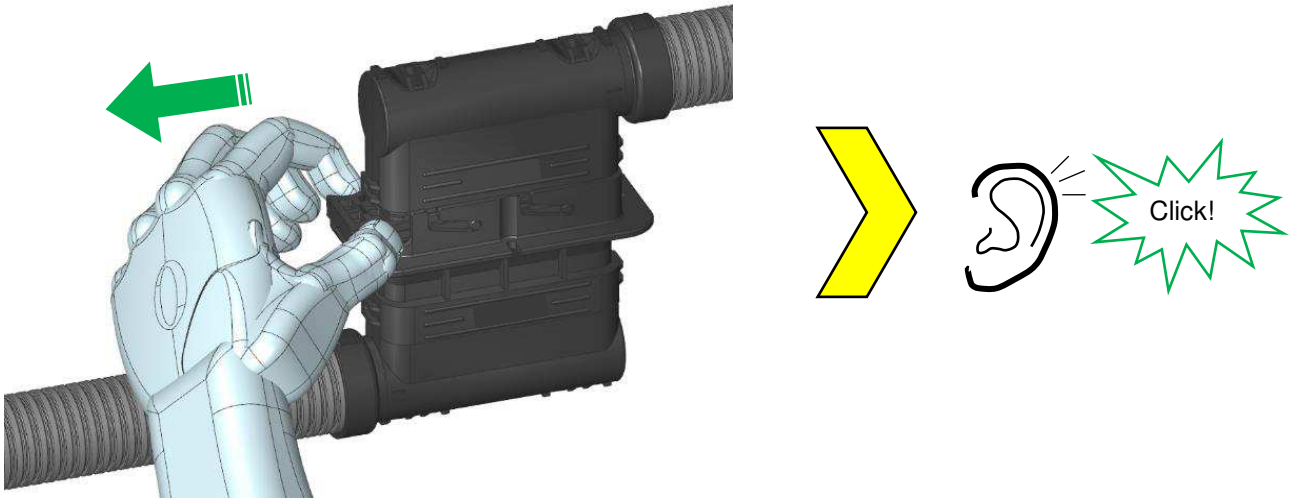


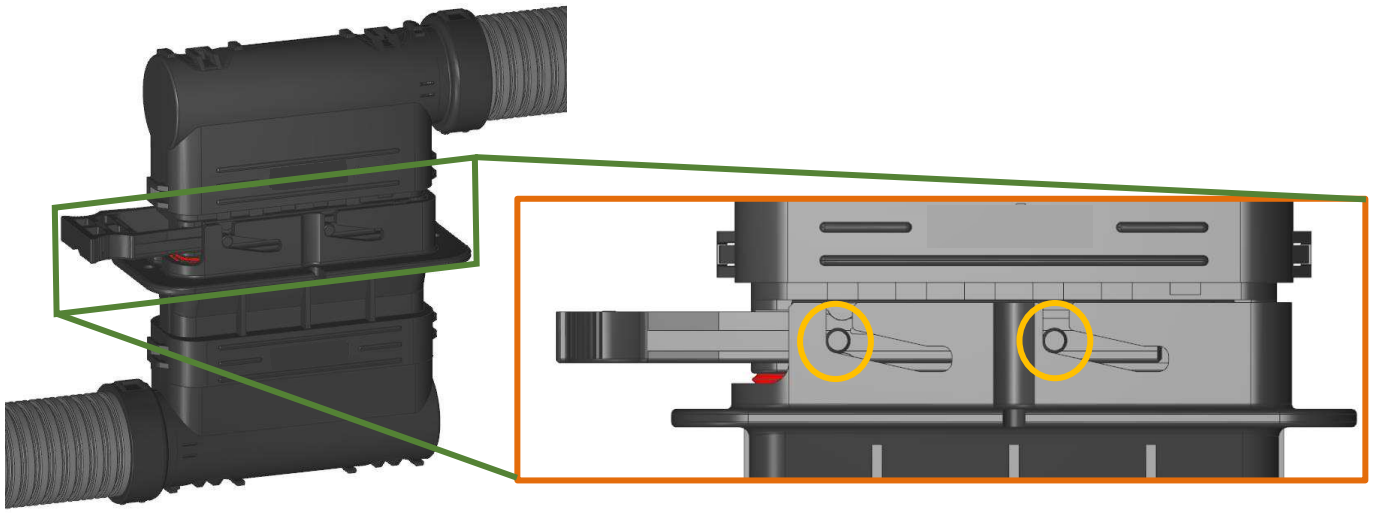
MATING THE CONNECTORS

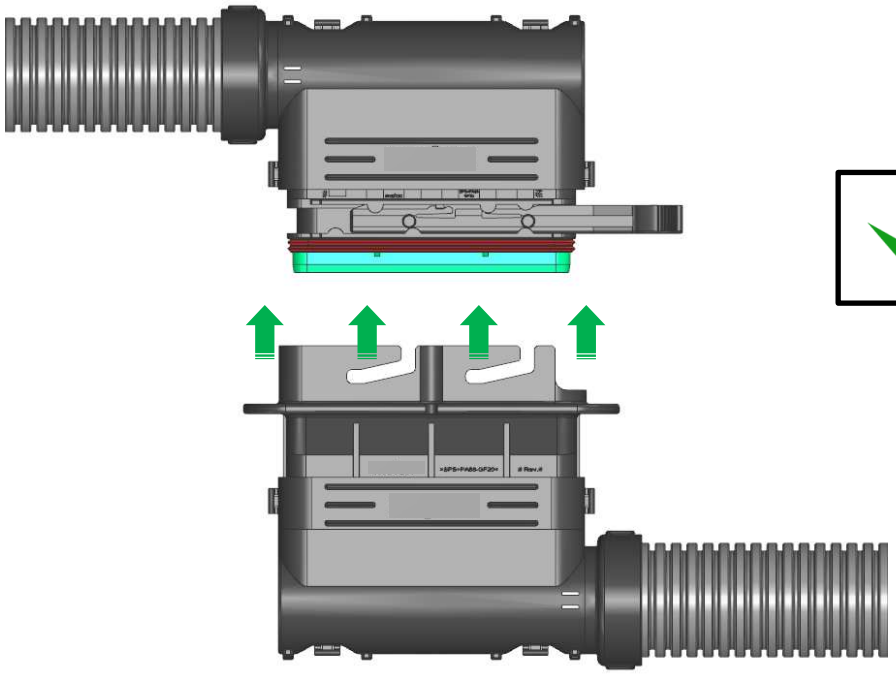




UNMATING THE CONNECTORS

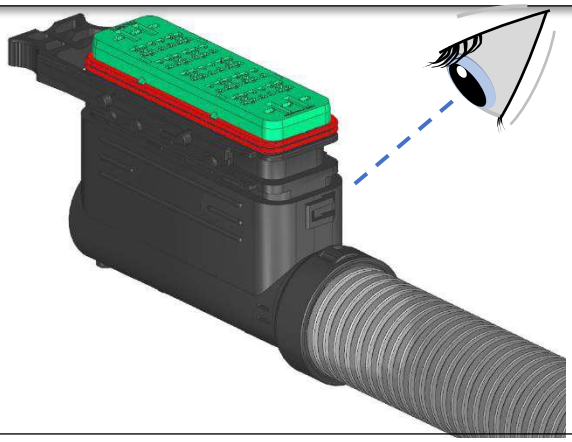


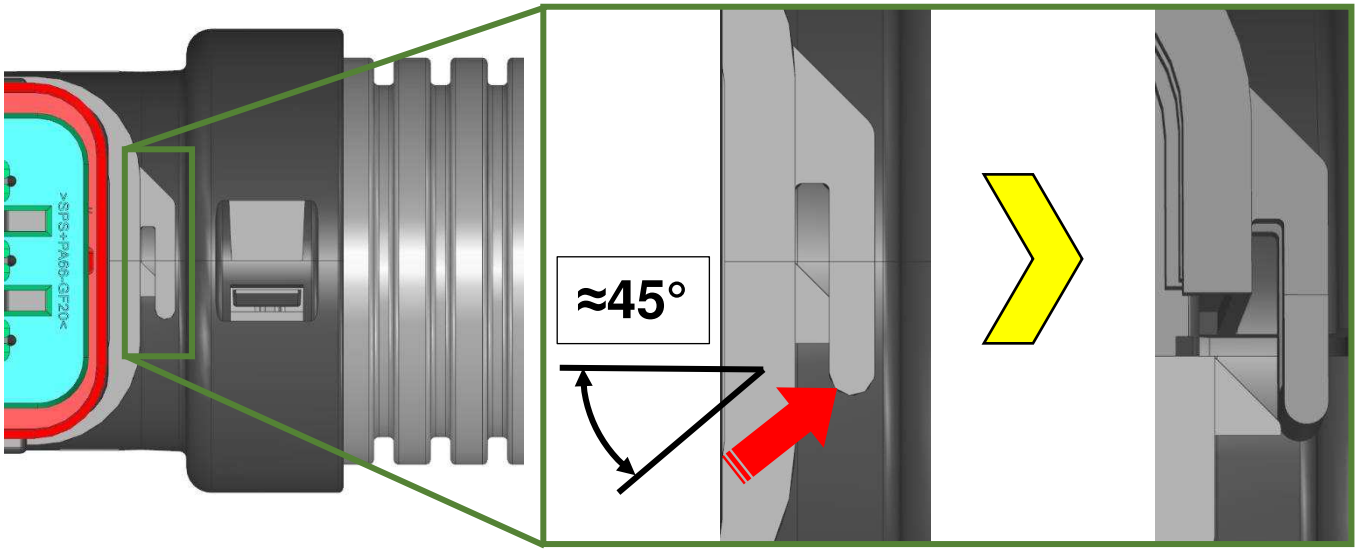


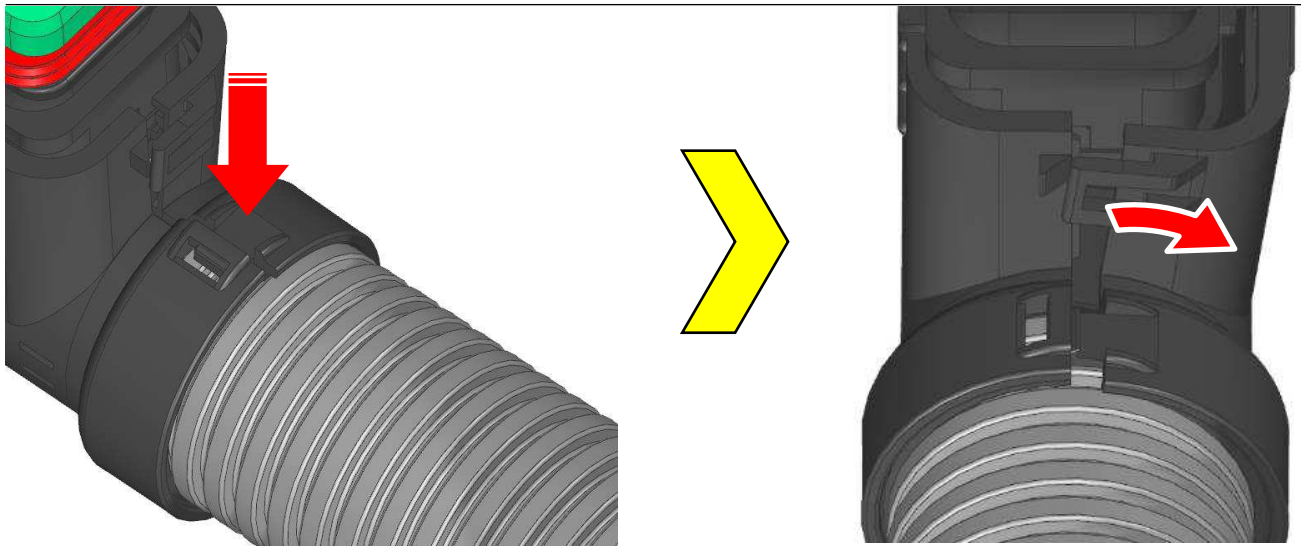


SUGGESTED REMOVAL SEQUENCE

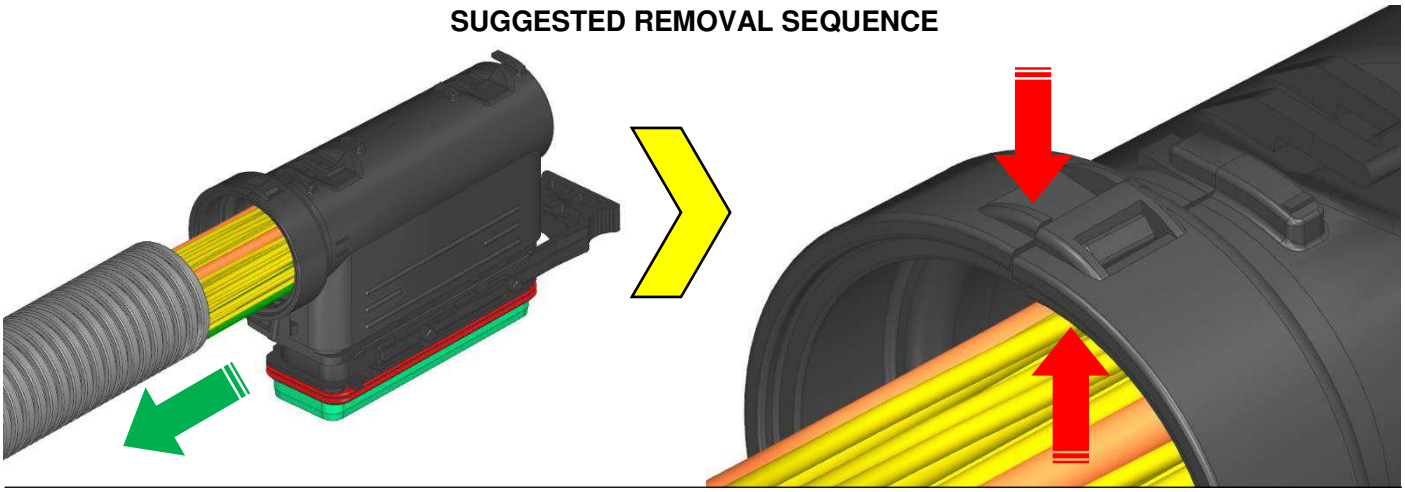
Removal sequence same for both male and female connectors

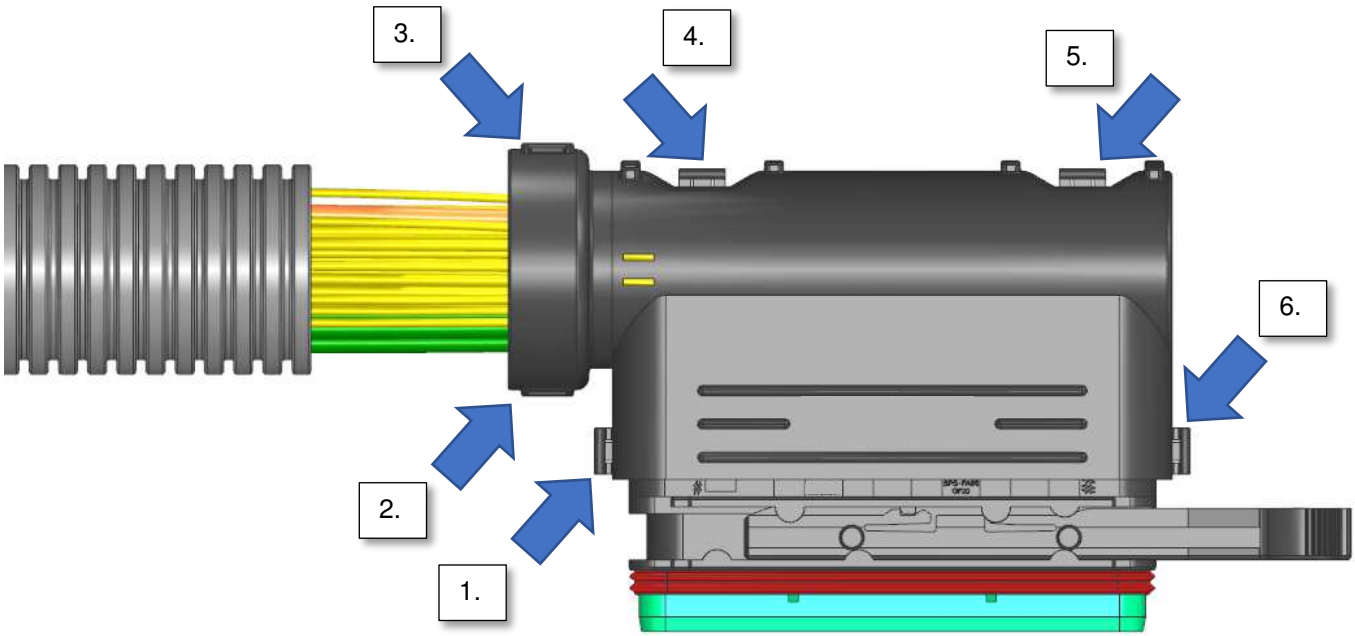






SUGGESTED REMOVAL SEQUENCE



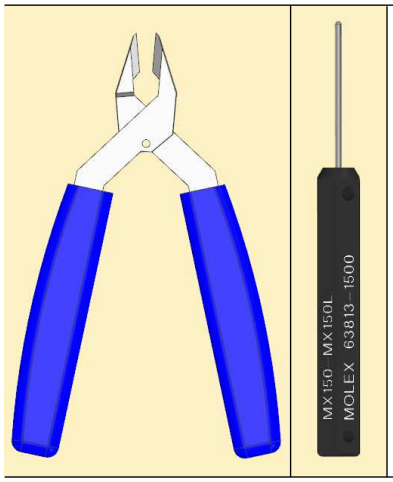


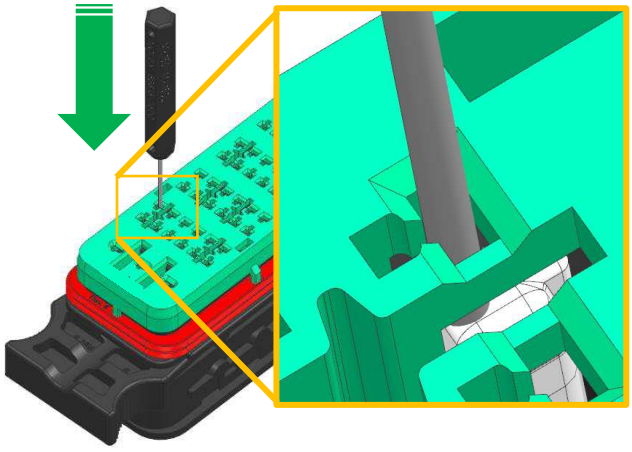
- Recommend sequence above
- Always start at latch nearest the connector
- Easier to start at an open exit side
- Continue de-latching in Clockwise / Anti-clockwise direction
- Same method for each latch & exit

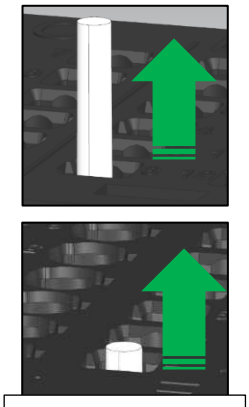
REMOVING SIGNAL BLIND CAVITY PLUGS FROM FEMALE ASSEMBLY

Open TPA – see sheet 6

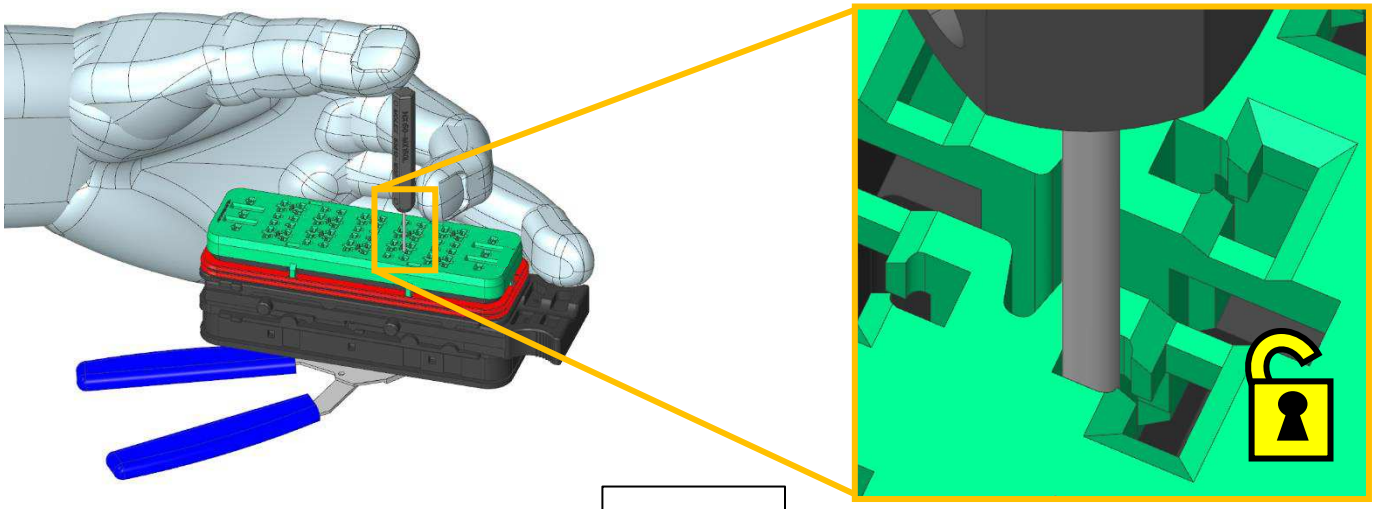
Do not damage cables when removing blind cavity plug





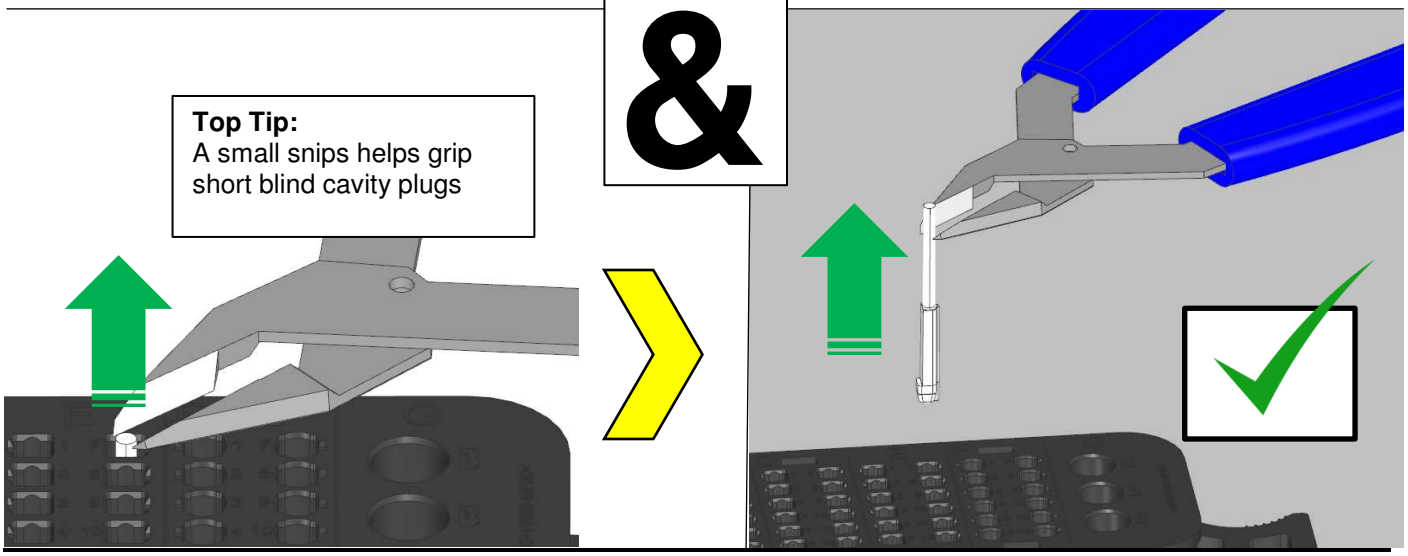


Previously Cut



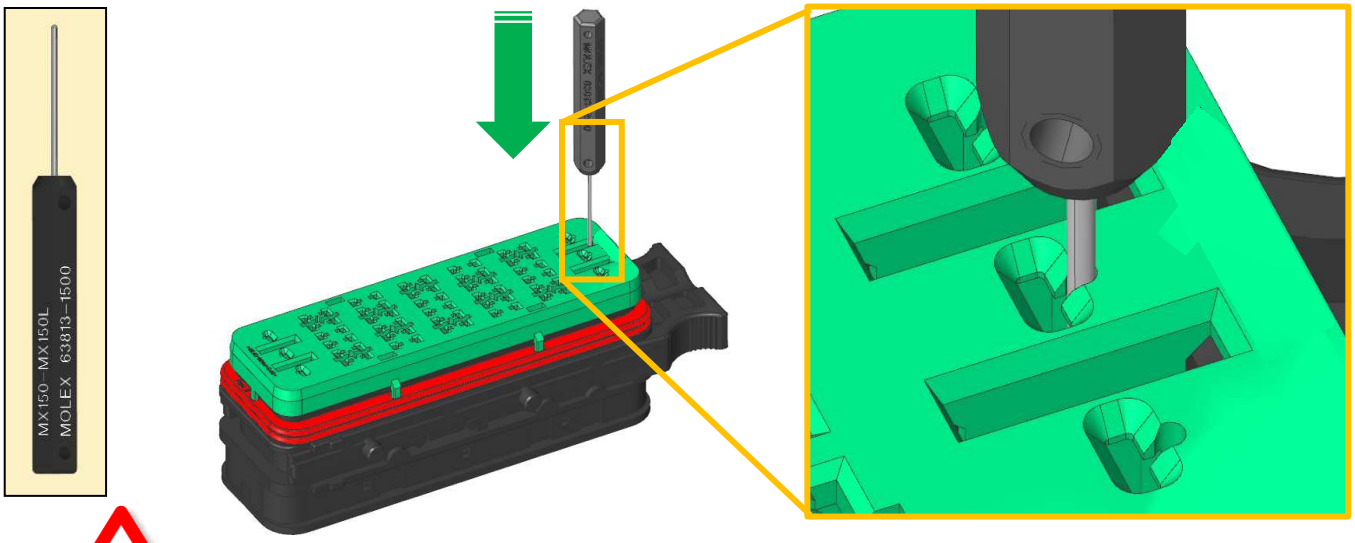
Top Tip:
A small snips helps grip short blind cavity plugs

&

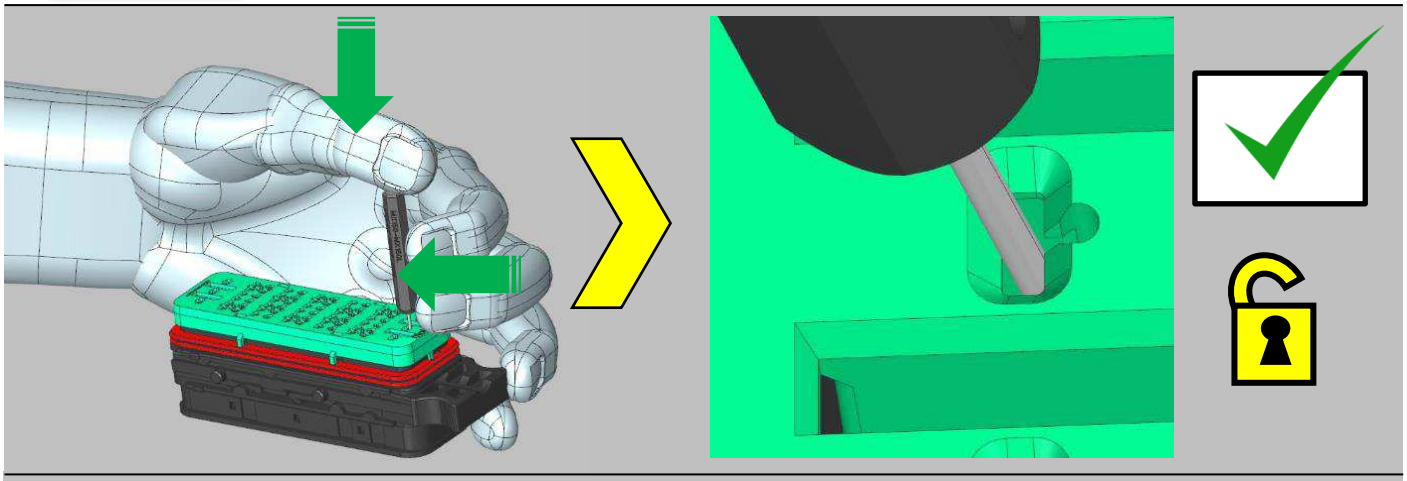


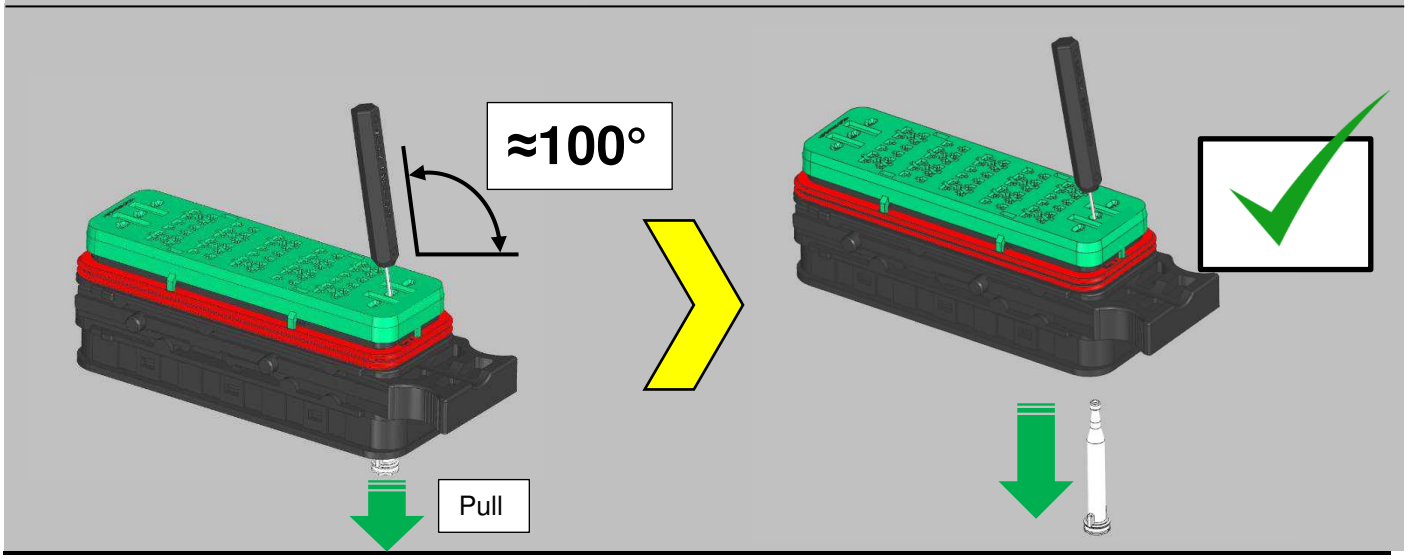
REMOVING POWER BLIND CAVITY PLUGS FROM FEMALE ASSEMBLY

OPEN TPA – SEE SHEET 6



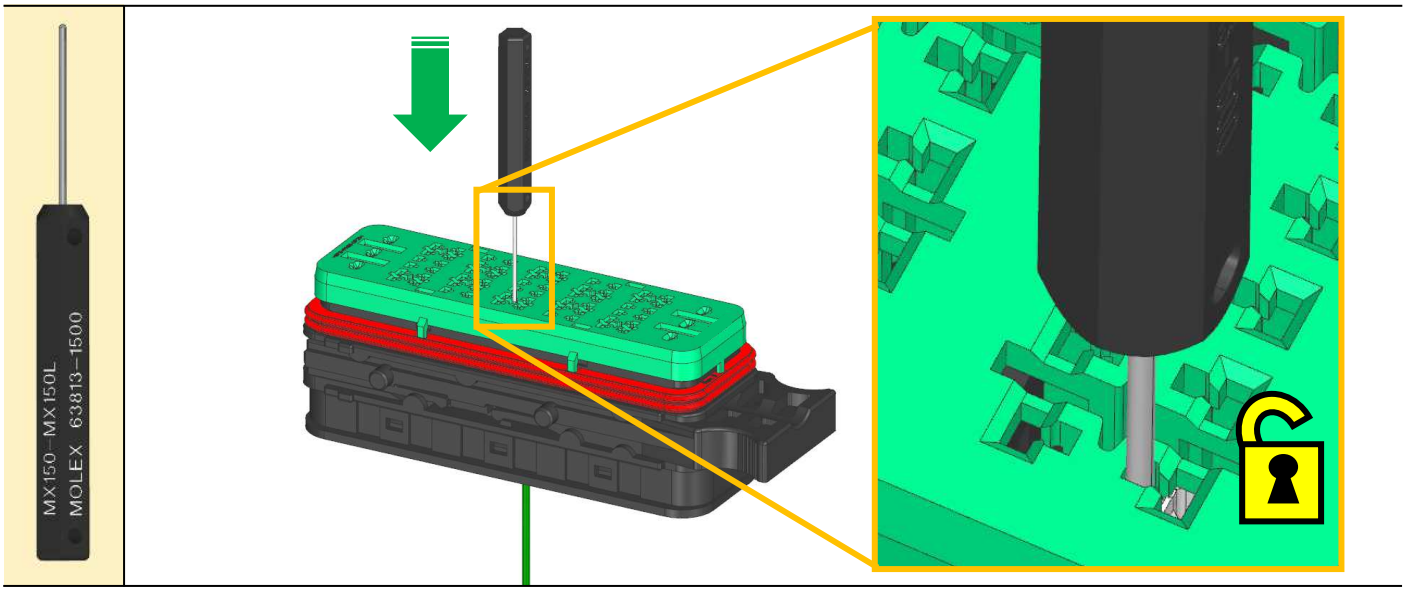
Special case for female power cavities



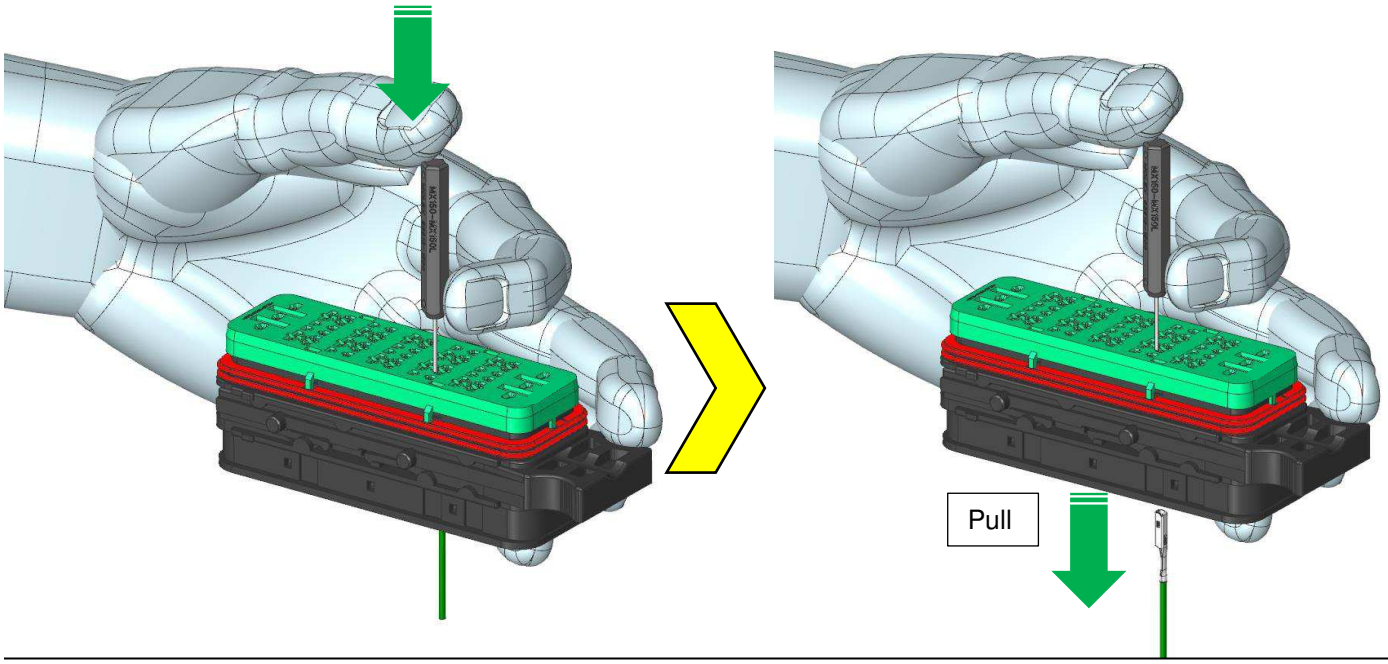


REMOVING SIGNAL & 2.5MM² TERMINALS FROM FEMALE ASSEMBLY

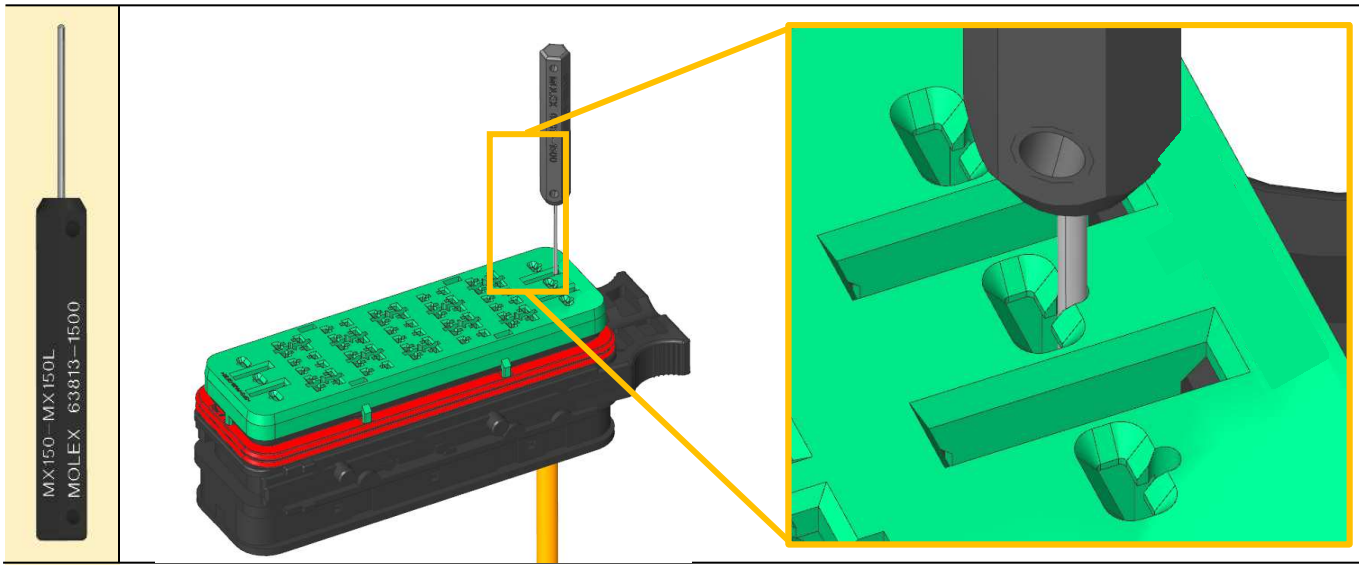
OPEN TPA – SEE SHEET 6



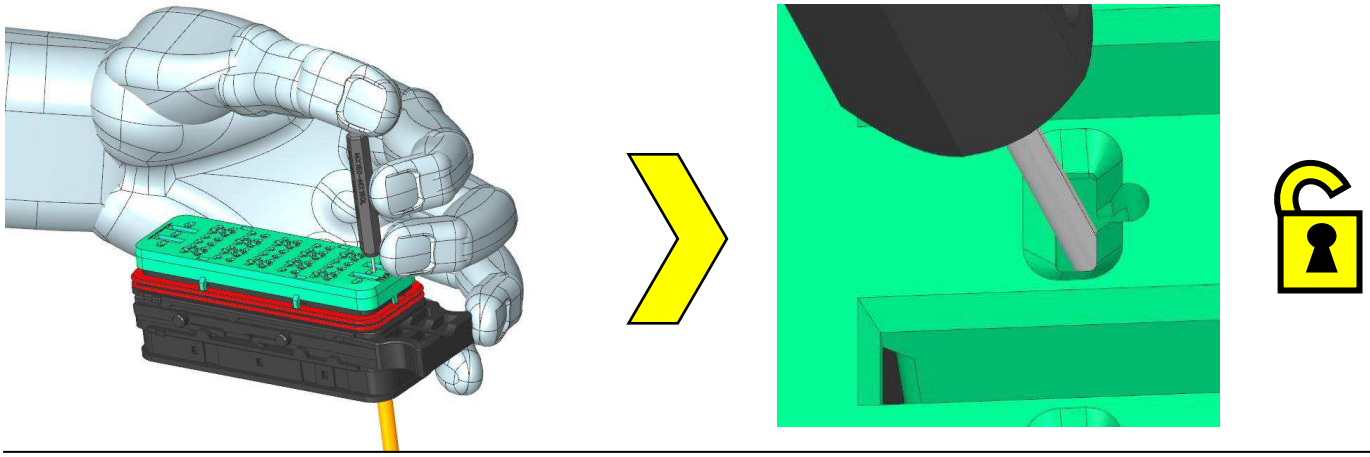
Pull cables carefully through the seal

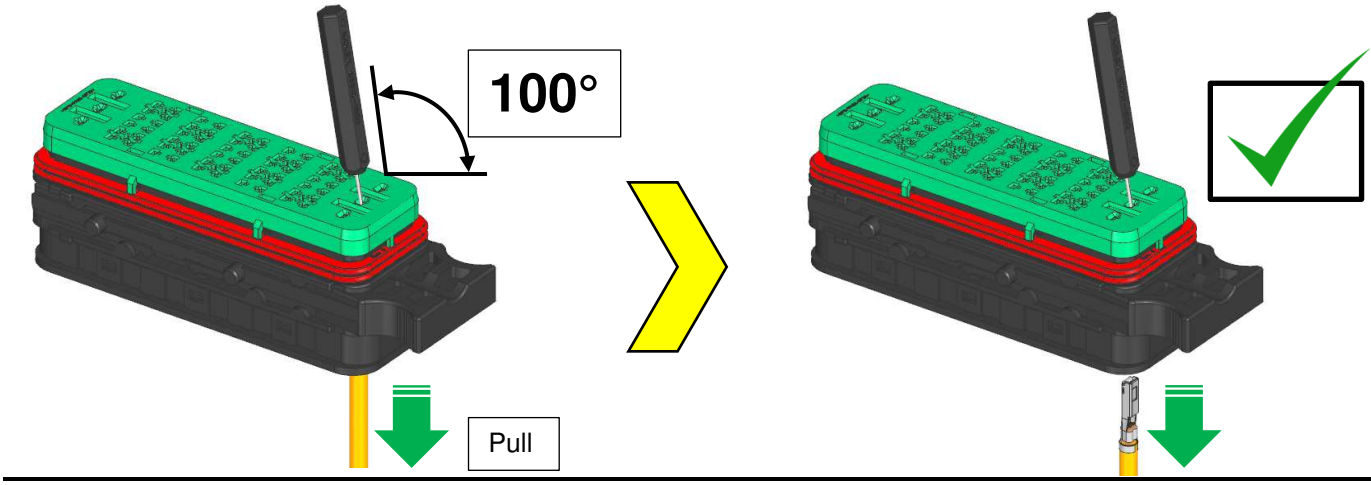


OPEN TPA – SEE SHEET 6

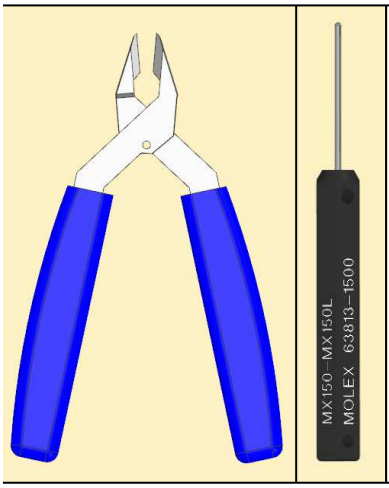


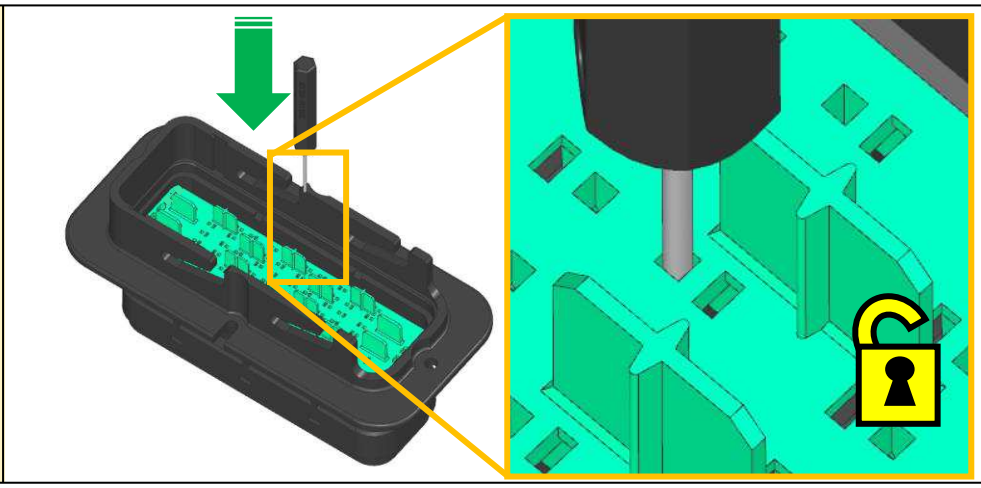
- **Special case for female power cavities**
- **Pull cables carefully through the seal**



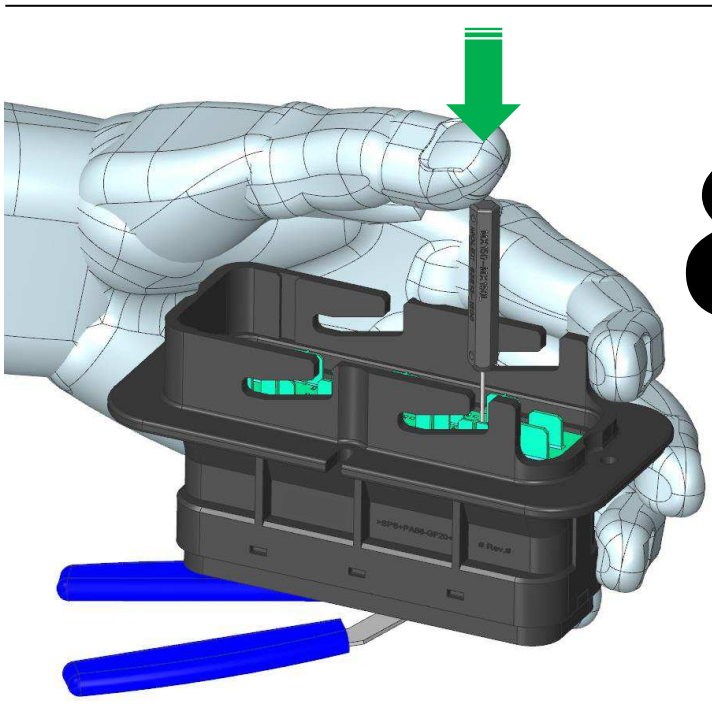


OPEN TPA – SEE SHEET 22

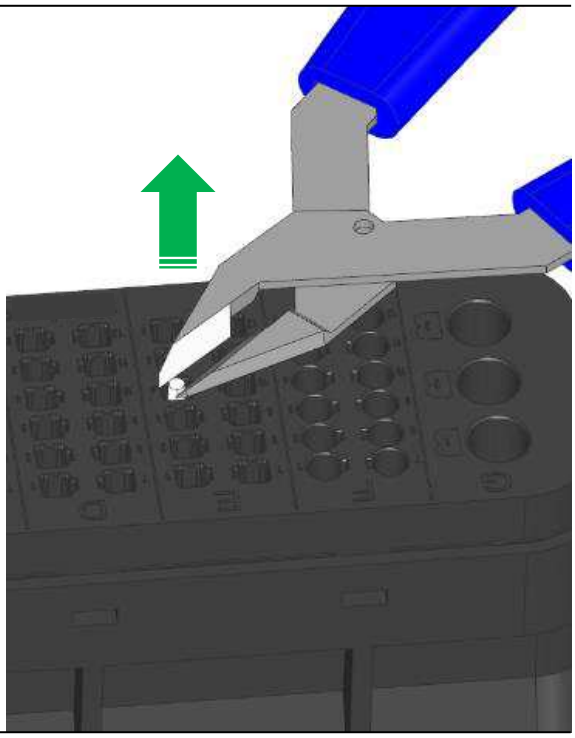




Top Tip:
A small snips helps grip short blind cavity plugs

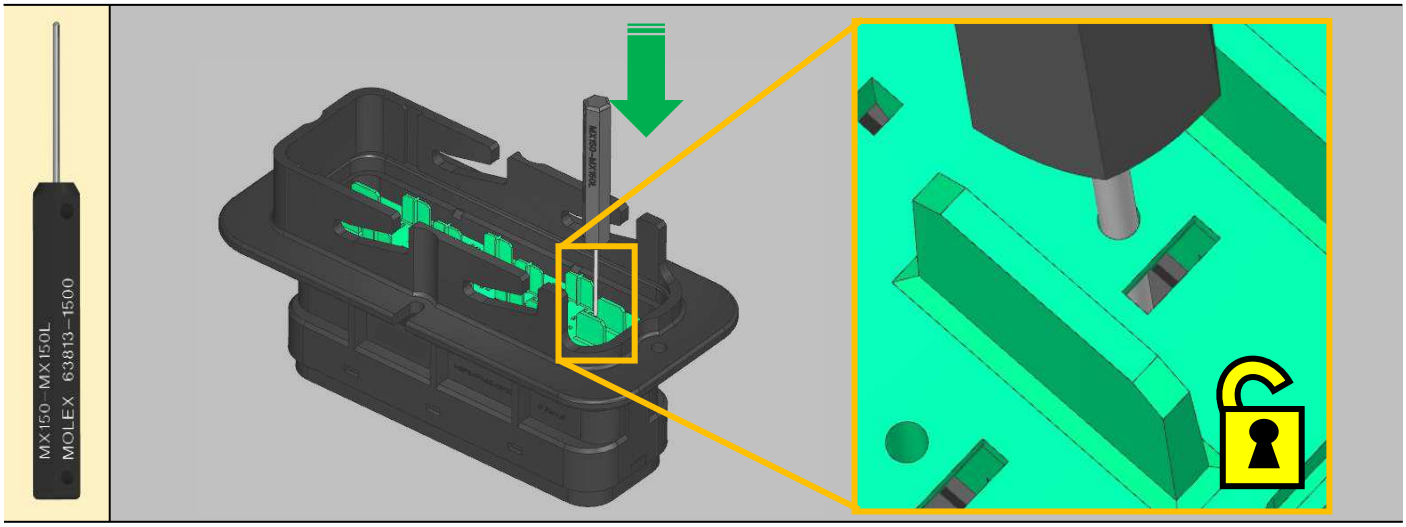


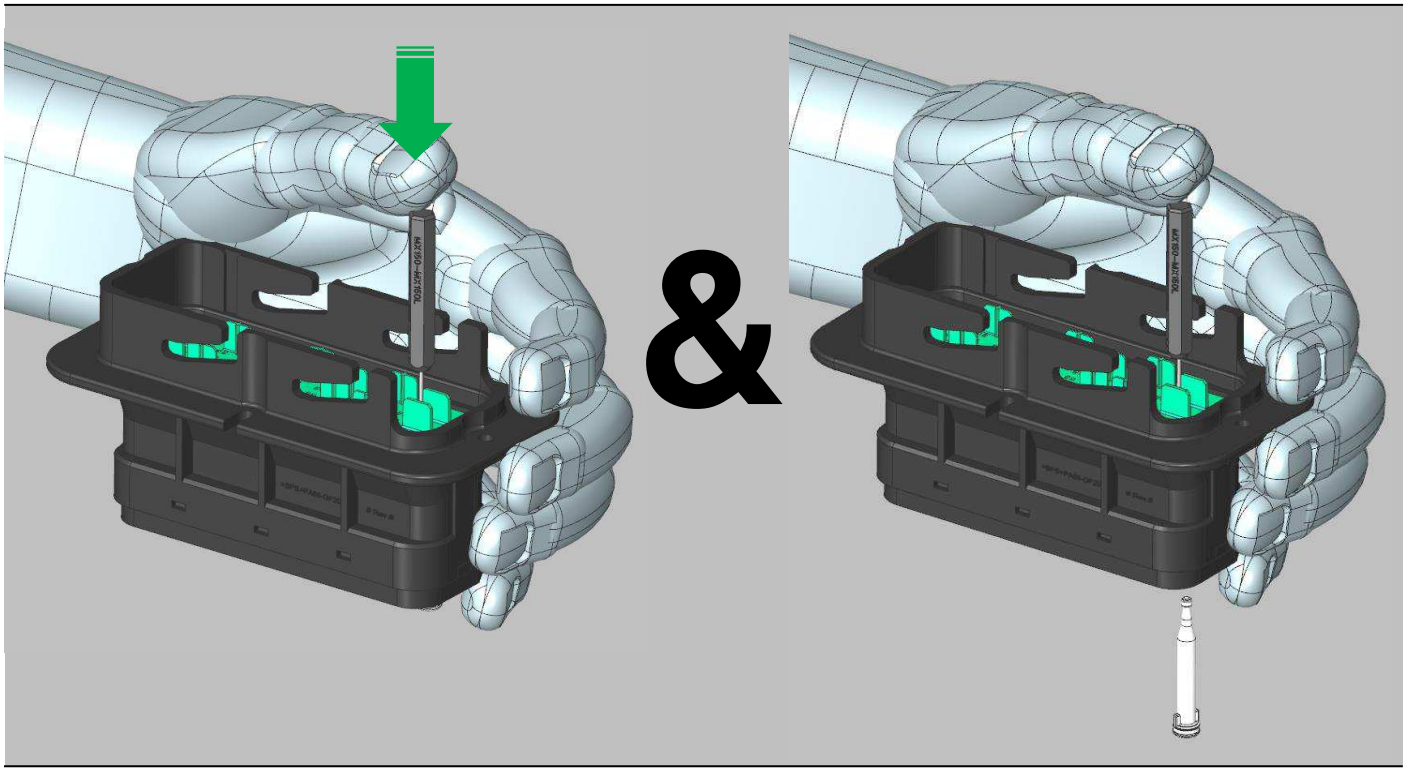
&



REMOVING POWER BLIND CAVITY PLUGS FROM MALE ASSEMBLY

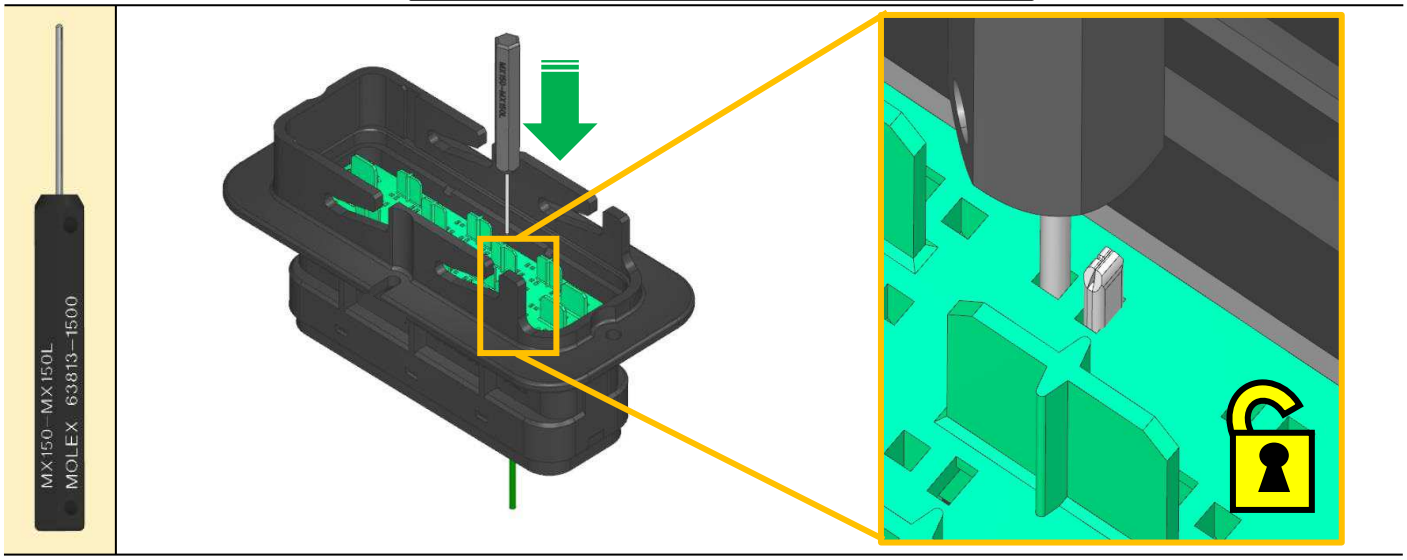
OPEN TPA – SEE SHEET 22



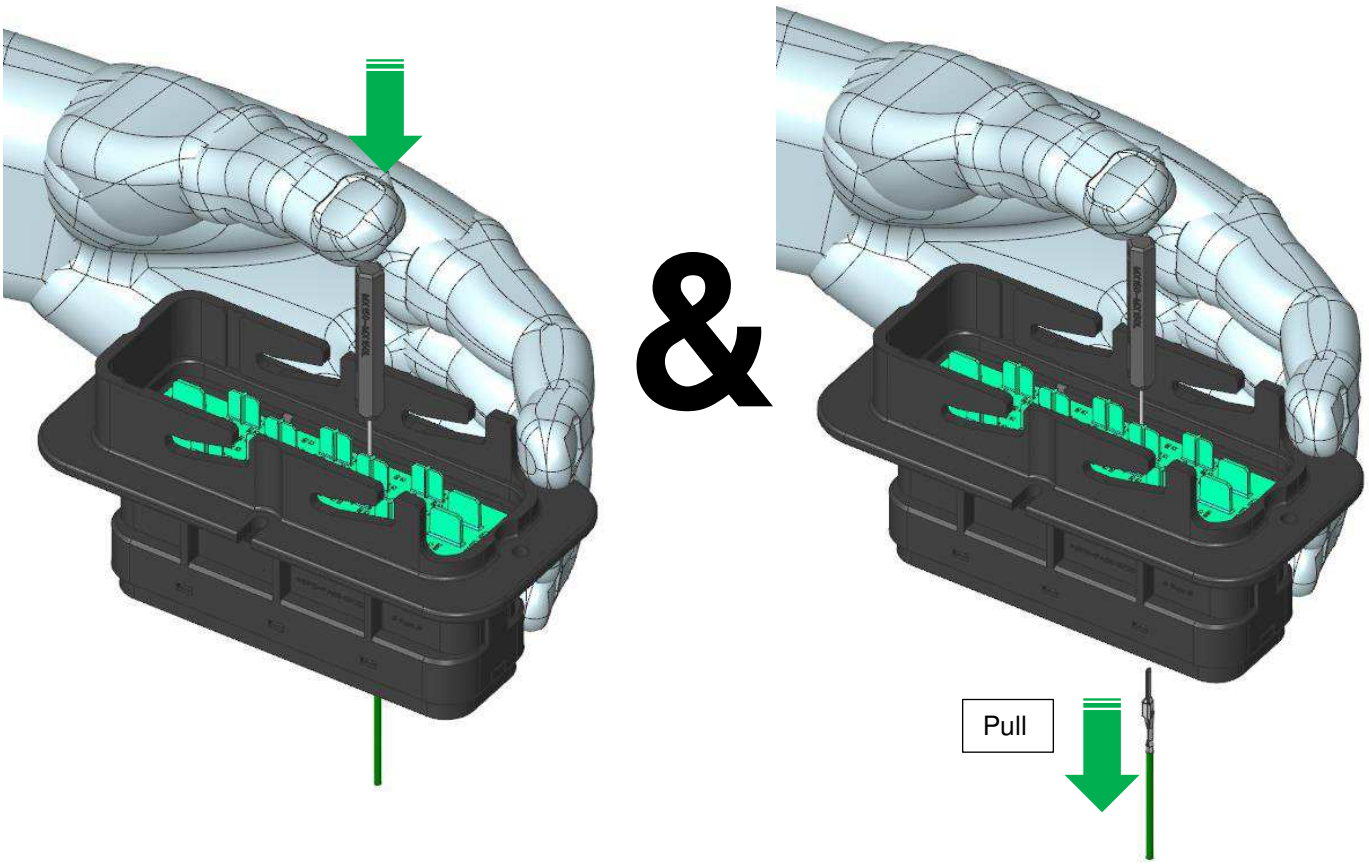


REMOVING SIGNAL & 2.5MM² TERMINALS FROM MALE ASSEMBLY

OPEN TPA – SEE SHEET 22

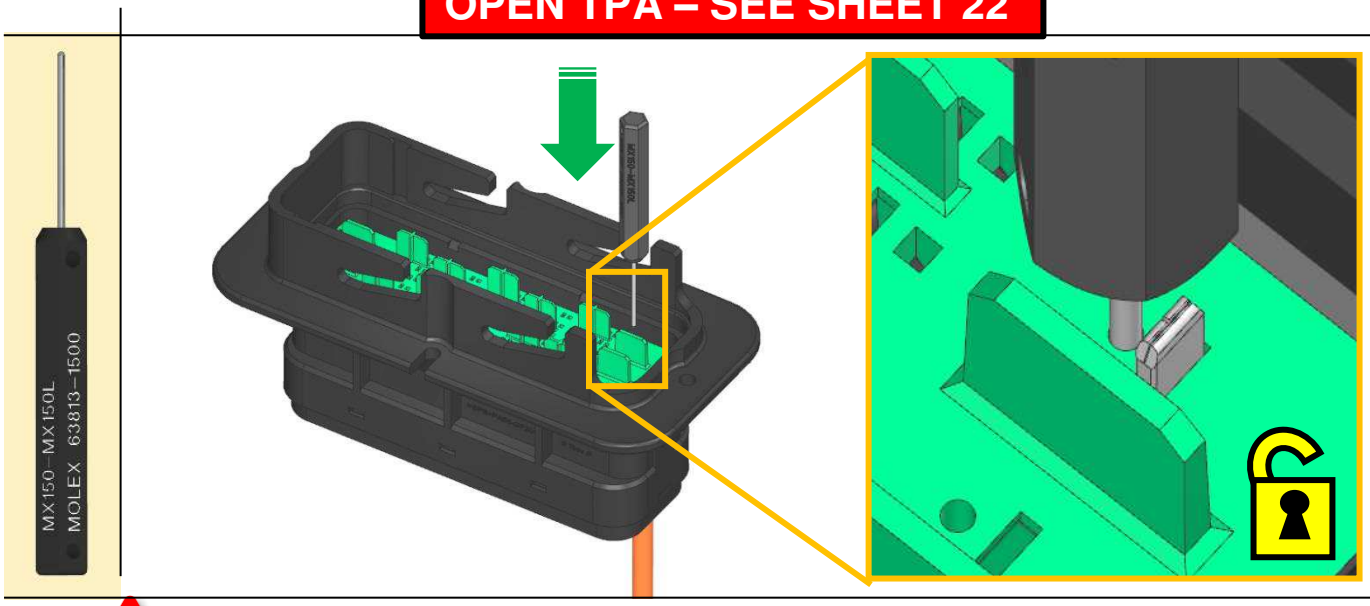


Pull cables carefully through the seal

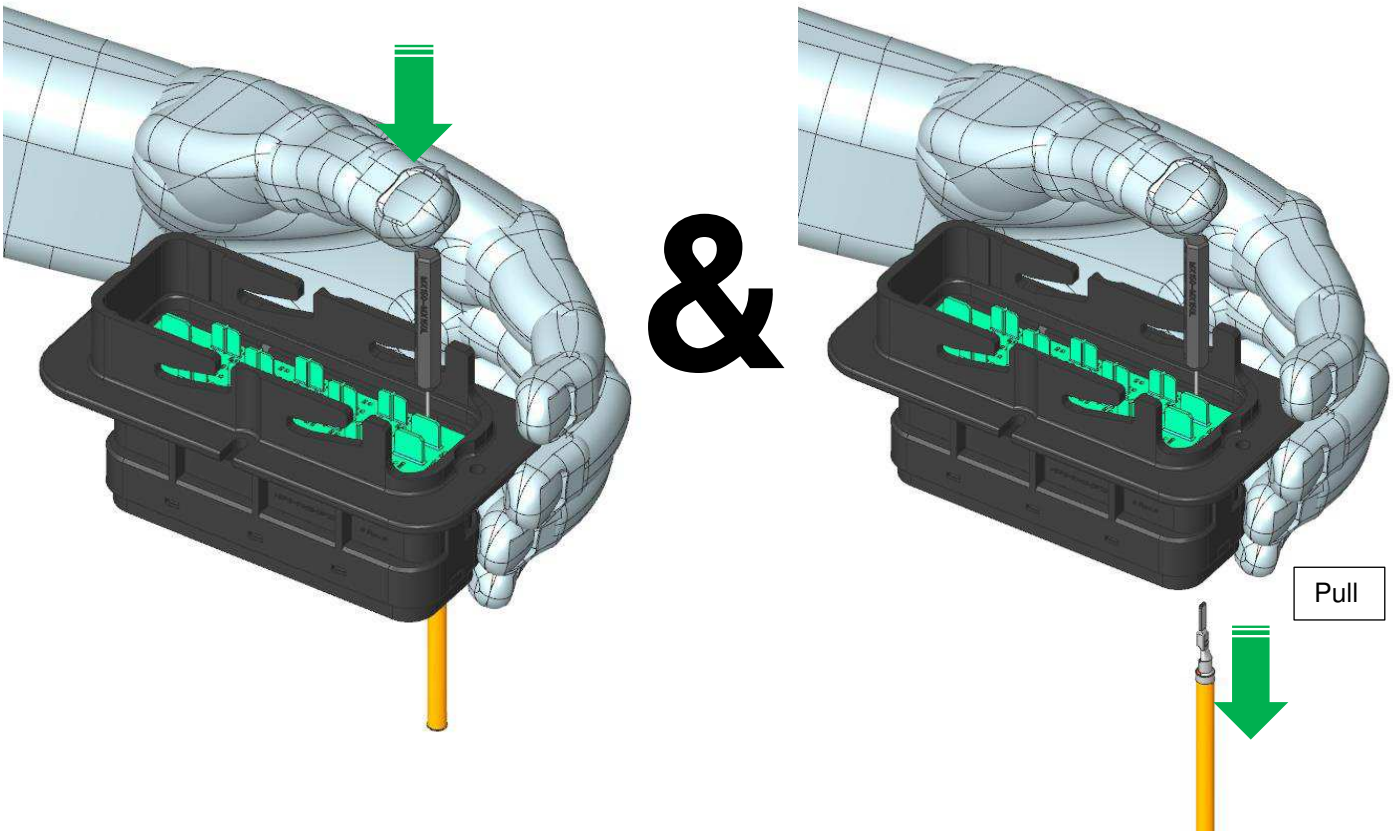


REMOVING POWER TERMINALS FROM MALE ASSEMBLY

OPEN TPA – SEE SHEET 22



Pull cables carefully through the seal



Disclaimer and Recommendations

1. Tools shown are recommendations only. TE connectivity will not be held responsible if an inappropriate tool is used for terminal removal.
2. Care must be taken when completing the 'Top Tip' sections. Terminal extraction tool must never be inserted into female terminals. Top Tip (page 9) is only ever to be used on signal blind cavity plugs to push them out in the event of over-insertion.
3. Take care when removing blind cavity plugs using a snips as they are easy to cut, the snips is only used to help grip the plugs.
4. TE connectivity recommends trimming the signal blind cavity plugs after insertion. This should always be completed before any wires are assembled into the connector housings.
5. Take care when removing blind cavity plugs from a fully assembled connector, do not damage the neighbouring cables with the snips.
6. Always insert the male terminal at 90° to the rear cover. Insert with care through the seal.
7. When inserting terminals hold the cable approx. 1cm back from the insulation crimp.
8. Conduit must be used in conjunction with the conduit interface/wire dress. Molex will not be held responsible if cables get damaged when conduit is not used with the conduit interface/wire dress. Each cable bundle should occupy a maximum of 70% of each conduit exit.
9. **This instruction manual shows a 60+6 configuration for demonstration purposes only. Always ensure the appropriate harness wiring diagram is followed.**
10. Power blind cavity plugs must be pulled fully back in the female housing before the TPA is closed.
11. Terminal and blind cavity plug removal – parts must be pulled out of assembly in the direction shown by the green arrow in the pictures.
12. Before mating connectors please ensure both connectors are fully populated and that the final checks have been completed.

Reference documents

2500000 thru 2500015	SRC Female Receptacle Housing Assembly Sales Drawing
2500016 thru 2500031	SRC Male Housing Assembly Sales Drawing (Extended Rear Cover)
2500034	SRC Female Conduit Interface Sales Drawing
2500035	SRC Male Conduit Interface Sales Drawing
TEC-108-160018	SRC Male and Female Mixed Power Assembly Product Specification
107-160003-02	SRC Male Assembly Packaging Specification (Extended Rear Cover)
107-160003-01	SRC Female Receptacle Housing Packaging Specification
107-160003-04	SRC Conduit interface Packaging Specification
TEC-108-160019	SRC Conduit interface Product Specification
2500033	SRC Power Blind Cavity Plug Sales Drawing
107-160003-05	SRC Power Blind Cavity Plug Packaging Specification
TEC-108-160020	SRC Power Blind Cavity Plug Product Specification

The following documents are Molex documents related to terminals used in the SRC Connectors

SD-19431-***	MX150L Various Male Blade Terminal Sales Drawings
SD-19434-***	MX150L Various Female Receptacle Terminal Sales Drawings
SD-33000-001	MX150 Male Blade Terminal Sales Drawing
SD-33012-002	MX150 Female Receptacle Terminal Sales Drawing
936420010 PSD	SRC 2.5mm² Blade Terminal Sales Drawing
936420010 PSK	SRC 2.5mm² Blade Terminal Packaging Specification
936430010 PSD	SRC 2.5mm² Receptacle Terminal Sales Drawing
936430010 PSK	SRC 2.5mm² Receptacle Terminal Packaging Specification
936420010 PSP	SRC 2.5mm² Terminal Product Specification

Thanks for choosing TE Connectivity